

2014

# flexOvit

INDUSTRIAL PERFORMANCE ABRASIVES

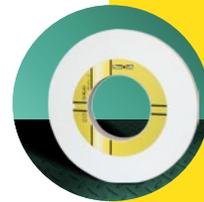


A complete collection:  
Cutting-Off & Grinding Wheels,  
Diamond Blades,  
Bonded, Coated  
& Super Abrasives



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# Introduction

## The Flexovit Industrial Program

Introducing the new Flexovit Industrial High Performance Abrasive Program, a complete collection of abrasive products; Coated Abrasives, Cutting-Off and Grinding Wheels, Bonded Abrasives, Super Abrasives, Diamond Blades and Accessories, for all industrial applications.

With unparalleled abrasive technology, Flexovit provides a wide range of products and solutions to meet every individual need and requirement whether for sanding, polishing, cutting, grinding, or sharpening, across general engineering, general manufacturing, metal fabrication, maintenance shops, repair shops, woodworking, construction, tool room, rail or foundry.

Based on core engineering and manufacturing expertise, Flexovit helps its customers to identify and implement cost-effective solutions for any industrial application. With a true leading position Flexovit contributes to improving results; by reducing the number of operations and machine cycle times, by increasing product quality, and by offering greater productivity ratios.

To help achieve this, Flexovit offers many **High Performance Products**, such as.....

- **73A:** Ceramic Bonded Wheels
- **FX777:** Ceramic Fibre Discs
- **SY674:** Zirconium Polyester Belts
- **Megaline:** Flap Discs, Thin Wheels and Diamond Blades

The Flexovit program includes a wide range of product qualities that satisfies all price/performance levels expected within demanding industrial markets.



**'Best':** High performance industrial abrasive products giving excellent results in demanding technical applications, e.g. Megaline MAXX, 73A, FX777...

**'Better':** Improved performance from technical products that are designed for use in more demanding applications, e.g. Flexovit Thin Cut Thin Wheels, Flexovit Laser GP Diamond Blades...

**'Good':** Lower cost product solutions with a standard performance level for general applications, e.g. Speedoflex, KJ313 Rolls, FX370 Fibre Discs...

*In addition there are **new** product ranges which play a key role in developing Flexovit's presence in many growing industrial areas:*

- **Flexbrite:** a new and complete range of non-woven abrasives
- **Superabrasives:** a high value product offer for re-sharpening operations



To allow customers to get the most important benefits from these advanced solutions, Flexovit regularly invites clients to the dedicated Centre's of Excellence; to share experience, to train technicians, to run product tests, and to maximize close collaboration between the teams in order to choose the right product and provide the best performances.

As well as our extremely comprehensive range of stock products Flexovit also has the capability to manufacture products, outside of the stock range, on a make to order basis.

With an emphasis on solution-oriented abrasives, the ethos of Flexovit is to establish effective business partnerships with its customers, through standard or customized **high performance industrial abrasive products**.

# The Flexovit Brand History

Founded in the Netherlands, Flexovit began manufacturing cutting-off and grinding wheels in 1958. By 1960, Flexovit had carved out its ambition to become a global player and began exporting products across Europe. This international development continued throughout the 1960's and 70's fuelled by the introduction of automated production presses ensuring continued manufacture of high performance quality wheels. With an excellent brand reputation Flexovit began adding to its product portfolio with coated abrasives, bonded abrasives and construction products.



## A Corporate Perspective

Flexovit is a vital ingredient in an effective portfolio of brands from Saint-Gobain Abrasives. The mission is to deliver a portfolio of highly recognized brands with unique value, fulfilling the complete spectrum of customer needs.

Saint-Gobain is a global manufacturer and provider of high-technology materials and associated services. Abrasives forms one key part of the Innovative Materials Division of Saint-Gobain, which is one of the 4 key areas of activity in which Saint-Gobain operate. The other three sectors of activities are Building Distribution, Construction Products and Packaging Verallia.

### Saint-Gobain at a Glance

- €43.2 billion of sales
- Around 193 000 employees
- Presence in 64 countries
- 12 research centres and 101 development units
- European or world leader in all of its activities

### Saint-Gobain Abrasives

Saint-Gobain Abrasives takes time to understand and fulfil its evolving customer needs which is reflected in its worldwide market leader status. With a strong presence in every continent the Abrasives Division serves its customers through structured units in 28 countries and employs more than 11000 people providing a portfolio of products that offer complete solutions for every step of the abrasive process.

It is the only international manufacturer of abrasives that provides each of the 3 major types of abrasives; Bonded Abrasives (resinoid and vitrified), Coated Abrasives, and Diamond products. This is supported by exceptional technology, complete and innovative product lines, an irrefutable reputation for quality and safety, and experienced, committed, passionate people.

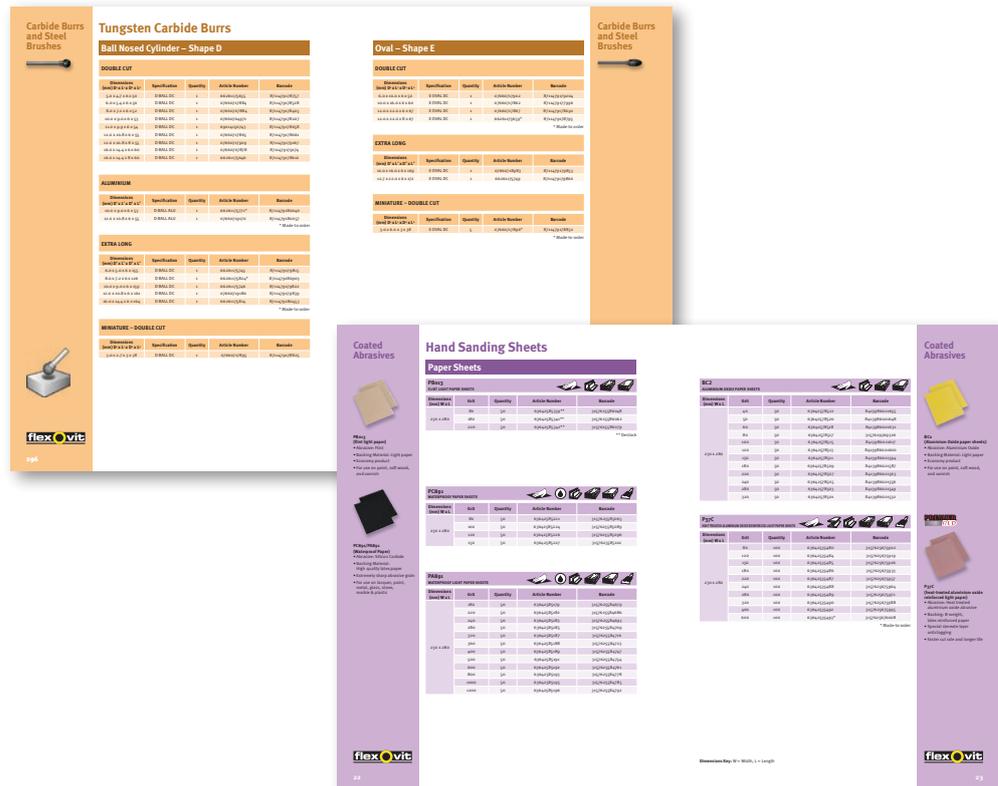
# Introduction

## How to Use this Catalogue

The catalogue is divided into colour coded sections by product type – Coated and Flexbrite (Non-Woven) Abrasives, Cutting-Off and Grinding Wheels, Diamond Blades, Bonded Abrasives, Super Abrasives, and Non-Specific Abrasive Products.

At the beginning of each section you will find a range of useful technical information including; Understanding the product and Selecting the right product, as well as general guidance on operation, and safety.

Each section contains informative and easy to use product charts that contain all of the information needed to make your selection.



## How to Order

Please contact your local Customer Service Centre, details can be found on the back page of the catalogue. For countries that are not listed please send your request to our European Headquarters.

When placing an order it helps to have the following information available:

- Your name
- Your account number
- Your order or reference number
- Product article number/s
- Required quantity
- Any special instructions

If you require additional product or technical information then please do not hesitate to contact your local Customer Service or Sales Representative.

### Prices

For prices and terms of sale please refer to the price list.

# Our Responsibility – Safety, Health, & Environment

Our responsibility to customers, particularly in the area of safety and comfort, is taken very seriously. Products are designed and produced to the most stringent quality standards to guarantee optimum personal safety and user comfort. **Saint-Gobain Abrasives is an active member of both FEPA and oSa.**

Flexovit Industrial products comply with all expectations of European health, safety and environmental standards.

**FEPA**, the Federation of European Producers of Abrasives, is dedicated to the promotion of safety in the use of abrasives and is actively involved in the preparation and implementation of the European (EN) and International Standards (ISO) for Abrasives and Grinding Machines.

**oSa**, the Organisation for Safety of Abrasives pursues in close collaboration with FEPA the objectives of supporting both the currently attained safety standards for abrasive products and their further developments.

The internal testing and certification is based on the following standards:

- Safety requirements for bonded abrasive products (EN12413: 1999)
- Safety requirements for superabrasive products (EN13236: 2001)
- Safety requirements for coated abrasives (EN13743: 2002)
- Safety requirements for diamond blades (EN13236: 2001).

Thus the oSa symbol on the abrasive signifies enhanced application safety for the user, a reduced liability risk and excellent brand image for manufacturers, traders and those in marketing.

**ISO9001**, certifies Quality Management system is in accordance with requirements of quality standards.

**ISO14001**, certifies Environmental Management system is in accordance with requirements of environmental standards.

**OHSAS18001**, health and safety at work certification.



# Marketing Tools

A range of marketing tools are available to support the Flexovit Industrial Range. For further information, please contact your local Sales Representative.



Stand & Graphic Display Kit



Merchandising Promotional Activity



Catalogues & Brochures

# Coated Abrasives



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# Technical Information

The Flexovit Industrial Coated Abrasive range contains a selection of products suitable for both hand and machine use in an extremely wide variety of applications and markets.

## Understanding the Product





## CAP Code Guide

All Flexovit Industrial coated abrasive products can be identified by their CAP codes which follow one of two systems, either four or five digits.

4 Digit System					
<b>Example 1: P64E 180</b>					
	P				Paper (backing)
		6			Aluminum oxide (grain)
			4		Internal description
				E	Backing weight
				180	Grit size
Backing	1. Letter:				
	P				Paper
	T				Cloth
	C				Combination
Grain	1. Number:				
		3			Light aluminum oxide
		6			Aluminum oxide
		8			Silicon carbide
		9			Zirconium
Internal description		2. Number:			
Backing weight			2. Letter:		
			A		75 g/m <sup>2</sup> paperweight
			B		100 g/m <sup>2</sup> paperweight
			C		125 g/m <sup>2</sup> paperweight
			D		180 g/m <sup>2</sup> paperweight
			E		250 g/m <sup>2</sup> paperweight
			F		300 - 400 g/m <sup>2</sup> paperweight
			X		Heavy cloth or polyester
			N		Light combination



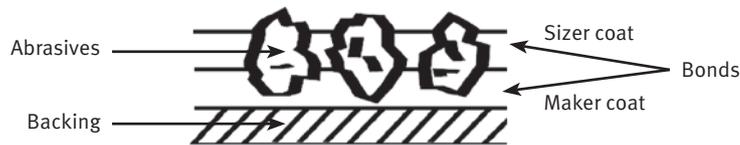
## Technical Information

### 5 Digit System

Example 2: KJ370 180					
	K				Cloth
	J				Light cloth (backing)
		3			Aluminium oxide (grain)
			7		Internal description
				o	Internal description
				180	Grit size
Explanation of backing	1. Letter:				
	P				Paper
	K				Cloth
	M				Mixed fibres (cloth + polyester)
	S				Polyester
	F				Fibre
	2. Letter:				
	A				75 g/m <sup>2</sup> paperweight
	B				100 g/m <sup>2</sup> paperweight
	C				125 g/m <sup>2</sup> paperweight
	D				180 g/m <sup>2</sup> paperweight
	E				250 g/m <sup>2</sup> paperweight
	F				300 - 400 g/m <sup>2</sup> paperweight
	L				Very light cloth
	F				Very flexible cloth
	J				Light cloth
	T				Light, flexible X cloth
	X				Heavy cloth or polyester
	Y				Extra heavy cloth or polyester
Explanation for grain	1. Number:				
		0			Flint
		1			White aluminum oxide
		2			Light brown aluminum oxide
		3			Brown aluminum oxide
		5			Granulated grain (Al <sub>2</sub> O <sub>3</sub> )
		6			Zirconia alumina
		7			Ceramic grain
		8			Silicon carbide
		9			Granulated grain (SiC)
Internal description	2. Number:				
Internal description	3. Number:				

## What is a Coated Abrasive?

Modern coated abrasives are the product of an extremely technical process developed through many years of research and development. They remain, however, a product composed of three basic elements: a flexible or semi-rigid backing to which abrasive grains are bonded by an adhesive.



## Abrasives Types

### ABRASIVES

The ideal abrasive grain offers maximum resistance to point wear, yet fractures before serious dulling occurs, thereby satisfying both stock removal and finishing requirements.

**Aluminium Oxide** is tough and well adapted to grinding high tensile materials, such as carbon steel, alloy steels, tough bronze and hard woods. Wherever toughness (ability to resist fracturing) is the main consideration, aluminium oxide outperforms all other coated abrasive grains.

**Zirconia Alumina** has a unique self-sharpening characteristic which gives it long life on rugged stock removal operations. Zirconia alumina is well suited for heavy grinding of metals and planing of wood, because the controlled fracturing of the grain continuously produces sharp, new abrading points.

**Silicon Carbide** is the hardest and sharpest of the minerals used in coated abrasives. Its hardness and sharpness make it the ideal abrasive for sanding non-ferrous metals (aluminium, brass, bronze, magnesium, titanium, etc.), rubber, glass, plastics, fibrous woods, enamel and other relatively soft materials. Silicon carbide is superior to any other abrasive in its ability to penetrate and cut faster under light pressure.

**Ceramic Aluminium Oxide** is a long-lasting, tough, dense abrasive due to its micro structure. The extremely small micron size particles break off during grinding, producing multiple new cutting edges. As it stays sharp, especially when used in medium and high pressure operations, it cuts at a higher rate than other abrasives. Recommended for use on forged and carbon steels, high nickel and cobalt alloys.

### ABRASIVE GRAIN DISTRIBUTION

There are two types of abrasive grain coverage on the backing:

- Openly spaced distribution where between 30% and 60% of the backing is covered leaving large spaces between each abrasive grain. It is used in operations where the grinding swarf would otherwise 'load' or clog the surface, reducing cutting efficiency and shortening the coated abrasive life
- Closely packed grain distribution is where the grain completely covers the backing. The greater number of abrading points in a given area leads to faster stock removal. It is recommended where loading is not a problem and where smoother surface finishes are desired



# Technical Information

## Abrasive Grain Size

Abrasive grains are separated (graded) into standard particle sizes using screens carefully made from silk threads of exact size and number per square inch to ensure extreme accuracy. The grit number (mesh number) appearing on the coated abrasive backing represents the number of openings per linear inch in the final screen. The European standard of grit sizes is the FEPA grading system. All FEPA grit sizes are preceded with the letter 'P', i.e. P180 etc. However, some products are coated with non-FEPA graded abrasives like Emery, Glasspaper, Flint and Ceramic.

Further information about the different abrasive grading systems is given in the table on the opposite page.

## Abrasive Bonds

There are two common types of adhesives in use: one based on animal glue and the other based on synthetic heat hardenable resins. The adhesive is applied with a minimum of two bonding applications. The first, or 'maker' coat, adheres the abrasive grain to the backing ensuring proper anchoring and orientation. After drying or curing, the second or 'sizer' coat is applied. The 'sizer' adhesive unites with the 'maker' bond to provide final grain anchoring and the required total adhesive level for the finished product.

## Backing Types

### BACKINGS

Whether paper, cloth, vulcanised fibre or polyester, the backing must be smooth enough for a uniform adhesive coating, strong enough to withstand grinding pressures and flexible enough to conform to contours.

### PAPER

The lighter the backing, the greater the degree of flexibility; the heavier the backing, the greater the resistance to tearing.

**A-Weight (85g)** – Light and flexible, A-weight is used primarily for hand finishing operations both wet and dry. Grits 80 and finer.

**C-Weight (115-125g)** – Stronger and less flexible than A-weight. This backing is chosen for hand sanding, dry or wet, and for use on small portable power sanders. Intermediate through fine sanding. Grits 60 through 180.

**D-Weight (150-185g)** – Stronger and less flexible than C-weight. This backing is also chosen for hand sanding and for use on small portable power sanders. Coarse through intermediate sanding. Grits 36 through 80.

**E-Weight (220-270g)** – Stronger and less flexible than D-weight, this backing is used primarily on roll, belt and disc applications where high resistance to tearing is needed.

**F-Weight (270-300g)** – The strongest, least flexible paper backing utilised. Used for crankshaft lapping rolls, tannery industry belts and rolls.

### CLOTH

Cloth backings are more durable than paper, offering greater resistance to tearing, and can tolerate continual bending and flexing during use.

The cloth backing has construction characteristics designed to make it ideally suited to specific applications. Below is an explanation of the weights of cloth backing available in the Flexovit Range.

**J-Weight** – The lightest and most flexible cloth backing, this backing is used where surface finish and uniformity are more important than stock removal. It is ideal for finishing, blending and where flexibility is required, such as when working on curved surfaces.

**X-Weight** – This backing is strong and relatively stiff when compared to J-weight. Consistent productivity, excellent finish and long product life are characteristics of products made using X-weight backings. Products with a coarse grit and an X-weight backing are ideal for stock removal applications and the finer grits are more suited to finishing and polishing applications.

# Coated Abrasives



Particle Size In Micron	Aluminium Oxide, Silicon Carbide, Zirconia Alumina		Emery Cloth	Glass Paper	Flint
	Grading Systems				
	CAMI	FEPA			
0.3	-	-	-	-	-
0.5	-	-	-	-	-
1.0	-	-	-	-	-
2.0	-	-	-	-	-
3.0	-	-	-	-	-
4.0	-	-	-	-	-
5.0	-	-	-	-	-
6.0	-	-	-	-	-
6.5	1200	-	-	-	-
9.0	-	-	-	-	-
9.2	1000	-	-	-	-
12.0	-	-	-	-	-
12.2	800	-	-	-	-
15.0	-	-	-	-	-
15.3	-	P1200	-	-	-
16.0	600	-	-	-	-
18.3	-	P1000	-	-	-
19.7	500	-	-	-	-
20.0	-	-	-	-	-
21.8	-	P800	-	-	-
23.6	400	-	-	-	-
25.0	-	-	-	-	-
27.75	-	P600	-	-	-
28.8	360	-	-	-	-
30.0	-	-	-	-	-
30.2	-	P500	-	-	-
35.0	-	P400	-	-	-
36.0	320	-	-	-	-
40.0	-	-	-	-	-
40.5	-	P360	-	-	-
44.0	280	-	-	-	-
45.0	-	-	-	-	-
46.2	-	P320	-	-	-
50.0	-	-	-	-	-
52.5	-	P280	-	-	-
53.5	240	-	-	-	-
55.0	-	-	-	-	-
58.5	-	P240	-	-	-
60.0	-	-	-	-	-
60.5	-	P220	-	-	-
66.0	220	-	-	-	4/0
78.0	180	P180	-	00	3/0
93.0	150	-	Fine	-	2/0
97.0	-	P150	-	0	-
116.0	120	-	-	-	0
127.0	-	P120	-	1	-
141.0	100	-	Medium	-	1
156.0	-	P100	-	11/2	-
192.0	80	-	-	-	3
197.0	-	P80	-	F2	-
260.0	-	P60	-	M2	-
268.0	60	-	Coarse	-	4
326.0	-	P50	-	S2	-
351.0	50	-	-	-	-
412.0	-	P40	-	21/2	-
428.0	40	-	-	-	6
524.0	-	P36	-	36	-
535.0	36	-	X Coarse	-	-
622.2	-	P30	-	-	-
638.0	30	-	-	-	-
715.0	24	-	-	-	-
740.0	-	P24	-	-	-
905.0	20	-	-	-	-
984.0	-	P20	-	-	-
1320.0	16	-	-	-	-
1324.0	-	P16	-	-	-
1764.0	-	P12	-	-	-
1842.0	12	-	-	-	-



# Technical Information

## Surface Finish & Grinding Efficiency Variables

### SURFACE FINISH VARIABLES

Changes in any one of many factors can affect the surface finish generated by a product.

The purpose of this chart is to show the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The length of the arrows has no significance as the effect of each variable factor will not be the same.

The chart is meant to be general in nature and to show direction or trend.

Variable Factor	Rough Surface Higher Ra Reading	Smooth Surface Lower Ra Reading
1. Grit Size	Coarse	Fine
2. C/A Product Condition	New	Used
3. Adhesive Bond	Resin	Resin/Glue Glue
4. Coating Method	Open-Coated	Close-Coated
5. Product Flex	Single Linear	Double Triple
6. Contact Wheel Configuration	Serrated	Smooth
Composition	Wider Groove Width Steel	Rubber Wider Width Canvas
Diameter	Smaller	Larger
7. Belt Speed	Slower	Faster
8. Grinding Aid	Dry	Water Oil Solubles Staight Oils Grease
9. Abrasive Mineral Type	Zirconia Alumina	Ceramic Aluminium Oxide Silicon Carbide Emery
10. Workpiece Hardness	Softer	Harder



## CUTTING EFFICIENCY OF COATED ABRASIVE PRODUCTS

Although general in nature, this chart can serve as a useful guide as to what effect a change in a single given factor in the specification will have on the cutting efficiency of coated abrasive products. Arrows have been used to signify the trend direction. The length of arrows has no significance. Some important machine and setup parameters have also been included since they do have significant impact on product performance.

Variable Factor	More Aggressive Better Cut	Less Aggressive Lower Cut
1. Workpiece Feed Speed	← Slower	Faster →
2. C/A Belt Speed (m/s)	← Slower	Faster →
3. Abrasive Product Condition	← New	Used →
4. Grit Size	← Coarse	Fine →
5. Product Durability	← Fibre	Cloth → Paper
6. Abrasive Mineral Type	← Zirconia Alumina	Ceramic Aluminium Oxide Silicon Carbide Emery →
7. Adhesive Bond	← Resin	Resin/Glue → Glue
8. Coating Method	← Close-Coated	Open-Coated →
9. Contact Wheel Configuration	← Serrated	Smooth →
Composition	← Steel	Rubber → Canvas
Diameter	← Smaller	Larger →
10. Pressure	← High	Low →
11. Grinding Aid	← Oil	Soluble Oil → Water → Dry
12. Workpiece Hardness	← Softer	Harder →



## Technical Information

### Safety in the Storage & Use of Coated Abrasives

#### TRANSPORT & STORAGE

All coated abrasives should be handled carefully. Damage can be caused by mishandling, which should be avoided.

Coated abrasives should be stored in dry, frost free conditions. They should be kept away from heat sources, cold, damp walls, doors or windows and should not be in direct contact with the floor. Temperatures and humidity should be between 18°C and 22°C and 45%-65% relative humidity. Coated abrasives should not be exposed to direct sunlight. Products should be kept in their original packaging until immediately before use. Once unpacked, they should be stored in a way which avoids distortion.

#### PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

#### PERSONAL PROTECTION



Mouth  
Protection



Wear  
Gloves



Eye  
Protection



Ear  
Protection



Read  
Instruction



Dry



Wet

#### GENERAL PRECAUTIONS

Safety instructions provided by the machine manufacturers must be followed. Where fitted all guards, covers and hoods must be in place on the machine during grinding, and should not be modified in any way. Coated abrasives should not be used near inflammable material or in an environment where there is a risk of explosion. Sparks should be directed away from the face and body, if possible towards the floor. Dust extraction equipment must be used whenever it is available. The instructions for use given by the abrasive manufacturer must be followed e.g. 'Not to be used without a support', or 'Not to be used for wet grinding'. The workpiece must be firmly fixed before grinding starts. Check all abrasives visually before use and make certain that the product is suitable for the application. No modifications should be made to abrasive products after delivery. When using a portable grinder always switch it off and allow the spindle to stop completely before putting the tool down. Wet grinding should only be carried out on machines designed for this purpose and with abrasives designated as suitable for this type of operation.





# Technical Information

## MACHINE PICTOGRAMS



Angle Grinder



Backstand  
Grinder



Bench  
Grinder



Delta Sander



Die Grinder



Eccentric  
Sander



File Belt  
Machine



Flexible Shaft  
Grinder



Hand



Iron Orbital  
Sander



Belt Sander



Sanding  
Block



Satinex  
machine



Orbital  
Sander

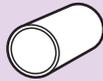


Pneumatic  
Grinder

## APPLICATION PICTOGRAMS



Steel



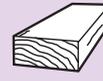
Stainless  
Steel



Non-ferrous



Hard Wood



Soft Wood



Paint &  
Varnish

# Coated Abrasives

## Hand Sanding Sheets



## Coated Abrasives



### PB013 (flint light paper)

- Abrasive: Flint
- Backing Material: Light paper
- Economy product
- For use on paint, soft wood, and varnish



### PC891/PA891 (Waterproof Paper)

- Abrasive: Silicon Carbide
- Backing Material: High quality latex paper
- Extremely sharp abrasive grain
- For use on lacquer, paint, metal, glass, stone, marble & plastic

# Hand Sanding Sheets

## Paper Sheets

### PB013 FLINT LIGHT PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	80	50	63642585339**	3157625586048
	180	50	63642585341**	3157625586062
	220	50	63642585342**	3157625586079

\*\* Destock

### PC891 WATERPROOF PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	80	50	63642585221	3157625585065
	100	50	63642585224	3157625585089
	120	50	63642585226	3157625585096
	150	50	63642585227	3157625585102

### PA891 WATERPROOF LIGHT PAPER SHEETS



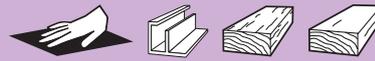
Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	180	50	63642585179	3157625584679
	220	50	63642585182	3157625584686
	240	50	63642585183	3157625584693
	280	50	63642585185	3157625584709
	320	50	63642585187	3157625584716
	360	50	63642585188	3157625584723
	400	50	63642585189	3157625584747
	500	50	63642585191	3157625584754
	600	50	63642585192	3157625584761
	800	50	63642585193	3157625584778
	1000	50	63642585195	3157625584785
	1200	50	63642585196	3157625584792

## Coated Abrasives



### BC2

#### ALUMINIUM OXIDE PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	40	50	63642578522	8413986021655
	50	50	63642578520	8413986021648
	60	50	63642578518	8413986021631
	80	50	63642578517	3157629369326
	100	50	63642578515	8413986021617
	120	50	63642578513	8413986021600
	150	50	63642578511	8413986021594
	180	50	63642578509	8413986021587
	220	50	63642578507	8413986021563
	240	50	63642578505	8413986021556
	280	50	63642578503	8413986021549
	320	50	63642578501	8413986021532

### BC2 (Aluminium Oxide paper sheets)

- Abrasive: Aluminium Oxide
- Backing Material: Light paper
- Economy product
- For use on paint, soft wood, and varnish

### P37C

#### HEAT-TREATED ALUMINIUM OXIDE REINFORCED LIGHT PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	80	100	63642535480	3157625675902
	120	100	63642535484	3157625675919
	150	100	63642535485	3157625675926
	180	100	63642535486	3157625675933
	220	100	63642535487	3157625675957
	240	100	63642535488	3157625675964
	280	100	63642535489	3157625675971
	320	100	63642535490	3157625675988
	400	100	63642535492	3157625675995
	600	100	63642535493*	3157625676008

\* Made-to-order

**PREMIER  
RED**



### P37C (heat-treated aluminium oxide reinforced light paper)

- Abrasive: Heat treated aluminium oxide abrasive
- Backing: B-weight, latex reinforced paper
- Special stearate layer anticlogging
- Faster cut rate and longer life

Dimensions Key: W = Width, L = Length

**flexovit**

## Coated Abrasives



### KJ313 (aluminium oxide, flexible cloth)

- Abrasive: Aluminium oxide
- Backing Material: Flexible cotton
- Flexible
- Quality product and competitive price
- Ideal for hand sanding applications



### KF271 (technical aluminium oxide cloth)

- Abrasive: Aluminium oxide
- Backing Material: Flexible cotton
- Ideal for sanding profiled surfaces
- Flexible
- For use on wood, and metal (derusting or light finishing)

# Hand Sanding Sheets

## Cloth Sheets

### KJ313

#### ALUMINIUM OXIDE FLEXIBLE CLOTH SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	40	25	63642585198	3157625584808
	50	25	63642585201	3157625584815
	60	25	63642585204	3157625584907
	80	50	63642585207	3157625584921
	100	50	63642585208	3157625584938
	120	50	63642585209	3157625584945
	150	50	63642585212	3157625584952
	180	50	63642585213	3157625584969
	220	50	63642585215	3157625584983
	240	50	63642585216	3157625585003
	320	50	63642585218	3157625585034
	400	50	63642585219	3157625585041

### KF271

#### TECHNICAL ALUMINIUM OXIDE FLEXIBLE CLOTH SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
230 x 280	40	25	63642585117	3157625583719
	60	25	63642585147	3157625584365
	50	25	69957392553	3157625729094
	80	50	63642585151	3157625584372
	100	50	63642585152	3157625584389
	120	50	63642585154	3157625584396
	150	50	63642585155	3157625584402
	180	50	63642585157	3157625584419
	220	50	63642585158	3157625584426
	240	50	63642585160	3157625584433
	320	50	63642585162	3157625584457
	400	50	63642585163	3157625584464

# Coated Abrasives

Cloth,  
Paper &  
Soft Rolls



## Coated Abrasives



### BC2 (aluminium oxide light paper)

- Abrasive: Aluminium oxide
- Backing Material: Flexible paper
- Semi-open coat resists clogging
- For use on lacquer, primer, metal, and all types of wood

**PREMIER  
RED**



### P37C (heat-treated aluminium oxide reinforced light paper)

- Abrasive: Heat treated aluminium oxide abrasive
- Backing: B-weight, latex reinforced paper
- Special steriate layer anticlogging
- Faster cut rate and longer life

# Cloth, Paper & Soft Rolls

## Paper Rolls

### BC2 ALUMINIUM OXIDE LIGHT PAPER



Dimensions W x L	Grit	Quantity	Article Number	Barcode
95mm x 25M	60	1	66254481849*	3157629297827
	80	1	66254481850*	3157629297834
	100	1	66254481851*	3157629297841
	120	1	66254481852*	3157629297858

\* Made-to-order

### P37C HEAT-TREATED ALUMINIUM OXIDE LIGHT PAPER ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
95mm x 25M	180	1	66261026885*	8711479432835
	240	1	66261026886*	8711479432842
95mm x 50M	80	2	66261090027*	8711479444531
	120	2	66261090030*	8711479444562
	150	2	66261090031*	8711479444579
	180	2	66261090032*	8711479444586
	220	2	66261090033*	8711479444593
	240	2	66261090035*	8711479444616
115mm x 50M	80	2	63642535506	3157625676138
	120	2	63642535507	3157625676145
	150	2	63642535508	3157625676152
	180	2	63642535509	3157625676169
	220	2	63642535510	3157625676176
	240	2	63642535511	3157625676183
	280	2	63642535512	3157625676206
	320	2	63642535513	3157625676213
	400	2	63642535514	3157625676237
	500	2	63642535515	3157625676244
600	2	63642535516	3157625676251	

\* Made-to-order

## Coated Abrasives

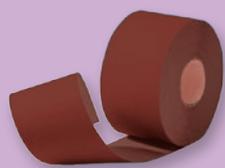
### PE173 ALUMINIUM OXIDE PAPER ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
95mm x 50M	60	1	63642585814	3157625598003
	80	1	63642585910	3157625598027
	120	1	63642585913	3157625598034
	150	1	63642585914	3157625598041
115mm x 50M	40	1	63642585917	3157625598058
	60	1	63642585921	3157625598065
	80	1	63642585923	3157625598072
	120	1	63642585928	3157625598089
	150	1	63642585930	3157625598096

- PE173  
(aluminium oxide paper)**
- Abrasive: Aluminium oxide
  - Backing Material: Heavy paper
  - Ideal for use on paint, hard wood and metal

Dimensions Key: W = Width, L = Length



- P64E**  
**(aluminium oxide heavy paper)**
- Abrasive: High performance aluminium oxide
  - Backing material: Heavy paper
  - Ideal for sanding flat wood, or metal surfaces

## Cloth, Paper & Soft Rolls

### P64E ALUMINIUM OXIDE HEAVY PAPER ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
95mm x 25M	40	1	63642588303	3157625679672
	60	1	63642588304	3157625679689
	80	1	63642588305	3157625679696
	100	1	63642588306	3157625680517
	120	1	63642588307	3157625680524
	150	1	63642588308	3157625680531
115mm x 25M	40	1	63642588309	3157625680548
	60	1	63642588310	3157625680555
	80	1	63642588311	3157625680562
	100	1	63642588312	3157625680579
	120	1	63642588313	3157625680586
	150	1	63642588314	3157625680593

### P64E ALUMINIUM OXIDE HEAVY PAPER ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
100mm x 50M	40	1	63642585614	3157625589612
	50	1	63642578948	8413986038950
	60	1	63642585618	3157625589629
	80	1	63642585620	3157625589636
	120	1	63642585621	3157625589643
	150	1	63642585623	3157625589667
	180	1	63642585624	3157625589674
115mm x 50M	40	1	63642585625	3157625589681
	60	1	63642585627	3157625589698
	80	1	63642585628	3157625589704
	120	1	63642585629	3157625589711
	150	1	63642585630	3157625589728
	180	1	63642585632	3157625589735

## Cloth Rolls “with plastic flanges”

### KJ313

ALUMINIUM OXIDE LIGHT CLOTH ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
25mm x 25M	40	1	63642585262	3157625585362
	50	1	63642585265	3157625585379
	60	1	63642585266	3157625585386
	80	1	63642585267	3157625585393
	100	1	63642585268	3157625585508
	120	1	63642585269	3157625585515
	150	1	63642585270	3157625585522
	180	1	63642585271	3157625585539
	220	1	63642585273	3157625585546
	240	1	63642585275	3157625585553
	320	1	63642585276	3157625585577
400	1	63642585278	3157625585584	
38mm x 50M	40	1	63642585279	3157625585461
	60	1	63642585283	3157625585485
	80	1	63642585285	3157625585607
	100	1	63642585287	3157625585621
	120	1	63642585288	3157625585638
	150	1	63642585289	3157625585645
	180	1	63642585290	3157625585591
	220	1	63642585293	3157625585706
	240	1	63642585295	3157625585713
	320	1	63642585297	3157625585737
	400	1	63642585298	3157625585744
50mm x 50M	40	1	63642585299	3157625585751
	60	1	63642585301	3157625585775
	80	1	63642585302	3157625585782
	100	1	63642585303	3157625585799
	120	1	63642585304	3157625585805
	150	1	63642585305	3157625585812
	180	1	63642585307	3157625585829
	220	1	63642585308	3157625585836
	240	1	63642585309	3157625585843
	320	1	63642585310	3157625585867
	400	1	63642585311	3157625585874

### KJ313

(aluminium oxide light cloth)

- Abrasive: Aluminium oxide
- Backing material: Light cotton
- Ideal for hand sanding applications
- Flexible



## KF271 (technical aluminium oxide flexible cloth)

- Abrasive: Aluminium oxide
- Backing material:  
Flexible cotton
- Dispenser unit allows  
easy storage
- Flexible
- Ideal for sanding  
profiled surfaces
- For use on wood and metal

# Cloth, Paper & Soft Rolls

## Cloth Rolls “in a box”

### KF271

TECHNICAL ALUMINIUM OXIDE FLEXIBLE CLOTH ROLLS “IN-A-BOX”



Dimensions W x L	Grit	Quantity	Article Number	Barcode
25mm x 25M	40	1	63642585733	3157625591578
	60	1	63642585736	3157625591592
	80	1	63642585737	3157625591608
	100	1	63642585738	3157625591615
	120	1	63642585739	3157625591622
	150	1	63642585740	3157625591639
	180	1	63642585743	3157625591646
	220	1	63642585744	3157625591653
	240	1	63642585745	3157625591677
	320	1	63642585747	3157625591684
38mm x 25M	40	1	63642570216	3564653792998
	50	1	63642559129	3564653627580
	60	1	63642515525	3564657997863
	80	1	63642512992	3564656226162
	100	1	63642512993	3564656226179
	120	1	63642512994	3564656226186
	150	1	63642512995	3564656226193
	180	1	63642512996	3564656226209
	220	1	63642512997	3564656226223
	240	1	63642512998	3564656226230
	320	1	63642559092	3157623625503
	400	1	63642570213	3564653792967
50mm x 25M	40	1	63642559076	3564653625272
	50	1	63642559073	3564653625258
	60	1	63642559067	3564653625128
	80	1	63642559066	3564653625111
	100	1	63642559064	3564653625098
	120	1	63642559062	3564653625074
	150	1	63642559061	3564653625067
	180	1	63642559059	3564653625043
	220	1	63642559057	3564653625029
	240	1	63642559055	3564653625005
	320	1	63642559052	3564653624978
	400	1	63642585753	3157625591691

## Coated Abrasives

### KF271 TECHNICAL ALUMINIUM OXIDE FLEXIBLE CLOTH ROLLS "IN-A-BOX"



Dimensions W x L	Grit	Quantity	Article Number	Barcode
50mm x 50M	80	1	63642591769	8711479427589
	100	1	63642591770	8711479427596
	120	1	63642591771	8711479427602
	150	1	63642591773	8711479427626
	180	1	63642591774	8711479427633
	220	1	63642591775	8711479427657
	240	1	63642591776	8711479427664
	280	1	63642591777	8711479427671
	320	1	63642591778	8711479427688
	400	1	63642591779	8711479427695



### KF271 (technical aluminium oxide flexible cloth)

- Abrasive: Aluminium oxide
- Backing material: Flexible cotton
- Dispenser unit allows easy storage
- Flexible
- Ideal for sanding profiled surfaces
- For use on wood and metal

### KF271 TECHNICAL ALUMINIUM OXIDE FLEXIBLE CLOTH ROLLS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
100mm x 50M	40	1	66261165506	8711479139789
	60	1	66261165517	8711479139895
	80	1	66261165523	8711479139956
	100	1	66261165529	8711479140020
	120	1	66261165535	8711479140082
	150	1	66261165541	8711479140143
	180	1	66261165549	8711479140204
	240	1	66261165555	8711479140266
	320	1	66261165564	8711479140341

Dimensions Key: W = Width, L = Length



**P37C**  
(heat treated aluminium oxide reinforced light paper)

- Abrasive: Heat treated aluminium oxide abrasive
- Backing: Soft foam interface layer allows hand sanding with uniform pressure
- Conforms to all contours and gives the best possible finish
- Pre-cut for easy tearing

# Cloth, Paper & Soft Rolls

## Soft Rolls

**P37C**

HEAT TREATED ALUMINIUM OXIDE REINFORCED LIGHT PAPER SHEETS



Dimensions W x L	Grit	Quantity	Article Number	Barcode
115mm x 25M	150	2	63642535517	3157625676268
	180	2	63642535520	3157625676299
	220	2	63642535521	3157625676305
	240	2	63642535522	3157625676312
	280	2	63642535523	3157625676329
	320	2	63642535524	3157625676336
	400	2	63642535525	3157625676343
	500	2	63642535526	3157625676367
	600	2	63642535528	3157625676381
	800	2	63642535530	3157625676398
	1000	2	63642535531	3157625676404

# Coated Abrasives

## Abrasive Sponges



## Coated Abrasives



### Abrasive sponges

- Long lasting
- Conforms easily to contours
- Tear resistant
- For wet or dry use

# Abrasive Sponges

## Abrasive Sponges

### ABRASIVE SPONGES

1 SIDE



Dimensions (mm) W x L x T	Grit	Quantity	Article Number	Barcode
140 x 115 x 6	100	20	63642549803	3157625679023
	180	20	63642549804	3157625679047
	220	20	63642549808	3157625679054

### ABRASIVE SPONGES

2 SIDED



Dimensions (mm) W x L x T	Grit	Quantity	Article Number	Barcode
120 x 98 x 13	60	60	63642549810	3157625679078
	100	60	63642549812	3157625679085
	180	60	63642550587	3157625679092

### ABRASIVE SPONGES

4 SIDED



Dimensions (mm) W x L x T	Grit	Quantity	Article Number	Barcode
100 x 66 x 26	60	60	63642550593	3157625679108
	100	60	63642550594	3157625679115
	180	60	63642550595	3157625679122

### SANDING BLOCK



Dimensions (mm) W x L	Quantity	Article Number	Barcode
70 x 125	1	63642588213	3157625679269

# Coated Abrasives

Paper and  
Soft-Touch  
Discs &  
Cut Sheets





## Paper and Soft-Touch Discs

### Preparation for Use

Paper discs should be used only on machines with a suitable back-up pad. Damaged or misshapen discs and pads should not be used. Discs and pads must not be modified in any way. Take care to fix the disc securely and centrally to the back-up pad. The diameter of the disc must be at least 2mm bigger than the back-up pack but no more than 4mm.

