

Fed. Std. No. 115B
 January 6, 1970
 (SS-S-736, Issues in Effect)
 SUPERSEDING
 Fed. Std. No. 115A
 September 4, 1958

FEDERAL STANDARD
 STONES, SHARPENING

Authority. This standard is issued pursuant to the Federal Property and administrative Services Act of 1949, as amended, and its application to purchase of commodities referred to herein is mandatory on all Federal agencies.

S1. Purpose and scope. The purpose of this standard is the establishment of a standard list of sharpening stones as required for ordinary maintenance purposes by Government activities. This standard will keep the varieties of such sharpening stones which are to be procured and stocked to the minimum consistent with such requirements. The nonstandard items listed will no longer be authorized for procurement.

S2. Application. Purchases of sharpening stones under Federal Specification SS-S-736 of the issue in effect on date of invitation for bids shall be limited to the items listed herein. Existing Government stocks of sharpening stones listed as nonstandard items shall be issued until exhausted. In those cases where this Federal Standard eliminates supply items and the items so eliminated are under contract, if the contract cannot be negotiated or amended to conform to the standard items, the Federal Standard becomes mandatory at the contract expiration date.

S3. Standard items. The standard items with their applicable Federal Stock Number shall conform to the characteristics listed in the following tables:

Type I, Sharpening Stone, Mounted in Box. Natural (Novaculite) in Hard and Soft Grit as Specified. Not Oil Treated.

TABLE I. Type I, Class B, Style 1, natural stone (novaculite), mounted, rectangular

Federal Stock No.	Grit	Dimensions		
		Length, A	Width, B	Thickness, C
		Inches	Inches	Inches
5345-982-4551	Hard	3-1/2	1	1/2 to 1
5345-584-4626	Hard	4	1-7/8	3/4 to 1
5345-262-9464	Soft	6	1-7/8	3/4 to 1
5345-270-6908	Hard	6	1-7/8	3/4 to 1
5345-262-9465	Soft	8	1-7/8	3/4 to 1
5345-265-3126	Hard	8	1-7/8	3/4 to 1

Type II, Sharpening Stone, Unmounted. Class A-1, Artificial, (Aluminum Oxide) and Class A-2, Artificial, (Silicon Carbide), Style 1 in Fine, Medium, Coarse and Combination Grit, as Specified. Class B, Natural (Novaculite or other Materials Sedimentary in Nature), in Soft and Hard Grit, as specified.

TABLE II. Type II, Class A-1, A-2, and B, Style 1, artificial and natural, unmounted, rectangular

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
			Inches	Inches	Inches
5345-408-0451	B	Hard	2-1/2	1/4	3/32
5345-985-6921	A-2	Fine	3	7/8	1/4
5345-292-2314	A-2	Fine	3	7/8	3/8
5345-584-4486	B	Hard	3	1	1/4 to 3/8
5345-584-4487	B	Soft	3	1	1/4 to 3/8
5345-584-4543	B	Hard	3 to 3-1/2	3/8 to 1/2	1/8 to 3/16
5345-474-8787	A-2	Medium	3-1/2	3/4	1/2
5345-247-5955	A-1	Fine	4	1/2	1/16
5345-584-4587	A-2	Fine	4	1	1/4
5345-584-4574	A-2	Medium	4	1	1/4
5345-584-4573	A-2	Coarse	4	1	1/4
5345-161-9692	B	Hard	4	1	1/4 to 3/8
5345-598-8277	B	Soft	4	1	1/4 to 3/8

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TABLE II. Type II, Class A-1, A-2, and B, Style 1, artificial and natural, unmounted, rectangular (con.)

