

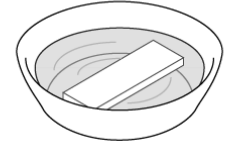
Shapton Naoru Cast Iron Lapping System Instructions

Step 1

The stones you are intending to lap should be immersed in water for 2 to 3 minutes before starting work on them.

When lapping non-Shapton stones, you should ensure the stones absorb plenty of water first.

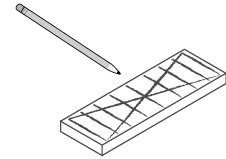
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Step 2

As a guide, use a pencil to draw a grid on the stone surface to be flattened.

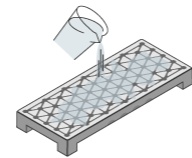
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Step 3

Place the NAORU lapping plate somewhere stable. Apply enough water to permeate the whole plate. If any water is left on the surface, the powder may get washed away.

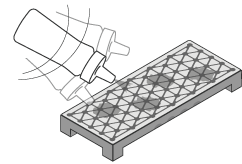
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Step 4

Sprinkle a little powder onto 3 or 4 places on the plate, then rub it gently with a stone using a circular motion so that the powder gets distributed evenly across the plate.

4



Step 5

Place the uneven surface of the stone requiring lapping onto the plate, and slide it backwards and forwards as shown in ①, then diagonally backwards and forwards as in ② and ③.

Make sure that you use the whole plate.

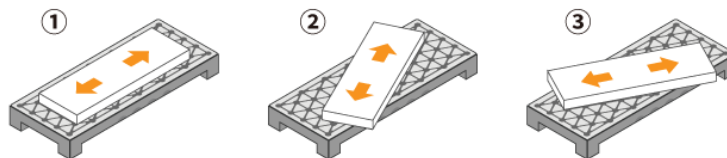
As you slide the stone to and fro, it may start to feel sticky or goeey, in which case you should add a little water.

Conversely, if you add too much water it may start to feel smooth or slippery, in which case you should add some more powder.

Get this balance right and you will be able to use the plate effectively without wasting powder.

Parts where the lines get erased show where the lapping plate has made contact, i.e. where flattening has been performed correctly.

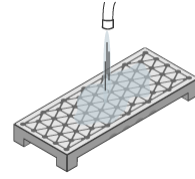
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Step 6

6

When you have finished lapping the stone, wash the plate off until it is clean, and allow it to dry. Even if the NAORU appears to 'rust' during storage, that will not affect its performance.



Notes

The quality of the finish you obtain on the sharpening stone surface will vary depending on the type of powder used, so be sure you choose the right powder for the particular stone you will be lapping.

Lapping Powder	Application
Coarse	Stones up to 320 grit
Medium	Stones 500 to 3000 grit
Fine	Stones 400 grit and above

- If the waterstone is especially uneven, you can use lapping powder one level coarser than recommended, but you will need to re-lap with the recommended powder afterwards.
- Be sure to wash the plate and sharpening stone well each time you change to a different type of powder.
- If you apply a rough finish to the surface of a sharpening stone of 4000 grit or finer, you will not be able to harness the stone's full potential, and will be unable to give your blades their intended finish. Always lap such a stone with a fine powder at the end, to produce a mirror-like finish, before you start sharpening.
- Fine powders are sold separately.

Frequently Asked Questions

I lapped the stone with "NAORU" and "Fine Lapping Powder", but its surface is still rough, not like a mirror finish.

If softening of the stone has progressed beyond a certain depth, you will be unable to lap it with "Fine Lapping Powder". In such cases, first use "Medium Lapping Powder" to scrape away the soft parts, then thoroughly rinse away any dirt and once again use "Fine Lapping Powder" to finish the stone's surface.

How should the NAORU be stored?

After use, use cold water to wash away any slurry or powder, then let the water drain away well before storage. Some rust may appear depending on how the product is stored, but this has no impact on usage.

Can I use NAORU to flatten sharpening stones of any grit?

You can, but make sure you use a lapping powder that matches the stone's grit.