### Sanding Operation

Only start to sand when the machine is 'up to speed', except on pneumatic random orbital machines which must be started with light pressure on the disc. The machine should be operated with the disc making the smallest possible angle to the workpiece.

Use only light pressure at first when grinding with quick release backed discs.

Do not allow overheating of the disc to occur. After use the machine should be stored carefully.

The face of the abrasive should not be in contact with the floor or work bench.

## PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

### PERSONAL PROTECTION



Mouth  
Protection



Wear  
Gloves



Eye  
Protection



Ear  
Protection



Read  
Instruction



Dry



Wet

# Coated Abrasives

## Paper Discs

**P37C**  
QUICK RELEASE REINFORCED PAPER DISCS (FESTO)



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 125 	80	100	63642535529	3157625675827
	120	100	63642535532	3157625675834
	150	100	63642535533*	3157625675841
	240	100	63642535535	3157625675858
	320	100	63642535537	3157625675865

\* Made-to-order

**PREMIER RED**



## Soft Discs

**P37C**  
QUICK RELEASE PERFORATED FOAM DISCS



Diameter (mm)	Colour	Grit	Quantity	Article Number	Barcode
 150 7 holes 	Red	220	20	63642535438	3157625675537
	Pink	320	20	63642535439	3157625675544
	Yellow	400	20	63642535440	3157625675551
	Fuchsia	600	20	63642535441	3157625675568
	Blue	800	20	63642535442	3157625675575
	White	1000	20	63642535443	3157625675582
 150 15 holes 	Red	220	20	66254494900	3157629331637
	Pink	320	20	66254494905	3157629331644
	Yellow	400	20	66254494906	3157629331651
	Fuchsia	600	20	66254494907	3157629331668
	Blue	800	20	66254494908	3157629331675
	White	1000	20	66254494909	3157629331682

**P37C**  
(heat-treated aluminium oxide reinforced light paper)

- Abrasive: Heat treated aluminium oxide abrasive
- Backing: B-weight latex reinforced paper
- Special steriate layer anticlogging
- Faster cut rate and longer life

**PREMIER RED**



**P37C Soft Discs**  
(quick release)

- Abrasive: Heat treated aluminium oxide
- Backing: Soft-foam interface layer between the abrasive and the self-grip
- Conforms to all contours and gives the best possible finish
- Colour coded for easy recognition of grit sizes

**P37C**  
QUICK RELEASE REINFORCED PAPER DISCS (BOSCH, RUPES)



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150 	80	100	63642535345	3157625675742
	120	100	63642535346	3157625675735
	150	100	63642535348	3157625675414
	180	100	63642535349	3157625675421
	220	100	636425353430	3157625675438
	240	100	636425353431	3157625675445
	280	100	636425353432	3157625675452
	320	100	636425353433	3157625675469
	400	100	636425353434	3157625675476
	500	100	636425353435	3157625675483
	600	100	636425353436	3157625675506
	800	100	636425353437	3157625675513

**flexovit**

**PREMIER  
RED**



- P37C**  
(heat-treated aluminium oxide reinforced light paper)
- Abrasive: Heat treated aluminium oxide abrasive
  - Backing: B-weight latex reinforced paper
  - Special steriate layer anticlogging
  - Faster cut rate and longer life

## Paper and Soft-Touch Discs

### Paper Discs

#### P37C QUICK RELEASE REINFORCED PAPER DISCS (FESTO)



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	80	100	63642535444	3157625675599
	120	100	63642535445	3157625675605
	150	100	63642535446	3157625675612
	180	100	63642535447	3157625675629
	220	100	63642535448	3157625675636
	240	100	63642535449	3157625675643
	280	100	63642535450	3157625675667
	320	100	63642535451	3157625675674
	400	100	63642535452	3157625675681
	500	100	63642535453	3157625675698
	600	100	63642535454	3157625675704
	800	100	63642535455	3157625675711

#### P37C QUICK RELEASE REINFORCED PAPER DISCS (DP 14 E 14212)



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	80	100	66254405888	3157629209738
	120	100	66254405884	3157629209592
	150	100	66254405886	3157629209615
	180	100	66254405889	3157629209745
	220	100	66254405890	3157629209752
	240	100	66254405902	3157629209899
	320	100	66254405887	3157629209721
	400	100	66254405904	3157629209912
	500	100	66254405905	3157629209929
	600	100	66254405906	3157629209936
	800	100	66254405907	3157629209943

#### P37C QUICK RELEASE REINFORCED PAPER DISCS WITH NO HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	80	100	66261020455	3157625814882
	120	100	66261020456	3157625814899
	150	100	66261020457	3157625815001
	180	100	66261020458	3157625815018
	220	100	66261020459	3157625815025
	240	100	66261020460	3157625815032
	280	100	66261020462*	3157625815049
	320	100	66261020463	3157625815056
	400	100	66261020464	3157625815063
	800	100	66261020467*	3157625815117

\* Made-to-order

# Coated Abrasives



- P64E  
(quick release, perforated)**
- Abrasive: High performance
  - Aluminium oxide
  - Backing: Heavy paper
  - Ideal for sanding flat wood, or metal surfaces

## P64E QUICK RELEASE PERFORATED PAPER DISCS WITH NO HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 115 	40	50	63642588504*	3157625682054
	60	50	63642588505*	3157625682061
	80	50	63642588506*	3157625682078
	100	50	63642588507*	3157625682085
	120	50	63642588508*	3157625682092
	180	50	63642588509*	3157625682108
	 125 	40	50	63642588510*
60		50	63642588511*	3157625682122
80		50	63642588512*	3157625682139
100		50	63642588513*	3157625682146
120		50	63642588514*	3157625682153
150		50	63642588515*	3157625682177
180		50	63642588516*	3157625682184
 150 	40	50	63642535364	3157625676718
	60	50	63642535366	3157625676725
	80	50	63642535367	3157625676732
	100	50	63642588517	3157625682191
	120	50	63642588518	3157625682207
	150	50	63642588519	3157625682214
	180	50	63642588520*	3157625682221

\* Made-to-order

## P64E QUICK RELEASE PERFORATED PAPER DISCS WITH 8 HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 125 	40	50	63642585764	3157625591806
	60	50	63642585770	3157625591844
	80	50	63642585772	3157625591851
	100	50	63642585773	3157625591868
	120	50	63642585775	3157625591882
	150	50	63642585777	3157625591899
	180	50	63642585778	3157625591905

## Coated Abrasives



- P64E  
(quick release, perforated)**
- Abrasive: High performance
  - Aluminium oxide
  - Backing: Heavy paper
  - Ideal for sanding flat wood, or metal surfaces

# Paper and Soft-Touch Discs

## P64E QUICK RELEASE PERFORATED PAPER DISCS WITH 7 HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	40	50	63642585780	3157625591912
	60	50	63642585786	3157625591936
	80	50	63642585787	3157625591974
	100	50	63642585790	3157625591998
	120	50	63642585791	3157625592001
	150	50	63642585793	3157625592407
	180	50	63642585816	3157625592414

## P64E QUICK RELEASE PERFORATED PAPER DISCS WITH 9 HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	40	50	63642585827	3157625592506
	60	50	63642585829	3157625592513
	80	50	63642585830	3157625592537
	100	50	63642585832	3157625592544
	120	50	63642585833	3157625592551
	150	50	63642585834	3157625592568
	180	50	63642585835	3157625592575

## P64E QUICK RELEASE PERFORATED PAPER DISCS WITH 14 HOLES



Diameter (mm)	Grit	Quantity	Article Number	Barcode
 150	40	50	63642585817*	3157625592421
	60	50	63642585819*	3157625592438
	80	50	63642585821*	3157625592445
	100	50	63642585822*	3157625592452
	120	50	63642585823*	3157625592469
	150	50	63642585825*	3157625592476
	180	50	63642585826*	3157625592483

\* Made-to-order

## Accessories



**M8 + 5/16**  
QUICK RELEASE MEDIUM DENSITY BACK-UP PADS



- Suitable for use with paper discs

Diameter (mm)	Quantity	Article Number	Barcode
125	1	69957384732	3157625644113



**8 SCREW**  
QUICK RELEASE MEDIUM DENSITY BACK-UP PADS



- Suitable for use with paper discs

Diameter (mm)	Quantity	Article Number	Barcode
200	1	69957371442	3157620738398



**M14**  
QUICK RELEASE MEDIUM DENSITY BACK-UP PADS



- Suitable for use with paper discs

Diameter (mm)	Quantity	Article Number	Barcode
115	1	07660707234	8711479202445

## Coated Abrasives



### Back-up pads

- Foam back-up pads for Flexovit quick-release discs.
- Industrial design
- High quality

## Coated Abrasives



### P64E (aluminium oxide, heavy paper)

- Abrasive: High performance aluminium oxide
- Backing material: Heavy paper
- Ideal for sanding flat wood, or metal surfaces



## Cut Sheets

### P64E ALUMINIUM OXIDE HEAVY PAPER



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 80 x 133 	40	50	63642588488*	3157625681705
	60	50	63642588489	3157625681712
	80	50	63642588490	3157625681729
	100	50	63642588491	3157625681736
	120	50	63642588492	3157625681743
	150	50	63642588493*	3157625681767
	180	50	63642588494	3157625681774
	240	50	63642588495*	3157625681781

\* Made-to-order

### P64E ALUMINIUM OXIDE HEAVY PAPER



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 100 X 150 	60	50	63642588500	3157625681835
	80	50	63642588501	3157625681842
	120	50	63642588502	3157625681859
	180	50	63642588503	3157625681866

### P64E ALUMINIUM OXIDE HEAVY PAPER



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 94 x 94 x 94 	60	100	63642588522	3157625682252
	80	100	63642588523	3157625682269
	120	100	63642588524	3157625682276
	180	100	63642588525*	3157625682283

\* Made-to-order

# Coated Abrasives

**PREMIER  
RED**



## P37C (heat-treated aluminium oxide reinforced light paper)

- Abrasive: Heat treated aluminium oxide abrasive
- Backing: B-weight latex reinforced paper
- Special steriate layer anticlogging
- Faster cut rate and longer life

### P37C HEAT-TREATED ALUMINIUM OXIDE REINFORCED LIGHT PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 70 x 125 	80	100	63642535505*	3157625676121
	120	100	63642535504*	3157625676114
	150	100	63642535503*	3157625676107
	180	100	63642535502*	3157625675292
	220	100	63642535501*	3157625675285
	240	100	63642535500*	3157625675278

\* Made-to-order

### P37C HEAT-TREATED ALUMINIUM OXIDE REINFORCED LIGHT PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 115 x 230 	80	100	63642535457*	3157625675308
	120	100	63642535467*	3157625675315
	150	100	63642535469*	3157625675322
	180	100	63642535470*	3157625675339
	220	100	63642535472*	3157625675346
	240	100	63642535473*	3157625675353
	280	100	63642535475*	3157625675377
	320	100	63642535476*	3157625675384
	400	100	63642535478*	3157625675391

\* Made-to-order

### P37C HEAT-TREATED ALUMINIUM OXIDE REINFORCED LIGHT PAPER SHEETS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
 70 x 420 	80	100	63642535499	3157625675261
	120	100	63642535498	3157625675254
	150	100	63642535497*	3157625675247
	180	100	63642535496*	3157625675223
	220	100	63642535495*	3157625675216
	240	100	66261035333	3157629204023
	320	100	66261035335	3157629203514

\* Made-to-order

Dimensions Key: W = Width, L = Length



# Coated Abrasives

## Fibre Discs





# Fibre Discs

## Preparation for Use

Fibre discs must be used with the correct sized back-up pad. Do not use other fibre discs as a back-up pad. The diameter of the disc must be at least 3mm but not more than 15mm greater than the diameter of the back-up pad. Do not use a fibre disc which is damaged in any way. Always check visually for damage before use. Make certain that both the disc and the back-up pad are fitted correctly to the machine spindle. The maximum peripheral operating speed of a fibre disc is 80m/s. This is shown on the box label by way of a red stripe, which is a FEPA Standard indicating a recommended operating speed of 80m/s. In no circumstances should this speed be exceeded. The spindle speed of the machine must never exceed the maximum operating speed of the disc: spindle speeds in rpm corresponding to 80m/s for different disc diameters are given below.

MAXIMUM OPERATING SPEED	
Disc Diameter	80m/s Max rpm
100mm	15300
115mm	13300
125mm	12300
150mm	10200
180mm	8600

## Grinding Operation

The fibre disc should only be brought into contact with the workpiece when the machine is running at its operational speed. The disc should be applied to the workpiece at the shallowest angle possible – about 10 degrees is recommended. Grind ‘off’ an edge rather than ‘into’ it when grinding rough welds or metal edges. Do not attempt to use a fibre disc for slot grinding, cutting off or wet grinding. After use the angle grinder should be stored with care. The face of the disc must not be in contact with bench or floor.

## Personal Protection

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

PERSONAL PROTECTION						
						
Mouth Protection	Wear Gloves	Eye Protection	Ear Protection	Read Instruction	Dry	Wet

## Storage

Fibre discs should be stored at a temperature of 18 – 22°C and 45% – 60% relative humidity.



### FX170

- Abrasive: Aluminium oxide
- Backing material: 0.8mm - 0.6mm fibre
- General-purpose, most of the metal grinding applications

## Fibre Discs



### FX170

FIBRE DISC WITH 0.8MM / 0.6MM FIBRE BACKING



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
115 x 22	16	25	66623391839	3157629520222
	24	25	66623391751	3157629519615
	36	25	66623391670	3157629519608
	40	25	66623391843	3157629520239
	50	25	66623391752	3157629520024
	60	25	66623391753	3157629520031
	80	25	66623391754	3157629520048
	100	25	66623391755	3157629520055
	120	25	66623391756	3157629520062
125 x 22	16	25	66623391844	3157629520246
	24	25	66623391757	3157629520079
	36	25	66623391758	3157629520086
	40	25	66623391847	3157629520253
	50	25	66623391759	3157629520093
	60	25	66623391760	3157629520109
	80	25	66623391761	3157629520116
	100	25	66623391762	3157629520123
	120	25	66623391763	3157629520147
180 x 22	16	25	66623391856	3157629520277
	24	25	66623391771	3157629520154
	36	25	66623391772	3157629520161
	40	25	66623391858	3157629520284
	50	25	66623391773	3157629520178
	60	25	66623391774	3157629520185
	80	25	66623391775	3157629520192
	100	25	66623391776	3157629520208
	120	25	66623391777	3157629520215

Dimensions Key: D = Diameter, B = Bore

## Coated Abrasives

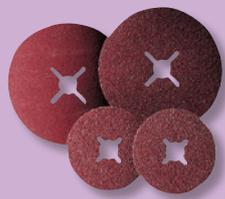


### FX370

- Abrasive: Aluminium oxide
- Backing material: 0.8mm fibre
- Ideal for deburring and weld blending on metal surfaces

### FJ370 (120 grit)

- Abrasive: Aluminium oxide
- Backing material: 0.6mm flexible fibre
- Ideal for general finishing applications on metal



### FX370 (120 grit)

- Abrasive: Aluminium oxide
- Backing material: 0.8mm fibre
- Ideal for deburring and weld blending on metal surfaces

### FJ370

- Abrasive: Aluminium oxide
- Backing material: 0.6mm flexible fibre
- Ideal for general finishing applications on metal

## Fibre Discs



### FX370 / FJ370

FIBRE DISC WITH 0.8MM / 0.6MM FIBRE BACKING



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
100 x 16	24	25	63642532395	8711479202582
	36	25	69957389586	3157625668386
	50	25	69957389589	3157625668607
	60	25	69957389590	3157625668614
	80	25	69957389591	3157625668621
115 x 22	16	25	662611666168	8711479143748
	24	25	63642585505	3157625588271
	36	25	63642585509	3157625588295
	40	25	63642585513	3157625588318
	50	25	63642585514	3157625588325
	60	25	63642585516	3157625588349
	80	25	63642585518	3157625588356
125 x 22	24	25	63642585522	3157625588387
	36	25	63642585523	3157625588394
	40	25	63642585529	3157625586376
	50	25	63642585531	3157625586383
	60	25	63642585532	3157625588417
	80	25	63642585534	3157625588431
	100	25	63642585535	3157625588455



### Fx370 / FJ370

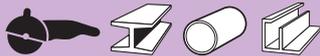
FIBRE DISC WITH HIGH QUALITY 0.8MM / 0.6MM FIBRE BACKING



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
180 x 22	24	25	63642585537	3157625588479
	36	25	63642585539	3157625588486
	40	25	63642585540	3157625588493
	50	25	63642585542	3157625588509
	60	25	63642585544	3157625588523
	80	25	63642585547	3157625588547
	100	25	63642585548	3157625588554

# Coated Abrasives

**FX672**  
FIBRE DISC WITH HIGH QUALITY 0.8MM FIBRE BACKING



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
115 x 22	24	25	63642585560	3157625588677
	36	25	63642585564	3157625588684
	40	25	63642585565	3157625588691
	50	25	63642585567	3157625588714
	60	25	63642585569	3157625588738
	80	25	63642585570	3157625588745
	100	25	63642585571	3157625588752
	120	25	63642585572	3157625588776
125 x 22	24	25	63642585574	3157625588806
	36	25	63642585575	3157625588813
	40	25	63642585577	3157625588844
	50	25	63642585581	3157625588882
	60	25	63642585582	3157625588899
	80	25	63642585583	3157625588905
	100	25	63642585584	3157625588929
	120	25	63642585585	3157625588936
180 x 22	24	25	63642585586	3157625588943
	36	25	63642585587	3157625588967
	40	25	63642585588	3157625588974
	50	25	63642585589	3157625588981
	60	25	63642585590	3157625588998
	80	25	63642585591	3157625589001
	100	25	63642585592	3157625589018
	120	25	63642585594	3157625589025

**FX777**  
FIBRE DISC WITH HIGH QUALITY 0.8MM FIBRE BACKING

MEGA-LINE  
MAXXX



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
115 x 22	36	25	66254493915	3157629325667
	50	25	66254493916	3157629325674
	60	25	66254493917	3157629325681
	80	25	66254493918	3157629325698
125 x 22	36	25	66254493919	3157629325704
	50	25	66254493920	3157629325711
	60	25	66254493921	3157629327623
	80	25	66254493922	3157629327647
180 x 22	36	25	66254493923	3157629327654
	50	25	66254493924	3157629327661
	60	25	66254493925	3157629327678
	80	25	66254493926	3157629327685



**FX672**

- Abrasive: Zirconia alumina
- Backing material: High quality 0.8mm fibre
- Extremely sharp grain
- Ideal for achieving high stock removal on stainless steel surfaces



**FX777**

- Abrasive: SG Hi-Pal ceramic
- Backing material: 0.8mm high quality fibre
- Extremely sharp grain
- Extra long life
- Third layer supersize reduces the heat generation
- Ideal for heat sensitive materials such as stainless steel

Dimensions Key: D = Diameter, B = Bore

## Coated Abrasives



### Nylon

- Medium density suitable for medium/fine applications

- Hard density suitable for coarse applications

### Air cool rubber

- Hard density suitable for tough applications

# Fibre Discs

## Accessories

### BACK-UP PADS (M14 ATTACHMENT) FOR FIBRE DISCS



Diameter (mm)	Product Material Type	Density	Quantity	Article Number	Barcode
115	Nylon	Medium	5	69957382815	3157625620667
	Nylon	Hard	1	69957382818	3157625620698
	Air cool rubber	Hard	1	69957382821	3157625620728
125	Nylon	Medium	5	69957382816	3157625620674
	Nylon	Hard	1	69957382819	3157625620704
	Air cool rubber	Hard	1	69957382823	3157625620735
180	Nylon	Medium	5	69957382817	3157625620681
	Nylon	Hard	1	69957382820	3157625620711
	Air cool rubber	Hard	1	69957382824	3157625620742

# Coated Abrasives

## Fibreflex Discs



## Coated Abrasives



### Aluminium oxide

- For stainless steel, weldings, large surfaces derusting, aluminium and most metal applications

## Fibreflex Discs

Fibreflex semi-flexible discs are made by coating heavy duty fibre with multiple layers of a special resin bonded abrasive. The amount of abrasive used combined with the unique disc pattern means the semi-flexible disc has a longer life as it resists loading and it allows grinding to be carried out at cooler temperatures.

They are suitable for use in a wide range of applications. Semi-flexible discs can be used instead of depressed centre grinding wheels and sanding discs. The flexibility of the product leads to improved performance as it easily works around contours, requiring limited pressure to be applied making it easy to use.

Flexovit fibreflex discs should be used with a suitable back-up pad on an angle grinder. All fibreflex discs have a maximum operating speed of 80m/s.

### Aluminium Oxide – A

Ideal for use on stainless steel, welds, derusting large surfaces, aluminium, and most other metal applications.

### Silicon Carbide – C

Ideal for use on marble, granite, terrazzo, concrete, fibreglass and cast iron.

Excellent for cleaning the hulls of ships and boats. Can also be used for cleaning the hooves of cows.

## Fibreflex Discs

### ALUMINIUM OXIDE - FLAT SHAPE

Dimensions (mm) D x T x B	Description	Quantity	Article Number	Barcode
115 x 5 x 22.2	A 24 FIBREFLEX	25	66261168698	8711479163425
	A 36 FIBREFLEX	25	66261168678	8711479163135
125 x 5 x 22.2	A 24 FIBREFLEX	25	66261168701*	8711479163463
	A 36 FIBREFLEX	25	66261168694	8711479163234

### ALUMINIUM OXIDE - CURVED SHAPE

Dimensions (mm) D x T x B	Description	Quantity	Article Number	Barcode
125 x 5 x 22.2	A 24 FIBREFLEX	25	07660718342*	3564653672153
	A 36 FIBREFLEX	25	07660718343*	3564653672160
	A 60 FIBREFLEX	25	07660718344*	3564653672184
180 x 5 x 22.2	A 24 FIBREFLEX 8 DH	25	66261168704*	8711479163494
	A 36 FIBREFLEX 8 DH	25	66261162955	8711479163159
	A 60 FIBREFLEX 8 DH	25	07660717832	3157625622814
	A 80 FIBREFLEX 8 DH	25	66261168705*	8711479163500

\* Made-to-order



## Silicon carbide

- For marble, granite, terrazo, concrete, fibre glass bodies, cast iron, cleaning of ship hulls and cleaning hoofs of cows

## SILICON CARBIDE - FLAT SHAPE

Dimensions (mm) D x T x B	Description	Quantity	Article Number	Barcode
115 x 5 x 22.2	C 16 FIBREFLEX	25	66261168675	8711479163104
	C 24 FIBREFLEX	25	69957336400	8711479163517
	C 36 FIBREFLEX	25	69957336397	8711479103896
	C 60 FIBREFLEX	25	69957336394	8711479163203
	C 80 FIBREFLEX	25	69957336391	8711479163524
	C 120 FIBREFLEX	25	66261168757	8711479164002
125 x 5 x 22.2	C 16 FIBREFLEX	25	66261168709	8711479163531
	C 24 FIBREFLEX	25	69957336399	8711479163548
	C 36 FIBREFLEX	25	69957336396	8711479163555
	C 60 FIBREFLEX	25	69957336393	8711479163562
	C 80 FIBREFLEX	25	66261168713	8711479163579
	C 120 FIBREFLEX	25	66261168714*	8711479346569
180 x 5 x 22.2	C 16 FIBREFLEX	25	69957336401	8711479163128
	C 24 FIBREFLEX	25	69957336398	8711479163142
	C 36 FIBREFLEX	25	69957336395	8711479163166
	C 60 FIBREFLEX	25	69957336392	8711479163586
	C 80 FIBREFLEX	25	66261162956	8711479163593
	C 120 FIBREFLEX	25	66261168758*	8711479355905
230 x 5 x 22.2	C 16 FIBREFLEX	25	66261168690*	8711479346576
	C 24 FIBREFLEX	25	66261168691*	8711479346583
	C 36 FIBREFLEX	25	66261168692*	8711479346590
	C 60 FIBREFLEX	25	66261168693*	8711479346606

\* Made-to-order

## SILICON CARBIDE - CURVED SHAPE

Dimensions (mm) D x T x B	Description	Quantity	Article Number	Barcode
125 x 5 x 22.2	C 16 FIBREFLEX	25	07660718145*	3564654678352
180 x 5 x 22.2	C 36 FIBREFLEX	25	07660718151*	3564654678444

\* Made-to-order

## Accessories

### BACK-UP PADS (M14 ATTACHMENT) FOR FIBREFLEX DISCS

Diameter (mm)	Product Material Type	Density	Quantity	Article Number	Barcode
115	Nylon	Hard	1	69957382818	3157625620698
125	Nylon	Hard	1	69957382819	3157625620704
180	Nylon	Hard	1	69957382820	3157625620711

Dimensions Key: D = Diameter, T = Thickness, B = Bore



# Coated Abrasives

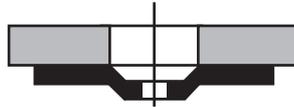
## Flap Discs



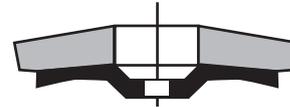


## Flap Discs

Flexovit flap discs are available in a variety of specifications to cover the different needs and applications of the market. The range offers aluminium oxide, zirconia alumina and ceramic products, with either a fibreglass or a plastic backing plate. The discs are available in two designs, flat and conical (convex) shape. The flat form is mainly used for face and plane surface grinding. The conical shape is used for applications on curved and more difficult to access areas as well as for face and surface grinding.



**Flat**  
for grinding and finishing at a small angle (up to 15°)



**Conical**  
for grinding at an angle of 15-25°

The positioning of the flaps provide high flexibility and a constant surface finish, as well as fast stock removal, and a very balanced all round performance. As a result of the operating speed, flap discs are particularly suitable for rough grinding and intermediate grinding, blending and finishing. The cloth flaps are designed and positioned to wear evenly so that new grits are exposed helping to maintain a uniform result over a long period of time. The abrasive flaps stay sharp until the disc is completely worn out, meaning the full life of the product can be used in each application.

The wide range of available grits and grain types mean Flexovit offers a flap disc range suitable for a variety of applications. Coarser grits are ideally suited for applications where fast and high rates of stock removal are needed. Finer grits offer a good balance between effective stock removal and a good surface finish.

Low set-up times, reduced noise level, comfortable and cool grinding, anti-clogging technology and the fact that no backing-pad is required ensures excellent performance.

## Preparation for Use

Damaged, misshapen or modified flap discs and back-up pads, should not be used. Always ensure that the flap disc and the support pad are safely and centrally fixed to the machine spindle. Do not use a flap disc with an oversize or undersize bore. The maximum peripheral operation speed and the maximum rpm of a flap disc should not be exceeded. The spindle speed of the machine in rpm must be equal to or less than the maximum operating speed shown on the flap disc. This follows the E13743 maximum speed guidelines which is indicated by a colour stripe on the label.

 Yellow = 63m/s

 Red = 80m/s

MAXIMUM OPERATING SPEED/RPM		
Diameter (mm)	Max. Operating Speed	Max. RPM
110 x 22	63m/s	11000 rpm
115 x 22	80m/s	13300 rpm
125 x 22	80m/s	12200 rpm
180 x 22	80m/s	8500 rpm

## Personal Protection

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

### PERSONAL PROTECTION



Mouth  
Protection



Wear  
Gloves



Eye  
Protection



Ear  
Protection



Read  
Instruction



Dry



Wet



## GRINDING OPERATION

The flap disc should only be brought into contact with the work, when the machine is running at its operational speed. Apply the flap disc to the work at the shallowest angle possible. About 10 degrees is recommended. Grind 'off' an edge rather than 'into' it when grinding rough welds or metal edges. Do not attempt to use a flap disc for slot grinding, cutting-off or wet grinding. After use the angle grinder should be stored with care and the face of the flap disc must not be in contact with bench or floor.