Federal Stock No.	Class	Grit	Dimensions		
			Length, A Inches	Width, B Inches	Thickness, C Inches
5345-190-5524	A-2	Combination <u>Fine</u> Coarse	4	1-1/2	1/2
5345-198-8047	A-2	Fine	4	1-3/4	1/2
5345-190-5525	A-2	Medium	4	1-3/4	5/8
5345-190-5520	A-2	Combination <u>Fine</u> Coarse	4	1-3/4	
5345-584-4639	A-1	Fine	6	2	1
5345-265-3125	A-1	Medium	6	2	1
5345-198-8048	A-2	Fine	6	2	1
5345-198-8045	A-2	Medium	6	2	1
5345-198-8054	A-2	Coarse	6	2	1
5345-198-8050	A-2	Combination <u>Fine</u> Coarse	6	2	
5345-584-4580	A-1	Combination <u>Fine</u> Coarse	6	2	1
5345-260-0759	A-1	Combination <u>Fine</u> Coarse	8	2	1
5345-190-5528	A-1	Medium	8	2	1
5345-198-8058	A-2	Fine	8	2	1
5345-198-8040	A-2	Medium	8	2	1
5345-198-8057	A-2	Coarse	8	2	1
5345-161-9695	A-2	Combination <u>Fine</u> Coarse	8	2	
5345-243-6080	A-2	Medium	10	1-1/4	3/4

TABLE III. Type II, Class A-1/A-2, and B/A-1, Style 1, hones (for sharpening microtone knives)

Federal Supply No.	Class	Grit	Dimensions		
			Length Inches	Width Inches	Thickness Inches
5345-190-5531	<u>A-1</u> A-2	Combination <u>Extra Fine</u> Fine	4	2	5/8
5345-433-8660	<u>B</u> A-1	Combination <u>Hard</u> Extra Fine	11-1/2	2-1/2	1

TABLE IV. Type II, Class A-1 and A-2, Style 2, artificial, unmounted, half-round

Federal Stock No.	Class	Grit	Dimensions		
			Length, A Inches	Width, B Inches	Thickness, C Inches
5345-242-2555	A-1	Fine	4	5/16	5/32
5345-224-6595	A-1	Fine	4	3/8	3/16
5345-198-8046	A-2	Medium	6	5/8	5/16

TABLE V. Type II, Class A-1 and B, Style 3, artificial and natural, unmounted, round

Federal Stock No.	Class	Grit	Dimensions	
			Length, A	Diameter, B
			Inches	Inches
5345-198-8060	B	Hard	3 - 3-1/2	1/4 - 5/16
5345-260-0754	A-1	Fine	4	1/4
5345-247-5959	A-1	Medium	4	1/4
5345-247-5960	A-1	Coarse	4	1/4
5345-584-4554	A-1	Fine	4	3/8
5345-247-5958	A-1	Medium	4	3/8
5345-282-8850	A-1	Fine	4	1/2
5345-247-5957	A-1	Medium	4	1/2
5345-584-4556	A-1	Coarse	4	1/2

TABLE VI. Type II, Class A-1, A-2, and B, Style 4, artificial and natural, unmounted, square

Federal Stock No.	Class	Grit	Dimensions	
			Length, A	Width, B Thickness, C
			Inches	Inches
5345-243-6087	B	Hard	3 - 3-1/2	1/4
5345-256-3648	B	Hard	3 - 3-1/2	3/8
5345-584-4483	B	Hard	3 - 3-1/2	1/2
5345-271-6895	A-1	Fine	4	1/4
5345-253-4400	A-1	Medium	4	1/4
5345-243-6082	A-1	Fine	4	3/8
5345-262-9460	A-1	Medium	4	3/8
5345-286-9057	A-1	Medium	4	1/2
5345-238-9987	A-2	Fine	4	1/2
5345-584-4607	A-1	Fine	6	1/2
5345-584-4608	A-1	Medium	6	1/2
5345-584-4609	A-1	Coarse	6	1/2
5345-584-4546	A-1	Medium	6	5/8
5345-198-8041	A-1	Fine	6	3/4
5345-247-5943	A-1	Medium	6	3/4
5345-247-5938	A-1	Coarse	6	3/4
5345-247-5941	A-1	Fine	6	1

TABLE VII. Type II, Class A-1, A-2, and B, Style 5, artificial and natural, unmounted, triangular (equilateral)

Federal Stock No.	Class	Grit	Dimensions	
			Length, A	Width, B
			Inches	Inches
5345-271-6896	B	Hard	3 - 3-1/2	1/8
5345-184-1372	B	Hard	3 - 3-1/2	1/4
5345-584-4496	B	Hard	3 - 3-1/2	3/8
5345-260-0756	A-1	Fine	4	1/4
5345-247-5949	A-1	Medium	4	1/4
5345-584-4616	A-1	Medium	4	3/8
5345-584-4615	A-1	Fine	4	3/8
5345-281-4044	A-2	Medium	4	3/8
5345-247-5948	A-1	Medium	4	1/2
5345-584-4523	A-1	Fine	6	1/2
5345-616-7672	A-1	Medium	6	5/8
5345-584-4534	A-1	Fine	6	1

