

## Using a lap grinder

1. With the machine running, pour about 4 tbsp of 80 grit onto the lap plate.
2. Pour in enough water to create a slurry.
3. Stop the machine and place the item to be lapped on the lap plate and start the machine.
4. Due to the grit breaking down as the machine runs, it is recommended that 1 tbsp. of grit be added for every hour of operation.

### How to tell when material is flat

1. Wash the piece off.
2. Using an aluminum marking pencil, mark the bottom of the piece off in ½" squares.
3. Replace and lap for about 10 more minutes.
4. Remove the piece and examine the bottom. If the lines have been lapped off, the piece is flat and ready for the next lapping operation.

### Second lapping operation

Remove the grit in the lap and replace with 4 tbsp of 220 grit and enough water to create a slurry. This should be sufficient for 4 hours of lapping, which should take you to the next stage in the lapping process.

### Third lapping operation

Exchange 220 grit for 400 grit and run for about 4 hours.

### Fourth lapping operation

Exchange for 600 grit and run for about 5 hours.

### Polishing

Install the Neoprene polishing pad smooth side up. Replace the splash guard and bumper ring. Start the machine and place 3 tbsp of tin oxide on the pad and add enough water to create a liquid state. Most objects require about 5 hours of lapping to be polished – however, the size and weight of the object will make a difference in the lapping time and you will have to be your own judge.

### NOTE:

These instructions are for a 24" lap plate. Use proportionately larger or smaller amounts of grit for larger or smaller lap plates.