## Coated Abrasives



### MEGA-LINE SG LONGLIFE

- Next generation SG® ceramic abrasive grain
- Heavy polyester cloth
- Cool and fast cut for higher metal removal and longer product life
- Ideal for stainless steel, inconels, chromium cobalt, titanium or other hard-to-grind material



### MEGA-LINE TWIN POWER

- Premium SG® ceramic aluminium oxide and zirconia alumina abrasive blend
- Heavy cotton cloth
- Special double-flap construction
- Achieves a much longer life due to the high density of flaps
- Aggressive stock removal with less pressure, giving a cooler cut



### MEGA-LINE BLUE

- Premium zirconia abrasive
- Longlife polycotton backing
- Ideal for heavy duty operations
- Very effective on steel and stainless steel

## Flap Discs

### Mega-Line SG LONGLIFE FIBREGLASS BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 125 x 22	40	10	66261086960	3157629121214
	60	10	66261086961	3157629121238

### Mega-Line TWIN POWER ZIRCONIA ALUMINA/CERAMIC WITH PLASTIC BACKING - FLAT



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	40	10	63642507393	3564654352344
	60	10	63642508545	3564654723854

### Mega-Line TWIN POWER ZIRCONIA ALUMINA/CERAMIC WITH FIBREGLASS BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	40	10	66261162861	8711479345333
	60	10	66261168553	8711479345340
	80	10	66261168554	8711479345357
125 x 22	40	10	66261162862	8711479345388
	60	10	66261086953	3157629118665
	80	10	66261086954	3157629118672

### Mega-Line BLUE LONGLIFE ZIRCONIA ALUMINA WITH FIBRE BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	40	10	66261099926	3157629355251
	60	10	66623300320	3157629355268
	80	10	66623300350	3157629355275
	120	10	66623302749*	3157629360255
125 x 22	40	10	66623300355	3157629355282
	60	10	66623300357	3157629355299
	80	10	66623300358	3157629355305
	120	10	66623302750	3157629360262

\* Made-to-order

**flexOvit** HEAVY DUTY ZIRCONIA ALUMINA WITH FIBREGLASS BACKING - FLAT 

Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	40	10	66261168632	8711479243554
	60	10	66261168633	8711479243547
125 X 22	40	10	66261168620	8711479253058
	60	10	66261168622	8711479253065
	80	10	66261168623	8711479253072
180 X 22	40	10	66261168625	8711479253096

**flexOvit** HEAVY DUTY ZIRCONIA ALUMINA WITH FIBREGLASS BACKING - CONICAL 

Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	40	10	66261162940	8711479243509
	60	10	66261162941	8711479243516
125 X 22	40	10	66261162944	8711479253188
	60	10	66261168639	8711479253195
	80	10	66261168640	8711479253201

**flexOvit** ZIRCONIA ALUMINA WITH PLASTIC BACKING - FLAT 

Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	40	10	63642564451	8711479337017
	60	10	63642564452	8711479337031
	80	10	66261168538	8711479337055

## Coated Abrasives



### Flexovit Zirconia Alumina (heavy duty)

- Fibreglass backing
- Flat or conical shape
- Extra long life
- For tough grinding
- Application: Stainless steel, aluminium and grinding of weld seams



### Flexovit Zirconia Alumina

- Fibreglass backing
- Flat or conical shape
- Extra long life
- Application: Stainless steel and aluminium

Dimensions Key: D = Diameter, B = Bore

# Coated Abrasives



## Flexovit Zirconia Alumina

- Fibreglass backing
- Flat or conical shape
- Extra long life
- Application: Stainless steel and aluminium



## Zirconia Alumina

- Plastic Backing
- High stock removal at low pressure
- Inserted flap discs construction for maximum life
- Max. speed 63m/s

# Flap Discs

## flexOvit ZIRCONIA ALUMINA WITH FIBREGLASS BACKING - FLAT



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	36	10	66261168570	8711479161810
	40	10	63642517987	3564650053634
	60	10	63642517988	3564650053641
	80	10	63642517989	3564650053658
	120	10	63642517990	3564650053665
125 x 22	40	10	63642517991	3564650069321
	60	10	63642517992	3564650061943
	80	10	63642517993	3564650071225
	120	10	66261168591	8711479316722
180 x 22	36	10	66261168602*	8711479184734
	40	10	66261168580	8711479245596
	60	10	66261168610	8711479162107
	80	10	66261168611*	8711479162114

\* Made-to-order

## flexOvit ZIRCONIA ALUMINA INSERTED FLAPS WITH FIBREGLASS BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	36	10	66261162886	8711479161872
	40	10	63642534630	3564650009723
	60	10	63642517978	3564650009730
	80	10	63642517979	3564650009747
	120	10	63642517980	3564650009754
125 x 22	36	10	66261168592	8711479161933
	40	10	63642517981	3564650009808
	60	10	63642519304	3564650009815
	80	10	63642517982	3564650009822
	120	10	63642517983	3564650009839
180 x 22	36	10	66261168603*	8711479162053
	40	10	63642517984	3564650009884
	60	10	63642519305	3564650009891
	80	10	63642517985	3564650009907
	120	10	63642517986	3564650009914

\* Made-to-order

## flexOvit ZIRCONIA ALUMINA INSERTED FLAP WITH PLASTIC BACKING - FLAT (MOS 63M/S)



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 110 x 22	40	20	66261164140	8711479161094
	60	20	66261164141	8711479161124
	80	20	66261164142	8711479161155
	120	20	66261164154	8711479161339

## Coated Abrasives



### Aluminium oxide

- Fibreglass backing
- Flat or conical shape
- Extra long life
- Application: Various steels, non-ferrous metals and wood

flexOvit		ALUMINIUM OXIDE WITH FIBREGLASS BACKING - FLAT		
Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	36	10	66261168565	8711479161766
	40	10	63642521046	3564650053672
	60	10	63642521047	3564650053689
	80	10	63642521048	3564650053696
	120	10	66261162876	8711479161803

flexOvit		ALUMINIUM OXIDE WITH FIBREGLASS BACKING - CONICAL		
Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	36	10	66261168575*	8711479161865
	40	10	63642521034	3564650009686
	60	10	63642521035	3564650009693
	80	10	63642521036	3564650009709
	120	10	63642521037	3564650009716
125 X 22	36	10	66261168586	8711479161889
	40	10	63642521038	3564650009761
	60	10	63642521039	3564650009778
	80	10	63642521040	3564650009785
	120	10	63642521041	3564650009792
180 X 22	40	10	63642521042	3564650009846
	60	10	63642521043	3564650009853
	80	10	63642521044*	3564650009860
	120	10	63642521045*	3564650009877

\* Made-to-order

flexOvit		ALUMINIUM OXIDE INSERTED FLAPS WITH PLASTIC BACKING - FLAT		
Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 110 X 22	40	20	66261164139	8711479161087
	60	20	66261164138	8711479161117
	80	20	66261164175	8711479161148
	120	20	66261168527	8711479161216



### Aluminium oxide

- Plastic Backing
- High stock removal at low pressure
- Inserted flap construction for a maximum life
- Max speed 63m/s

Dimensions Key: D = Diameter, B = Bore

## Coated Abrasives



### SPEEDOFLEX ZIRCONIA

- Long life
- Application: Stainless steel and aluminium



## Flap Discs

### SPEEDO FLEX ZIRCONIA ALUMINA WITH PLASTIC BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	40	10	66261168542	8711479337130
	60	10	66261168543*	8711479337154
	80	10	66261168544*	8711479337178
125 x 22	40	10	63642564527	8711479337192
	60	10	63642564528	8711479337215
	80	10	63642564529	8711479337239

\* Made-to-order

### SPEEDO FLEX ZIRCONIA ALUMINA WITH PLASTIC BACKING - FLAT



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	36	10	66261039422	8326101800403
	40	10	66261039428	8326101800410
	50	10	66261039436	8326101800427
	60	10	66261039446	8326101800434
	80	10	66261039454	8326101800441
	100	10	66261039461	8326101800458
	120	10	66261039508	8326101800465
125 x 22	40	10	63642564454	8711479337079
	60	10	63642564455	8711479337093
	80	10	63642564456	8711479337116

### SPEEDO FLEX ZIRCONIA ALUMINA WITH FIBREGLASS BACKING - FLAT



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 125 x 22	40	10	63642518579	3157625597167
	60	10	63642518580	3157625591174
	80	10	63642518581	3157625597181

### SPEEDO FLEX ZIRCONIA ALUMINA WITH FIBREGLASS BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 x 22	40	10	63642517997	8711479188404
	60	10	63642517998	8711479188411
	80	10	63642517999	8711479188428
	120	10	662611688618	8711479347108
125 x 22	40	10	63642518000	8711479335723
	60	10	63642518001	8711479335747
	80	10	63642518002	8711479335761



ALUMINIUM OXIDE  
WITH FIBREGLASS BACKING - CONICAL



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 125 X 22	40	10	69957384757	3157625644281
	60	10	69957384758	3157625644304
	80	10	69957384760	3157625644311



FLEXI-DISCS ZIRCONIUM  
FIBREGLASS BACKING - FLAT



Dimensions (mm) D x B	Grit	Quantity	Article Number	Barcode
 115 X 22	40	10	66261177336*	8711479347825
	60	10	66261177337*	8711479347832
	80	10	66261177338*	8711479347849
125 X 22	40	10	66261177412*	8711479397585
	60	10	66261177413*	8711479397592
	80	10	66261177414*	8711479397608

\* Made-to-order

## Accessories

M14 NUT FOR USE WITH PLASTIC BACKED FLAP DISCS



Attachment	Quantity	Article Number	Barcode
M14	1	66261175131	8711479162558



### FLEXOVIT FLEXI-DISCS

- Zirconia abrasive
- Special flap construction
- For blending and finishing
- Speciale suited for sanding contours
- Long life & cool grinding
- Application: Stainless steel and aluminium



Dimensions Key: D = Diameter, B = Bore





# Coated Abrasives

## Flap Wheels





## Flap Wheels

Manufactured with abrasive cloth edges radially arranged about a core, flap wheels are one of the most commonly used abrasive tools. They are particularly suited to roughing, smoothing, and polishing operations on materials such as iron, brass, wood, and synthetic materials, they can be mounted on electrical and pneumatic portable machines or on fixed machines such as grinders, polishers.

The wheels may also be used for specialised wet machining applications and may be shaped for special workpieces.

### Flange Mounted Flap Wheels

#### PREPARATION BEFORE USE

Flange mounted flap wheels must only be used on machines specifically manufactured for this purpose. Always use the mounting flanges supplied by the wheel manufacturer. Ensure that the wheels are mounted strictly in accordance with the manufacturer's instructions. Ensure that the wheel is centrally and securely mounted on the machine and that it runs in the same direction as the arrow marked on it. Check that the maximum operating speed of the wheel, given in RPM, is higher than or equal to the spindle speed of the machine. Never exceed the maximum operating speed recommended by the manufacturer.

#### PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection, leather aprons and safety shoes must be worn.

#### PERSONAL PROTECTION



Mouth Protection



Wear Gloves



Eye Protection



Ear Protection



Read Instruction



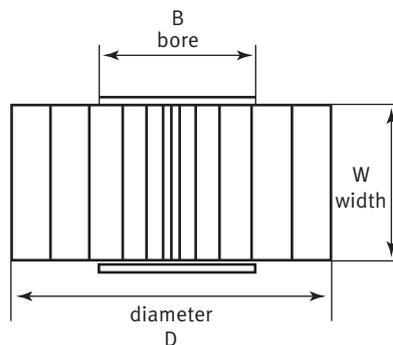
Dry



Wet

#### STORAGE

Flap wheels should be stored in accordance with the recommendations given and should be stored flat or hung on their spindles to avoid permanent deformation.

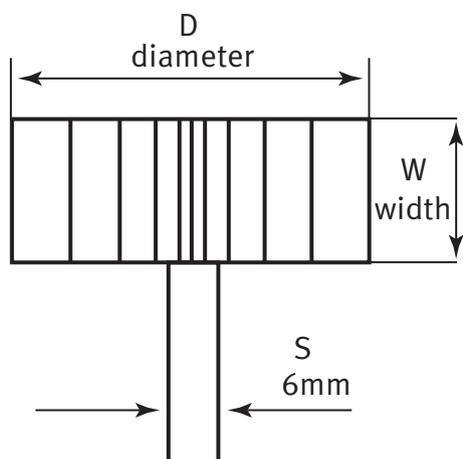


#### MAXIMUM OPERATING SPEED

Diameter (mm)	Max rpm
100	8000
150	5800
165	5500
200	4500
250	3500
300	2800
350	2500
400	2200

## Spindle Mounted Flap Wheels

Particularly appropriate where grinding or polishing work has to be carried out in limited space. They are made of edges in abrasive cloth arranged radially about a resin core which incorporates a shaft. They are generally mounted on electrical and pneumatic portable machines or Flexible shaft machines, and operate with a high rotary speed. Spindle mounted flap wheels are made in accordance with EN 13743:2001 Standards.



### RECOMMENDED OPERATING SPEED

Dimension (mm) D x W x S	Recommended Minimum RPM	Recommended Optimum RPM	Recommended Maximum RPM
30 x 15 x 6	12000	16500	25500
30 x 20 x 6	12000	16500	25500
40 x 20 x 6	9600	12500	19100
50 x 20 x 6	7000	10000	15300
50 x 30 x 6	7000	10000	15300
60 x 15 x 6	6300	8300	12700
60 x 30 x 6	6300	8300	12700
60 x 40 x 6	6300	8300	12700
80 x 50 x 6	4800	6200	9600

**Dimensions Key:** D = Diameter, W = Width, S = Spindle



### Flap wheels with flanges

- Cotton backing
- Comfortable, stable grinding
- Finishing
- Suited for curved surfaces, profiles and pipes
- For handheld and fixed machines
- Aluminium oxide abrasive suitable for use on steels, nonferrous metals and wood

# Flap Wheels

**KX300**

ALUMINIUM OXIDE FLAP WHEELS WITH FLANGES



Dimensions (mm) D x W x B	Grit	Quantity	Article Number	Barcode
150 x 25 x 25	80	1	63642522337	8711479160431
	120	1	66261162845	8711479160455
150 x 50 x 25	80	1	66261168474	8711479160486
165 x 25 x 30	60	1	66261168480	8711479160530
	120	1	63642524155*	8711479160561
165 x 30 x 30	40	1	63642585405*	3157625586864
	60	1	63642585411	3157625586918
	80	1	63642585413	3157625586925
	100	1	63642585414*	3157625586932
	120	1	63642585415	3157625586949
	150	1	66261168492*	8711479160653
165 x 50 x 30	40	1	63642585416	3157625586956
	60	1	63642585417	3157625586963
	80	1	63642585418	3157625586987
	100	1	63642585419	3157625586994
	120	1	63642585420	3157625587007
200 x 50 x 30	60	1	63642585421	3157625587014
	80	1	63642585423	3157625587021
	100	1	63642585425*	3157625587038
	120	1	63642585426*	3157625587045

\* Made-to-order

See Accessories page for Reduction bushings

# Coated Abrasives

## KX300

### ALUMINIUM OXIDE SPINDLE MOUNTED FLAP WHEELS



Dimensions (mm) D x W x S	Grit	Quantity	Article Number	Barcode
20 x 10 x 6	60	10	66261162828	8711479363276
	80	10	66261168437	8711479158742
	120	10	66261168442	8711479186943
20 x 15 x 6	80	10	66261168445	8711479250286
20 x 20 x 6	40	10	66261168440	8711479158896
30 x 5 x 6	120	10	66261168438	8711479158773
30 x 10 x 6	40	10	66261168405*	8711479158179
	60	10	66261168370	8711479157646
	80	10	66261168358	8711479157455
	120	10	66261168398	8711479158063
	150	10	66261168410*	8711479158216
	240	10	66261168411	8711479158223
30 x 15 x 6	40	10	63642585429	3157625587205
	60	10	63642585432	3157625587366
	80	10	63642585434	3157625587373
	120	10	63642585435	3157625587397
	150	10	63642585436	3157625587403
	240	10	66261168394	8711479158025
	320	10	66261168406	8711479158193
30 x 20 x 6	40	10	63642523264	8711479157257
	60	10	63642523265	8711479157882
	80	10	63642520055	8711479157318
	100	10	66261162614*	8711479190575
	120	10	66261168387	8711479157950
	150	10	63642585437	3157625587434
	240	10	66261168375	8711479157745
40 x 10 x 6	120	10	66261168424*	8711479158377
40 x 15 x 6	40	10	63642564831	8711479157844
	60	10	66261168293	8711479156755
	80	10	63642564832	8711479156885
	120	10	66261168318	8711479157042
	150	10	66261168331	8711479157172
	240	10	66261168378	8711479157776
	320	10	66261168416*	8711479158278
40 x 20 x 6	40	10	63642585439	3157625587441
	60	10	63642585441	3157625587458
	80	10	63642585443	3157625587472
	100	10	66261162816	8711479156984
	120	10	63642585444	3157625587489
	150	10	63642585445	3157625587496
	180	10	66261162635	8711479190797
	240	10	66261168366	8711479157585
	320	10	66261162637*	8711479190810

\* Made-to-order



#### Spindle mounted flap wheels

- Cotton backing
- Comfortable, stable grinding
- Suitable for use on difficult to access areas, such as pipes and moulds/matrixes
- Aluminium oxide abrasive for use on various steels, non-ferrous metals and wood

Dimensions Key: D = Diameter, W = Width, S = Spindle, B = Bore



## Spindle mounted flap wheels

- Cotton backing
- Comfortable, stable grinding
- Suitable for use on difficult to access areas, such as pipes and moulds/matrixes
- Aluminium oxide abrasive for use on various steels, non-ferrous metals and wood

# Flap Wheels

**KX300**

ALUMINIUM OXIDE SPINDLE MOUNTED FLAP WHEELS



Dimensions (mm) D x W x S	Grit	Quantity	Article Number	Barcode
50 x 10 x 6	120	10	66261168426*	8711479158445
50 x 15 x 6	80	10	66261168362	8711479157554
	120	10	66261168363	8711479157561
50 x 20 x 6	40	10	63642543478	8711479156670
	60	10	63642585447	3157625587519
	80	10	63642585449	3157625587526
	100	10	63642532515	8711479190940
	120	10	63642585451	3157625587533
	150	10	63642523267	8711479157769
50 x 30 x 6	40	10	63642585452	3157625587557
	60	10	63642585453	3157625587564
	80	10	63642585455	3157625587588
	120	10	63642585456	3157625587595
	150	10	66261168371*	8711479157684
60 x 15 x 6	60	10	63642585457	3157625587618
	80	10	63642585460	3157625587632
	120	10	63642585462	3157625587649
60 x 20 x 6	40	10	63642522336*	8711479157868
	80	10	66261168310*	8711479156922
	120	10	66261168323*	8711479157097
	150	10	66261168334*	8711479157202
60 x 30 x 6	40	10	63642585463	3157625587656
	60	10	63642585464	3157625587687
	80	10	63642585465	3157625587717
	120	10	63642585466	3157625587724
	150	10	66261168335	8711479157219
	240	10	66261168356	8711479157431
60 x 40 x 6	40	10	63642585467	3157625587731
	60	10	63642585469	3157625587755
	80	10	63642585470	3157625587762
	120	10	63642585471	3157625587779
60 x 50 x 6	40	10	63642524153*	8711479156717
	80	10	66261168313*	8711479156953
	120	10	66261168326*	8711479157127
	150	10	66261162819*	8711479157981
	240	10	66261168368*	8711479157608
80 x 30 x 6	40	10	66261168290	8711479156724
	60	10	66261168303	8711479156854
	80	10	66261168314	8711479156960
	120	10	66261168328	8711479157141
80 x 50 x 6	40	10	63642585474	3157625587786
	60	10	63642585476	3157625587816
	80	10	63642585478	3157625587823
	120	10	63642585480	3157625587854

\* Made-to-order

# Coated Abrasives

## Belts





## Belts

The results achieved when sanding with belts depends on several factors including:

- The machine condition and available horsepower
- The belt speed
- The grinding pressure
- The contact wheel
- The choice of the belt in relation to the shape of the part and material type
- The use of coolant (when machine and belt allows)

### Belt Speed

The speed of the belt has a direct relationship with its cut rate, as well as the amount of heat generated, the surface finish achieved, and the stress on abrasive grain. Some abrasives like zirconia alumina and ceramic, support much higher stresses because they have a better resistance to uncontrolled fracture. Some materials are more sensitive to heat generation: The chart below gives the recommended speed range according to material.

RECOMMENDED GRINDING BELT SPEED			
Heat sensitive materials, plastics, etc.	5-15m/s	Stainless steel, high-speed steel and tool steel	20-30m/s
Sintered metals and carbides	8-15m/s	Grey cast iron and cast steel	30-40m/s
Titanium and similar alloys	8-15m/s	Carbon steel	30-40m/s
Glass, porcelain and special steel	8-15m/s	Brass, copper, zinc, bronze and tin	25-35m/s
Heat-resistant plastics	20-30m/s	Aluminium and light metal	20-35m/s
Wood	15-30m/s	Varnish	10-15m/s

### Grinding Pressure

The amount of grinding pressure depends on:

- The force used
- The size of the contact area between the belt and the workpiece
- The backing on which the belt runs (generally a contact wheel)

Higher pressure increases the cut rate and the amount of heat generated increases the stress on the individual abrasive grain (a minimum stress is necessary to achieve a controlled fracture of the abrasive grain), and generally generates a rougher finish.



# Coated Abrasives



## MX240 (aluminium oxide)

- Abrasive: Aluminium oxide
- Backing material: Polycotton
- Semi-open coat resists clogging
- Specially designed for belt applications on wood and metal



## SY674 (zirconium)

- Abrasive: new needle shape zirconia grain
- Backing material: heavy polyester cloth (YY for coarse grits and Y for 50 and finer)
- Abrasive belt combining a tough grain with optimized fracturing behavior and an improved cutting efficiency
- Recommended for all type of steels, from low to high pressure applications

# Belts

## File Belts

### MX240 ALUMINIUM OXIDE CLOTH FILE BELTS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
10 x 330	40	100	63642585988	3157625593916
	60	100	63642585992	3157625593923
	80	100	63642585993	3157625593947
	120	100	63642585994	3157625593954
	180	100	63642585996*	3157625593961
13 x 454	40	100	63642586006	3157625594029
	60	100	63642586008	3157625594036
	80	100	63642586009	3157625594043
	120	100	63642586012	3157625594067
	180	100	63642586015*	3157625594074
13 x 457	40	100	66254481845	3157629297766
	60	100	66254481846	3157629297773
	80	100	66254481847	3157629297797
	120	100	66254481848	3157629297803
13 x 610	40	100	63642586017	3157625594081
	60	100	63642586018	3157625594098
	120	100	63642586021	3157625594111
20 x 480	40	100	63642586033*	3157625593688
	60	100	63642586035	3157625594203
	80	100	63642586036	3157625594227
	120	100	63642586037	3157625594234
20 x 520	40	100	63642590752	3157625696839
	60	100	63642590768	3157625696846
	80	100	63642590771	3157625696853
40 x 305	60	10	63642588526	3157625682436
	80	10	63642588527	3157625682306
	120	10	63642588528	3157625682313

\* Made-to-order

### SY674 ZIRCONIA POLYESTER FILE BELTS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
10 x 330	40	20	66623312535	3157629382677
	60	20	66623312540	3157629382721
	80	20	66623312541	3157629382738
20 x 520	40	20	66623312534	3157629382653
	60	20	66623312542	3157629382745
	80	20	66623312370	3157629381076

## Portable Belts

### T33X

ALUMINIUM OXIDE CLOTH BELTS TAPE JOINT



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
30 x 533	40	10	63642585902	3157625593077
	60	10	63642585905	3157625593084
	80	10	63642585906	3157625593091
	120	10	63642585907	3157625593107
60 x 400	40	10	63642585852	3157625592681
	60	10	63642585860	3157625592391
	80	10	63642585866	3157625592704
	100	10	63642585867	3157625592711
	120	10	63642585871	3157625592728
65 x 410	40	10	63642585875	3157625592735
	60	10	63642585876	3157625592742
	80	10	63642585878	3157625592759
	100	10	63642585879	3157625592766
	120	10	63642585880	3157625592773
75 x 457	40	10	63642585881	3157625592902
	50	10	63642585882	3157625592919
	60	10	63642585883	3157625592926
	80	10	63642585885	3157625592933
	100	10	63642585886	3157625592957
	120	10	63642585887	3157625592964
75 x 480	40	10	63642588529	3157625682337
	60	10	63642588530	3157625682344
	80	10	63642588531	3157625682351
	100	10	63642588532	3157625682368
	120	10	63642588533	3157625682375
75 x 533	40	10	63642585889	3157625592988
	50	10	63642585893	3157625592995
	60	10	63642585896	3157625593008
	80	10	63642585897	3157625593015
	100	10	63642585898	3157625593022
	120	10	63642585900	3157625593039
	150	10	63642585901	3157625593053
75 x 610	40	10	63642588534	3157625682382
	60	10	63642588539	3157625682399
	80	10	63642588540	3157625682405
	100	10	63642588541	3157625682412
	120	10	63642588542	3157625682429

### T33X

(aluminium oxide)

- Abrasive: Aluminium oxide
- Backing material: Heavy cotton
- Specially designed for belt applications
- Good performance at low speeds
- Ideal for floor and furniture applications

Dimensions Key: W = Width, L = Length

## Coated Abrasives



### T33X (aluminium oxide)

- Abrasive: Aluminium oxide
- Backing material:  
Heavy cotton
- Specially designed  
for belt applications
- Good performance  
at low speeds
- Ideal for floor and  
furniture applications

## Belts

### Portable Belts

#### T33X

ALUMINIUM OXIDE CLOTH BELTS TAPE JOINT



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
100 x 560	40	10	63642585922	3157625593169
	50	10	63642585925	3157625593176
	60	10	63642585926	3157625593183
	80	10	63642585927	3157625593329
	100	10	63642585929	3157625593336
	120	10	63642585934	3157625593343
100 x 610	40	10	63642585937	3157625593374
	50	10	63642585939	3157625593381
	60	10	63642585941	3157625593398
	80	10	63642585942	3157625593404
	100	10	63642585943	3157625593411
	120	10	63642585944	3157625593428
	150	10	63642585945	3157625593435
100 x 620	40	10	63642585947	3157625593442
	60	10	63642585949	3157625593466
	80	10	63642585950	3157625593497
	100	10	63642585952	3157625593503
	120	10	63642585953	3157625593527
110 x 620	40	10	63642585956	3157625593558
	60	10	63642585957	3157625593565
	80	10	63642585958	3157625593572
	100	10	63642585959	3157625593589
	120	10	63642585960	3157625593596

## Narrow Belts

### SX373

ALUMINIUM OXIDE POLYESTER SANDING BELTS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
100 x 915	40	10	63642585978	3157625593862
	60	10	63642585979	3157625593879
	80	10	63642585980	3157625593886
	100	10	63642585984	3157625593893
	120	10	63642585986	3157625593909
50 x 2000	36	10	63642586039*	3157625594258
	40	10	63642586044	3157625594265
	60	10	63642586046	3157625594272
	80	10	63642586048	3157625594289
	120	10	63642586049*	3157625594296
75 x 2000	36	10	63642586052	3157625594302
	40	10	63642586053	3157625594319
	60	10	63642586056	3157625594326
	80	10	63642586059	3157625594333
	120	10	63642586060	3157625594357
	180	10	63642586062	3157625594364
75 x 2500	36	10	63642586082	3157625594524
	60	10	63642586084*	3157625594531
	80	10	63642586085	3157625594548
150 x 2000	60	10	63642588378*	3157625680791

\* Made-to-order

### SX373

(aluminium oxide)

- Abrasive: Aluminium oxide
- Backing material: Heavy polyester
- Ideal for use on metal and hard wood

# Coated Abrasives



## SY674 (zirconium)

- Abrasive: new needle shape zirconia grain
- Backing material: heavy polyester cloth (YY for coarse grits and Y for 50 and finer)
- Abrasive belt combining a tough grain with optimized fracturing behavior and an improved cutting efficiency
- Recommended for all type of steels, from low to high pressure applications

# Belts

## SY674 ZIRCONIA POLYESTER SANDING BELTS



Dimensions (mm) W x L	Grit	Quantity	Article Number	Barcode
50 x 2000	40	10	66623312442	3157629381946
	60	10	66623312441	3157629381939
	80	10	66623312440	3157629381922
	120	10	66623312455	3157629382011
75 x 2000	36	10	66623312437	3157629381892
	40	10	66623312436	3157629381885
	50	10	66623315784	3157629389645
	60	10	66623312435	3157629381878
	80	10	66623312434	3157629381861
	120	10	66623312413	3157629381106
75 x 2250	40	10	66623315785	3157629389652
	60	10	66623315786	3157629389669
	80	10	66623315787	3157629389676
75 x 2500	36	10	66623312432	3157629381847
	40	10	66623315788	3157629389683
	60	10	66623312431	3157629381823
	80	10	66623312430	3157629381816
	120	10	66623312433	3157629381854
100 x 2000	36	10	66623315789	3157629389706
	40	10	66623315833	3157629390054
	60	10	66623315791	3157629389713
	80	10	66623315792	3157629390023
	120	10	66623315793	3157629390047
150 x 2000	36	10	66623312473	3157629382219
	40	10	66623312472	3157629382202
	60	10	66623312464	3157629382127
	80	10	66623312368	3157629381052

# Coated Abrasives

## Spirabands





# Spirabands

Spirabands are made of Abrasive Cloth which is rolled and glued onto a cotton backing. Spirabands can be used on metals, leather, glass, plastic and wood. They are ideal for paint stripping, surface cleaning and grinder applications. They can be used on electric or pneumatic power tools and must be fitted on the correct size serrated rubber holder.

### MAXIMUM OPERATING SPEED

Size (mm)	MAX RPM
ZSB 10 x 20	36000
ZSB 12 x 25	36000
ZSB 15 x 30	36000
ZSB 19 x 25	30000
ZSB 22 x 20	26000
ZSB 25 x 25	24000
ZSB 30 x 20	19100
ZSB 30 x 30	19100
ZSB 38 x 25	15000
ZSB 45 x 30	12700
ZSB 51 x 25	11200
ZSB 60 x 30	9500

### BENEFITS

- Easy to fit
- Good access to curves / bends
- Excellent blending & deburring tool
- Strong construction gives an aggressive cut however rubber holder gives a forgiving finish
- Cuts down time on operation
- Leaves a great preparation surface
- Band locks on rubber expanding holder – no tools required

## Spirabands

### ZIRCONIA ALUMINA



#### Zirconia alumina

- Quicker removal
- Longer life for use on high alloyed metals, stainless steel, carbon steel and non-ferrous metals

Dimensions (mm) D x W	Grit	Quantity	Article Number	Barcode
10 x 20	36	50	63642584999	3157625582453
	50	50	63642585001	3157625582477
	60	50	63642585002	3157625582484
	80	50	63642585004	3157625582491
	120	50	63642585009	3157625582804
12 x 25	50	50	63642585023	3157625582897
	80	50	63642585024	3157625582927
	120	50	63642585025	3157625582941
	150	50	63642584981*	3157625582606
	180	50	63642584983*	3157625582613
	240	50	63642584984*	3157625582637
15 x 30	36	50	63642585076	3157625583344
	50	50	63642585080	3157625583368
	60	50	63642585081	3157625583375
	80	50	63642585083	3157625583382
	120	50	63642585086	3157625583405
	150	50	66261168258	8711479348099
19 x 25	36	50	63642585026	3157625582958
	50	50	63642585027	3157625582972
	80	50	63642585028	3157625582989
	120	50	63642585030	3157625583009
22 x 20	36	50	63642585012	3157625582811
	50	50	63642585017	3157625582828
	60	50	63642585018	3157625582835
	80	50	63642585019	3157625582859
	120	50	63642585021	3157625582866
	240	50	63642584980*	3157625582583

\* Made-to-order

Dimensions Key: D = Diameter, W = Width

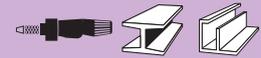


## Zirconia alumina

- Quicker removal
- Longer life for use on high alloyed metals, stainless steel, carbon steel and non-ferrous metals

# Spiralbands

## ZIRCONIA ALUMINA



Dimensions (mm) D x W	Grit	Quantity	Article Number	Barcode
25 x 25	36	50	63642585032	3157625583023
	50	50	63642585033	3157625583047
	80	50	63642585035	3157625583054
	120	50	63642585036	3157625583078
30 x 20	120	50	63642585022*	3157625582873
30 x 30	36	50	63642585088	3157625583429
	50	50	63642585090	3157625583443
	60	50	63642585093	3157625583467
	80	50	63642585095	3157625583474
	120	50	63642585097	3157625583498
38 x 25	36	50	63642585039	3157625583085
	50	50	63642585040	3157625583108
	80	50	63642585041	3157625583115
	120	50	63642585043	3157625583122
45 x 30	36	50	63642585100	3157625583504
	50	50	63642585101	3157625583511
	60	50	63642585102	3157625583528
	80	50	63642585103	3157625583535
	120	50	63642585104	3157625583542
51 x 25	36	50	63642585044	3157625583139
	50	50	63642585046	3157625583146
	80	50	63642585047	3157625583177
	120	50	63642585048	3157625583184
60 x 30	36	50	63642585105	3157625583559
	50	50	63642585107	3157625583573
	80	50	63642585108	3157625583597
	120	50	63642585109	3157625583603
	240	50	63642584996*	3157625582712
75 x 30	50	50	66261168251	8711479155956

\* Made-to-order



## Aluminium oxide

- Application: All types of iron and steel
- Backing material: Cotton

ALUMINIUM OXIDE				
Dimensions (mm) D x W	Grit	Quantity	Article Number	Barcode
10 x 10	80	50	66261168229*	8711479155734
	150	50	66261168225*	8711479155680
10 x 20	50	50	66261168235*	8711479155796
	80	50	66261168192*	8711479155383
	150	50	66261168217*	8711479155628
15 x 30	50	50	63642564259	8711479155291
	80	50	63642565237	8711479155406
	150	50	63642565242	8711479155499
19 x 25	50	50	66261168184	8711479155307
	80	50	66261168195	8711479155413
	150	50	66261168204	8711479155505
22 x 20	50	50	66261168185	8711479155314
	80	50	66261168196	8711479155420
	150	50	63642584977	3157625582569
25 x 25	50	50	66261168226	8711479155697
	80	50	63642569344	8711479155604
	150	50	66261168227	8711479155710
30 x 30	50	50	66261162797	8711479155338
	80	50	63642565251	8711479155444
	150	50	63642584985	3157625582644
	240	50	63642584991*	3157625582668
45 x 30	50	50	66261162798	8711479155345
	80	50	66261168199	8711479155451
	150	50	63642584992	3157625582682
	240	50	63642584993*	3157625582699
60 x 30	50	50	66261162799	8711479155352
	80	50	66261168200	8711479155468
	150	50	63642584995	3157625582705
75 x 30	50	50	66261168190	8711479155369
	80	50	66261168201	8711479155475
	150	50	66261168210	8711479155567
100 x 40	50	50	66261168191	8711479155376
	80	50	66261168211	8711479155574
	150	50	66261168212	8711479155581

\* Made-to-order

Dimensions Key: D = Diameter, W = Width



### Rubber mandrels

- Flexible due to rubber expanding mandrel
- Mandrel diameter 6mm

# Spirabands

## Accessories

### SPIRABAND MANDRELS



Dimensions (mm) D x W x S	Quantity	Article Number	Barcode
10 x 10 x 6	5	07660739758	8711479156410
10 x 20 x 6	5	63642562526	3157625597716
12 x 25 x 6	5	63642562528	3157625597815
15 x 30 x 6	5	63642562530	3157625597822
19 x 25 x 6	5	63642562531	3157625597839
22 x 20 x 6	5	63642562532	3157625597846
25 x 25 x 6	5	63642562533	3157625597853
30 x 20 x 6	5	63642562534	3157625597877
30 x 30 x 6	5	63642562535	3157625597884
38 x 25 x 6	5	63642562536	3157625597891
45 x 30 x 6	5	63642562537	3157625597907
51 x 25 x 6	5	63642562538	3157625597914
60 x 30 x 6	5	63642562539	3157625597921
75 x 30 x 8	5	07660739762	8711479156540
100 x 40 x 8	5	07660739763	8711479156557

# Coated Abrasives

## Quick Change Discs





## Quick Change Discs

The need for small finishing abrasive discs has increased to achieve the high standard of finish required in a modern world. One of the major reasons for the success and growth of these discs is the quick-change ability. Major abrasive users recognise that if a saving of 3 or 4 seconds per disc change can be achieved, the overall daily or weekly reduction in downtime can be enormous.

Quick Change Discs are a range of small abrasive discs ranging in sizes 19mm, 25mm, 38mm, 50mm, 75mm and 100mm. Grits 36-50 are ideal for stock (weld) removal, and grits 60-120 are more suited to the removal of imperfections and blending work. An outstanding quick change sanding disc range for general use applications, including blending light welds, breaking edges and removing parting lines and machine marks. These versatile discs can be used for working mild contours as well as flat surfaces and are most effective when used with pneumatic tools.

### Features

- Quick change fastener
- Twist on and twist off in 2-1/2 turns
- 25mm-75mm SL2 discs – all-metal fasteners
- 25mm-75mm SL3 discs – rubberthreaded hubs
- Small disc sizes

### Benefits

- Quick, tool-free disc changes allow for more grinding time
- Disc locks securely to back-up pad, but is easily removed
- Mount to the appropriate Flexovit Quick Change back-up pad
- Discs can access restricted corners and contours

OPTIMUM TOOL SPEED						
Diameter	Stainless	Aluminium	Mild Steel	Titanium	Glass	Composites
38mm	20000	20000	30000	9000	9000	15000
50mm	15000	15000	20000	7000	7000	10000
75mm	10000	10000	15000	4500	4500	8000

## Attachments/Back-up Pads

Type 2 – SL2



Turn on/turn off system using a metal to metal fixing

Type 3 – SL3



Roll-on/roll-off system using a nylon threaded male button



**Application Tip:** For greater flexibility in contoured applications use a holder one size smaller than the diameter of the disc, e.g. use a 38mm holder with a 50mm disc.

Also use 75mm discs with a 75mm Blue Holder for cost efficient, versatile Quick Change maintenance product on a 115mm angle grinder with an M14 thread.

Other sizes, grain types and grits are available on request to make a wider range of choice for all your Quick Change Disc needs.

## Abrasive Types

### ALUMINIUM OXIDE A/O – ZMD ALOX

Most popular for general applications, mild steel, low carbon steel and other ferrous metals. Good performance and economical. Fast Cutting and long life. Available in Lantuck (edge wear resistance) and X-Cloth (flexibility) lamination. Can be used on flat or contoured surfaces.

### ALUMINIUM OXIDE A/O PLUS – ZMD ALOX PLUS

Economic product for use on steel and alloys, aluminium and heat-sensitive metals. Supersized coating with grinding aids running cooler and more efficiently.

### ZIRCONIA – ZMD ZIR

High stock removal on coarse grits, performs well on stainless steel. Zirconia's inherent feature of cooler cutting when grinding makes it a much more durable and hard wearing grain than aluminium oxide and less likely to discolour stainless steel. Use heavy pressure for optimum performance.

### ZIRCONIA PLUS – ZMD ZIR PLUS

High stock removal with cool action on stainless steel, titanium and nimonics. Supersized coating with grinding aids running cooler and more efficiently. High pressure required to get optimum performance.

### CERAMIC – ZMD CERAMIC

Micron size particles break off during grinding producing many, new, self sharpening cutting points. Very high and fast stock removal on exotic and hard alloys, stainless steel and titanium. Outlasts A/O and Zirconia in many applications. Runs cooler than conventional A/O and Zirconia.

### CERAMIC FIBRE – ZMD FIBRE CERAMIC

The fibre backing makes this product a tough performing disc resisting tearing which allows the product to perform to its optimum. Ceramic is perfect for those applications that require a firm aggressive disc and rapid stock removal. High pressure required for optimum performance.