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TABLE VIII. Type II, Class A-1 and B, Style 6, artificial and natural, unmounted, knife blade

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
5345-602-6923	A-1	Medium	Inches 2-1/4	Inches 7/8	Inches 3/16 Back
5345-184-1374	B	Hard	3 - 4	3/4 - 1	1/8 - 1/4
5345-247-5942	A-1	Medium	4	1	1/8 Back

TABLE IX. Type II, Class A-1 and B, Style 7, artificial and natural, unmounted, point

Federal Stock No.	Class	Grit	Dimensions	
			Length, A	Base diameter, B
5345-584-4529	A-1	Fine	Inches 3	Inches 5/16
5345-247-5944	A-1	Medium	3	5/16
5345-584-4500	B	Hard	3 - 3-1/2	1/4

TABLE X. Type II, Class B, Style 8, natural, unmounted, oval

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
5345-584-4492	B	Hard	Inches 3 to 3-1/2	Inches 1/2	Inches 3/16 to 1/4

TABLE XI. Type II, Class A-1, Style 9, artificial, unmounted, silversmiths', oval tapered

Federal Stock No.	Class	Grit	Dimensions				
			Length A	Width of		Thickness of	
				Wide end, B	Narrow end, C	Thick end, D	Thin end, E
5345-584-4474	A-1	Fine	Inches 4	Inches 3/8	Inches 3/16	Inches 1/8	Inches 1/16
5345-584-4475	A-1	Medium	4	3/8	3/16	1/8	1/16
5345-247-5956	A-1	Fine	4	1/2	1/4	5/16	1/8
5345-247-5952	A-1	Medium	4	1/2	1/4	5/16	1/8

TABLE XII. Type II, Class A-1, Style 10, artificial, unmounted, silversmiths' rectangular-tapered

Federal Stock No.	Class	Grit	Dimensions				
			Length A	Width of		Thickness of	
				Wide end, B	Narrow end, C	Thick end, D	Thin end, E
5345-198-8044	A-1	Medium	Inches 4	Inches 5/16	Inches 5/16	Inches 3/16	Inches 1/16
5345-247-5953	A-1	Medium	4	1/2	5/16	1/4	1/8

TABLE XIII. Type II, Class B, Style 11, natural, unmounted, diamond

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
5345-584-4494	B	Hard	Inches 3 - 3-1/2	Inches 1/2	Inches 3/16 - 1/4

TABLE XIV. Type II, Class A-1, Style 12, artificial, unmounted, reamer

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
5345-598-4696	A-1	Medium	Inches 4-1/2	Inches 1	Inches 5/16
5345-198-8043	A-1	Fine	5	1	3/16

TABLE XV. Type II, Class A-1, Style 13, artificial, unmounted, slip stones, special gauge

Federal Stock No.	Class	Grit	Dimensions				
			Length	Large End		Small End	
				Width	Thickness	Width	Thickness
5345-584-4491	A-1	Fine	Inches 6	Inches 2	Inches 1	Inches 1/2-3/8	Inches 3/8 - 3/16

TABLE XVI. Type II, Class A-1, A-2, and B, Style 14, artificial and natural, unmounted, round edge slip

Federal Stock No.	Class	Grit	Dimensions			
			Length, A	Width B	Thickness of	
					Thick edge, C	Thick edge, D
			Inches	Inches	Inches	Inches
5345-584-4518	A-1	Fine	4	1	7/16	3/16
5345-198-8055	A-1	Medium	4	1	7/16	3/16
5345-584-4516	B	Hard	4	1-1/4 to 1-1/2	1/4 to 3/8	1/8 to sharp
5345-243-6086	B	Hard	4	1-3/4 to 2	3/8 to 1/2	1/8 to 3/16
5345-576-9193	B	Soft	4	1-3/4 to 2	3/8 to 1/2	1/8 to 3/16
5345-584-4520	A-1	Fine	4-1/2	1-3/4	3/8	1/8
5345-198-8056	A-1	Medium	4-1/2	1-3/4	3/8	1/8
5345-584-4521	A-1	Coarse	4-1/2	1-3/4	3/8	1/8
5345-198-8051	A-2	Medium	4-1/2	1-3/4	1/2	3/16
5345-183-8179	A-2	Fine	4-1/2	2-1/8	5/8	5/16
5345-198-8052	A-2	Medium	4-1/2	2-1/8	5/8	5/16
5345-183-8175	A-2	Coarse	4-1/2	2-1/8	5/8	5/16
5345-584-4512	A-2	Fine	6	2-1/4	3/4	3/8
5345-198-8053	A-2	Medium	6	2-1/4	3/4	3/8