### FLEXBRITE (NON WOVEN) – ZMD SCM

A non-woven synthetic fibre mesh, impregnated with abrasives and bound with resins – for surface preparation applications such as de-burring, blending, cleaning and corrosion removal. This versatile disc can blend weld seams, remove imperfections on metal surfaces and is ideal for creating decorative finishes. Designed for use where stock removal is not required.

There are three colour coded grades available:

- Brown – Coarse (K46-K60)
- Maroon – Medium (K80-K120)
- Blue – Fine (K180-K240)

For these types see FLEXBRITE section.

### UNITIZED DISCS

Constructed from compressed non woven web, specialised resin and grain to produce high performance finishing products. Excellent for light deburring of flashing and threads, blending alloys, polishing & finishing. Unitized discs are used widely in the preparation of metal surfaces. Unitized discs hold their shape well and do not undercut or gouge which limits accidental damage to the component.

For these types see FLEXBRITE section.

### STRIPPA DISCS – ZMD STRIPPA DISCS

Nylon webbing construction provides a unique combination of aggressive performance, long life and improved finish. Ideal for surface refinishing, cleaning and blending and is a cost effective and safer alternative to a wire wheel. Excellent for rust, paint, scale & coatings removal on a variety of substrates including metal, stone, wood & plastics. Essential maintenance tool in shipyards, heavy plant engineering, steelworks and construction. Particularly efficient in Automotive After Market for removal of fillers and paint stripping. Also use with 75mm Blue Holder for cost efficient, versatile Quick Change maintenance product on a 115mm angle grinder with an M14 thread. For these types see FLEXBRITE section.

For these types see FLEXBRITE section.



## Coated Abrasives



### ALOX

- General purpose use on various steels
- Good performance, economic use
- Long life and good cutting rate
- For use on flat and contoured surfaces



### ZIR

- High stock removal at coarser grits
- Aggressive cut, cool cutting, long life
- Very good results on stainless steel

### ZIR PLUS

- As ZIR supersized with active filler for cool cutting
- Excellent for stainless steel and titanium
- Best results at high pressure

# Quick Change Discs

## Attachment - SL2

### ZMD ALOX SL2

ALUMINIUM OXIDE QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
25	60	100	63642562673	3157625598973
	120	100	63642562676	3157625598997
38	36	100	63642562678	3157625599024
	60	100	63642562684	3157625599048
	120	100	63642562689*	3157625599062
50	36	100	63642562694	3157625599086
	60	100	63642562699	3157625599109
	80	100	63642562701	3157625599116
	120	100	63642562707	3157625599154
75	36	100	63642562711	3157625599178
	60	100	63642562716	3157625599185
	80	100	63642562774	3157625599239
	120	100	63642562722	3157625599222

\* Made-to-order

### ZMD ZIR SL2

ZIRCONIA QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
25	60	100	63642562166	3157625598829
38	36	100	63642556155	3157625598294
	60	100	63642556156	3157625598317
50	36	100	63642561989	3157625598584
	60	100	63642561996	3157625598607
	80	100	63642562000	3157625598621
75	60	100	63642562009	3157625598669
	80	100	63642562012	3157625598683

### ZMD ZIR PLUS SL2

ZIRCONIA PLUS QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
50	36	100	63642562857*	3157625599277
	60	100	63642562859*	3157625599291
75	60	100	63642556158*	3157625598331

\* Made-to-order

## Coated Abrasives



### CERAMIC

- Self sharpening ceramic abrasive
- Aggressive cut, high stock removal
- Very good results on hard alloys, stainless steel and titanium
- Cooler cut compared to conventional abrasives



### ZMD CERAMIC SL2 CERAMIC QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
38	36	100	63642556159*	3157625598348
	60	100	63642562184*	3157625598836
50	36	100	63642556161*	3157625598362
	60	100	63642556162*	3157625598379
75	36	100	63642556164*	3157625598393
	60	100	63642556165*	3157625598409

\* Made-to-order

## Accessories

### BU SL2 BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
25	1	63642562235	3157625598867
38	1	63642562238	3157625598881
50	1	63642562241	3157625598904
75	1	63642562246	3157625598928

## Coated Abrasives



### ALOX

- General purpose use on various steels
- Good performance, economic use
- Long life and good cutting rate
- For use on flat and contoured surfaces

### ALOX PLUS

- As ALOX supersized with active filler for cool cutting
- Good performance on steel, steel alloys, heat sensitive metals and aluminium



### ZIR

- High stock removal at coarser grits
- Aggressive cut, cool cutting, long life
- Very good results on stainless steel

### ZIR PLUS

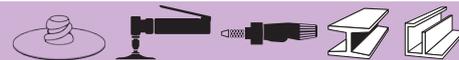
- As ZIR supersized with active filler for cool cutting
- Excellent for stainless steel and titanium
- Best results at high pressure

**flexovit**

# Quick Change Discs

## Attachment - SL<sub>3</sub>

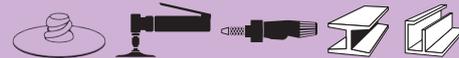
### ZMD ALOX SL<sub>3</sub> ALUMINIUM OXIDE QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
25	60	100	63642562672*	3157625598966
	120	100	63642562677*	3157625599017
38	36	100	6364256119*	3157625598256
	60	100	63642562682*	3157625599031
	120	100	63642562688*	3157625599055
50	36	100	63642562693	3157625599079
	60	100	63642562698	3157625599093
	80	100	63642562702	3157625599123
	120	100	63642562705	3157625599147
75	36	100	63642562710	3157625599161
	60	100	63642562718	3157625599192
	80	100	63642562719	3157625599208
	120	100	63642562721	3157625599215

\* Made-to-order

### ZMD ALOX PLUS SL<sub>3</sub> ALUMINIUM OXIDE PLUS QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
50	36	100	6364256153*	3157625598263
	60	100	6364256154*	3157625598287

\* Made-to-order

### ZMD ZIR SL<sub>3</sub> ZIRCONIA QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
25	60	100	63642562165*	3157625598812
38	36	100	63642561979*	3157625598553
	60	100	63642561982*	3157625598577
50	36	100	63642561990	3157625598591
	60	100	63642561997	3157625598614
	80	100	63642566811	3157625599338
75	36	100	63642562003	3157625598645
	60	100	63642562008	3157625598652
	80	100	63642562011	3157625598676

\* Made-to-order

### ZMD ZIR PLUS SL<sub>3</sub> ZIRCONIA PLUS QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
50	36	100	63642562858	3157625599284
	60	100	6364256157	3157625598324
75	60	100	63642562866	3157625599307

## Coated Abrasives



### CERAMIC

- Self sharpening ceramic abrasive
- Aggressive cut, high stock removal
- Very good results on hard alloys, stainless steel and titanium
- Cooler cut compared to conventional abrasives



### QUICK CHANGE CONVERSION KIT

- Instantly convert a 115mm Angle Grinder into a multipurpose grinding & blending tool for both on and off-site maintenance work



### ZMD CERAMIC SL<sub>3</sub> CERAMIC QUICK CHANGE DISCS



Diameter (mm)	Grit	Quantity	Article Number	Barcode
38	36	100	63642556160*	3157625598355
	60	100	63642562185*	3157625598843
50	36	100	63642556163	3157625598386
	60	100	63642562029	3157625598706
75	36	100	63642562271	3157625598942
	60	100	63642556166	3157625598416

\* Made-to-order

### QUICK CHANGE CONVERSION KIT

MAKE YOUR ANGLE GRINDER INTO A MORE VERSATILE TOOL

Diameter (mm)	Grit	Quantity	Article Number	Barcode
KIT		1	69957348082	

## Accessories

### BU SL<sub>3</sub> BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
25	1	63642562236	3157625598874
38	1	63642562239	3157625598898
50	1	63642562244	3157625598911
75	1	63642562247	3157625598935

### BU M14/SL<sub>3</sub> BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
75	1	63642568065	3157625581906



# Coated Abrasives

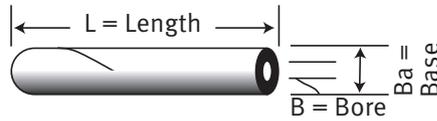
## Cartridge Rolls





## Cartridge Rolls

Cartridge Rolls are made up of rolls of Resin Bond Abrasive Cloth which allow a new cutting surface to be uncovered as the top layer is worn away. They are available in 2 different shapes and in a wide variety of sizes and grades. Cartridge Rolls are suitable for a range of applications including flash removal, polishing, edge breaking and removing machine tool marks. They are also especially good for reaching into corners. They are available in Aluminium Oxide – with a resin bond and also to special order in Silicon Carbide. Many operations use straight cartridge and spiral rolls together. They are more flexible than a bonded mounted point and cause less chatter marks than a spiraband.



### Aluminium Oxide Straight Cartridge Rolls – ZPE Alox

- Straight with no taper. Most popular
- Wears to shape required
- For sanding and polishing channels, fillets, recesses, side walls and bottoms of dead-end holes
- Metal channels
- Fillets
- Recesses
- Contours
- Bottoms of dead end holes
- Removing parting lines, imperfections and burrs
- Deburring stampings and dies
- Corners
- Tight radii
- Angles



### Aluminium Oxide Tapered Cartridge Rolls – ZSPI Alox

- Taper from tip to base
- Particularly adaptable to grinding/polishing of channels, fillets, radii and small contours of metal parts

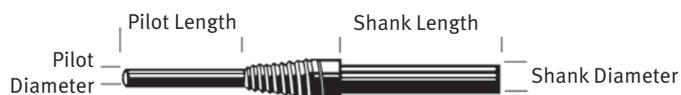




## Accessories

### CARTRIDGE ROLL MANDRELS – FOR ZPE/ZSPI

Precision machined from high quality steel featuring sharp course threads which hold rolls securely in place during operation. They also have a good lead in thread allowing the roll to start easily on the mandrel.



Pilot length should be 6-12mm shorter in length than the Cartridge Roll.  
The Mandrel Pilot diameter should match the size of the Cartridge Roll Pilot Hole.  
Always insert glued end first onto Mandrel.

#### RECOMMENDED PILOT LENGTH FOR CARTRIDGE ROLLS

19mm Cartridge Roll Length	Use 13mm Pilot
25mm Cartridge Roll Length	Use 19mm Pilot
38mm Cartridge Roll Length	Use 25mm Pilot
50mm Cartridge Roll Length	Use 38mm Pilot

#### MAXIMUM RPM'S

3mm to 12mm dia	16000-23000 maximum RPM
16mm to 25mm dia	12000-18000 maximum RPM
25mm to 38mm dia	10000-15000 maximum RPM



# Cartridge Rolls

## Aluminium Oxide Cartridge Roll Kit – ZPE/ZSPI Alox

- Trial kits available to purchase – allow testing of a variable range of shapes, grits and sizes



This 69957383465 kit contains:

Type	Dimensions (mm)	Grit	Quantity
ZPE	10 x 38 x 3	80	6
ZPE	10 x 38 x 3	120	6
ZPE	13 x 38 x 3	80	4
ZPE	13 x 38 x 3	120	4
ZPE	6 x 38 x 3	80	12
ZPE	6 x 38 x 3	120	12
ZPE	6 x 25 x 3	80	8
ZPE	6 x 25 x 3	80	8
ZPE	6 x 25 x 3	120	8
ZPE	6 x 25 x 3	120	8
ZPE	10 x 25 x 3	80	6
ZPE	10 x 25 x 3	120	6
ZPE	10 x 38 x 3	80	6
ZPE	10 x 38 x 3	120	6
ZPE	13 x 38 x 3	80	4
ZPE	13 x 38 x 3	120	4
ZSPI	13 x 38 x 3	80	6
ZSPI	10 x 38 x 3	80	9
CRM 4	3.2 x 19 x 6	Mandrel	1
CRM 5	3.2 x 25 x 6	Mandrel	1

# Coated Abrasives

## ZPE

### ALUMINIUM OXIDE STRAIGHT CARTRIDGE ROLLS



Dimensions (mm) Ba x L x B	Grit	Mandrel	Quantity	Article Number	Barcode
6 x 25 x 3.2	80	CRM4	100	63642562285	3157625599741
	120	CRM4	100	63642562286	3157625599758
6 x 38 x 3.2	80	CRM5	100	63642562287	3157625599765
	120	CRM5	100	6364256508	3157625599697
	150	CRM5	100	63642562289*	3157625599772
10 x 25 x 3.2	80	CRM4	100	63642562292	3157625599796
	120	CRM4	100	63642562293	3157625599802
10 x 38 x 3.2	60	CRM5	100	63642562294	3157625599819
	80	CRM5	100	63642562295	3157625599826
	120	CRM5	100	63642562296	3157625599833
13 x 25 x 3.2	80	CRM4	100	63642566646*	3157625600034
13 x 38 x 3.2	80	CRM5	100	63642562299	3157625599864
	120	CRM5	100	63642562300	3157625599871
16 x 38 x 4.8	80	CRM7	100	63642562301*	3157625599888
19 x 25 x 4.8	80	CRM6	100	63642562302*	3157625599895
19 x 50 x 4.8	80	CRM8	100	63642562305*	3157625599918

\* Made-to-order



## ZSPI

### ALUMINIUM OXIDE TAPERED CARTRIDGE ROLLS



Dimensions (mm) Ba x L x B	Grit	Mandrel	Quantity	Article Number	Barcode
10 x 25 x 3.2	60	CRM4	100	63642562291	3157625599789
13 x 38 x 3.2	80	CRM5	100	63642562369	3157625599925
13 x 38 x 3.2	120	CRM5	100	63642562379*	3157625599949
19 x 25 x 4.8	80	CRM6	100	63642562381*	3157625599956
19 x 38 x 3.2	80	CRM5	100	63642562383*	3157625599963

\* Made-to-order



## ZPE/ZSPI

### ALUMINIUM OXIDE CARTRIDGE ROLL KIT



Dimensions (mm) Ba x L x B	Specification	Quantity	Article Number	Barcode
For content see page opposite	125 Cartridge roll kit and 2 mandrels	1	69957383465	3157625624689

## Accessories

### MANDRELS ZPE/ZSPI



Dimensions (mm) Ba x L x B	Mandrel	Quantity	Article Number	Barcode
3.2 x 19 x 6	CRM4	1	63642562516	3157625599987
3.2 x 25 x 6	CRM5	1	63642562517	3157625599994
4.8 x 19 x 6	CRM6	1	63642562518	3157625600003
4.8 x 25 x 6	CRM7	1	63642562519	3157625600027
4.8 x 38 x 6	CRM8	1	6364256513	3157625599727



Dimensions Key: Ba = Base Diameter, L = Length, B = Bore



# Flexbrite Non-Woven Abrasives



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# Technical Information

## Flexbrite Non-Woven Abrasives

Flexovit offers a broad range Flexbrite non-woven abrasives for cleaning, finishing and polishing operations. Flexbrite products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic and non-rusting.

Flexbrite products are an ideal completion to the Flexovit Coated Abrasive Range. Our new extended Surface Blending line provides a unique combination of aggressive performance, good lifetime and excellent finish. The broad range of shapes, types, abrasives, grit sizes and densities results in a product that can be used on a wide variety of surfaces for various applications.

ABRASIVES		
Aluminium Nickel Zinc Ceramics Fibreglass	Brass Chromium Titanium Glass Wood	Copper Stainless steel Tantalum Plastic Plywood
APPLICATIONS		
Deburring Scouring Highlighting Dulling laminates Rubbing sealers	Cleaning Blending De-flashing plastics Removing oxides & rust Removing raised wood fibres & imparting satin finishes	Scrubbing Polishing De-fussing plywood Scuffing paint before repaint

Flexbrite products often prove to be the most cost efficient and effective means of getting the job done with superior results. Used wet or dry, Flexovit Flexbrite products offer:

- A predictably consistent, uniform finish
- Minimal smearing & discoloration of workpieces
- Comfortable & easy to use
- Conformability to irregular surfaces

These advantages make Flexbrite products an excellent alternative to set-up wheels, greaseless compounds, and steel wool.

## Specification Parameters Abrasives

Flexbrite products are manufactured using either silicon carbide or aluminium oxide abrasive grain. Silicon Carbide is a hard, sharp, brittle abrasive grain which tends to break down under pressure. It is sharper, tends to cut faster and produces finer scratch patterns on most surfaces. Aluminium oxide is a tough, blocky abrasives that is more durable than silicon carbide and tends to last longer, produce less discoloration on aluminium, and be more aggressive on certain applications such as hardened steel parts.



## Grits

The 'grit' refers to the particle size of the abrasive grain. Use of large particles results in a Flexbrite product that acts more aggressively and produces a coarse surface finish. Two systems are currently in use. Some products use the actual mesh number of the screen used to grade the particle size. Mesh numbered Flexbrite products are available in 1000, 600, 320, 240, 220, 180, 150, 120, 100, 80, 60 and 40 grit sizes. Other Flexbrite products use a 'simplified' grading system. These products are available in micro fine, ultra fine, very fine, fine, medium and coarse, in sequence from smallest to largest particle size.

The following chart provides a comparison between these two grading systems:

Simplified Grading	Mesh Numbers
Micro Fine (MF)	1000
Ultra Fine (UF)	600-800
Very Fine (VF)	280-360
Fine (F)	180-240
Medium (M)	100-150
Coarse (C)	40-80

In any specific given product shape, only those grits are available which are deemed suitable for the intended applications of these products.

## Densities

The 'density' refers to the number of fibres which have been compressed on to the nylon web material. 'Hard' density wheels cut faster, last longer and produce finer finishes than medium density wheels which offer greater conformability and less tendency to load the workface. Flexbrite Series 1000, 2000 and 4000 wheels offer anywhere from 2 to 4 density ranges, thereby providing the maximum in soft to hard density alternatives.

## Bonds

Waterproof resins are used throughout the manufacture of Flexbrite web material to bond the nylon fibres together and to firmly anchor the abrasive grains throughout the web. A variety of resins are used in order to obtain different levels of softness (or hardness), toughness and flexibility thereby making different products suitable for different applications.



# Flexbrite Non-Woven Abrasives

## Flat Stock





## Flat Stock

Flexovit Flexbrite Hand pads, discs and rolls are ideal for a broad range of hand applications from cleaning and finishing to deburring and light polishing operations used in many industries.

The flexible action produces consistent, uniform contact with the work surface and prevents cutting or gouging of the workpiece.

CHARACTERISTICS (IN ORDER OF DECREASING AGGRESSIVENESS)					
GRADE	TARGET SUBSTRATE	APPLICATION / MARKETS	FEATURES / BENEFITS / ADVANTAGE		
F2302 Extra Cut Dark Tan Alum/Oxide	Stainless Steel - all metals	Heavy duty Oxide rust removal, blending, deburring. Grain finishing and weld bluing removal on Stainless Steel	Most aggressive Hand Pad, very durable, good life time, replaces coated abrasives, steel wool, wire brushes. Stiff and coarse	Coarser acting for general cleaning	
F2300 Medium A Maroon Alum/Oxide	Metals, Ceramics	First selection for cleaning. Overall cleaning/deburring, rust & coating removal	Strong and open construction, resistant to loading, good lifetime - provides Matt Satin finishing	↑ ↓	
F2401 Fine A Maroon Alum/Oxide	Wood working / plastic	Cleaning and intermediate finish on Ferrous and non ferrous metals (e.g. Brass), defuzzing of wood / denibbing lacquers, paints and plastic	Slightly coarser and stiffer than Very Fine, provides a nice matt satin finish on various surfaces		
F2520 Very Fine A Maroon Alum/Oxide	Metal working, AAM - Car body repair - wood working / plastic	Rust removal, Automotive primer keying, defuzzing of wood / denibbing plastic	Conformable pad, provides excellent and consistent finishing results for a variety of applications		
F2504 Very Fine A Long Life Maroon Alum/Oxide	Metal working, AAM - Car body repair - wood working / plastic, General Purpose	Rust removal, Automotive primer keying, defuzzing of wood / denibbing plastic. Light sanding old paint, new primers	Fast initial cut, moderate flexibility with edge durability on demanding applications, provides excellent and consistent finishing results for a variety of applications. No colour bleeding when working with solvents		
F2510 Gen Purpose Clean & Scour Green Alumina Silicate	Metals, plastic	General purpose cleaning 'Potscrubbing'. Preparation for painting. Sanitary preparation of work surfaces, removal of light stains and oxidation marks on metal surfaces.	Durable nylon web, low cost, advanced performance at an economical price		
F4300 Medium S Dark Grey Silicon Carbide	Stainless Steel	Satin finishing, cleaning glass moulds. Grain finishing and weld bluing removal on Stainless steel - giving a bright finish.	Resilient and conformable to irregular surfaces		
F4804 / F4807 Ultra Fine S Grey Silicon Carbide	Metal working, AAM - Car body repair - wood working / plastic / Fibreglass	Keying of Clear coat / finishing of metal / deburring plastics, Finishing Aluminium doors and windows, blending paint, scuffing varnishes and keying acrylic coatings	Perfect for light cleaning, de-nibbing between finish coats and metal finishing		
F2801 Micro Fine Gold Calcined Alumina	Metals, Wood, Car bodywork	Final Shine Pad for most polishing or final rub applications. Keying of clear coat (lacquer)	Produces the highest quality surface finish. Good for precious metals		
F0001 White Cleaning White None	Nearly all substr. i.e. composites, metal, plastic, glass & ceramics	Light cleaning & polishing, light primer rub down, wood highlighting and rubbing	Highly conformable, tear resistant, use with liquid detergents. Provides paint overspray removal		Finer acting for light scuffing & blending

All material can be converted to different shapes – rolls, sheets, pads and discs



## Hand Pads & Discs

### Hand pads



Dimensions (mm) W x L	Grade	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
152 x 229	Extra Cut	Aluminium Oxide	Dark Tan	F2302	40***	63642558441	3157625582675
	Medium	Aluminium Oxide	Maroon	F2300	60***	63642558442	3157625582736
	Fine	Aluminium Oxide	Maroon	F2401	60**	63642558443	3157625582729
	Very Fine	Aluminium Oxide	Maroon	F2504	60**	66261018452	3157625598133
	Gen/Purpose Clean & Scour	Aluminium Oxide	Green	F2510	60**	66261018453	3157625598157
	Medium	Silicon Carbide	Black	F4300	60***	66261039803	3157625919716
	Ultra Fine	Silicon Carbide	Grey	F4804	60***	63642586014	3157625597747
	Ultra Fine	Silicon Carbide	Grey	F4807	60***	77696046255	3157629541838
	White Cleaning	None	White	F0001	60**	63642585982	3157625596238

\*\* 20 pads per pack

\*\*\* 10 pads per pack

### Perforated Hand pads



Dimensions (mm) W x L	Grade	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
152 x 229	Very Fine Long Life	Aluminium Oxide	Maroon	F2504	60	63642586016	3157625597754
	Ultra Fine	Silicon Carbide	Grey	F4807	60	63642586022	3157625597761

### Plain Discs



Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
150	Very Fine	Aluminium oxide	Maroon	F2520	10	63642558444*	3157625582743
	Ultra Fine	Silicon Carbide	Grey	F4804	10	63642558445*	3157625582767

\* Made-to-order





# Flat Stock

## Rolls

### Slit Rolls



Dimensions W x L	Grade	Abrasive	Colour	Cap Code	Quan- tity	Article Number	Barcode
100mm x 10M	Medium	Aluminium Oxide	Maroon	F2300	2	63642558446	3157625582842
	Fine	Aluminium Oxide	Maroon	F2401	2	63642586034	3157625597778
	Very Fine Long Life	Aluminium Oxide	Maroon	F2504	2	63642586040	3157625597785
	Very Fine A	Aluminium Oxide	Maroon	F2520	2	63642586370	3157625598119
	Ultra Fine	Silicon Carbide	Grey	F4601	1	07660739661*	8711479344510
	Ultra Fine	Silicon Carbide	Grey	F4804	2	63642558447	3157625582903
115mm x 10M	Coarse	Aluminium Oxide	Maroon	F2200	1	07660739670	8711479145902
	Medium	Aluminium Oxide	Maroon	F2309	1	66261163601	8711479145865
	Fine	Aluminium Oxide	Maroon	F2400	1	66261164137	8711479145919
	Very Fine	Aluminium Oxide	Maroon	F2500	1	07660739658	8711479145858
	General Purpose	Aluminium Oxide	Green	F2523	2	63642515711	3564653761628
	Ultra Fine	Silicon Carbide	Grey	F4600	1	07660739660	8711479145872
125mm x 10M	Medium	Aluminium Oxide	Maroon	F2300	2	63642558448	3157625582934
	Fine	Aluminium Oxide	Maroon	F2401	2	63642586041	3157625597792
	Very Fine Long Life	Aluminium Oxide	Maroon	F2504	2	63642586042	3157625598102
	Very Fine A	Aluminium Oxide	Maroon	F2520	2	63642586371	3157625598126
	Ultra Fine	Silicon Carbide	Grey	F4802	2	63642558449	3157625582965
150mm x 10M	Very Fine Long Life	Aluminium Oxide	Red	F2504	2	63642586045	3157625595927
	Ultra Fine	Silicon Carbide	Grey	F4804	2	63642558450	3157625582996

\* Made-to-order

# Flexbrite Non-Woven Abrasives

Surface  
Blending  
Discs & Belts





## Surface Blending – Discs & Belts

Flexovit offers a new extended range of Surface Blending Material. With the two new grades Extra Coarse and Super Fine covers that range application from aggressive but controlled cutting action over deburring, cleaning and blending right through to a superb finish on hard and soft metals, ideal for pre-polishing. Surface Blending Material ensures a long lifetime plus an added benefit of consistent performance. It is very resistant to loading and clogging. The material is very user friendly and the risk to damage the workpiece is reduced.

### Product Key Benefits:

- Fast cutting
- Conformable and forgiving
- Resistant to loading and clogging
- Long life time
- Low stretch backing for belts and discs
- Consistent finish

#### WHICH GRADE SHOULD I USE ?

Extra Coarse	Provides longest cutting life and highest aggressiveness to quickly achieve an even surface ready for finer finishing. Ideal for de-scaling and removing heavy rust and oxides.
Coarse	Ideal where a less coarse finish or increased flexibility, is required and an aggressive cut is necessary.
Heavy Medium	A fast cutting grade, for many applications where a finish slightly coarser than a standard medium is acceptable. Combines an excellent cut and finish ratio.
Medium	Achieves a good medium finish. Best choice for controlled results on softer materials, or expensive alloys.
Very Fine	Provides an excellent and uniform finish, ideal choice for fine finishing and pre-coat finishing.
Super Fine	The finest and most flexible Surface Conditioning for decorative finishes and excellent surfaces, on soft and hard metals, ideal for pre-polishing.

#### SURFACE CONDITIONING BELTS

##### Following Speed Recommendations should be observed

Decorative finishing	2.5m/s - 14m/s
Wood sanding	6m/s - 14m/s
Deburring	25m/s - 33m/s
Cleaning	10m/s - 25m/s
Oxide removal	23m/s - 33m/s

**Maximum Operation speed is 33m/s**

#### SURFACE CONDITIONING DISCS

Diameter (mm)	Maximum RPM
115	13000
125	10000
150	8000
178	6000



## SELECTING THE RIGHT PRODUCT

Industry	Application	Products
<b>Surface Blending Material</b>		
Aerospace, OEM and Maintenance	Weld blending / Cleaning of components: Turbine blades prior to inspection / Removing coatings during maintenance work on fuselage and wings in awkward areas / Finishing of turbine blades	Belts, discs, quick change discs (small sizes are ideal to reach hard to access areas on Aeroplanes)
Strip Metal Manufacturer	Finishing of strip metal as a final step after coated abrasive belts / Cleaning the rollers of strip metal manufacturing machines	Belts – grade medium & very fine
Marine	Cleaning & maintenance of ships, propellers etc / Finishing, blending welds on steel, brass and aluminium	Belts, discs, quick change discs – all grades
Automotive	Weld blending & finishing body in white irregular shaped surfaces / Removing paint & coatings / Blending out coated grind line scratches / Prepare panels for painting	Discs quick change discs, mainly coarse, medium & very fine
Sink Manufacture	Finishing of stainless steel sinks	Mainly belts – all grades
Chinaware	Smoothing the bottom of plates & cups	Belts – grade very fine
Ski Manufacturer	Finishing of edges – laminates / Surface smoothing	Belts
Stainless Steel Fabrication	Weld Blending / Surface finishing	Belts, discs
Rail	Cleaning & finishing of aluminium rail carriages / Weld blending	Discs, coarse, medium, very fine
Food Preparation Surfaces	Finishing	Belts, discs, all grades
Architectural Steelwork	Cleaning & finishing weld joints	Discs, belts, coarse medium
Metal Fittings, Plates	Achieving a decorative finish on door fittings, door handles etc.	Belts, very fine, super fine
Cutlery	Surface finishing	Belts – medium & very fine



# Surface Blending – Discs & Belts

## Discs

### SURFACE BLENDING

HOOK AND LOOP BACKING (WITH REMOVABLE 22mm CENTRE HOLE)



Diameter (x Hole) (mm)	Grade	Abrasive	Colour	Cap Code	Quan- tity	Article Number	Barcode
115 (x 22)	Extra Coarse	ALOX	Black	S2108	20	63642558451	3157625583061
	Coarse FB*	ALOX	Brown	S2211	20	63642558452	3157625583092
	Coarse	ALOX	Tan	S2208	20	63642558453	3157625583153
	Medium	ALOX	Red	S2308	20	63642586051	3157625596245
	Fine	ALOX	Green	S2408	20	77696068722	3157629543849
	Very Fine	ALOX	Blue	S2508	20	63642586055	3157625596252
	Super Fine	SIC	Grey	S4713	20	63642586057	3157625596269
125 (x 22)	Extra Coarse	ALOX	Black	S2108	20	63642586061	3157625596276
	Coarse FB*	ALOX	Brown	S2211	20	63642586064	3157625596283
	Coarse	ALOX	Tan	S2208	20	63642586066	3157625596306
	Medium	ALOX	Red	S2308	20	63642586072	3157625596313
	Fine	ALOX	Green	S2408	20	77696068721	3157629543856
	Very Fine	ALOX	Blue	S2508	20	63642586075	3157625596337
	Super Fine	SIC	Grey	S4713	20	63642586077	3157625596344
178 (x 22)	Extra Coarse	ALOX	Black	S2108	10	63642586080	3157625596351
	Coarse FB*	ALOX	Brown	S2211	10	63642586083	3157625596368
	Coarse	ALOX	Tan	S2208	10	63642586087	3157625596375
	Medium	ALOX	Red	S2308	10	63642586089	3157625596382
	Fine	ALOX	Green	S2408	10	77696068723	3157629543863
	Very Fine	ALOX	Blue	S2508	10	63642586092	3157625596399

FB\* = Fibre backed and with 22mm hole  
(for a stiffer, higher performing disc)

\* Made-to-order



## Accessories

### BACK-UP PADS M14 ATTACHMENT



Diameter (mm)	Quantity	Article Number	Barcode
115	1	69957382846	3157625621084
125	1	69957382841	3157625621046
178	1	69957382844	3157625621077

### BACK-UP PADS (M14 ATTACHMENT) FOR FIBRE DISCS



Diameter (mm)	Product Material Type	Density	Quantity	Article Number	Barcode
115	Nylon	Medium	5	69957382815	3157625620667
	Nylon	Hard	1	69957382818	3157625620698
	Air cool rubber	Hard	1	69957382821	3157625620728
125	Nylon	Medium	5	69957382816	3157625620674
	Nylon	Hard	1	69957382819	3157625620704
	Air cool rubber	Hard	1	69957382823	3157625620735
180	Nylon	Medium	5	69957382817	3157625620681
	Nylon	Hard	1	69957382820	3157625620711
	Air cool rubber	Hard	1	69957382824	3157625620742

## Belts

### MADE TO ORDER

PLEASE CONTACT YOUR LOCAL SALES REPRESENTATIVE FOR FURTHER INFORMATION

Available Grade	Power File Belts	Machine Belts	Wide Belts up to 1400mm
Extra Coarse		●	●
Heavy Medium		●	●
Coarse		●	●
Medium	●	●	●
Very Fine	●	●	●
Super Fine	●	●	●

#### USAGE KEY

● available



# Flexbrite Non-Woven Abrasives

Quick  
Change  
Discs





## Quick Change Discs

From cleaning and stripping through to final finishing just with one system. Just with one turn, discs can be changed easily. No slipping, no sticking and always centrally running. Provides the result of comfortable work and less downtime for tool changes.

### OPTIMUM TOOL SPEED (RPM) FOR MAXIMUM DISC CUT RATE AND LIFE

Diameter	Stainless	Aluminium	Mild Steel	Titanium	Glass	Composites
50mm	15000	15000	20000	7000	7000	10000
75mm	10000	10000	15000	4500	4500	8000

The operational speed is governed by the application and product size

### SELECTING THE RIGHT PRODUCT

Industry	Application	Products
Aerospace Maintenance	Removing coatings during maintenance work on fuselage & wings in awkward areas / Cleaning weld lines	50 & 75mm coarse and medium surface bendy discs
Marine	Cleaning of hulls / Finishing of aluminium castings	50 & 75mm Flexclean unitized discs
Automotive	Accessing hard to reach areas, under the bonnet, door frames etc / Removing of stone chip coatings	50 & 75mm Flexclean unitized discs
Composites	Removal of squeezed excessive glue	Unitized & surface blending discs
Wood	Removal of old paint & coatings from wooden surfaces – frames etc.	Flexclean & surface blending
Food Processing	Surface Finishing	Discs
Architectural Steelwork	Cleaning & Finishing of weld joints / Achieving decorative finishes	Unitized & surface blending discs



## Discs

### SURFACE BLENDING SL<sub>2</sub>



- Remove scratch marks and blend surface free of grinding defects

Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
50	Coarse	Alox	Tan	S2208	23000	50	63642562112	3157625598737
	Medium	Alox	Red	S2308	23000	50	63642562113	3157625598744
	Very Fine	Alox	Blue	S2508	23000	50	63642562116	3157625598775
	Super Fine	SIC	Grey	S4713	23000	50	63642587660	3157625606241
75	Coarse	Alox	Tan	S2208	18000	50	63642556177	3157625598522
	Medium	Alox	Red	S2308	18000	50	63642556176	3157625598515
	Very Fine	Alox	Blue	S2508	18000	50	63642556175	3157625598508
	Super Fine	SIC	Grey	S4713	18000	50	63642587665	3157625606289

### SURFACE BLENDING SL<sub>3</sub>



- Remove scratch marks and blend surface free of grinding defects

Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
50	Coarse	Alox	Tan	S2208	23000	50	63642562110	3157625598713
	Medium	Alox	Red	S2308	23000	50	63642562114	3157625598751
	Very Fine	Alox	Blue	S2508	23000	50	63642562115	3157625598768
	Super Fine	SIC	Grey	S4713	23000	50	63642586187*	3157625596474
75	Coarse	Alox	Tan	S2208	18000	50	63642562119	3157625598782
	Medium	Alox	Red	S2308	18000	50	63642562121	3157625598799
	Very Fine	Alox	Blue	S2508	18000	50	63642562123	3157625598805
	Super Fine	SIC	Grey	S4713	18000	50	63642586191*	3157625596511

\* Made-to-order

## Flexbrite Non-Woven Abrasives



## Quick Change Discs

### FLEXCLEAN SL3



- For aggressive rust, paint, scale & corrosion removal

Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
50	Extra Coarse	SIC	Black	R4101	15000	10	63642588152	3157625619302
75	Extra Coarse	SIC	Black	R4101	12000	10	63642588157	3157625619319

### ZMD STRIPPA DISCS SL3



- For rust, paint, scale & corrosion removal

Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
50	Extra Coarse	SIC	Black	R4104	15000	10	63642557677	3157625598539
75	Extra Coarse	SIC	Black	R4104	12000	10	63642557678	3157625598546

### UNITIZED DISCS SL3



- For deburring, blending and finishing

Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
50	2 FINE	SIC	Grey	U4401	18000	10	63642586194	3157625595842
	4 FINE	Alox	Grey	U2401	18000	10	63642586195	3157625596528
	2 MED	Alox	Grey	U2301	18000	10	63642586197	3157625596535
	6 MED	Alox	Grey	U2301	22100	10	63642586198	3157625596542
75	2 MED	SIC	Grey	U4401	12100	10	63642586199	3157625596559
	4 FINE	Alox	Grey	U2401	12100	10	63642586212	3157625596566
	2 MED	Alox	Grey	U2301	12100	10	63642586213	3157625596573
	6 MED	Alox	Grey	U2301	18000	10	63642586214	3157625596597

## Accessories

### BU SL2

#### BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
50	1	63642562241	3157625598904
75	1	63642562246	3157625598928

### BU SL3

#### BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
50	1	63642562244	3157625598911
75	1	63642562247	3157625598935

## Convert 115mm Angle Grinder to run 75mm Discs

### BU M14/SL3

#### BLUE NYLON - HOLDER



- Nylon pad with M14 thread to mount onto Angle Grinder spindle
- Light Maintenance

Diameter (mm)	Quantity	Article Number	Barcode
75	1	63642568065	3157625581906

### BU M14/SL3

#### RUBBER - HOLDER



- Rubber pad with M14 thread to mount onto Angle Grinder spindle
- Heavy Duty

Diameter (mm)	Quantity	Article Number	Barcode
75	1	63642562270	3157625615533

# Flexbrite Non-Woven Abrasives

## Flexclean Discs



## Flexbrite Non-Woven Abrasives



## Flexclean Discs

### SELECTING THE RIGHT PRODUCT

Industry	Application	Products
<b>Flexclean Discs, Fibre Backed and Discs SL4 Fitting</b>		
Pharmaceutical industry	Removing weld blueing and oxide on stainless steel vessels	100mm discs
Cast iron	Removing of old gasket material on cylinder heads of diesel engines	115mm Flexclean SL4 discs
Automotive	Removing of stone chip coating, paint and rust	115mm Flexclean SL4 discs
Stainless steel fabricators	Weld blending / Removing of imperfections / Blending spot welds	115mm Flexclean SL4 discs
Stainless steel fabricators	Grain finishing on sheets	Flexclean spindle mounted discs
<b>Quick Change SL4 Discs</b>		
Automotive Marine Maintenance	Excellent for removal of rust, undercoating, seam sealers and stone guards / Can get into hard to reach areas like wheel wells and under carriage / Use in trunk beds and door jambs / Use to remove oxidation from tire rims and to remove rust from brake assemblies	Flexclean SL4 discs



## Discs

### STANDARD WHEELS WITH CENTRE HOLE



Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
100 x 12	Extra Coarse	SIC	Black	R4101	8000	25	63642586215	3157625596603
150 x 12	Extra Coarse	SIC	Black	R4101	5500	15	63642586216	3157625596627
200 x 12	Extra Coarse	SIC	Black	R4101	4500	5	63642586218	3157625596634

### HOOK & LOOP BACKING



Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
125	Extra Coarse	SIC	Black	R4101	10000	10	63642586221*	3157625596658
150	Extra Coarse	SIC	Black	R4101	8000	10	63642587597*	3157625605176

\* Made-to-order

### FIBREGLASS BACKING DEPRESSED CENTRE T27



Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
115	Extra Coarse	SIC	Black	R4104	11000	10	63642586224	3157625596689
125	Extra Coarse	SIC	Black	R4104	9800	10	63642586225	3157625596696
178	Extra Coarse	SIC	Black	R4104	6500	5	63642586226	3157625596702
115	Extra Coarse	SIC	Black	R4101	12000	10	77696005105	3157629543931
125	Extra Coarse	SIC	Black	R4101	12000	10	77696019798	3157629543948

### SL4 WHEEL



Diameter (mm)	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
100	Extra Coarse	SIC	Black	R4101	8000	5	63642586228	3157625596719

### SPINDLE MOUNTED



Type	Dimensions (mm) D x T x S	Grade	Abrasive	Colour	Cap Code	Max RPM	Quantity	Article Number	Barcode
Small Area (1 disc)	75 x 13 x 6	Extra Coarse	SIC	Black	R4101	10000	10	63642586229	3157625596726
	100 x 13 x 6	Extra Coarse	SIC	Black	R4101	8000	10	63642586235	3157625596733
	150 x 13 x 8	Extra Coarse	SIC	Black	R4101	6000	5	63642586238	3157625596757
Large Area (2 discs)	75 x 25 x 6	Extra Coarse	SIC	Black	R4101	10000	5	63642586242	3157625596764
	100 x 25 x 6	Extra Coarse	SIC	Black	R4101	8000	5	63642586243	3157625596771
	150 x 25 x 8	Extra Coarse	SIC	Black	R4101	6000	5	63642586245*	3157625596788

\* Made-to-order

Dimensions Key: D = Diameter, T = Thickness, S = Spindle



# Flexclean Discs

## Accessories

### MANDRELS FOR FLEXCLEAN DISCS

PLUS SETS OF WASHERS FOR 12mm BORE, DISC WIDTH 13mm



Diameter (mm)	Shank diameter	Quantity	Article Number	Barcode
up to 150mm	6mm	1	07660707022	3157622826444
up to 200mm	8mm	1	07660707023	3157622928193

### BU SL4

BACK-UP PAD



Diameter (mm)	Cap Code	Quantity	Article Number	Barcode
100	R4101	1	63642586196	3157625595835

# Flexbrite Non-Woven Abrasives

## Flap Wheels & Brushes





## Flap Wheels & Brushes

Flexovit Flap Wheels and brushes are available in a wide range of abrasives, grits and densities. Flap wheels and brushes are used in many industries, from metal working to wood working. Flexbrite Flap Wheels are suitable for a variety of applications, from surface cleaning through to satin finishing and light deburring. The different densities make the products very versatile: from soft densities that give cushioning actions ideal for use on uneven or irregular surfaces, to hard densities ideal for cleaning and finishing metal.

### Flap Brushes

#### SELECTING THE RIGHT PRODUCT

Type	Industry	Application
Wide faced brushes	Strip metal	Cleaning / Finishing
	Wood chip board	De-fuzzing

**Advantages:** Flexbrite brushes have different densities and are interleaved with coated abrasives giving significant benefits over other types of abrasives.

### Flap Wheels

#### APPLICATION FLAP WHEELS

Type	Industry	Application
Flap Wheels all densities	Architectural hardware	Finishing brass aluminium & steel / Sateen finishing
	Cast Iron	Removing old gasket materials on cylinder heads of diesel engines
	Automotive	Removing stonechip coating, paint & rust
	Stainless Steel fabricators	Weld blending / Removing of imperfections / Blending spot welds
	Stainless Steel fabricators	Grain finishing on sheets

**Advantages:** Flexbrite Flap Wheels not only works well on flat areas, but is also ideal for use in finishing operations on uneven surfaces. They are especially suitable where they need to adjust to the surface and give a uniform finish. When used on most metals, A/O (Aluminium Oxide) Flap Wheels will produce a long line scratch pattern with a dull satin, matt type, finish. The SIC (Silicon Carbide) Flap Wheels will produce a long scratch finish with a semibright, matt type, finish.

# Flap Wheels

## FLANGE MOUNTED



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
150 x 20 x 25	Coarse	ALOX	PBF D05	1	66261175148	8711479163371
	Medium	ALOX	PBF D05	1	66261175164	8711479163678
	Very Fine	SIC	PBF D05	1	66261175165	8711479163685
150 x 50 x 25	Coarse	ALOX	PBF D05	1	66261175149	8711479163388
	Medium	ALOX	PBF D05	1	66261175166	8711479163692
	Fine	ALOX	PBF D05	1	66261175167	8711479163708
	Very Fine	SIC	PBF D05	1	66261175168	8711479163715
200 x 51 x 76	Medium	ALOX	F2301	1	63642588146	3157625619166
	Very Fine	ALOX	F2501	1	63642588147	3157625619173
	Very Fine	SIC	F4501	1	63642588151	3157625619197



## SPINDLE MOUNTED



Dimensions (mm) D x T x S	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
60 x 30 x 6	Fine	ALOX	F2401	10	63642586269	3157625596887
	Fine A interleaved	ALOX	F2401	10	63642586271	3157625596894
80 x 50 x 6	Fine	ALOX	F2401	10	63642586274	3157625596917
	Extra Cut	ALOX	F2401	10	63642586277	3157625596931
	Fine A interleaved	ALOX	F2302	10	63642586275	3157625596924
100 x 50 x 6	Fine	ALOX	F2401	10	63642586278	3157625596948
	Fine A interleaved	ALOX	F2401	10	63642586280	3157625596955



# Flexbrite Non-Woven Abrasives

Dimensions Key: D = Diameter, T = Thickness, B = Bore, S = Spindle



## Flap Wheels & Brushes

### MADE TO ORDER

PLEASE CONTACT YOUR LOCAL SALES REPRESENTATIVE FOR FURTHER INFORMATION

Densities	Diameter		Length		Brush Construction	Density
	Outer	Inner	Min	Max		
<b>All densities available:</b>  <b>Grades: Aluminium oxide:</b> very fine, fine, medium, coarse  <b>Grades: Silicon carbide:</b> very fine, fine, ultra fine, medium	110	25	15	1400	1	Medium
	125	50	15	1400	2	Hard
	150	50	15	1400	3	Interleaved
	175	65	15	1400		
	200	76-80	15	2000	<b>Max RPM</b>	
	250	115	25	2000	Outer Diameter (mm)	Max rpm
	300	150	25	1800	200	2500
	350	200	25	1800	250	2200
	400	250	25	2000	300	1900
	450	300	50	2000	350	1600
500	350	50	1400	400	1400	
				450	1100	

## Flap Brushes

### MADE TO ORDER

PLEASE CONTACT YOUR LOCAL SALES REPRESENTATIVE FOR FURTHER INFORMATION

Outer Diameter (mm)		Inner Diameter (mm)		Length	
Min	Max	Min	Max	Min	Max
200	500	25	350	800	2200

# Flexbrite Non-Woven Abrasives

## Satinex Wheels



## Flexbrite Non-Woven Abrasives



# Satinex Wheels

These versatile wheels are used on portable machines and are compatible with the most common used systems in the market. Satinex wheels consist of a core of radially bonded strips of Nonwoven Flaps. Ideal for decorative and satin finishes, light deburring, blending, polishing, removing oxide coatings on stainless steel and non-ferrous metals and also for smoothing wooden surfaces.

### SELECTING THE RIGHT PRODUCT

Type	Industry	Application	Selection
Satinex wheels	Architectural hardware	Decorative finish	Satinex Fine and Very Fine for bright linear finishes
	Wood	Removing paint & smoothing surface	Satinex Interleaved Grit 80
	Food Processing	Weld blending / Satin finishing	Satinex very fine – Polyurethane
	Stainless Steel fabricators	Surface finishing / Removing imperfections	Satinex medium A
	Metal	Cleaning / Removing scales / Oxide & rust	Satinex flexclean

## Wheels

### STANDARD WHEELS



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
110 x 100 x 19	Coarse	ALOX	F2204	6	63642586251	3157625596795
	Medium	ALOX	F2309	6	63642586256	3157625596801
	Fine	ALOX	F2405	6	63642586257	3157625596818
	Fine	ALOX	F2402	6	66261069721	3157629179963
	Very Fine	ALOX	F2528	6	63642586258	3157625596825

### INTERLEAVED WHEELS



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
110 x 100 x 19	Coarse + P80	ALOX	F2204	6	63642586259	3157625596832
	Medium + P150	ALOX	F2309	6	63642586260	3157625596849

### FLEXCLEAN



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
110 x 100 x 19	Extra Coarse	SIC	R4101	6	63642586263	3157625596856

### POLYURETHANE



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
110 x 100 x 19	60	ALOX	P2W01	6	63642586265	3157625596863

Dimensions Key: D = Diameter, T = Thickness, B = Bore

# Flexbrite Non-Woven Abrasives

## Unitized Wheels



## Flexbrite Non-Woven Abrasives



## Unitized Wheels

Flexovit Flexbrite Unitized wheels consist of compressed and bonded layers of non-woven abrasives. Different combinations of grain and resin offer an extensive range of wheels designed to meet all customer finishing requirements. Applications range from deburring, cleaning composites, removing sharp edges to achieving excellent finishes on nearly all surfaces. Unitized wheels are ideally suited for use on harder materials, such as Titanium or Stainless Steel.

Features	Benefits
Easily preformed	Usable on a wide variety of shapes/contours
Hold shape well	Less wheel dressing
Non-metallic	No contamination of workpiece
Uniform construction	Extra long life / Maintains part tolerance, prevents cutting or gouging
Smear resistant formula	Excellent smear free finish

### UNDERSTANDING THE PRODUCT

Product Line	Density		Abrasive Types	Grade
NEX	2	soft ↑ ↓ hard	A = Aluminium Oxide	F = Fine
NEX	3		S = Silicon Carbide	M = Medium
NEX	4			C = Coarse
NEX	6			XC = Extra coarse
NEX	7			
NEX	8			
NEX	9			

Example:

Name of product line: Nex

Naming Scheme: Similar to convolute wheels

NEX-8AC



## SELECTING THE RIGHT PRODUCT

Application Area	Specific Application	Specification	Recommended Speeds
<b>Cleaning:</b> Oxidation removal, coatings, contaminants	Welding preparation / Removal of weld blueing / Scale Removal / Gasket removal / Removing excessive bonding agents after curing / Cleaning steel castings	NEX 4AFINE, 6AF 8AMED	10-26m/s
<b>De-Burring:</b> Surface, edge, & thread de-burring	De-burring flashings, threaded parts, stamped parts, turbine blades, machined out parts / De-burr aluminium extrusions / De-burring pipes in the oil and gas industry	NEX 2SFINE, 4AFINE	10-26m/s
<b>Blending:</b> Removal parting lines, grindline conditioning	Parting line removal / Blending surface defects and forge marks	NEX 8MED, 8ACOARSE	30-40m/s
<b>Finishing:</b> Final finishing, satin finishing	Turbine blade edge radius / Medical implants (stainless steel and alloys) / Figurines / Jewellery / Finishing saw blades	NEX 6AF, 8AM	2.5-15m/s
<b>Polishing:</b> Polishing surface defects, surface preparation before buffing	Polishing precision metal pieces, welds etc.	NEX 2SFINE, 8AFINE	2.5-15m/s

Unitized Wheels can be run in either direction

Tools – Machinery according to diameter and application

Angle Grinder/MiniGrinder/Air/Electric (25mm to 125mm - 1" to 5") Straight Shaft/Flexi Shaft/Die Grinder 25mm to 150mm (1" to 6")

Bench Motor Pedestal Grinder 100 to 203 (4" to 8")

Application	Choose Density		
<ul style="list-style-type: none"> <li>• Light cleaning (lacquers, welding colours)</li> <li>• Removal of corrosion and scratches</li> <li>• Blending</li> <li>• Polishing</li> </ul>	2	soft	
<ul style="list-style-type: none"> <li>• Cleaning</li> <li>• Surface blending</li> <li>• Removal of scratches</li> <li>• Polishing after weld removal</li> <li>• Pre-polishing</li> </ul>	4		
<ul style="list-style-type: none"> <li>• De-burring</li> <li>• Removal of grinding scratches (G 80 on steel, G 120 on aluminium)</li> <li>• Edge breaking</li> <li>• Heavy cleaning</li> </ul>	6		
<ul style="list-style-type: none"> <li>• Heavy de-burring</li> <li>• Weld seam removal</li> </ul>	8		
<ul style="list-style-type: none"> <li>• De-burring on very hard material</li> </ul>	9		hard



## Unitized Wheels

### FLEXFINISH UNITISED TYPE 27 DISCS FOR ANGLE GRINDER



Dimensions (mm) D x T x H	Grade	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
115 x 12 x 22	NEX-2SF	SIC	Grey	U4401	10	66254492400	3157629329405
125 x 12 x 22	NEX-2SF	SIC	Grey	U4401	10	77696066957	3157629543320

### UNITIZED WHEELS

50 AND 75MM TO BE USED WITH WASHERS



Dimensions (mm) D x T x B	Grade	Abrasive	Cap Code	Quantity	Article Number	Barcode
50 x 3 x 6	NEX 8 Medium	ALOX	U2301	20	63642586354*	3157625597235
50 x 6 x 6	NEX-2 Medium	ALOX	U2301	20	63642586281*	3157625596962
	NEX-2 Fine	SIC	U4401	20	63642586283	3157625596986
	NEX-4 Fine	ALOX	U2401	20	63642586282*	3157625596979
	NEX-6 Fine	ALOX	U2401	20	63642586284*	3157625596993
	NEX-8 Medium	ALOX	U2301	20	63642586285*	3157625597006
75 x 3 x 6	NEX 8 Medium	ALOX	U2301	20	63642586355*	3157625597242
75 x 6 x 6	NEX-2 Medium	ALOX	U2301	10	63642586286*	3157625597013
	NEX-2 Fine	SIC	U4401	10	63642586289	3157625597044
	NEX-4 Fine	ALOX	U2401	10	63642586287*	3157625597037
	NEX-6 Fine	ALOX	U2401	10	63642586290*	3157625597051
	NEX-8 Medium	ALOX	U2301	10	63642586292*	3157625597068
150 x 6 x 12	NEX 2 Medium	ALOX	U2301	10	66261019411	3157625624467
	NEX 2 Fine	SIC	U4401	10	66261019415	3157625624498
	NEX 6 Medium	ALOX	U2301	10	66261019413	3157625624481
150 x 13 x 12	NEX 2 Medium	ALOX	U2301	5	63642586350	3157625597211
	NEX 2 Fine	SIC	U4401	5	63642586346	3157625597198
	NEX 4 Fine	ALOX	U2401	5	63642586349	3157625597204
150 x 25 x 25	NEX-2 Medium	ALOX	U2301	5	63642586293	3157625597075
	NEX-2 Fine	SIC	U4401	5	63642586295*	3157625597099
	NEX 4 Fine	ALOX	U2401	5	63642586294	3157625597082
200 x 25 x 25	NEX-2 Medium	ALOX	U2301	5	63642586296*	3157625597105
	NEX-2 Fine	SIC	U4401	5	63642586298*	3157625597112
150 x 20 x 25.4	Coarse	ALOX	FBR Ho2	1	66261175150*	8711479163395
	Medium	ALOX	FBR Ho4	1	66261175158*	8711479163609
	Fine	ALOX	FBR Ho2	1	66261175159*	8711479163616
	Very Fine	SIC	FBR Ho4	1	66261175160*	8711479163623
150 x 50 x 25.4	Coarse	ALOX	FBR Ho4	1	66261175151	8711479163401
	Medium	ALOX	FBR Ho4	1	66261175161	8711479163630
	Fine	ALOX	FBR Ho2	1	66261175162	8711479163647

\* Made-to-order

## Accessories

### UNITIZED WHEELS

PLUS SETS OF WASHERS (6MM SHANK)



Specification	Thickness	Bore Size	Quantity	Article Number	Barcode
M 3-6	up to 6mm	6mm	1	63642586234	3157625596153
M 3 L 6	from 6mm to 12mm	3-6mm	1	63642586236	3157625596177
M 22 EXL 6	12mm to 25mm	13mm	1	63642586239	3157625596184

**Dimensions Key:** D = Diameter, T = Thickness, H = Hole, B = Bore



# Flexbrite Non-Woven Abrasives

## Convolute Wheels



## Flexbrite Non-Woven Abrasives



# Convolute Wheels

Convolute Wheels are manufactured by wrapping Flexovit Flexbrite non-woven material impregnated with abrasive grain and resin around a centre core. Convolute Wheels offer a wide range of utility from heavy burr removal to cleaning rust and oxide through to satin finishing. These wheels are available in various diameters, grades and densities.

### UNDERSTANDING THE PRODUCT

Bond System	Density	Abrasive Types	Grit size
1 = Series 1000 bond	6	A = Aluminium Oxide	M = Medium
2 = Series 2000 bond	7	S = Silicon Carbide	F = Fine
3 = Series 4000 bond	8		VF = Very Fine
	9		

### TROUBLESHOOTING

<b>Slow cut rate</b>	Increase density Decrease wheel speed Use coarser grit
<b>Low conformability</b>	Decrease density Reduce pressure
<b>Poor form holding</b>	Increase density Decrease wheel speed Reduce pressure
<b>Poor finish</b>	Increase density Increase oscillation Use of lubricant Water – fine Water soluble – finer Oil – finest Increase wheel speed

### GETTING THE BEST FROM YOUR FLEXBRITE CONVOLUTE WHEELS

Pressure	Light to medium pressure is recommended for most operations. Avoid excessive pressure which may result in wheel deformation and damage the work surface.
Feed Speed	Feed speeds directly affect the number of pieces completed over a given period of time. Slow feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.
Oscillation	Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut may be experienced. A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.
Lubricants	Lubricants, such as water, water soluble oil, and straight oil, will decrease the heat generated while running, improve the lustre, and improve the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

# Flexbrite Non-Woven Abrasives



## APPLICATION CONVOLUTE WHEELS

Type	Features	Benefits	Application
Clean Finish wheels (DCS) – fine Finish with light pressure	Open mesh construction, Silicon Carbide Grain	Used with light to moderate pressure, low speed. Good for blending, rust removal, applying decorative contrast finishes and low to moderate speed applications. Not used for deburring	Blending weld areas on stainless steel to #4 finish. Removing rust and oxides. Applying decorative contrast finishes. General clean-up
Surface Finishing Wheels (DSS) uniform finish with moderate pressure	Stronger web compared to Clean / Finish wheels	More aggressive cutting action & more durability than Clean / Finish wheels. Ideal for rust and paint removal, coarse decorative finishes, and blending	Removing rust and paint. Applying coarse decorative finishes. Blending to a higher degree. General clean-up
Metal Finishing Wheels (DMA) Blending & final finishing	Strongest resin binders. Dense, very durable web. Premium, medium grit aluminium oxide grain. Uniform grain dispersion and coating	Resilient long life construction. Can be used for light deburring-applications. Generates uniform distinct satin and antique finishes. Cleans and conditions without gouging or changing dimensions of workpiece	Blend and match #3 or #4 mill finishes. Generate the uniform appearance required for decorative finishing. Prepare a surface for buffing or polishing. For blending or finishing operations
SERIES 1000 Wheels (D1*S/A) General deburring, blending & finishing	Smear and heat resistant formula. Waterproof Non metallic. Dense web construction (9 density). More open web construction (6 density)	Use dry, wet or with oil. No contamination of workpiece. Long life & consistent high quality results. Starting point for deburring, blending polishing and finishing. Smear proof & cool cutting on light deburring applications	General Deburring. Blending coated abrasive scratch patterns. Polishing stainless steel cutlery, golf clubs and computer parts. Deburring and finishing intricate shapes. Centreless polishing. Glass polishing. Edge radiusing
SERIES 4000 Wheels (D4*S/A) Heavy deburring applications	Improved resin bond system. High quality synthetic web. Smear & heat resistant. Premium abrasive grain.	Free cutting – Use both wet and dry. More consistent finish. Better performance. Long life for heavy deburring, edge breaking & removing parting lines on exotic metals	The choice where edge and form holding are of primary importance. Ideal for heavy duty deburring, edge breaking and parting line removal on metals for all sharp, narrow point of contract applications



## Convolute Wheels

### SELECTING THE RIGHT PRODUCT

Convolute Wheels must always be run in the direction indicated by the arrow printed on the side of each wheel.

Type	Application Area	Specific Application	Specification	Recommended
Convolute	Cleaning	General purpose cleaning / Removing rust oxidation, corrosion, discoloration, to 6000 SFPM flashings, pipe threads, machine parts, plastic moulded parts	1 6AM, 1 8AM	11-32m/s / 2200-6000 SFPM
	Deburring	Removing medium to heavy burrs / De-burring die cast / Smoothing radii on metal parts / Blending coated abrasive scratch pattern	1-9SF	28-41m/s / 5500-8000 SFPM
	Blending	Smoothing parting lines / Polishing welds / Machine parts	1-7SF	28-41m/s / 5500-8000 SFPM
	Finishing	Satin finish / Cosmetic finish / Brush finish	1-7SF	2 15m/s / 500-3000 SFPM

Testing may show that a slower or faster speed is desirable for specific operations. Never exceed the maximum R.P.M. rating of the wheel



## CONVOLUTE WHEELS AVAILABILITY

Product code	Product code	150 x T x 25.4 mm	200 x T x 76.2 mm	250 x T x 127 mm	300 x T x 127 mm
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**PLEASE CONTACT YOUR LOCAL SALES REPRESENTATIVE FOR FURTHER INFORMATION**

Silicon Carbide Wheels		C	M	F	VF												
DCS	Clean and Finish S/C	●	●			●	●			●	●			●	●		
DSS	Surface finishing S/C	●	◐			◐	◐			◐	◐			◐	◐		
D16S	Serie 1000 d6 S/C		●	●	◐		●	●	◐		◐	◐	◐		◐	◐	◐
D17S	Serie 1000 d7 S/C		●	●	◐		●	●	◐		◐	◐	◐		◐	◐	◐
D18S	Serie 1000 d8 S/C		●	●	◐		●	●	◐		◐	●	◐		◐	●	◐
D19S	Serie 1000 d9 S/C		◐	●			●	●			◐	●			◐	●	
D48S	Serie 4000 d8 S/C			●				●				◐				◐	
D49S	Serie 4000 d9 S/C			●				●				◐				◐	
Aluminium Oxide Wheels		C	M	F	VF												
DSA	Surface finishing A/O		◐				◐				◐				◐		
DMA	Metal finishing d5 A/O		◐				●				◐				◐		
D16A	Serie 1000 d6 A/O		◐	◐			◐	◐			◐	◐			◐	◐	
D17A	Serie 1000 d7 A/O		◐	◐			◐	◐			◐	◐			◐	◐	
D18A	Serie 1000 d8 A/O		◐	◐			●	◐			◐	◐			◐	◐	
D48A	Serie 4000 d8 A/O		●				●				◐				◐		

- Available from Flexovit Conversion in Europe (Thickness 10 to 600mm)
- ◐ Available on request (Thickness 13 to 600mm) – For Dia > 300mm consult with your local Sales Representative

C: coarse M: medium F: fine VF: very fine

## Convolute Wheels Series 1000



Dimensions (mm) D x T x H	Product Code	Grade	Abrasive	Density	Cap Code	Quantity	Article Number	Barcode
150 x 25 x 25	D17SF	Fine	SIC	7	C4404	1	63642589574	3157625688841
	D18SF	Fine	SIC	8	C4404	1	63642588971	3157625683686
	D19SF	Fine	SIC	9	C4404	1	63642588982	3157625685413
	D17SM	Medium	SIC	7	C4304	1	63642588989	3157625685444
200 x 25 x 76	D17SF	Fine	SIC	7	C4404	1	63642588981	3157625685406
	D17SM	Medium	SIC	7	C4304	1	63642588976	3157625683693
200 x 50 x 76	D17SF	Fine	SIC	7	C4404	1	63642589832	3157625689459
	D18SF	Fine	SIC	8	C4404	1	63642588958	3157625683662
	D19SF	Fine	SIC	9	C4404	1	63642588968	3157625683679

Dimensions Key: D = Diameter, T = Thickness, H = Hole



# Flexbrite Non-Woven Abrasives

## Floor Pads





## Floor Pads

Flexovit Flexbrite offers a wide range of Floor Pads from stripping right through to mirror gloss finishing. Scrubbing and Cleaning Pads for general scrubbing and cleaning applications Flexovit Flexbrite offers two pads that will remove surface dirt and grime to get the floor back in shape before re-coating or buffing.

### **Black Super Strip – JF178**

A thick pad that is aggressive, durable and consistent, for wet stripping application.

### **Green Super Scrub – JF180**

A heavy Duty wet scrubbing pad that will remove the toughest scuff marks in heavily soiled traffic areas.

### **Blue Super Clean – JF181**

For general duty scrubbing or heavy spray cleaning jobs buffing and polishing jobs designed to produce consistent performance and assure you a mirror gloss shine.

### **Beige – JF177**

For buffing and polishing, good for light traffic areas.

### **Red Buffer – JF176**

Generally used where a high gloss finish is desired when dry or spray buffing. It can also be used for light cleaning applications.

### **White Super Gloss – JF175**

A non abrasive polishing/ buffing pad, used dry or with a fine mist to yield a mirror gloss shine.



## Pads

### FLOOR PADS THICK LINE GENERAL PURPOSE

Diameter (mm)	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
406	Alox	Black	JF178	5	63642586356	3157625597259
	Alox	Blue	JF181	5	63642586357	3157625597266
	Alox	Beige	JF177	5	63642586358	3157625597273
	Alox	Green	JF180	5	63642586359	3157625597297
	Alox	Red	JF176	5	63642586360	3157625597303
	Geen	White	JF175	5	63642586362	3157625597327

### FLOOR PADS THIN LINE GENERAL PURPOSE

Diameter (mm)	Abrasive	Colour	Cap Code	Quantity	Article Number	Barcode
406	Alox	Black	JU014	10	63642586364	3157625597334
	Alox	Green	JF068	10	63642586365	3157625597341
	Alox	Beige	JF040	10	63642586366	3157625597358
	Geen	White	JF175	10	63642586367	3157625597365



# Accessories: For Coated Abrasives & Flexbrite Products



Coated Abrasives Accessories 144  
Flexbrite Accessories 146

**flex**  **vit**

**Accessories:  
For Coated  
Abrasives &  
Flexbrite Products**



# Coated Abrasives Accessories

## Back-Up Pads



**M8 + 5/16**  
 QUICK RELEASE MEDIUM DENSITY
 

Diameter (mm)	Quantity	Article Number	Barcode
125	1	69957384732	3157625644113



**8 SCREW**  
 QUICK RELEASE MEDIUM DENSITY
 

Diameter (mm)	Quantity	Article Number	Barcode
200	1	69957371442	3157620738398



**M14**  
 QUICK RELEASE MEDIUM DENSITY
 

Diameter (mm)	Quantity	Article Number	Barcode
115	1	07660707234	8711479202445

## Accessories

### FIBRE DISCS – (M14 ATTACHMENT)



Diameter (mm)	Product Material Type	Density	Quantity	Article Number	Barcode
115	Nylon	Medium	5	69957382815	3157625620667
	Nylon	Hard	1	69957382818	3157625620698
	Air cool rubber	Hard	1	69957382821	3157625620728
125	Nylon	Medium	5	69957382816	3157625620674
	Nylon	Hard	1	69957382819	3157625620704
	Air cool rubber	Hard	1	69957382823	3157625620735
180	Nylon	Medium	5	69957382817	3157625620681
	Nylon	Hard	1	69957382820	3157625620711
	Air cool rubber	Hard	1	69957382824	3157625620742



#### Nylon

- Medium hard, for medium/fine application
- Hard for coarser applications

#### Air cool rubber

- Hard for heavy applications

## Quick Change Discs Back-Up Pads

### QUICK CHANGE DISCS – BU SL2

BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
25	1	63642562235	3157625598867
38	1	63642562238	3157625598881
50	1	63642562241	3157625598904
75	1	63642562246	3157625598928



### QUICK CHANGE DISCS – BU SL3

BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
25	1	63642562236	3157625598874
38	1	63642562239	3157625598898
50	1	63642562244	3157625598911
75	1	63642562247	3157625598935



### QUICK CHANGE DISCS – BU SL3

BLUE NYLON – HOLDER



Diameter (mm)	Quantity	Article Number	Barcode
75	1	63642568065	3157625581906

## Accessories: For Coated Abrasives & Flexbrite Products



# Flexbrite Accessories

## Back-Up Pads

### SURFACE BLENDING DISCS – M14 ATTACHMENT



Diameter (mm)	Quantity	Article Number	Barcode
115	1	69957382846	3157625621084
125	1	69957382841	3157625621046
178	1	69957382844	3157625621077

### FLEXVIEW HOLDER



Diameter (mm)	Quantity	Article Number	Barcode
115	5	07660705168	3157626376297

### QUICK CHANGE DISCS – BU SL2

BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
50	1	63642562241	3157625598904
75	1	63642562246	3157625598928

### QUICK CHANGE DISCS – BU SL3

BACK-UP PADS



Diameter (mm)	Quantity	Article Number	Barcode
50	1	63642562244	3157625598911
75	1	63642562247	3157625598935

### QUICK CHANGE DISCS – BU SL3

BLUE NYLON – HOLDER



Diameter (mm)	Quantity	Article Number	Barcode
75	1	63642568065	3157625581906

### QUICK CHANGE DISCS – BU SL4

BACK-UP PADS



Diameter (mm)	Cap code	Quantity	Article Number	Barcode
100	R4101	1	63642586196	3157625595835

## Mandrels

### FLEXCLEAN DISCS

PLUS SETS OF WASHERS FOR 12mm BORE, DISC WIDTH 13mm



Diameter	Shank diameter	Quantity	Article Number	Barcode
to 150mm	6mm	1	7660707022	3157622826444
to 200mm	8mm	1	7660707023	3157622928193

### UNITIZED WHEELS

PLUS SETS OF WASHERS (12mm SHANK)



Specification	Thickness	Bore Size	Quantity	Article Number	Barcode
M 3-6	up to 6mm	6mm	1	63642586234	3157625596153
M 3 L 6	from 6mm to 12mm	3-6mm	1	63642586236	3157625596177
M 22 EXL 6	12mm to 25mm	13mm	1	63642586239	3157625596184

# Flexbrite Accessories

## REDUCTION BUSHINGS for Wheels

### SMALL BUSHINGS, STEEL

Wheel Centre hole (mm)	Reduces hole size to (mm)	For Wheel Diameter (mm)	Quantity	Article Number	Barcode
25	9.525	100 to 150	2	66261080522*	3157629184844
	12.7	100 to 150	2	66261080523	3157629184851
	15.875	100 to 150	2	66261080524*	3157629184868
	19.05	100 to 150	2	66261080525*	3157629184875
	22.25	100 to 150	2	66261080526*	3157629184882
50	12.7	150 to 200	2	66261082442	3157629017241

\* Made-to-order

### LARGE BUSHINGS, ALUMINIUM

Wheel Centre hole (mm)	Reduces hole size to (mm)	For Wheel Diameter (mm)	Quantity	Article Number	Barcode
50	12.7	150	2	66261080527*	3157629017241
	15.875	150	2	66261080528	3157629184936
	25.4	150	2	66261080529*	3157629184943
	31.75	150	2	66261080530*	3157629184967
76	25.4	200	2	66261080531	3157629184981
	31.75	200	2	66261080532	3157629185131
	38.1	200	2	66261080383*	3157629185001
	50.8	200	2	66261080514*	3157629185124
125	31.75	250 and 300	2	66261080534	3157629185148
	76.2	250 and 300	2	66261080535*	3157629185155

\* Made-to-order

Accessories:  
For Coated  
Abrasives &  
Flexbrite Products





# Polishing Products



# Polishing Products



## Cloth polishing mops

For polishing all materials with or without polishing compound.



## Multiple stitched polishing mops

For polishing all materials with or without polishing compound. Extra solid construction for polishing straight surfaces.



## Felt wheel

For polishing straight surfaces (harder than multiple stitched buffing wheel).



## Round fiber brush

For polishing straight or profiled pieces.

## CLOTH POLISHING MOPS

Dimensions (mm) D x W x A	Specification	Quantity	Article Number	Barcode
150 X 20.0 X 10.0	2X STITCHED	1	07660739030	8711479209321
200 X 20.0 X 10.0	2X STITCHED	1	07660739008	8711479209024

## MULTIPLE STITCHED CLOTH POLISHING MOPS

Dimensions (mm) D x W x A	Specification	Quantity	Article Number	Barcode
75 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660738997	8711479208959
100 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660738999	8711479208966
125 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739002	8711479208973
150 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739005	8711479208997
175 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739007	8711479209017
200 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739009	8711479209031
250 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739011	8711479209062
300 X 20.0 X 10.0	MULTIPLE STITCHED	1	07660739014	8711479209116

## FELT WHEEL

Dimensions (mm) D x W x A	Specification	Quantity	Article Number	Barcode
125 X 20.0 X 6.0	FELT WHEEL	1	07660739029	8711479209307
150 X 20.0 X 6.0	FELT WHEEL	1	07660739031	8711479209338
175 X 20.0 X 6.0	FELT WHEEL	1	07660739032	8711479209352
200 X 25.0 X 6.0	FELT WHEEL	1	07660739033	8711479209376

## ROUND FIBRE BRUSH

Dimensions (mm) D x W x A	Specification	Quantity	Article Number	Barcode
100 X 25.0 X 10.0	FIBRE BRUSH	1	07660739501*	8711479230592
125 X 25.0 X 10.0	FIBRE BRUSH	1	07660739502*	8711479230608
150 X 25.0 X 10.0	FIBRE BRUSH	1	07660739503*	8711479230615
200 X 25.0 X 15.0	FIBRE BRUSH	1	07660739504*	8711479230639
250 X 30.0 X 15.0	FIBRE BRUSH	1	07660739505*	8711479414046

\* Made-to-order

## Polishing Products



### Steel wool

For surface preparation and fine finishing of various materials.