Types III, IV, V, VI, VII, VIII, IX, and X Sharpening Stones, Unmounted. Class A-1 Artificial (Aluminum Oxide) and Class A-2, Artificial (Silicon Carbide), in Fine, Medium, Coarse and Combination Grit, as Specified. Class B, Natural (Novaculite or other Material Sedimentary in Nature), in Soft and Hard Grit, as Specified.

TABLE XVII. Type III, Class A-1, taper, round, artificial, fig. 15

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Large Diameter, D	Small Diameter, H
			Inches	Inches	Inches
5345-253-4401	A-1	Fine	4	1/2	1/4

TABLE XVIII. Type IV, Class A-2, artificial, scythe stone, oval, fig. 16

Federal Stock No.	Class	Grit	Dimensions		
			Length, A	Width, B	Thickness, C
			Inches	Inches	Inches
5345-584-4504	A-2	Coarse	10	1-1/4	3/4 (No Steel Rod Core)

TABLE XIX. Type V, Class A-2, knife sharpener, artificial, round and arrowhead shaped, tapered

Federal Stock No.	Class	Grit	Dimensions
			Length, over-all (includes 5 inch handle)
			Inches
5345-198-8042	A-2	Medium	13-1/2 to 15 fig 17a
5345-224-6596	A-2	Fine	7 to 7-1/2 fig 17b

TABLE XX. Type VI, Class B, sharpening stone, grooved (dental), (natural hard Arkansas, "bates"), suitable for dental office and laboratory use, fig. 18

Federal Stock No.	Class	Grit	Dimensions			
			Length	Width	Thickness	Diameter of 4 grooves
			Inches	Inches	Inches	Millimeters
5345-536-2150	B	Hard	4	1-1/2	1/2	1, 2, 4 and 8 respectively

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TABLE XXI. Type VII, Class A-2, ax stone; artificial, (silicon carbide) combination grit, coarse and fine, fig 19

Federal Stock No.	Class	Grit	Dimensions	
			Diameter Inches	Thickness Inches
5345-161-9707	A-2	Combination <u>Fine</u> <u>Coarse</u>	3	5/8

TABLE XXII. Type X, Class A-2 shoemaker's stone, artificial, combination, fig. 22

Federal Stock No.	Class	Grit	Dimensions		
			Length, O/A Inches	Width Inches	Thickness Inches
5345-190-5530	A-2	<u>Fine</u> <u>Coarse</u>	14-3/4	1-1/4	3/4

S4. Changes. When a Federal agency considers that a Federal Standard does not provide for its essential needs, written request for changing or adding to the standard, supported by adequate justification, shall be sent to the Administration. This justification will explain wherein the standard does not provide for essential needs. The request should be sent in duplicate to the General Services Administration, Federal Supply Service, Standardization Division, Washington, D. C. 20406. The Administration will determine the appropriate action to be taken and will notify the agency.

S5. Conflict with referenced specification. Where the requirements stated in this standard conflict with any requirements in a referenced specification, the requirements of the standard shall apply. Nature of conflict between the standard and the referenced specification shall be submitted in duplicate to General Services Administration, Federal Supply Service, Standardization Division, Washington, D. C. 20406.

S6. Unlisted federal stock numbers. The sharpening stones not listed in this standard have not been subjected to final standardization review.