### STEEL WOOL IN BOX

Weight	Specification	Quantity	Article Number	Barcode
175g	EXTRA COARSE	1	07660739052*	8711479209475
	COARSE	1	07660739053*	8711479209482
	MEDIUM	1	07660739054	8711479209499
	FINE	1	07660739055	8711479209505
	EXTRA FINE	1	07660739056	8711479209512

\* Made-to-order

## Polishing Compounds

### INDUSTRIAL POLISHING BLOCK

Colour	Specification	Quantity	Article Number	Barcode
BROWN	CLEANING VERY DIRTY MATERIAL	1	07660739107	8711479221217
GREEN	HIGH GLOSS FINISH	1	07660739108	8711479221224
WHITE	POLISHING STAINLESS STEEL AND ALUMINIUM	1	07660739109	8711479221231
PINK	POLISHING COPPER	1	07660739111	8711479221255
BLUE	POLISHING BRASS	1	07660739112	8711479221262

### POLISHING CREAM IN TUBE

WHITE	LANGSOL GENERAL PURPOSE	1	07660739116	8711479221415
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### POLISHING COMPOUND, OIL BASED

Weight	Specification	Quantity	Article Number	Barcode
500g	GRIT 100	1	07660739125	8711479221712
500g	GRIT 150	1	07660739126	8711479221729
500g	GRIT 250	1	07660739127	8711479221736
500g	GRIT 320	1	07660739128	8711479221743



### Polishing compound brown

For cleaning very dirty materials

### Polishing compound green

For satin gloss

### Polishing compound white

For polishing stainless steel and aluminium

### Polishing compound beige

For polishing plastics

### Polishing compound pink

For polishing copper

### Polishing compound blue

For polishing brass

### Polishing compound, oil based

General purpose for polishing /cleaning all metals.

### Solid polishing compound

Prevents the material from loading. Supports cool cutting.

Dimension Key: D = Diameter, W = Width, A = Arbor



# Cutting-Off & Grinding Wheels



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# Cutting-Off & Grinding Wheels

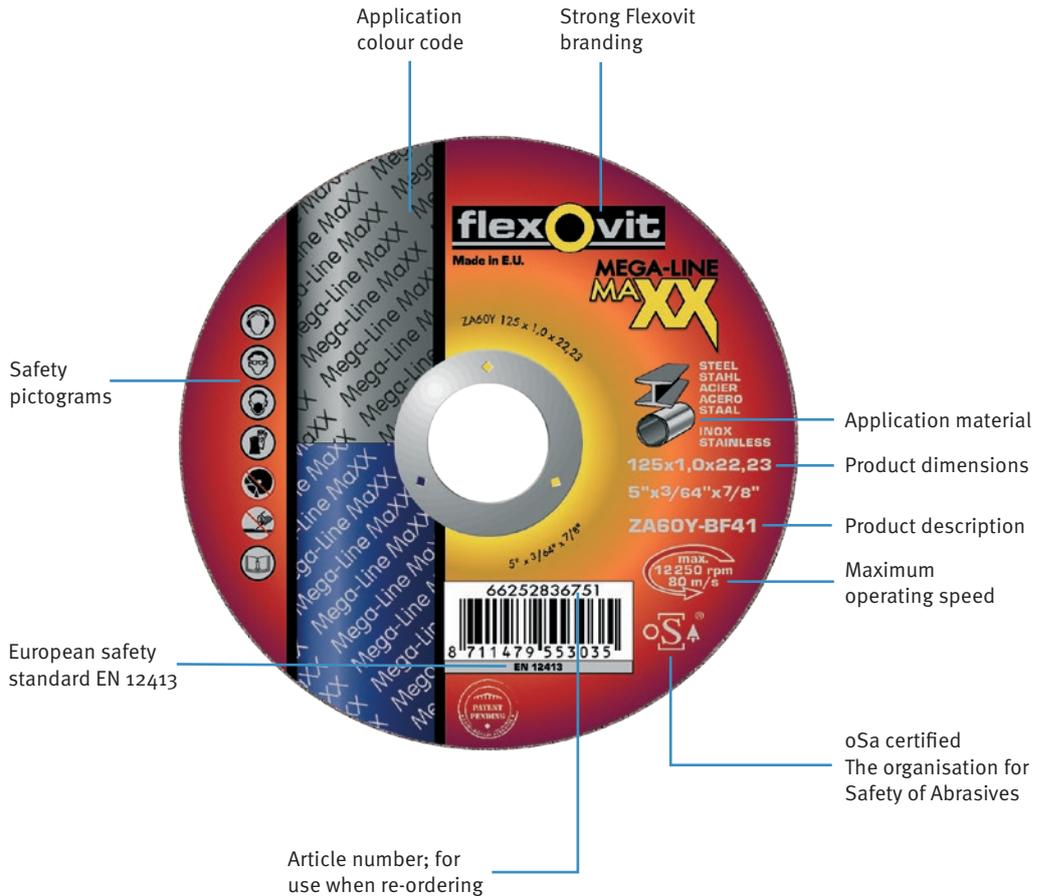


## Technical Information

Throughout the world, Flexovit cutting-off and grinding wheels are extensively used across a range of industries including aerospace, automotive, foundries, fabrication, ship-building and construction. Flexovit's wide range of products provide high value, high performance industrial solutions. High performance Flexovit products are backed up by a team of experienced product engineers providing the technical support that modern industrial companies demand.

Flexovit's stock delivery program ensures quick and reliable availability. This is why Flexovit is the preferred brand for professional users of abrasive wheels. This section presents our state-of-the-art industrial range of cutting-off and grinding wheels covering a wide variety of cutting-off and grinding applications.

### Understanding the Product



### METAL RING WITH VALIDITY DATE

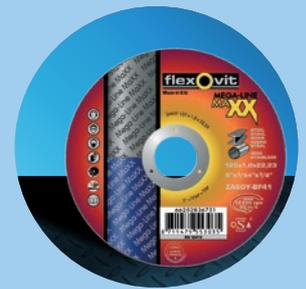
**V = validity date (production quarter + 3 year)**

	<b>V01</b>	<b>V04</b>	<b>V07</b>	<b>V10</b>
		1st quarter	2nd quarter	3rd quarter

Example:  
V04/2016 indicates production in the 2nd quarter of 2013 and advised usage before the 2nd quarter of 2016

## Differentiation in the Range

Flexovit provides the industry's widest selection of cutting-off and grinding wheels to help meet every requirement. The Flexovit Industrial range comprises three distinct product lines giving three different price/performance levels, satisfying all demands encountered in industrial markets. Flexovit cutting-off and grinding wheels are classified into Flexovit Mega-Line (premium performance), Flexovit (high performance), and Flexovit Speedoflex (economy performance) product lines to help you choose the right product for your specific application.



### FLEXOVIT MEGA-LINE

Flexovit Mega-Line is the premium quality product line of Flexovit and contains cutting-off and grinding wheels, designed to meet the demands of the most discerning users. The products work faster and have a longer life resulting in lower operating costs. The products have been designed to be exceptionally user friendly and easy to use, satisfying the ultimate requirements of the professional user.



### FLEXOVIT

Throughout the world, Flexovit cutting-off and grinding wheels are used extensively in a range of industries including aerospace, automotive, foundry, fabrication, ship-building and construction. Flexovit's wide range of products give high performance and high value levels, leading to lower costs.



### FLEXOVIT SPEEDOFLEX

Speedoflex cutting-off and grinding wheels offer good levels of performance with excellent price/performance ratio, an excellent economy product. They are suitable for cutting-off and grinding wheels a wide range of materials including steel, stainless steel, cast iron and stone.

## APPLICATION

Where greater differentiation of products by application is needed, this is done through colour coding.

### APPLICATION MATERIAL

Stone/  
Cast Iron

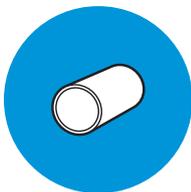
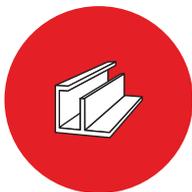
Non-ferrous

Inox/  
Stainless Steel

Steel

Steel/Inox  
Stainless Steel

### PICTOGRAMS



### WHEELS



### PACKAGING LABELS



# Cutting-Off & Grinding Wheels



## Technical Information

### MARKING SYSTEM OF ABRASIVE CUTTING-OFF & GRINDING WHEELS

Type of Abrasive A	Grit size 30			Hardness Grade S			Type of Bond BF27
	Coarse	Medium	Fine	Soft	Medium	Hard	
A = Aluminium Oxide	16	30	80	N	Q	T	B = Bakelite/ Resinoid bond BF = Bakelite and glass fibre reinforcement
C = Silicon Carbide	20	to	to	O	R	U	
Z = Zirconia Alumina	24	60	100	P	S	V	

### SHAPE SPECIFICATION SYSTEM

BF 27	BF 41	BF 42
Depressed centre grinding wheels, thickness from 2.2-10mm. Available in diameters 76-230mm for hand-held machines.	Flat cutting-off wheels. Available in diameters 76-406mm for hand-held machines and 300-406mm for stationery machines.	Depressed centre cutting-off wheels. Available in diameters 76-230mm.
Application: grinding	Application: cutting-off	Application: cutting-off

### MACHINE PICTOGRAMS

 Cutting-off	 Grinding	 Straight Grinder	 Angle Grinder
 Petrol Saw with clamping device (Rail)	 Petrol Saw	 Chop Saw	 Stationary machine



## Operating Speeds

Flexovit products are designed and tested for certain applications and operating speeds. Choose a wheel suitable for the application material. Suitable materials are indicated on the wheel label. For a comprehensive list please refer to Selecting the Right Product chart on page 164. Before mounting the grinding or cutting-off wheel on the machine, ensure that the operating speed of the machine does not exceed the maximum operating speed as it is marked on the product.

SPEED CONVERSION FOLLOWING EN 12413

Wheel diameter (mm)	Maximum peripheral operating speed in m/s		
	63	80	100
50/51	24100	30600	38200
63/65	19100	24300	30250
76	15850	20150	25150
80	15100	19100	23900
85	14200	18000	22500
100/102	12100	15300	19100
115	10500	13300	16650
125	9650	12250	15300
150/152	8050	10200	12700
180	6700	8500	10650
200	6050	7650	9550
230	5250	6650	8350
250/254	4850	6150	7650
300/305	4050	5100	6400
350/356	3450	4400	5500
400/406	3050	3850	4800

All figures are maximum operating speeds in RPM



## Technical Information

### Getting the best from your Cutting-Off & Grinding Wheels

- Decide which material is cut most and that you select the most suitable Flexovit wheel in accordance with the application chart in this chapter. To use the right wheel for the right material is very important for the life and cutting/grinding behaviour of the wheel
- Check if the machine is operating correctly and that the machine does not exceed the speed that is indicated on the wheel
- Use the wheel at the recommended speed indicated on the wheel and the maximum operating speed chart that you will find later in this chapter

The troubleshooting guide can easily help you recognise and solve problems.

#### TROUBLESHOOTING CUTTING OFF WHEELS

##### Wheel does not cut

<b>Cause</b>	in case of blue cutting: wheel too hard or too thick
<b>Solution</b>	use softer or Flexovit Thin Cut wheels, check peripheral speed
<b>Cause</b>	peripheral speed too low
<b>Solution</b>	increase rpm up to max. (80m/s)

##### Excessive wear

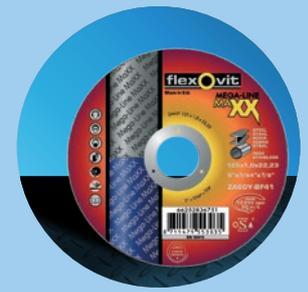
<b>Cause</b>	in case of white cutting edge: wheel too soft
<b>Solution</b>	use harder wheel
<b>Cause</b>	operating speed too low
<b>Solution</b>	increase rpm up to max (80m/s)
<b>Cause</b>	decrease of rpm during cutting
<b>Solution</b>	use machine with more power, reduce pressure on the machine

##### Crumbled wheel edge

<b>Cause</b>	cutting-off wheel used for grinding operations
<b>Solution</b>	use a grinding wheel for grinding operations
<b>Cause</b>	workpiece is moving
<b>Solution</b>	clamp the workpiece properly
<b>Cause</b>	too much side-pressure
<b>Solution</b>	add only the radial pressure to the wheel

##### Arborhole or centre break out

<b>Cause</b>	wheel sticks in the workpiece/material
<b>Solution</b>	use more radial pressure and swing the wheel forwards and backwards
<b>Cause</b>	cutting-off wheel used for grinding operations
<b>Solution</b>	use a grinding wheel for grinding operations
<b>Cause</b>	too much side pressure
<b>Solution</b>	add only the radial pressure to the wheel
<b>Cause</b>	different diameter top/bottom flange
<b>Solution</b>	use flanges with the same diameter



## TROUBLESHOOTING GRINDING WHEELS

### Wheel does not grind

<b>Cause</b>	wheel too hard, wheelglazing
<b>Solution</b>	use softer wheel
<b>Cause</b>	not enough pressure
<b>Solution</b>	increase pressure
<b>Cause</b>	machine power too low
<b>Solution</b>	use machine with more power
<b>Cause</b>	loading and wheelglazing (non-ferrous)
<b>Solution</b>	use Flexovit Alu wheels which counteracts loading and wheelglazing

### Excessive wheelwear

<b>Cause</b>	wheel too soft
<b>Solution</b>	use harder wheel
<b>Cause</b>	too much pressure
<b>Solution</b>	reduce pressure, let the wheel do the grinding
<b>Cause</b>	decrease of peripheral speed
<b>Solution</b>	use machine with more power, reduce pressure on the machine
<b>Cause</b>	too low peripheral speed
<b>Solution</b>	max. 80m/s is optimum speed

### Crumbled wheel edge

<b>Cause</b>	grinding angle too flat
<b>Solution</b>	change angle to 30 - 40°
<b>Cause</b>	workpiece is moving
<b>Solution</b>	clamp the workpiece properly
<b>Cause</b>	too much pressure
<b>Solution</b>	reduce pressure, let the wheel do the grinding

### Cracks on the bottom of the wheel

<b>Cause</b>	contact area too large
<b>Solution</b>	reduce contact area
<b>Cause</b>	too much pressure
<b>Solution</b>	reduce pressure, let the wheel do the grinding

### Unbalance

<b>Cause</b>	dirty flanges
<b>Solution</b>	clean flanges
<b>Cause</b>	wheel mounting insecure
<b>Solution</b>	tighten flanges
<b>Cause</b>	flanges with different diameter
<b>Solution</b>	replace flanges



## Technical Information

### SAFETY ADVICE – DO'S

✓	<b>DO</b> always handle and store wheels carefully. Cutting-off wheels should be stacked horizontally and flat, preferably on a steel base plate. Depressed centre wheels should be placed on top of each other or stored in the original packaging.
✓	<b>DO</b> always visually inspect all wheels before mounting for possible damage in transit.
✓	<b>DO</b> always use a safety guard and ensure that it is correctly positioned and securely fitted. It should cover at least one half of the wheel and protect the operator in the unlikely event of a wheel breakage. <b>NON-REINFORCED CUTTING-OFF WHEELS SHOULD ONLY BE USED ON FIXED MACHINES AND SHOULD BE CORRECTLY GUARDED.</b>
✓	<b>DO</b> always switch 'OFF' the power at supply source and/or remove the plug from the socket before changing the wheel.
✓	<b>DO</b> always use the tools supplied by the machine manufacturer to change the wheel.
✓	<b>DO</b> always ensure that the spindle speed of the machine does not exceed the operating speed marked on the wheel.
✓	<b>DO</b> always use the correct wheel mounting flanges and ensure that they are undamaged, clean and free from burrs.
✓	<b>DO</b> SEE EN 12413.
✓	<b>DO</b> allow newly mounted wheels to run at operating speed, with the guard in place, for a reasonable time before cutting or grinding.
✓	<b>DO</b> always wear EYE PROTECTION.
✓	<b>DO</b> always wear appropriate safety clothing such as DUST MASK, GLOVES, EAR PROTECTION, OVERALLS AND SAFETY SHOES.
✓	<b>DO</b> always have machine speeds checked regularly, especially after maintenance or repair. Machines fitted with speed control devices (Governors), must be properly maintained at all times.
✓	<b>DO</b> check tension of driving belts, where fitted, on a regular basis. Belts must be kept tight to ensure full power transmission.
✓	<b>DO</b> always secure the workpiece firmly while it is being cut or ground.
✓	<b>DO</b> put portable machines in suitable cradles, when not being used, to avoid damage to the wheel.
✓	<b>DO</b> always use a portable machine in a comfortable position, where the workpiece is well balanced and the machine is well supported.
✓	<b>DO</b> grind at an angle above 30 degrees to the workpiece with a depressed centre grinding wheel.
✓	<b>DO</b> keep the working area around cutting and grinding operations clear. It is very dangerous if an operator trips and falls with an operating machine in his hands.



### SAFETY ADVICE – DON'TS

<b>X</b>	<b>DON'T</b> handle wheels roughly.
<b>X</b>	<b>DON'T</b> use non-reinforced cutting-off wheels on portable machines.
<b>X</b>	<b>DON'T</b> store wheels in a damp atmosphere or in extreme temperatures.
<b>X</b>	<b>DON'T</b> mount a damaged wheel.
<b>X</b>	<b>DON'T</b> EVER exceed the maximum operating speed marked on the wheel.
<b>X</b>	<b>DON'T</b> force a wheel onto a machine spindle.
<b>X</b>	<b>DON'T</b> use mounting flanges which are incorrect, damaged, dirty or burred.
<b>X</b>	<b>DON'T</b> tighten the mounting nut or locking flange excessively. To do so can distort the flanges.
<b>X</b>	<b>DON'T</b> use blotters with depressed centre wheels less than or equal to 406mm (EN 12413).
<b>X</b>	<b>DON'T</b> use a machine which is not in good mechanical condition.
<b>X</b>	<b>DON'T</b> use a machine without a wheel guard.
<b>X</b>	<b>DON'T</b> use wheels without proper ventilation or dust protection equipment.
<b>X</b>	<b>DON'T</b> apply side pressure to cutting-off wheels. You should not bend the wheel.
<b>X</b>	<b>DON'T</b> stop the wheel by applying pressure to the periphery or face. Always switch the machine off and allow the wheel to stop revolving.
<b>X</b>	<b>DON'T</b> allow the wheel to be trapped or pinched in the cut.
<b>X</b>	<b>DON'T</b> apply excessive pressure onto the wheel so that the driving motor slows down.
<b>X</b>	<b>DON'T</b> grind on the side of cutting-off wheels or depressed centre wheels below 4.0mm thickness.
<b>X</b>	<b>DON'T</b> drop or lower a portable machine by the cable or airline onto the floor. A wheel can be easily cracked, if it is put down hard, by the weight of the machine. This is a common cause of wheel breakage.
<b>X</b>	<b>DON'T</b> grind with a depressed centre grinding wheel at an angle below 30 degrees to the workpiece.
<b>X</b>	<b>DON'T</b> use a machine in a position where you do not have full control of the machine and you are not well balanced.



## Technical Information

### Safety in the Storage & Use of Cutting-Off & Grinding Wheels

All cutting-off and grinding wheels are breakable and it is imperative that users take the appropriate precautions. Abrasive wheels that are damaged, improperly mounted or improperly used are dangerous and can cause serious injuries to any person in the vicinity. This section contains a summary of the most important precautions. Further safety recommendations can be found in the country laws, decrees and technical standards in the FEPA safety code (Federation of European Producers of Abrasives, [www.fepa-abrasives.org](http://www.fepa-abrasives.org)).

#### SELECTION OF THE WHEEL

Carefully read the label or the information on the wheel and make sure that the wheel is suitable for the application and has the correct dimensions. Check that the max. rpm of the machine spindle on which you will mount the wheel never exceeds the max. rpm printed on the wheel label. Follow any restriction of use and any specific instruction which may be indicated on the wheel or on attached documents.

#### INSPECTION & TEST BEFORE MOUNTING

Make sure that the instructions on the wheel and on the machine are compatible.

#### VISUAL INSPECTION

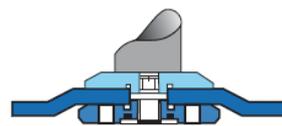
Carefully inspect the abrasive wheel: if it is damaged in any way do not use.

#### SAFETY EQUIPMENT

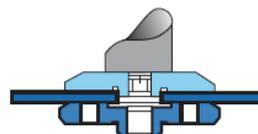
Before starting the cutting-off or grinding operation, the wheel guard must be in position and fixed securely. The wheel guard must be capable of catching broken wheel fragments effectively and capable of withstanding the impact caused by wheel breakage.

#### MOUNTING OF THE GRINDING WHEEL & USE OF THE MOUNTING DEVICES

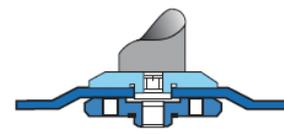
Only mount the wheels on machines designed for the operation. Never use force when mounting. Always use the mounting flanges supplied with the machine and ensure they are clean, never modify them in any way.



Type 27



Type 41



Type 42

## WORKPLACE CONDITIONS

Safe operations depend on a clean and tidy working environment. Adequate working space, good lighting and heating should be available. All relevant local, national and international regulations must be followed.

## INSTRUCTIONS FOR USE

Cutting-off and grinding wheels should only be used for materials they are suitable for. This is shown by means of pictograms on the product, on the packaging and in the catalogue.

### Cutting-off

When cutting-off, keep the wheel straight in the cut and add only radial pressure to the wheel.

### Grinding

When grinding keep the wheel at an angle of 20/30 degrees or more to the work piece.

## PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

### PERSONAL PROTECTION



Mouth Protection



Wear Gloves



Eye Protection



Ear Protection



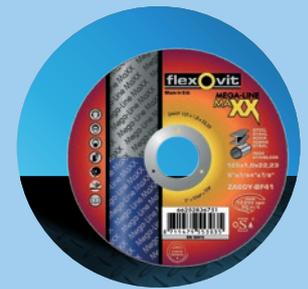
Read Instruction



Not for Side Grinding



Do not use Damaged Wheel



## PROTECTION OF THE WORKPIECE

Hand-held grinders should be used in such a manner that sparks fly away from the operators body and any flammable material.

## SAFETY GUARDS

The wheel guard of the machine must be in position and securely fixed.

## STOPPING THE MACHINE

Switch off the machine and allow the wheel to stop completely before placing it on a bench or on the floor. Never bring the wheel to rest by applying pressure to the wheel surface.

## Selecting the Right Product

### GRINDING WHEELS

	Steel, construction steel	Low-alloy steel	High-alloy steel	Thin sheets, plates profiles	Stainless steel, inox	Rail	Cast iron	Non-ferrous	Titanium	Stone, concrete	Glass, plastics, pvc
A24P MAXX	●	●	●		◐	●	●		◐		
A24/30S Speedoflex	●	●	◐	◐	◐		◐				
A24/30RS Speedoflex	●	●	◐	◐			◐				
A24/30Q Speedoflex	●	●	◐	◐	◐		◐				
A24Q Fast Cut	●	●	◐		◐		◐				
A30S General Purpose	●	●	◐		◐		◐				
A24V Long Life	◐	◐	●		●		◐				
ZA24Q Zirconia	◐	◐	●		●		●		◐		
A30P HP Mega-Line	●	●	●		●	●	◐				
A30W Mega-Line	●	●	◐	●	◐		◐				
A30Q INOX Mega-Line	◐	◐	●		●		◐				
ZA24R INOX Foundry	◐	◐	●		●		●				
ZA203R Foundry	◐	◐	◐		◐		●				
ZA203T Foundry	◐	◐	◐		◐		●				
A36Q Alu	◐	◐	◐		◐		●	●	●	●	●
C24/30RS Speedoflex											
C30T General Purpose							●		●	●	●

#### USAGE KEY

- strongly recommended
- ◐ recommended

## CUTTING-OFF WHEELS

Steel, construction steel	Low-alloy steel	High-alloy steel	Thin sheets, plates profiles	Stainless steel, inox	Rail	Cast iron	Non-ferrous	Titanium	Stone, concrete	Tiles, ceramic	Glass, plastics, pvc	
●	●	●	●	●								ZA 60 Y-BF41 Mega-Line
◐	◐	●	●	●			◐	◐				A46/60V Inox Speedoflex
●	●	◐	◐	◐		◐						A24/30S Speedoflex
●	●	◐	◐			◐						A24/30RS Speedoflex
◐	◐	●	●	●			◐	◐				A60T Thin Cut
●	●	◐	◐	◐		◐						A30S General Purpose
◐	◐	●	◐	●	●	◐						A24V INOX Long Life
●	●	◐	◐	◐		◐						A30V Extra Long Life
◐	◐	●	●	●			◐	◐				A60V INOX Mega-Line
◐	◐	●	◐	●		◐						A24V INOX Mega-Line
◐	◐	◐	●	◐								A60W Mega-Line
●	●	◐	◐	◐		◐						A30W Mega-Line
◐	◐	◐		◐		●						ZA24R Foundry
◐	◐	◐		◐		●						ZA30S Foundry
◐	◐	◐		◐		●						ZA203T Foundry
◐	◐	◐		◐		●						ZAC24S Foundry
●	●	●		●	◐	◐						A30S Petrol Saw
●	●	●		●								A30S Chop Saw
◐	◐	◐		◐	●							A24P Rail Cut
◐	◐	◐		◐	●							A24Q Rail Cut
◐	◐	◐		◐	●							ZA24Q Rail Cut
									●		●	C30S Petrol Saw
◐	◐	◐	●	◐			●	●				A60Q Alu

### USAGE KEY

- strongly recommended
- ◐ recommended

# Cutting-Off & Grinding Wheels

## CUTTING-OFF WHEELS

A36Q Alu
C24/30RS Speedoflex
C30S/C30T General Purpose

	Steel, construction steel	Low-alloy steel	High-alloy steel	Thin sheets, plates profiles	Stainless steel, inox	Rail	Cast iron	Non-ferrous	Titanium	Stone, concrete	Tiles, ceramic	Glass, plastics, pvc
A36Q Alu	◐	◐	◐	◐	◐		◐	●	●			
C24/30RS Speedoflex							●		●	●		●
C30S/C30T General Purpose							◐		●	●	●	

### USAGE KEY

- strongly recommended
- ◐ recommended

# Cutting-Off & Grinding Wheels

Wheels  
for Angle  
Grinders



# Centre of Excellence

To familiarize customers with the biggest advantages of our advanced solutions, Flexovit regularly invites customers to the dedicated Centre of Excellence in Eibergen, The Netherlands. This technical grinding centre has an excellent reputation when it comes to testing cutting and grinding wheels and it has machines at its disposal which are selected with care for the most occurring grinding situations.

All Flexovit cutting- and grinding wheels from diameter 76 to 406mm can be tested here on grinding performance and on security.

The Centre of Excellence Flexovit also disposes of facilities to give customized trainings. All users and sellers of our products can be trained by us. Our trainings are based on more than 70 years of experience within the Saint-Gobain Abrasives group. Participants can put into practice what they learned by doing grinding tests.

Upon demand Flexovit specialists can carry out product tests on location, to find technical solutions for problems. Motives for a test on location can be; the material/object to be treated, the machine on which the wheels are mounted or the work situation of the user.



# Cutting-Off & Grinding Wheels

**flex**  **vit**

*Mega-Line*



Flexovit Mega-Line is the premium quality product line of Flexovit and contains cutting-off and grinding wheels, designed to meet the demands of the most discerning users. The products work faster and have a longer life resulting in lower operating costs. The products have been designed to be exceptionally user friendly and easy to use, satisfying the ultimate requirements of the professional user.

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# Cutting-Off & Grinding Wheels



# Wheels for Angle Grinders

## Grinding – BF 27

**MEGA-LINE MAXX CUT** FLEXOVIT MAXX CUT GRINDING WHEELS FOR ULTIMATE COMFORT AND METAL REMOVAL



- Super Fast stock removal
- Steel/stainless steel/inox
- Premium Performance for demanding operations
- Very comfortable working

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	A 24 P	10	66252844265	8711479579288
125 x 7.0 x 22.23	A 24 P	10	66252844266	8711479579295
180 x 7.0 x 22.23	A 24 P	10	66252844267	8711479579301
230 x 7.0 x 22.23	A 24 P	10	66252844268	8711479579318

**MEGA-LINE MAXX ZIRCONIA** FLEXOVIT MAXX ZIRCONIA GRINDING WHEELS



- Steel/stainless steel/inox
- Premium Performance for demanding operations
- Long wheellife
- 180 and 230mm optimized for High Frequency Grinders
- Easy to use
- Fast stock removal
- Long Life

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	ZA 24 Q	10	66252842311	8711479577239
125 x 7.0 x 22.23	ZA 24 Q	10	66252842312	8711479577246
180 x 7.0 x 22.23	ZA 24 Q HF	10	66252844524	8711479580635
230 x 7.0 x 22.23	ZA 24 Q HF	10	66252844525	8711479580642

**Mega-Line** A 30 W-BF27



- Steel
- Heavy and rough grinding jobs
- Optimised for sharp edges
- Long wheellife
- Easy to use

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	A 30 W-BF27	10	66252919149	8711479259449
125 x 7.0 x 22.23	A 30 W-BF27	10	66252919150	8711479259661
150 x 7.0 x 22.23	A 30 W-BF27	10	66252919674	8711479269127
180 x 7.0 x 22.23	A 30 W-BF27	10	66252919151	8711479259883
180 x 8.0 x 22.23	A 30 W-BF27	10	66252829249	8711479259968
230 x 7.0 x 22.23	A 30 W-BF27	10	66252919153	8711479261176
230 x 8.0 x 22.23	A 30 W-BF27	10	66252919720	8711479260247

## Mega-Line A 30 Q-BF27 INOX



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife
- Easy to use
- Fast stock removal

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	A 30 Q-BF27 INOX	10	66252919148	8711479259401
125 x 7.0 x 22.23	A 30 Q-BF27 INOX	10	66252833006	8711479259623
150 x 7.0 x 22.23	A 30 Q-BF27 INOX	10	66252919673	8711479260988
180 x 7.0 x 22.23	A 30 Q-BF27 INOX	10	66252833013	8711479259845
180 x 8.0 x 22.23	A 30 Q-BF27 INOX	10	66252919691	8711479259982
230 x 7.0 x 22.23	A 30 Q-BF27 INOX	10	66252919713	8711479260148
230 x 8.0 x 22.23	A 30 Q-BF27 INOX	10	66252919719	8711479261190



## Mega-Line A 30 P-BF27 HP



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Fast stock removal
- Operator friendly
- Easy to use

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
180 x 7.0 x 22.23	A 30 P-BF27 HP	10	66252829243	8711479108464
180 x 8.0 x 22.23	A 30 P-BF27 HP	10	66252919696	8711479333118
230 x 7.0 x 22.23	A 30 P-BF27 HP	10	66252829272	8711479330711
230 x 8.0 x 22.23	A 30 P-BF27 HP	10	66252919724	8711479333125



## Mega-View Grinding & Polishing Grinding – BF 29



### Mega-View A 60 T-BF29/A 36 T-BF29



- Steel/stainless steel/inox
- Continuous view of workpiece
- Grinding and polishing in 1 action
- Long wheellife
- Low vibrations
- Comfortable working; operator friendly
- Uniquely patterned face prevents loading
- No backing pad needed
- Use at 15° angle
- Grit 36 for stock removal
- Grit 60 for polishing

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 4.0 x 22.23	A 36 T-BF29	20	66252828974	8711479358487
115 x 4.0 x 22.23	A 60 T-BF29	20	66252828975	8711479358517
125 x 4.0 x 22.23	A 36 T-BF29	20	66252828976	8711479358531
125 x 4.0 x 22.23	A 60 T-BF29	20	66252828977	8711479356865





## Wheels for Angle Grinders

### Cutting – BF 41



- High metal removal rate
- Fast cutting
- High stability
- Low vibration
- Less material loss
- Less noise & dust
- Less energy consumption
- Burr-free cutting
- White and clean cutting
- Extreme precision and straight cutting

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	ZA 60 Y-BF41	25	66252836749	8711479553011
115 x 1.3 x 22.23	ZA 60 Y-BF41	25	66252836911	8711479553967
115 x 1.6 x 22.23	ZA 46 Y-BF41	25	66252836750	8711479553028
125 x 1.0 x 22.23	ZA 60 Y-BF41	25	66252836751	8711479553035
125 x 1.3 x 22.23	ZA 60 Y-BF41	25	66252836912	8711479553974
125 x 1.6 x 22.23	ZA 46 Y-BF41	25	66252836752	8711479553042
125 x 2.0 x 22.23	ZA 46 Y-BF41	25	66252844450	8711479580536
180 x 1.6 x 22.23	ZA 46 Y-BF41	25	66252841204	8711479571435
230 x 1.9 x 22.23	ZA 46 Y-BF41	25	66252841205	8711479571442



A 60 V-BF41 INOX/A 46 V-BF41 INOX/A 36 V-BF41 INOX



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheel life
- Quick cutting
- Easy to use
- Optimised for powerful machines
- High stability

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	A 60 V-BF41 INOX	25	66252832594	8711479293214
115 x 1.6 x 22.23	A 46 V-BF41 INOX	25	66252832920	8711479303203
125 x 1.0 x 22.23	A 60 V-BF41 INOX	25	66252832599	8711479293276
125 x 1.6 x 22.23	A 46 V-BF41 INOX	25	66252919145	8711479303227
180 x 1.6 x 22.23	A 36 V-BF41 INOX	25	66252832607	8711479312946
230 x 1.9 x 22.23	A 36 V-BF41 INOX	25	66252832923	8711479318740

## Mega-Line A 24 V-BF<sub>41</sub> INOX



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheel life
- Quick cutting
- Easy to use
- Optimised for powerful machines
- High stability

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919380	8711479299162
125 x 2.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919381	8711479299179
180 x 2.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919382	8711479299186
230 x 2.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919383	8711479299193
115 x 2.5 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919977	8711479261701
125 x 2.5 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252920007	8711479261787
150 x 2.5 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252920023	8711479261824
180 x 2.5 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252920042	8711479261862
180 x 3.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252920050	8711479261886
230 x 2.5 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252920065	8711479299209
230 x 3.0 x 22.23	A 24 V-BF <sub>41</sub> INOX	25	66252919221	8711479261923



## Mega-Line A 60 W-BF<sub>41</sub>/A 46 W-BF<sub>41</sub>/A 30 W-BF<sub>41</sub>



- Steel
- Long wheel life
- Quick cutting
- Easy to use
- Optimised for powerful machines

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	A 60 W-BF <sub>41</sub>	25	66252832592	8711479293191
115 x 1.6 x 22.23	A 46 W-BF <sub>41</sub>	25	66252833016	8711479293238
125 x 1.0 x 22.23	A 60 W-BF <sub>41</sub>	25	66252833017	8711479293252
125 x 1.6 x 22.23	A 46 W-BF <sub>41</sub>	25	66252833019	8711479293290
115 x 2.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66252919973	8711479299117
125 x 2.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66252950809	8711479299124
180 x 2.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920036	8711479299131
230 x 2.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66243451721	8711479299148
115 x 2.5 x 22.23	A 30 W-BF <sub>41</sub>	25	66252919981	8711479256868
125 x 2.5 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920009	8711479120824
150 x 2.5 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920024	8711479269165
180 x 2.5 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920044	8711479257049
180 x 3.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66252831067	8711479257087
230 x 2.5 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920066	8711479299155
230 x 3.0 x 22.23	A 30 W-BF <sub>41</sub>	25	66252920074	8711479257223





## Wheels for Angle Grinders

### Cutting – BF 42



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- 0.8mm wheel thickness for extremely precise and straight cutting
- Optimised for material thickness < 2mm

- Reduced energy consumption
- Low noise, dust and material loss
- Less sparks
- Minimal vibration

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 0.8 x 22.23	ZA 60 Y-BF42	25	66252840226	8711479564499
125 x 0.8 x 22.23	ZA 60 Y-BF42	25	66252840227	8711479564505

### Mega-Line A 24 V-BF42 INOX



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife

- Quick cutting
- Easy to use
- Optimised for powerful machines

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252919154	8711479260889
125 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252919657	8711479260902
150 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252919669	8711479260940
180 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252919676	8711479331749
230 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252919702	8711479331763
115 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252919647	8711479331787
125 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252919659	8711479264245
180 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252919679	8711479261053
230 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252829578	8711479261114

### Mega-Line A 30 W-BF42



- Steel
- Long wheellife
- Quick cutting

- Easy to use
- Optimised for powerful machines

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.5 x 22.23	A 30 W-BF42	25	66252919155	8711479259241
125 x 2.5 x 22.23	A 30 W-BF42	25	66252919156	8711479259487
180 x 2.5 x 22.23	A 30 W-BF42	25	66252919678	8711479261213
230 x 2.5 x 22.23	A 30 W-BF42	25	66252919703	8711479261091
115 x 3.0 x 22.23	A 30 W-BF42	25	66252919648	8711479331725
125 x 3.0 x 22.23	A 30 W-BF42	25	66252919660	8711479264269
180 x 3.0 x 22.23	A 30 W-BF42	25	66252919157	8711479261039
230 x 3.0 x 22.23	A 30 W-BF42	25	66252832569	8711479261138

# Cutting-Off & Grinding Wheels

**flex**  **vit**



Throughout the world, Flexovit cutting-off and grinding wheels are used extensively in a range of industries including aerospace, automotive, foundry, fabrication, ship-building and construction. Flexovit's wide range of products give high performance and high value levels, leading to lower costs.

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# Cutting-Off & Grinding Wheels



# Wheels for Angle Grinders

## Cutting, Grinding, Polishing – BF27



ALL IN 1 WHEEL



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Cutting, light grinding and polishing with one product
- No more time loss due to machine or product changing
- Low vibrations
- Comfortable working; operator friendly
- Excellent and uniform finishing result
- Maximum safety due to 3 layered strong reinforcement

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.2 x 22.23	A 46 S-BF27	25	66252830579	8711479428043
125 x 2.2 x 22.23	A 46 S-BF27	25	66252830580	8711479428067

## Grinding – BF 27

**flexOvit** ZIRCONIA



- Steel/stainless steel/inox/cast iron
- Free of iron, sulphur and chlorine
- Fast stock removal
- Long wheellife

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	ZA 24 Q-BF27	10	66252829208	8711479329012
125 x 7.0 x 22.23	ZA 24 Q-BF27	10	66252829223	8711479329036
150 x 7.0 x 22.23	ZA 24 Q-BF27	10	66252919672	8711479329050
180 x 7.0 x 22.23	ZA 24 Q-BF27	10	66252829248	8711479329074
180 x 8.0 x 22.23	ZA 24 Q-BF27	10	66252919693	8711479329098
230 x 7.0 x 22.23	ZA 24 Q-BF27	10	66252829278	8711479329111
230 x 8.0 x 22.23	ZA 24 Q-BF27	10	66252919723	8711479329135

**flexOvit** LONG LIFE - COMBINATION WHEEL



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 4.0 x 16.0	A 24 V-BF27	20	66252829177	8711479259227
115 x 4.0 x 22.23	A 24 V-BF27	20	66252829194	8711479106590
125 x 4.0 x 22.23	A 24 V-BF27	20	66252918945	8711479107221
150 x 4.5 x 22.23	A 24 V-BF27	20	66252919671	8711479107702
180 x 4.0 x 22.23	A 24 V-BF27	20	66252829229	8711479108204
230 x 4.0 x 22.23	A 24 V-BF27	20	66252829256	8711479109935

**flexOvit** LONG LIFE



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 7.0 x 16.0	A 24 V-BF27	10	66252829181	8711479106330
115 x 7.0 x 22.23	A 24 V-BF27	10	66252829204	8711479106866
125 x 7.0 x 22.23	A 24 V-BF27	10	66252829225	8711479107566
150 x 7.0 x 22.23	A 24 V-BF27	10	66252918946	8711479107801
180 x 7.0 x 22.23	A 24 V-BF27	10	66252829242	8711479108891
230 x 7.0 x 22.23	A 24 V-BF27	10	66252829271	8711479110467

# Cutting-Off & Grinding Wheels

## flexOvit GENERAL PURPOSE - COMBINATION WHEEL



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 4.5 x 16.0	A 30 S-BF27	20	66252829176	8711479331701
115 x 4.5 x 22.23	A 30 S-BF27	20	66252829193	8711479106637
125 x 4.0 x 22.23	A 30 S-BF27	20	66252829211	8711479107207
150 x 4.0 x 22.23	A 30 S-BF27	20	66252832891	8711479107665
180 x 4.0 x 22.23	A 30 S-BF27	20	66252829230	8711479108143
230 x 4.0 x 22.23	A 30 S-BF27	20	66252950741	8711479109751



## flexOvit GENERAL PURPOSE



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 7.0 x 16.0	A 30 S-BF27	10	66252829182	8711479103834
115 x 7.0 x 22.23	A 30 S-BF27	10	66252829205	8711479103858
125 x 7.0 x 22.23	A 30 S-BF27	10	66252829220	8711479105029
150 x 7.0 x 22.23	A 30 S-BF27	10	66252832558	8711479107740
180 x 7.0 x 22.23	A 30 S-BF27	10	66252829244	8711479108716
230 x 7.0 x 22.23	A 30 S-BF27	10	66252833243	8711479110320



## flexOvit FAST CUT



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Fast stock removal

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	A 24 Q-BF27	10	66252829203	8711479327322
125 x 7.0 x 22.23	A 24 Q-BF27	10	66252829224	8711479327346
150 x 7.0 x 22.23	A 24 Q-BF27	10	66252918893	8711479327360
180 x 7.0 x 22.23	A 24 Q-BF27	10	66252829241	8711479326790
180 x 8.0 x 22.23	A 24 Q-BF27	10	66252919694	8711479331022
230 x 7.0 x 22.23	A 24 Q-BF27	10	66252829270	8711479327384
230 x 8.0 x 22.23	A 24 Q-BF27	10	66252919726	8711479331060



## flexOvit ALU



- Non-ferrous
- Free of iron, sulphur and chlorine
- Special combination counteracts loading and wheel glazing

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 7.0 x 16.0	A 36 Q-BF27	10	66252918944	8711479106316
115 x 7.0 x 22.23	A 36 Q-BF27	10	66252829206	8711479106835
125 x 7.0 x 22.23	A 36 Q-BF27	10	66252833005	8711479107504
150 x 7.0 x 22.23	A 36 Q-BF27	10	66252832921	8711479187711
180 x 7.0 x 22.23	A 36 Q-BF27	10	66252829245	8711479108990
230 x 7.0 x 22.23	A 36 Q-BF27	10	66252832861	8711479260209





## Wheels for Angle Grinders

### Grinding – BF 27 (cont)



#### flexOvit GENERAL PURPOSE



- Stone/cast iron
- Iron free
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	C 30 T-BF27	10	66252829597	8711479104992
125 x 7.0 x 22.23	C 30 T-BF27	10	66252829221	8711479105036
180 x 7.0 x 22.23	C 30 T-BF27	10	66252829246	8711479105074
230 x 7.0 x 22.23	C 30 T-BF27	10	66252833245	8711479305115

### Cutting – BF 41



#### flexOvit LONG LIFE



- Steel
- Long wheellife

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 30 V-BF41 EXTRA	25	66252950746	8711479120138
125 x 2.0 x 22.23	A 30 V-BF41 EXTRA	25	66252950747	8711479120671
150 x 2.0 x 22.23	A 30 V-BF41 EXTRA	25	66252920021	8711479121197
180 x 2.0 x 22.23	A 30 V-BF41 EXTRA	25	66252832610	8711479121609
230 x 2.0 x 22.23	A 30 V-BF41 EXTRA	25	66252829290	8711479122378
115 x 2.5 x 22.23	A 30 V-BF41 EXTRA	25	66252919980	8711479104909
125 x 2.5 x 22.23	A 30 V-BF41 EXTRA	25	66252920008	8711479104916
150 x 2.5 x 22.23	A 30 V-BF41 EXTRA	25	66252920022	8711479121319
180 x 2.5 x 22.23	A 30 V-BF41 EXTRA	25	66252920043	8711479103919
230 x 2.5 x 22.23	A 30 V-BF41 EXTRA	25	66252829289	8711479104930

#### flexOvit LONG LIFE



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 24 V-BF41 INOX	25	66252831036	8711479120190
125 x 2.0 x 22.23	A 24 V-BF41 INOX	25	66252829287	8711479120770
150 x 2.0 x 22.23	A 24 V-BF41 INOX	25	66252920020	8711479188749
180 x 2.0 x 22.23	A 24 V-BF41 INOX	25	66252919163	8711479121661
230 x 2.0 x 22.23	A 24 V-BF41 INOX	25	66252832614	8711479122453
115 x 2.5 x 22.23	A 24 V-BF41 INOX	25	66252829283	8711479120268
125 x 2.5 x 22.23	A 24 V-BF41 INOX	25	66252918947	8711479120916
150 x 2.5 x 22.23	A 24 V-BF41 INOX	25	66252918949	8711479121401
180 x 2.5 x 22.23	A 24 V-BF41 INOX	25	66252831060	8711479121821
230 x 2.5 x 22.23	A 24 V-BF41 INOX	25	66252829288	8711479122606

## flexOvit THIN CUT



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Easy and comfortable cutting
- Burr-free cutting result
- High stability

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	A 60 T-BF41	25	66252829282	8711479261640
115 x 1.6 x 22.23	A 46 T-BF41	25	66252833015	8711479331251
125 x 1.0 x 22.23	A 60 T-BF41	25	66252829285	8711479261725
125 x 1.6 x 22.23	A 46 T-BF41	25	66252833018	8711479331275
150 x 1.0 x 22.23	A 60 T-BF41	25	66252832962	8711479332494
150 x 1.6 x 22.23	A 46 T-BF41	25	66252832605	8711479121135
180 x 1.6 x 22.23	A 46 T-BF41	25	66252832606	8711479326752
230 x 1.9 x 22.23	A 46 T-BF41	25	66252829660	8711479326776



## flexOvit GENERAL PURPOSE



- Steel/stainless steel/inox
- Free of iron sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 30 S-BF41	25	66252920392	8711479120114
125 x 2.0 x 22.23	A 30 S-BF41	25	66252920003	8711479120596
180 x 2.0 x 22.23	A 30 S-BF41	25	66252919160	8711479121562
230 x 2.0 x 22.23	A 30 S-BF41	25	66252832613	8711479122255
100 x 2.5 x 16.0	A 30 S-BF41	25	66252829280	8711479103667
115 x 2.5 x 22.23	A 30 S-BF41	25	66252950914	8711479103674
125 x 2.5 x 22.23	A 30 S-BF41	25	66252920476	8711479120879
150 x 2.5 x 22.23	A 30 S-BF41	25	66252918948	8711479104923
180 x 2.5 x 22.23	A 30 S-BF41	25	66252829685	8711479121760
230 x 2.5 x 22.23	A 30 S-BF41	25	66252831080	8711479122545





## Wheels for Angle Grinders

### Cutting – BF 41 (cont)

#### flexOvit ALU



- Special combination counteracts loading and wheel glazing

- Non-ferrous
- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	A 60 Q-BF41	25	66252832590	8711479334740
115 x 1.6 x 22.23	A 46 Q-BF41	25	66252832919	8711479334764
125 x 1.0 x 22.23	A 60 Q-BF41	25	66252832598	8711479334788
125 x 1.6 x 22.23	A 46 Q-BF41	25	66252951061	8711479334801
180 x 1.6 x 22.23	A 46 Q-BF41	25	66252832925	8711479334825
230 x 1.9 x 22.23	A 46 Q-BF41	25	66252832924	8711479334849
100 x 2.5 x 16.0	A 36 Q-BF41	25	66252829292	8711479182044
115 x 2.5 x 22.23	A 36 Q-BF41	25	66252918923	8711479120213
125 x 2.5 x 22.23	A 36 Q-BF41	25	66252829286	8711479120930
150 x 2.5 x 22.23	A 36 Q-BF41	25	66252920029	8711479121425
180 x 2.5 x 22.23	A 36 Q-BF41	25	66252833020	8711479121739
230 x 2.5 x 22.23	A 36 Q-BF41	25	66252833021	8711479122507

#### flexOvit GENERAL PURPOSE



- Stone/cast iron
- Iron free

- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 3.0 x 22.23	C 30 S-BF41	25	66252918959	8711479103704
125 x 3.0 x 22.23	C 30 S-BF41	25	66252918960	8711479103711
150 x 3.0 x 22.23	C 30 S-BF41	25	66252918827	8711479134883
180 x 3.0 x 22.23	C 30 S-BF41	25	66252829662	8711479103728
230 x 3.0 x 22.23	C 30 S-BF41	25	66252950760	8711479103735

## Cutting – BF 42



**flexOvit** LONG LIFE



- Steel
- Long wheel life

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.5 x 22.23	A 30 V-BF42 EXTRA	25	66252832551	8711479104985
125 x 2.5 x 22.23	A 30 V-BF42 EXTRA	25	66252832553	8711479105005
150 x 2.5 x 22.23	A 30 V-BF42 EXTRA	25	66252833007	8711479107627
180 x 2.5 x 22.23	A 30 V-BF42 EXTRA	25	66252832559	8711479105067
230 x 2.5 x 22.23	A 30 V-BF42 EXTRA	25	66252831194	8711479326813



**flexOvit** LONG LIFE



- Stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheel life

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 24 V-BF42 INOX	25	66252831166	8711479255922
125 x 2.0 x 22.23	A 24 V-BF42 INOX	25	66252919655	8711479331381
180 x 2.0 x 22.23	A 24 V-BF42 INOX	25	66252919675	8711479331404
230 x 2.0 x 22.23	A 24 V-BF42 INOX	25	66252950740	8711479186776
100 x 2.5 x 16.0	A 24 V-BF42 INOX	25	66252919004	8711479259203
115 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252831164	8711479184000
125 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252831174	8711479184024
150 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252833234	8711479237690
180 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252833009	8711479184048
230 x 2.5 x 22.23	A 24 V-BF42 INOX	25	66252832566	8711479187117
115 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252831169	8711479106460
125 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252831178	8711479106958
180 x 3.0 x 22.23	A 24 V-BF42 INOX	25	66252831188	8711479107931
230 x 3.4 x 22.23	A 24 V-BF42 INOX	25	66252831197	8711479109454



**flexOvit** GENERAL PURPOSE



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 3.4 x 16.0	A 30 S-BF42	25	66252831155	8711479106019
115 x 3.4 x 22.23	A 30 S-BF42	25	66252831167	8711479103889
125 x 3.4 x 22.23	A 30 S-BF42	25	66252831176	8711479107061
150 x 3.4 x 22.23	A 30 S-BF42	25	66252832557	8711479105043
180 x 3.4 x 22.23	A 30 S-BF42	25	66252831186	8711479103933
230 x 3.4 x 22.23	A 30 S-BF42	25	66252831198	8711479109591



Dimensions Key: D = Diameter, T = Thickness, B = Bore

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## Wheels for Angle Grinders

### Cutting – BF 42



#### flexOvit ALU



- Non-ferrous
- Free of iron, sulphur and chlorine
- Special combination counteracts loading and wheel glazing

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 3.0 x 16.0	A 36 Q-BF42	25	66252918941	8711479105975
115 x 3.0 x 22.23	A 36 Q-BF42	25	66252950734	8711479106408
125 x 3.0 x 22.23	A 36 Q-BF42	25	66252950736	8711479106910
180 x 3.0 x 22.23	A 36 Q-BF42	25	66252832892	8711479107856
230 x 3.0 x 22.23	A 36 Q-BF42	25	66252829416	8711479109515

#### flexOvit GENERAL PURPOSE



- Stone/cast iron
- Iron free
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 3.4 x 22.23	C 30 T-BF42	25	66252833002	8711479103872
125 x 3.4 x 22.23	C 30 T-BF42	25	66252833003	8711479105012
180 x 3.4 x 22.23	C 30 T-BF42	25	66252833012	8711479103940
230 x 3.4 x 22.23	C 30 T-BF42	25	66252831199	8711479105098

# Cutting-Off & Grinding Wheels

**flexOvit**

*SPEEDO*  *FLEX*



Speedoflex cutting-off and grinding wheels offer good levels of performance with excellent price/performance ratio, an excellent economy product. They are suitable for cutting-off and grinding wheels a wide range of materials including steel, stainless steel, cast iron and stone.

**flexOvit**

## Wheels for Angle Grinders

### Grinding – BF 27



#### SPEEDO FLEX A 24/30 S-BF27



- Steel/stainless steel/inox

- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 4.0 x 16.0	A 24/30 S-BF27	20	66252919641	8711479316210
115 x 4.0 x 22.23	A 24/30 S-BF27	20	66252919649	8711479311802
125 x 4.0 x 22.23	A 24/30 S-BF27	20	66252832555	8711479311819
180 x 4.0 x 22.23	A 24/30 S-BF27	20	66252832561	8711479311826
230 x 4.0 x 22.23	A 24/30 S-BF27	20	66252919707	8711479311840

#### SPEEDO FLEX A 24/30 RS-BF27



- Steel

- Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 6.4 x 22.23	A 24/30 RS-BF27	10	66252829195	8711479104817
125 x 6.4 x 22.23	A 24/30 RS-BF27	10	66252829512	8711479104824
150 x 6.4 x 22.23	A 24/30 RS-BF27	10	66252832580	8711479268045
180 x 6.4 x 22.23	A 24/30 RS-BF27	10	66252829231	8711479103926
230 x 6.4 x 22.23	A 24/30 RS-BF27	10	66252829257	8711479184086

#### SPEEDO FLEX A 24/30 Q-BF27



- Steel/stainless steel/inox

- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 6.4 x 16.0	A 24/30 Q-BF27	10	66252919737	8711479327407
115 x 6.4 x 22.23	A 24/30 Q-BF27	10	66252832575	8711479327421
125 x 6.4 x 22.23	A 24/30 Q-BF27	10	66252832577	8711479327445
150 x 6.4 x 22.23	A 24/30 Q-BF27	10	66252832579	8711479327469
180 x 6.4 x 22.23	A 24/30 Q-BF27	10	66252832581	8711479326820
230 x 6.4 x 22.23	A 24/30 Q-BF27	10	66252919152	8711479327483

#### SPEEDO FLEX C 24/30 RS-BF27



- Stone/cast iron

- Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 6.4 x 22.23	C 24/30 RS-BF27	10	66252832957	8711479301919
125 x 6.4 x 22.23	C 24/30 RS-BF27	10	66252950786	8711479301933
150 x 6.4 x 22.23	C 24/30 RS-BF27	10	66252919774	8711479301957
180 x 6.4 x 22.23	C 24/30 RS-BF27	10	66252919136	8711479301971
230 x 6.4 x 22.23	C 24/30 RS-BF27	10	66252829265	8711479301995

## Cutting – BF 41

### SPEEDO FLEX A 46/60 V-BF41 INOX



- Stainless steel/inox

- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 1.0 x 22.23	A 46/60 V-BF41 INOX	25	66252832591	8711479303999
115 x 1.6 x 22.23	A 30/46 V-BF41 INOX	25	66252832596	8711479302015
125 x 1.0 x 22.23	A 46/60 V-BF41 INOX	25	66252832600	8711479304019
125 x 1.6 x 22.23	A 30/46 V-BF41 INOX	25	66252832388	8711479302039
150 x 1.6 x 22.23	A 30/46 V-BF41 INOX	25	66252920018	8711479326691
180 x 1.6 x 22.23	A 30/46 V-BF41 INOX	25	66252832608	8711479326714
230 x 1.9 x 22.23	A 30/46 V-BF41 INOX	25	66252832611	8711479326738



### SPEEDO FLEX A 24/30 S-BF41



- Steel/stainless steel/inox

- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 2.0 x 22.23	A 24/30 S-BF41	25	66252832597	8711479311864
125 x 2.0 x 22.23	A 24/30 S-BF41	25	66252832604	8711479311871
180 x 2.0 x 22.23	A 24/30 S-BF41	25	66252832609	8711479311888
230 x 2.0 x 22.23	A 24/30 S-BF41	25	66252832612	8711479305122
115 x 2.5 x 22.23	A 24/30 S-BF41	25	66252919983	8711479104077
125 x 2.5 x 22.23	A 24/30 S-BF41	25	66252920012	8711479104084
150 x 2.5 x 22.23	A 24/30 S-BF41	25	66252920027	8711479316449
180 x 2.5 x 22.23	A 24/30 S-BF41	25	66252920041	8711479104091
230 x 2.5 x 22.23	A 24/30 S-BF41	25	66252833274	8711479104107



### SPEEDO FLEX A 24/30 RS-BF41



- Steel

- Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 2.5 x 16.0	A 24/30 RS-BF41	25	66252919959	8711479271120
115 x 2.5 x 22.23	A 24/30 RS-BF41	25	66252829423	8711479104749
125 x 2.5 x 22.23	A 24/30 RS-BF41	25	66252950812	8711479104756
150 x 2.5 x 22.23	A 24/30 RS-BF41	25	66252920026	8711479268182
180 x 2.5 x 22.23	A 24/30 RS-BF41	25	66252950813	8711479104763
230 x 2.5 x 22.23	A 24/30 RS-BF41	25	66252950815	8711479104770
115 x 3.0 x 22.23	A 24/30 RS-BF41	25	66252919985	8711479271083
125 x 3.0 x 22.23	A 24/30 RS-BF41	25	66252920016	8711479271106
180 x 3.0 x 22.23	A 24/30 RS-BF41	25	66252920046	8711479270994
230 x 3.0 x 22.23	A 24/30 RS-BF41	25	66252920071	8711479122866



Dimensions Key: D = Diameter, T = Thickness, B = Bore



## Wheels for Angle Grinders

### Cutting – BF 41 (cont)

**SPEEDO FLEX** C 24/30 RS-BF41



• Stone/cast iron

• Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 3.0 x 16.0	C 24/30 RS-BF41	25	66252920203	8711479271205
115 x 3.0 x 22.23	C 24/30 RS-BF41	25	66252920204	8711479104787
125 x 3.0 x 22.23	C 24/30 RS-BF41	25	66252920208	8711479104794
150 x 3.0 x 22.23	C 24/30 RS-BF41	25	66252920211	8711479268168
180 x 3.0 x 22.23	C 24/30 RS-BF41	25	66252920213	8711479267956
230 x 3.0 x 22.23	C 24/30 RS-BF41	25	66252920216	8711479104800

## Cutting – BF 42



### SPEEDO FLEX A 24/30 S-BF42



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 2.5 x 16.0	A 24/30 S-BF42	25	66252919640	8711479182099
115 x 2.5 x 22.23	A 24/30 S-BF42	25	66252832552	8711479104220
125 x 2.5 x 22.23	A 24/30 S-BF42	25	66252832554	8711479104633
180 x 2.5 x 22.23	A 24/30 S-BF42	25	66252832560	8711479104237
230 x 2.5 x 22.23	A 24/30 S-BF42	25	66252832571	8711479104244
230 x 3.0 x 22.23	A 24/30 S-BF42	25	66252832568	8711479311833



### SPEEDO FLEX A 24/30 RS-BF42



- Steel
- Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
100 x 3.0 x 16.0	A 24/30 RS-BF42	25	66252831156	8711479271144
115 x 3.0 x 22.23	A 24/30 RS-BF42	25	66252831168	8711479268069
125 x 3.0 x 22.23	A 24/30 RS-BF42	25	66252829414	8711479182464
150 x 3.0 x 22.23	A 24/30 RS-BF42	25	66252832578	8711479268083
180 x 3.0 x 22.23	A 24/30 RS-BF42	25	66252831187	8711479268106
230 x 3.0 x 22.23	A 24/30 RS-BF42	25	66252831204	8711479269844



### SPEEDO FLEX C 24/30 RS-BF42



- Stone
- Iron free

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 3.0 x 22.23	C 24/30 RS-BF42	25	66252832574	8711479111617
125 x 3.0 x 22.23	C 24/30 RS-BF42	25	66252832576	8711479112393
180 x 3.0 x 22.23	C 24/30 RS-BF42	25	66252831193	8711479269899
230 x 3.0 x 22.23	C 24/30 RS-BF42	25	66252831209	8711479114175



Dimensions Key: D = Diameter, T = Thickness, B = Bore



# Cutting-Off & Grinding Wheels

## Small Diameter Wheels



# Cutting-Off & Grinding Wheels



## Small Diameter Wheels

### Grinding – BF 27



#### flexOvit GENERAL PURPOSE



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
76 x 4.5 x 10.0	A 30 S-BF27	50	66252919030	8711479105623
76 x 7.0 x 10.0	A 30 S-BF27	50	66252829279	8711479105661

### Cutting – BF 41



#### flexOvit GENERAL PURPOSE



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Universal applications

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
76 x 2.0 x 6.0	A 30 S-BF41	100	66252919946	8711479119286
76 x 2.0 x 8.0	A 30 S-BF41	100	66252919947	8711479119309
76 x 2.0 x 10.0	A 30 S-BF41	100	66252950745	8711479119347

#### flexOvit THIN CUT



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Easy and comfortable cutting
- Burr-free cutting result
- High stability

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
76 x 1.0 x 6.0	A 60 T-BF41	100	66252919378	8711479119088
76 x 1.0 x 8.0	A 60 T-BF41	100	66252919940	8711479329449
76 x 1.0 x 10.0	A 60 T-BF41	100	66252833014	8711479119149
76 x 1.6 x 6.0	A 46 T-BF41	100	66252919000	8711479119187
76 x 1.6 x 8.0	A 46 T-BF41	100	66252919944	8711479329463
76 x 1.6 x 10.0	A 46 T-BF41	100	66252833237	8711479119224

# Cutting-Off & Grinding Wheels

## Foundry





## Foundry

### Grinding – BF 27

#### flexOvit Foundry ZA 203 T



- Hardness: hard
- Steel/nodular and grey cast iron

- Optimised for high frequency machines with power > 3KW

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 7.0 x 22.23	ZA 203 T-BF27	10	66252829266	8711479110566

#### flexOvit Foundry ZA 203 R



- Hardness: medium
- Steel/nodular and grey cast iron

- Optimised for high frequency machines with power > 3KW

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
115 x 7.0 x 22.23	ZA 203 R-BF27	10	66252829207	8711479334955
125 x 7.0 x 22.23	ZA 203 R-BF27	10	66252829222	8711479260926
180 x 7.0 x 22.23	ZA 203 R-BF27	10	66252829247	8711479261077
230 x 7.0 x 22.23	ZA 203 R-BF27	10	66252832573	8711479240126

#### flexOvit Foundry ZA 24 R INOX



- Hardness: medium
- Stainless steel/inox/modular and grey cast iron

- Free of iron, sulphur and chlorine
- Optimised for high frequency machines with power > 3KW

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
180 x 7.5 x 22.23	ZA 24 R-BF27 INOX	10	66252833222	8711479304392
230 x 7.5 x 22.23	ZA 24 R-BF27 INOX	10	66252832955	8711479304415

#### flexOvit Foundry ZA 30 S



- Hardness: medium

- Steel/nodular and grey cast iron

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 4.0 x 22.23	ZA 30 S-BF27	20	66252919708	8711479109973
230 x 4.5 x 22.23	ZA 30 S-BF27	20	66252829252	8711479243165
230 x 5.0 x 22.23	ZA 30 S-BF27	10	66252919711	8711479334931

#### flexOvit Foundry ZA 24 R INOX



- Hardness: soft
- Stainless steel/inox/nodular and grey cast iron

- Free of iron, sulphur and chlorine

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
125 x 7.0 x 22.23	ZA 24 R-BF27 INOX	10	66252919667	8711479304354
180 x 7.0 x 22.23	ZA 24 R-BF27 INOX	10	66252919690	8711479181672
230 x 7.0 x 22.23	ZA 24 R-BF27 INOX	10	66252919715	8711479335150

## Grinding – BF 41 & BF 42

### flexOvit Foundry ZA 203 T



- Hardness: hard
- Nodular and grey cast iron

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 3.4 x 22.23	ZA 203 T-BF42	25	66252950768	8711479186257

### flexOvit Foundry ZA 30 S



- Hardness: medium
- Nodular and grey cast iron

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 3.4 x 22.23	ZA 30 S-BF41	25	66252831082	8711479334894
230 x 3.4 x 22.23	ZA 30 S-BF42	25	66252831202	8711479186738

### flexOvit Foundry ZAC 24 S



- Hardness: medium
- Steel/cast sand/white and grey cast iron
- Special combination of zirconia, aluminium oxide and silicon carbide grain

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 2.5 x 22.23	ZAC 24 S-BF41	25	66252919222	8711479122705
230 x 3.0 x 22.23	ZAC 24 S-BF41	25	66252920075	8711479123078
230 x 3.4 x 22.23	ZAC 24 S-BF42	25	66252829573	8711479336997

### flexOvit Foundry ZA 24 R



- Hardness: soft
- Nodular and grey cast iron

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
230 x 3.4 x 22.23	ZA 24 R-BF41	25	66252920078	8711479335594
230 x 3.4 x 22.23	ZA 24 R-BF42	25	66252831201	8711479109645





# Cutting-Off & Grinding Wheels

## Rail





## Rail

### Cutting – BF 41

#### flexOvit ZA 24 Q-BF41 HARD



- Rail/steel
- Hardness: hard
- Special combination of zirconia and aluminium oxide grain
- White and straight cuts
- Quick and free cutting
- Long wheellife
- Designed for petrol and electric rail cut machines with clamping device
- 300mm wheels 80m/s
- 356/406mm wheels 100m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 22.23	ZA 24 Q-BF41/80 Rail Cut Hard	10	66252920092	8711479338168
356 x 4.0 x 22.23	ZA 24 Q-BF41/100 Rail Cut Hard	10	66252920150	8711479355882
356 x 4.0 x 25.4	ZA 24 Q-BF41/100 Rail Cut Hard	10	66252833001	8711479338229
406 x 4.0 x 25.4	ZA 24 Q-BF41/100 Rail Cut Hard	10	66252833112	8711479338281

#### flexOvit A 24 Q-BF41 MEDIUM



- Rail/steel
- Hardness: medium
- White and straight cuts
- Quick and free cutting
- Designed for petrol and electric rail cut machines with clamping device
- 300mm wheels 80m/s
- 356/406mm wheels 100m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 22.23	A 24 Q-BF41/80 Rail Cut Medium	10	66252920091	8711479338144
356 x 4.0 x 20.0	A 24 Q-BF41/100 Rail Cut Medium	10	66252920149	8711479378669
356 x 4.0 x 22.23	A 24 Q-BF41/100 Rail Cut Medium	10	66252921826	8711479391347
356 x 4.0 x 25.4	A 24 Q-BF41/100 Rail Cut Medium	10	66252832796	8711479338205
406 x 4.0 x 25.4	A 24 Q-BF41/100 Rail Cut Medium	10	66252832954	8711479338267

#### flexOvit A 24 P-BF41 SOFT

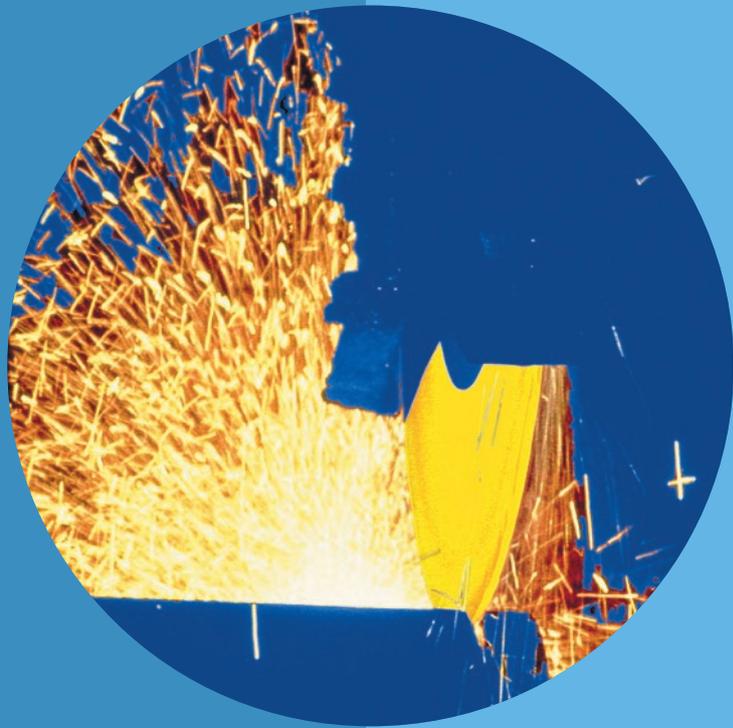


- Rail/steel/stainless steel/inox
- Iron free
- Hardness: soft
- White and straight cuts
- Quick and free cutting
- Designed for petrol and electric rail cut machines with clamping device
- 300mm wheels 80m/s
- 356/406mm wheels 100m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 22.23	A 24 P-BF41/80 Rail Cut Soft	10	66252920090	8711479338120
356 x 4.0 x 25.4	A 24 P-BF41/100 Rail Cut Soft	10	66252833233	8711479338182
406 x 4.0 x 25.4	A 24 P-BF41/100 Rail Cut Soft	10	66252920164	8711479338243

# Cutting-Off & Grinding Wheels

Large  
Diameter  
Wheels





## Large Diameter Wheels

### Petrol Saws – BF 41

#### flexOvit A 30 S-BF41



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheellife
- Quick and free cutting
- 300mm wheels 80m/s
- 356mm wheels 100m/s
- Petrol and electrical saws

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 20.0	A 30 S-BF41/80	10	66252918950	8711479338304
300 x 3.5 x 22.23	A 30 S-BF41/80	10	66252918951	8711479338328
300 x 3.5 x 25.4	A 30 S-BF41/80	10	66252918952	8711479338571
356 x 4.0 x 20.0	A 30 S-BF41/100	10	66252920154	8711479338359
356 x 4.0 x 22.23	A 30 S-BF41/100	10	66252920155	8711479338373
356 x 4.0 x 25.4	A 30 S-BF41/100	10	66252918956	8711479338397

#### flexOvit C 30 S-BF41



- Stone/concrete/masonry
- Iron free
- Long wheellife
- Quick and free cutting
- 300mm wheels 80m/s
- 356mm wheels 100m/s
- Petrol and electrical saws

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 20.0	C 30 S-BF41/80	10	66252951158	8711479338410
300 x 3.5 x 22.23	C 30 S-BF41/80	10	66252951156	8711479338434
300 x 3.5 x 25.4	C 30 S-BF41/80	10	66252951157	8711479338458
356 x 4.0 x 20.0	C 30 S-BF41/100	10	66252920237	8711479338472
356 x 4.0 x 22.23	C 30 S-BF41/100	10	66252920238	8711479338496
356 x 4.0 x 25.4	C 30 S-BF41/100	10	66252918961	8711479338519

#### SPEEDO FLEX A 24/30 S-BF41



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- 80m/s
- Petrol and electrical saws

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 20.0	A 24/30 S-BF41/80	10	66252920115	8711479302800
300 x 3.5 x 22.23	A 24/30 S-BF41/80	10	66252831103	8711479302824
300 x 3.5 x 25.4	A 24/30 S-BF41/80	10	66252833022	8711479291692

## **SPEEDO FLEX** C 24/30 RS-BF41



- Stone
- Iron free
- 80m/s
- Petrol and electrical saws

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 20.0	C 24/30 RS-BF41/80	10	66252920225	8711479302848
300 x 3.5 x 22.23	C 24/30 RS-BF41/80	10	66252833024	8711479302862
300 x 3.5 x 25.4	C 24/30 RS-BF41/80	10	66252920226	8711479291715



## Chop Saws – BF 41

### **flexOvit** A 30 S-BF41



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheel life
- Quick and free cutting
- Burn and burr-free cutting
- High stability provides straight cuts
- Designed for small electric table and fixed machines
- Maximum safety due to 2 reinforcements
- 80m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 2.6 x 25.4	A 30 S-BF41/80	10	66252920082	8711479338533
300 x 2.6 x 32.0	A 30 S-BF41/80	10	66252920084	8711479350276
356 x 2.6 x 25.4	A 30 S-BF41/80	10	66252918953	8711479338557
356 x 2.6 x 32.0	A 30 S-BF41/80	10	66252833057	8711479356087
406 x 3.2 x 25.4	A 30 S-BF41/80	10	66252918957	8711479356100
406 x 3.2 x 32.0	A 30 S-BF41/80	10	69936617084	8711479335082



### **SPEEDO FLEX** A 24/30 S-BF41



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- 80m/s
- Small electric table machines

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 2.6 x 25.4	A 24/30 S-BF41/80	10	66252832864	8711479123610
356 x 2.6 x 25.4	A 24/30 S-BF41/80	10	66252831130	8711479289255





## Large Diameter Wheels

### Stationary Machines – BF 41

**flexOvit** A 30 S-BF41



- Steel/stainless steel/inox
- Free of iron, sulphur and chlorine
- Long wheel life
- Quick and free cutting
- Burn and burr-free cutting
- High stability provides straight cuts
- Designed for stationary machines
- 80m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 3.5 x 22.23	A 30 S-BF41/80	10	66252920097	8711479355929
300 x 3.5 x 25.4	A 30 S-BF41/80	10	66252920098	8711479355943
300 x 3.5 x 32.0	A 30 S-BF41/80	10	66252920100	8711479355967
356 x 3.5 x 25.4	A 30 S-BF41/80	10	66252918954	8711479355981
356 x 3.5 x 32.0	A 30 S-BF41/80	10	66252920130	8711479356001
406 x 4.0 x 25.4	A 30 S-BF41/80	10	66252920168	8711479356025
406 x 4.0 x 32.0	A 30 S-BF41/80	10	66252832996	8711479356049
406 x 4.0 x 40.0	A 30 S-BF41/80	10	66252920169	8711479356063

### Rescue – BF 41

**flexOvit** AC 30 S-BF 41



- Rescue cutting wheel for all kind of materials like metal, stone, concrete, asphalt, rail, glass and pvc thanks to the special blend of premium aluminium oxide and silicon carbide grains
- Quick and free cutting
- Extremely strong reinforcements insure considerable increases of reliability, stability and safety within rescue work
- Designed for powerful portable petrol rescue cutting machines
- 100m/s

Dimensions (mm) D x T x B	Specification	Quantity per Case	Article Number	Barcode
300 x 4.0 x 25.4	AC 30 S-BF41/100	10	66252920112	8711479348211
356 x 4.0 x 25.4	AC 30 S-BF41/100	10	66252920158	8711479348235
406 x 4.5 x 25.4	AC 30 S-BF41/100	10	66252920179	8711479348259

# Diamond Blades



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# Diamond Blades

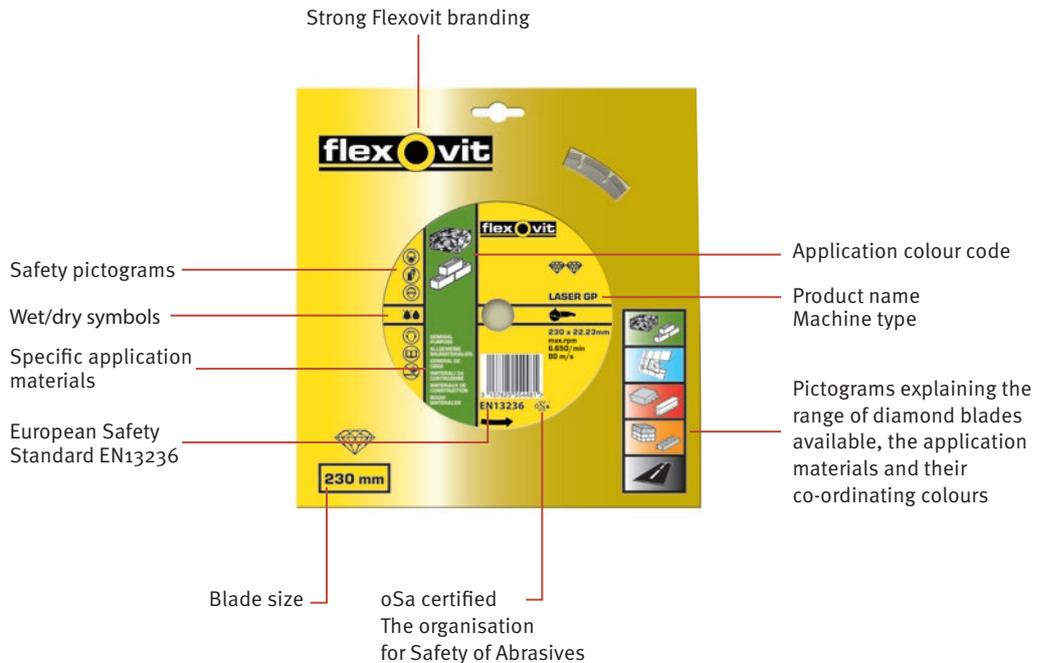


# Technical Information

The use of diamond blades is rapidly growing as people become increasingly more knowledgeable and experienced, demanding better finishes and faster results. With an in depth knowledge of the construction and building industry Flexovit provides a range of diamond blades to meet any demand.