S7. Nonstandard items. The nonstandard items are listed as follows:

Stones, Sharpening	
FIIN Sequence	Recommended Replacement FIIN
5345-027-4565	None
5345-063-1645	None
5345-132-6127	5345-198-8056
5345-161-6712	5345-584-4616
5345-161-9699	5345-198-8052
5345-161-9706	5345-161-9695
5345-161-9710	5345-584-4491
5345-183-8176	None
5345-183-8177	5345-584-4512
5345-183-8178	5345-183-8179
5345-183-8599	5345-584-4504
5345-183-8600	None
5345-183-8603	5345-260-0759
5345-183-8606	5345-198-8050
5345-184-1375	5345-584-4500
5345-184-6238	5345-260-0759
5345-184-6239	5345-265-3125
5345-190-5517	5345-198-8050
5345-198-8049	5345-190-5520
5345-198-8059	5345-584-4486
5345-198-8061	5345-584-4483
5345-198-8062	5345-243-6087
5345-224-6594	5345-584-4615
5345-224-6598	None
5345-242-2556	5345-584-4543
5345-242-2560	5345-190-5520
5345-242-5548	5345-584-4615
5345-243-6081	5345-584-4554
5345-243-6083	5345-584-4520

Stones, Sharpening (con.)	
FIIN Sequence	Recommended Replacement FIIN
5345-243-6084	5345-198-8060
5345-243-6085	5345-576-9193
5345-243-6089	5345-190-5528
5345-247-2554	None
5345-247-5926	5345-243-6087
5345-247-5928	5345-584-4483
5345-247-5932	5345-584-4496
5345-247-5936	5345-584-4609
5345-247-5940	5345-243-6082
5345-247-5946	5345-262-9465
5345-247-5947	5345-224-6596
5345-247-5950	5345-584-4615
5345-247-5954	5345-247-5955
5345-253-4402	None
5345-260-0758	5345-161-0759
5345-260-0760	None
5345-260-0761	5345-221-0694
5345-262-9466	5345-584-4486
5345-262-9467	5345-584-4483
5345-262-9468	5345-584-4504
5345-270-6906	5345-584-4496
5345-270-6907	5345-584-4492
5345-270-6910	5345-184-1372
5345-270-6918	5345-184-1374
5345-271-6898	5345-243-6087
5345-281-4043	5345-262-9465
5345-281-4045	5345-253-4400
5345-281-4047	5345-584-4534
5345-281-9485	5345-161-9707
5345-282-8673	5345-247-5950
5345-285-4717	5345-260-0759
5345-286-9993	5345-584-4494
5345-290-4766	5345-584-4580
5345-433-8650	5345-433-8660
5345-474-8790	None
5345-515-9978	5345-584-4504
5345-527-4510	None
5345-527-4951	None
5345-576-9192	5345-265-3126
5345-579-0992	5345-260-0759
5345-579-6214	5345-584-4504
5345-579-7025	5345-584-4504
5345-584-0138	5345-256-3648
5345-584-4479	5345-247-5953
5345-584-4507	5345-584-4516
5345-584-4510	None
5345-584-4524	5345-616-7672
5345-584-4551	5345-224-6595
5345-584-4558	5345-247-5958
5345-584-4561	5345-247-5957
5345-584-4564	5345-247-5957
5345-584-4567	5345-247-5957
5345-584-4576	5345-242-2555
5345-584-4578	5345-242-2555
5345-584-4583	5345-190-5528
5345-584-4585	5345-262-9465
5345-584-4586	5345-265-3126
5345-584-4588	5345-198-8046
5345-584-4592	5345-260-0754
5345-584-4601	5345-224-6595
5345-584-4602	5345-247-5957
5345-584-4605	5345-584-4607
5345-584-4612	5345-247-5943

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Stones, Sharpening (con.)	
FIIN Sequence	Recommended Replacement FIIN
5345-584-4618	5345-247-5959
5345-584-4634	5345-584-4580
5345-584-4638	5345-198-8048
5345-584-4645	5345-198-8045
5345-584-4646	5345-198-8040
5345-584-4672	5345-587-4580
5345-597-7885	5345-262-9464
5345-616-7671	5345-584-4524
5345-616-7673	5345-247-5949
5345-616-7675	5345-253-4400
5345-720-9225	5345-260-0759
5345-720-9226	5345-265-3126
5345-781-9000	5345-265-3126
5345-823-9814	5345-161-9695
5345-848-7352	5345-198-8040
5345-848-7353	5345-262-9464
5345-848-7354	5345-198-8040
5345-857-8727	5345-198-8050
5345-975-2831	5345-271-6895

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