All Flexovit diamond blades conform to the highest European safety standard, EN13236, which ensures that all products are manufactured and tested to the highest quality. All Flexovit products are laser-marked in accordance with the requirements of EN13236.

## Understanding the Product



## Differentiation in the Range

Flexovit offers a comprehensive selection of Diamond Blades helping to meet every requirement encountered in all Industrial and Construction Markets. The Flexovit Industrial Range comprises 3 distinct product lines giving 3 different price/performance levels, satisfying all encountered demands. Flexovit diamond blades are classified into Flexovit Mega-Line (premium performance), Flexovit (high performance), and Flexovit Speedoflex (economy performance) product lines to help you choose the right product for your specific application.



### FLEXOVIT MEGA-LINE

Flexovit Mega-Line is the premium quality product line of Flexovit and contains diamond blades, designed to meet the demands of the most discerning users. The products work faster and have a longer life resulting in lower operating costs. The products have been designed to be exceptionally user friendly and easy to use, satisfying the ultimate requirements of the professional user.



### FLEXOVIT

Flexovit diamond blades are designed for use in a wide range of industries and construction. The wide range of Flexovit products give high performance and high value levels leading to lower costs.



### FLEXOVIT SPEEDOFLEX

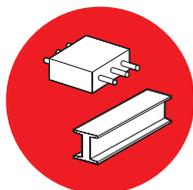
Speedoflex professional diamond blades offer good levels of performance with excellent price/performance ratio, an excellent value for money product. They are suitable for cutting a wide range of materials including concrete, asphalt, stone, and other building materials.



## APPLICATION

Where greater differentiation of products by application is needed, this is done through colour coding.

**Steel/Reinforced  
Concrete**



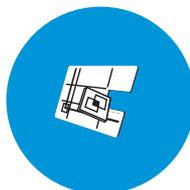
**General Purpose/  
Granite**



**Concrete/  
Hard Materials**



**Tile**



**Asphalt/Abrasive  
Materials**



## Operating Speeds

### MAXIMUM OPERATING SPEED

Diameter (mm)	Max m/s	Max RPM
100	80	15300
115	80	13300
125	80	12250
150	80	10200
180	80	8500
200	80	7650
230	80	6650
250	100	7650
300	100	6400
350	100	5500

**Never exceed the Maximum Operating Speeds:**

- Hand held blades  $\varnothing < 230\text{mm}$  : 80m/s
- Hand held blades  $\varnothing > 230\text{mm}$  : 100m/s
- Others : 63m/s

## Personal Protection

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

### PERSONAL PROTECTION



Mouth  
Protection



Wear  
Gloves



Eye  
Protection



Ear  
Protection



Read  
Instruction



Not for  
Side Grinding



Dry  
Cutting



Wet  
Cutting



## Technical Information

### SAFETY ADVICE – DO'S

For your safety you should ensure that you are fully aware of how to safely use diamond blades

- ✓ **DO** Read the safety instructions provided by the abrasives and equipment supplier
- ✓ **DO** Store abrasives in dry, frost-free conditions avoiding wide variations in temperature
- ✓ **DO** Ensure that the product is suitable for its purpose
- ✓ **DO** Handle, store and transport products with care
- ✓ **DO** Disconnect the power to the machine before fitting the product
- ✓ **DO** Examine all products before mounting and periodically during blade use for possible defects or damage (core flatness, fatigue cracks, undercutting, arbor hole damage...)
- ✓ **DO** Check that correct mounting devices are used and that they are clean, undistorted and free from burrs
- ✓ **DO** Ensure that work rests are properly adjusted and secure
- ✓ **DO** Always use a correctly designed and adjusted guard (on the blade and belts)
- ✓ **DO** Ensure that the workpiece is secure
- ✓ **DO** Wear appropriate personal protective equipment at all times
- ✓ **DO** Avoid clogging and uneven wear to ensure that the product is working efficiently
- ✓ **DO** Ensure accordance between product direction arrow / machine rotation
- ✓ **DO** Ensure that all machines using abrasives meet the requirements of the current european machinery directives-CE
- ✓ **DO** Be aware of the hazards likely during the use of abrasives and observe the recommended precautions to be taken:
  - Bodily contact with the abrasive product at operating speed
  - Injury resulting from product breakage during use
  - Grinding debris, sparks, fumes and dust generated by the grinding process
  - Noise
  - Vibration

## SAFETY ADVICE – DON'TS

For your safety you should ensure that you are fully aware of how to safely use diamond blades

<b>✗</b>	<b>DON'T</b> Allow untrained people to use abrasives
<b>✗</b>	<b>DON'T</b> Use a product that is damaged or one which has been dropped
<b>✗</b>	<b>DON'T</b> Use a product if it cannot be properly identified
<b>✗</b>	<b>DON'T</b> Use a machine that is not in good working order or one with defective parts
<b>✗</b>	<b>DON'T</b> Force the abrasive onto the mounting device or modify the size of the mounting hole
<b>✗</b>	<b>DON'T</b> Exceed the maximum operating speed marked on the product
<b>✗</b>	<b>DON'T</b> Apply shock or excessive force to the product or let it overheat
<b>✗</b>	<b>DON'T</b> Use mounting flanges which are not clean and flat
<b>✗</b>	<b>DON'T</b> Tighten the mounting device excessively
<b>✗</b>	<b>DON'T</b> Start the machine until the guard is in place and fastened securely
<b>✗</b>	<b>DON'T</b> Continue to use a product if vibration occurs. True or replace it
<b>✗</b>	<b>DON'T</b> Grind on the part of the product which is not designed for the operation
<b>✗</b>	<b>DON'T</b> Start the machine with the workpiece in contact with the abrasive product
<b>✗</b>	<b>DON'T</b> Grind material for which the product is not designed
<b>✗</b>	<b>DON'T</b> Stop the abrasive by applying pressure to its surface, let it stop naturally
<b>✗</b>	<b>DON'T</b> Exceed permissible rotation speeds: refer to values engraved on product
<b>✗</b>	<b>DON'T</b> Use blades with missing segments or core cracks
<b>✗</b>	<b>DON'T</b> Use dry products marked for wet use
<b>✗</b>	<b>DON'T</b> Wear loose clothing, ties and jewellery
<b>✗</b>	<b>DON'T</b> Use abrasive products near flammable materials





## Technical Information

### TROUBLESHOOTING

#### Diamond blade does not cut

**Cause** The segments are too hard for the material  
**Solution** Check if the blade is suitable for the material

**Cause** The segments have become blunt  
**Solution** Sharpen the segments by cutting an abrasive material (e.g. sandstone)

**Cause** Insufficient machine power  
**Solution** Check the voltage, machine power and filters

#### Excessive wear

**Cause** The segment is too soft for the material (e.g. if a blade for hard material is used to cut abrasive material)  
**Solution** Check if the diamond blade is suitable for the material

#### Cracking of steel centre

**Cause** The segments are too hard for the material  
**Solution** Check if the blade is suitable for the material

**Cause** Excessive cutting pressure, overheating, material slippage, twisting or jamming in the cut  
**Solution** Leave the blade to do the work, do not exert too much pressure and allow the blade to cool regularly by leaving it to rotate away from the workpiece for a few seconds

#### Loosening or cracking of segments

**Cause** The segments are too hard for the material. This results in the diamond blade bouncing in the cut resulting in cracking segments  
**Solution** Check if the diamond blade is suitable for the material

#### Scorching of segments

**Cause** Excessive cutting pressure causing overheating. This is easily recognisable from the blue colouring where the segments and the steel core are welded together  
**Solution** Allow the diamond blade to cool regularly by rotating the blade away from the workpiece for a few seconds

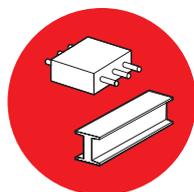
**Cause** The segments are too hard for the material  
**Solution** Check if the diamond blade is suitable for the material. Alternatively use less cutting pressure and let the blade do the work

#### Undercutting

**Cause** Undercutting occurs when the steel core wears faster than the segment, i.e. where the segment and steel core meet. This is usually caused by materials that are highly abrasive. The cutting debris is not removed sufficiently and the steel core is affected. Undercutting is certain to occur if a diamond blade for hard materials is used to cut abrasive materials  
**Solution** Use a diamond blade suitable for the specific material

### APPLICATION COLOUR KEY

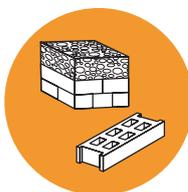
Steel/Reinforced  
Concrete



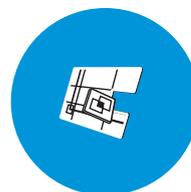
General Purpose/  
Granite



Concrete/  
Hard Materials



Tile



Asphalt/Abrasive  
Materials



# Selecting the Right Product

RED	GREEN								YELLOW	ORANGE				LIGHT BLUE					BLACK		
Mega-Line Laser MP	Mega-Line Turbo Plus	Flexovit Turbo Granit	Flexovit Laser Turbo Granit	Flexovit Laser GP	Flexovit Pro Surf	Speedoflex Laser GP	Speedoflex TURBO	Speedoflex UNI	Silent MAXX	Mega-Line Low Noise	Flexovit Laser Concrete	Flexom MR / CG Turbo	Speedoflex Concrete	Mega-Line Thin Cut Plus	Flexovit Ceram	Flexovit Thin Cut	Flexovit Tile	Speedoflex Tile	Flexovit Laser AS	Speedoflex Asphalt	Abrasiveness
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## Diamond Blades

### ABRASIVENESS

- 1 hard material, not abrasive
- 2 medium hard material, medium abrasive
- 3 soft material, very abrasive

3	Abrasive natural stone
3	Asphalt
1	Brick
2	Cellular concrete
1	Ceramic tiles
1	Clay roof tile
1	Concrete
2	Concrete block
2	Concrete floor
2	Concrete pipe
2	Concrete roof tile
1	Ductile iron
1	Granite
3	Green concrete
2	Hard natural stone
1	Hard roof tile
1	Kerb stone
2	Limestone
1	Marble
2	Mortar
1	Porcelain
1	Quarry tiles
2	Refractory block
1	Reinforced concrete
2	Sandstone
2	Sandstone pipe
1	Steel
1	Terrazo
1	Washed concrete

### USAGE KEY

- strongly recommended
- ◐ recommended
- occasional use



## Diamond Blades



# Technical Information

## MACHINE PICTOGRAMS



Angle Grinder



Hand Drill



Petrol Saw



Masonry Saw



Tile Saw



Floor Saw

# Diamond Blades

## Angle Grinders





## Angle Grinders

### General Purpose & Granite



#### Mega-Line TURBO PLUS



- Sintered diamond blade
- Corrugated jet rim

- Steel centre reinforced with additional flange
- 80m/s maximum operating speed

- Brick, Clay roof tile, Concrete, Concrete block, Concrete pipe, Concrete roof tile, Hard natural stone, Hard roof tile, Kerb stone, Limestone, Refractory block, Reinforced concrete, Sandstone, Washed concrete

- Ceramic tiles, Concrete floor, Granite, Quarry tiles, Sandstone pipe
- Abrasive natural stone, Cellular concrete, Marble, Mortar

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
125 x 12 x 2.4 x 22.23	1	70184623437	5450248233848
230 x 12 x 2.9 x 22.23	1	70184623438	5450248233855

#### flexOvit LASER GP



- Laser-welded diamond blade
- Segmented rim

- Standard steel centre
- 80m/s maximum operating speed

- Brick, Clay roof tile, Concrete, Concrete block, Concrete pipe, Concrete roof tile, Kerb stone, Limestone, Reinforced concrete, Sandstone, Washed concrete

- Cellular concrete, Concrete floor, Granite, Hard roof tile
- Hard natural stone, Marble, Refractory block, Sandstone pipe

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 10 x 2.2 x 22.23	1	70184626410	5450248350408
125 x 10 x 2.2 x 22.23	1	70184626411	5450248350415
150 x 10 x 2.5 x 22.23	1	70184626412	5450248350422
180 x 10 x 2.5 x 22.23	1	70184626413	5450248350439
230 x 10 x 2.5 x 22.23	1	70184626414	5450248350446

#### flexOvit TURBO GRANIT



- Sintered diamond blade
- Corrugated jet rim

- Waved steel centre
- 80m/s maximum operating speed

- Brick, Clay roof tile, Concrete roof tile, Granite, Kerb stone

- Abrasive natural stone, Cellular concrete, Ceramic tiles, Concrete, Concrete block, Concrete floor, Concrete pipe, Hard natural stone, Hard roof tile, Marble, Quarry tiles, Refractory block, Reinforced concrete, Sandstone, Washed concrete

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 9 x 2.2 x 22.23	1	70184623406	5450248233541
125 x 9 x 2.2 x 22.23	1	70184623407	5450248233558
230 x 9 x 3.0 x 22.23	1	70184623408	5450248233565
230 x 9 x 3.0 x 22.23 and Alu-Flange	1	70184623409	5450248233572

## flexovit LASER TURBO GRANIT



- Laser-welded diamond blade
  - Corrugated segmented rim
  - Standard steel centre
  - 80m/s maximum operating speed
- Brick, Clay roof tile, Concrete roof tile, Granite, Kerb stone
- Abrasive natural stone, Cellular concrete, Ceramic tiles, Concrete, Concrete block, Concrete floor, Concrete pipe, Hard natural stone, Hard roof tile, Marble, Quarry tiles, Refractory block, Reinforced concrete, Sandstone, Washed concrete

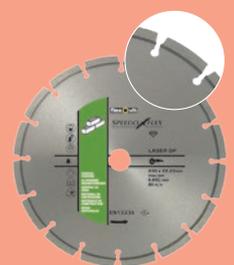


Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 12 x 2.2 x 22.23	1	70184626156	5450248348788
125 x 12 x 2.2 x 22.23	1	70184626157	5450248348795
230 x 15 x 3 x 22.23	1	70184626160	5450248348825

## SPEEDO FLEX LASER GP



- Laser-welded diamond blade
  - Segmented rim
  - Standard steel centre
  - 80m/s maximum operating speed
- Brick, Clay roof tile, Concrete, Concrete block, Concrete pipe, Concrete roof tile, Kerb stone, Limestone, Reinforced concrete
- Cellular concrete, Washed concrete
- Concrete floor, Hard natural stone, Marble, Mortar, Sandstone pipe



Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 7 x 2.2 x 22.23	1	70184623387	5450248233350
125 x 7 x 2.2 x 22.23	1	70184623388	5450248233367
230 x 7 x 2.5 x 22.23	1	70184623389	5450248233374

## SPEEDO FLEX TURBO



- Sintered diamond blade
  - Corrugated turbo rim
  - Perforated steel centre
  - 80m/s maximum operating speed
- Abrasive natural stone, Brick, Cellular concrete, Clay roof tile, Concrete block, Concrete floor, Concrete pipe, Concrete roof tile, Kerb stone, Limestone, Mortar, Refractory block, Sandstone pipe, Washed concrete
- Ceramic tiles, Concrete, Granite, Hard natural stone, Hard roof tile, Marble, Quarry tiles, Reinforced concrete, Sandstone



Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 10 x 2.1 x 22.23	1	70184623377	5450248233268
125 x 10 x 2.2 x 22.23	1	70184623378	5450248233275
230 x 10 x 2.6 x 22.23	1	70184623380	5450248233299



## Angle Grinders

### General Purpose & Granite (cont)



**SPEEDO FLEX UNI**



- Sintered diamond blade
- Segmented rim

- Standard steel centre
- 80m/s maximum operating speed

- Brick, Clay roof tile, Concrete pipe, Concrete roof tile

- Concrete, Concrete block, Kerb stone, Limestone, Reinforced concrete
- Cellular concrete, Concrete floor, Hard natural stone, Marble, Mortar, Washed concrete

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 10 x 2.0 x 22.23	1	70184623382	5450248233305
125 x 10 x 2.1 x 22.23	1	70184623383	5450248233312
150 x 10 x 2.3 x 22.23	1	70184623384	5450248233329
180 x 10 x 2.4 x 22.23	1	70184623385	5450248233343
230 x 10 x 2.5 x 22.23	1	70184623386	5450248233336

### Ceramic & Stone Tiles



**Mega-Line THIN CUT PLUS**



- Sintered diamond blade
- Corrugated extra-thin rim

- Steel centre reinforced with additional flange
- 80m/s maximum operating speed

- Ceramic tiles, Marble, Porcelain, Quarry tiles

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 10.5 x 1.2 x 22.23	1	70184623444	5450248233909
125 x 10.5 x 1.2 x 22.23	1	70184623445	5450248233916

**flexOvit THIN CUT**



- Sintered diamond blade
- Corrugated extra-thin rim

- Perforated steel centre
- 80m/s maximum operating speed

- Ceramic tiles, Porcelain, Quarry tiles

- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 8 x 1.4 x 22.23	1	70184623420	5450248233688
125 x 8 x 1.4 x 22.23	1	70184623421	5450248233695

# Diamond Blades

## flexOvit TILE



- Sintered diamond blade
- Continuous rim
- Standard steel centre
- 80m/s maximum operating speed

- Ceramic tiles, Quarry tiles
- Porcelain
- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 7 x 1.5 x 22.23	1	70184623413	5450248233619
125 x 7 x 1.5 x 22.23	1	70184623414	5450248233626
180 x 7 x 1.7 x 22.23	1	70184623415*	5450248233633

\* Made-to-order



## SPEEDO FLEX TILE



- Sintered diamond blade
- Continuous rim
- Standard steel centre
- 80m/s maximum operating speed

- Ceramic tiles, Quarry tiles
- Porcelain

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
115 x 7 x 1.8 x 22.23	1	70184623390	5450248233381
125 x 7 x 1.8 x 22.23	1	70184623391	5450248233398



## Steel & Reinforced Concrete

### Mega-Line LASER MP



- Laser-welded diamond blade
- Segmented rim
- Perforated steel centre
- 80m/s maximum operating speed

- Abrasive natural stone, Brick, Concrete, Concrete block, Concrete floor, Concrete roof tile, Ductile iron, Kerb stone, Mortar, Reinforced concrete, Steel, Washed concrete
- Asphalt, Cellular concrete, Clay roof tile, Concrete pipe, Granite, Hard natural stone, Hard roof tile, Limestone, Sandstone, Sandstone pipe
- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
125 x 10 x 2.5 x 22.23	1	70184628402**	5450248393184
230 x 12 x 2.5 x 22.23	1	70184623440	5450248233862 <b>NEW!</b>

\*\* steel center without holes



## Diamond Blades



## Angle Grinders

### flexOvit MEGA-LINE MAXX SILENT MAXX



- Laser-welded diamond blade
- Segmented rim
- Silent steel centre
- Very high speed of cut and long life
- 80m/s maximum operating speed

- Brick, Cellular concrete, Concrete, Concrete block, Concrete floor, Concrete pipe, Concrete roof tile, Granite, Kerb stone, Reinforced concrete, Washed concrete
- Mortar, Sandstone, Sandstone pipe
- Clay roof tile

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
230 x 17 x 2.8 x 22.23	1	70184645003	5450248525998

### Concrete & Hard Materials



### flexOvit CG TURBO



- Smoother finish than CG
- Brazed cup grinder
- Segmented rim
- Cup grinder
- 63m/s maximum operating speed
- High speed of grinding

- Marble, Concrete, Terrazo, Granite

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
125 x 5 x 8.0 x 22.23	1	70184630633	5450248443469

### flexOvit FLEXOM MR



- Brazed cup grinder
- Segmented rim
- Cup grinder
- 63m/s maximum operating speed

- Marble, Concrete, Terrazo, Granite

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
100 x 5 x 8.0 x 22.23/16	1	70184622076	5450248232131
125 x 5 x 8.0 x 22.23	1	70184622077	5450248232148

### flexOvit PRO SURF



- Electro-plated diamond blade for both cutting and grinding building materials, concrete, resins, ductile iron, natural stone, granite, marble

Dimensions (mm) D x B x T	Quantity	Article Number	Barcode
125 x M14 x 2.4	1	70184644107	5450248533504

# Diamond Blades

## Tile & Masonry Saws



## General Purpose & Granite



### flexOvit LASER TURBO GRANIT



- Laser-welded diamond blade
  - Corrugated segmented rim
  - Standard steel centre
  - 100m/s maximum operating speed
- Brick, Clay roof tile, Concrete roof tile, Granite, Kerb stone
- Abrasive natural stone, Cellular concrete, Ceramic tiles, Concrete, Concrete block, Concrete floor, Concrete pipe, Hard natural stone, Hard roof tile, Marble, Quarry tiles, Refractory block, Reinforced concrete, Sandstone, Washed concrete

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 12 x 3.2 x 20	1	70184626162	5450248233589
350 x 12 x 3.2 x 25.4	1	70184626163	5450248348856

## Ceramic & Stone Tiles



### flexOvit CERAM



- Sintered diamond blade
  - Continuous rim
  - Standard steel centre
  - 80m/s maximum operating speed
- Ceramic tiles, Marble, Porcelain, Quarry tiles

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
180 x 7 x 1.7 x 30/25.4	1	70184623416	5450248233640
200 x 7 x 1.8 x 30/25.4	1	70184623417	5450248233657
250 x 7 x 1.8 x 25.4	1	70184623418*	5450248233664

\* Made-to-order



## Steel & Reinforced Concrete



### Mega-Line LASER MP



- Laser-welded diamond blade
  - Segmented rim
  - Perforated steel centre
  - 100m/s maximum operating speed
- Abrasive natural stone, Brick, Concrete, Concrete block, Concrete floor, Concrete roof tile, Ductile iron, Kerb stone, Mortar, Reinforced concrete, Steel, Washed concrete
- Asphalt, Cellular concrete, Clay roof tile, Concrete pipe, Granite, Hard natural stone, Hard roof tile, Limestone, Sandstone, Sandstone pipe
- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 10 x 2.5 x 20	1	70184623441	5450248233879
300 x 10 x 2.5 x 25.4	1	70184623472	5450248234005
350 x 10 x 2.8 x 25.4	1	70184623442	5450248233886



## Accessories

### PATENTED QUICKFIX REDUCTION RINGS

- For mounting 25.4 or 22.23mm bored blades, on 20mm spindle machines

Dimensions (mm) D x B	Quantity	Article Number	Barcode
103 x 25.4/22.23/20	1	70184624549	5450248236870

- For mounting 25.4 on 22.23mm spindle machines

Dimensions (mm) D x B	Quantity	Article Number	Barcode
103 x 25.4/22.23	1	70184624550	5450248236887





# Diamond Blades

## Petrol Handheld & Floor Saws



# Diamond Blades



# Petrol Handheld & Floor Saws

## Steel & Reinforced Concrete



### Mega-Line LASER MP



- Laser-welded diamond blade
  - Segmented rim
  - Perforated steel centre
  - 100m/s Maximum Operating Speed
- Abrasive natural stone, Brick, Concrete, Concrete block, Concrete floor, Concrete roof tile, Ductile iron, Kerb stone, Mortar, Reinforced concrete, Steel, Washed concrete
- Asphalt, Cellular concrete, Clay roof tile, Concrete pipe, Granite, Hard natural stone, Hard roof tile, Limestone, Sandstone, Sandstone pipe
- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 10 x 2.5 x 20	1	70184623441	5450248233879

### Mega-Line LASER MP



- Laser-welded diamond blade
  - Segmented rim
  - Perforated steel centre
  - 100m/s maximum operating speed
- Abrasive natural stone, Brick, Concrete, Concrete block, Concrete floor, Concrete roof tile, Ductile iron, Kerb stone, Mortar, Reinforced concrete, Steel, Washed concrete
- Asphalt, Cellular concrete, Clay roof tile, Concrete pipe, Granite, Hard natural stone, Hard roof tile, Limestone, Sandstone, Sandstone pipe
- Marble

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 10 x 2.5 x 25.4	1	70184623472	5450248234005
350 x 10 x 2.8 x 25.4	1	70184623442	5450248233886

## Concrete & Hard Materials



### flexOvit LASER CONCRETE



- Laser-welded diamond blade
  - Segmented rim
  - Standard steel centre
  - 100m/s maximum operating speed
- Clay roof tile, Concrete, Concrete block, Concrete pipe, Kerb stone, Reinforced concrete, Sandstone pipe, Washed concrete
- Brick, Cellular concrete, Concrete floor, Granite, Sandstone
- Ductile iron

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 10 x 2.5 x 20	1	70184623428*	5450248233770
300 x 10 x 2.5 x 25.4	1	70184623430*	5450248233787
350 x 10 x 2.8 x 25.4	1	70184623431*	5450248233794
400 x 10 x 2.8 x 25.4	1	70184626405*	5450248350354
450 x 10 x 2.8 x 25.4	1	70184626406*	5450248350361

\* Made-to-order

### SPEEDO FLEX CONCRETE



- Laser-welded diamond blade
  - Segmented rim
  - Standard steel centre
  - 100m/s maximum operating speed
- Concrete, Concrete block, Concrete roof tile, Kerb stone, Mortar, Reinforced concrete, Washed concrete
- Brick, Cellular concrete, Concrete floor, Concrete pipe, Sandstone pipe
- Abrasive natural stone, Clay roof tile, Granite, Hard natural stone, Limestone, Marble, Sandstone

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 7 x 2.5 x 25.4	1	70184623397	5450248233459
350 x 7 x 2.8 x 25.4	1	70184623398	5450248233466

● strongly recommended    ● recommended    ○ occasional use    also see table on page 207  
**Dimensions Key:** D = Diameter, H = Height, T = Thickness, B = Bore

## Asphalt & Abrasive Materials



### flexOvit LASER AS



- Laser-welded diamond blade
- Segmented rim
- Steel centre with undercutting protection
- 100m/s maximum operating speed

- Asphalt  Green concrete

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 7 x 2.8 x 20	1	70184623432*	5450248233800
300 x 7 x 2.8 x 25.4	1	70184623434*	5450248233817
350 x 7 x 3.2 x 25.4	1	70184623435*	5450248233824
400 x 7 x 3.2 x 25.4	1	70184626407*	5450248350385
450 x 7 x 3.2 x 25.4	1	70184626408*	5450248350392

\* Made-to-order



### SPEEDO FLEX ASPHALT

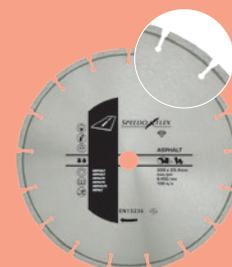


- Laser-welded diamond blade
- Segmented rim
- Standard steel centre
- 100m/s maximum operating speed

- Asphalt  Green concrete

Dimensions (mm) D x H x T x B	Quantity	Article Number	Barcode
300 x 8 x 2.5 x 25.4	1	70184623394*	5450248233428
350 x 8 x 2.8 x 25.4	1	70184623395	5450248233435

\* Made-to-order



## Accessories

### PATENTED QUICKFIX REDUCTION RINGS

- For mounting 25.4 or 22.23mm bored blades, on 20mm spindle machines

Dimensions (mm) D x B	Quantity	Article Number	Barcode
103 x 25.4/22.23/20	1	70184624549	5450248236870

- For mounting 25.4 on 22.23mm spindle machines

Dimensions (mm) D x B	Quantity	Article Number	Barcode
103 x 25.4/22.23	1	70184624550	5450248236887





# Bonded Abrasives



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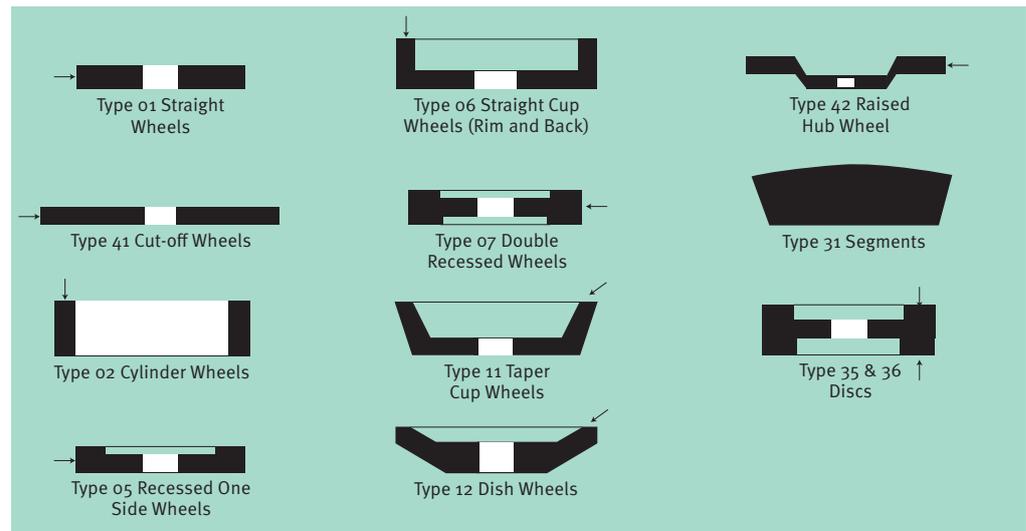
## Technical Information

Flexovit has a reputation for meeting the changing needs of industry, coupled with a comprehensive support and technical service from teams of experts with knowledge in a wide variety of industrial applications.

### Understanding the Product



### STANDARD GRINDING WHEEL AND PERIPHERY SHAPES



→ indicates grinding face



## What is a Grinding Wheel?

A grinding wheel is a precision tool with thousands of cutting points. It consists of abrasive grains held in a matrix of bond and separated by pores. The abrasive grains are the cutting points while the purpose of the bond is to hold the individual grains together. The pores (hollow spaces between adjacent abrasive grains and the bond) serve to provide clearance for coolant penetration and metal chips removed in the grinding process.

When the wheel is rotated at grinding speed and applied to the workpiece, the abrasive grains cut the material that is being ground, removing the material in small chips.

Under the action of the forces imposed during grinding the abrasive cutting points are worn flat, resulting in the points becoming blunt. This causes an increase in friction, heat build up and the forces imposed on the wheel.

The increase in grinding forces causes either the abrasive to fracture, exposing new cutting edges, or fractures the bond bridges holding the abrasive grains. In the latter case fresh abrasive grains are exposed to cut the workpiece.

In normal vitrified grinding applications the wheel has to be dressed.

By varying the properties of the abrasive, the type of bond, the make-up of the wheel, it is possible to produce grinding wheels with a vast range of different grinding characteristics.

## ABRASIVES

Modern synthetic abrasives allow accurate control over the physical properties and form of the abrasive grain. This helps to ensure that grinding wheels can be manufactured with consistent cutting properties.

Flexovit offers a comprehensive selection of abrasive types to provide a wide range of specific grinding characteristics. This is necessary for maximum efficiency in the large variety of operations demanded by the industry today.

### Abrasive Grain Size

The grain or grit size is most important in determining a wheel's ability to achieve the required surface finish and remove stock. The size is designated by a number which increases as grain size decreases. For example 10 grit has a median size of about 2.0mm and 60 grit 0.25mm.

Standard sizes are used in all Flexovit wheels as specified in the European Standards laid down by FEPA.

An ideal grinding abrasive has the ability to stay sharp with minimum point dulling, and when dulling begins it fractures revealing new sharp cutting edges. Abrasive grains used in the manufacture of bonded abrasives come in three main categories:

Abrasive Type	Size of the Abrasive Grain			Hardness of the Bond				Type of Bond
	Coarse	Medium	Fine	Soft	Med	Hard	Extra hard	
<b>WA = Aluminium Oxide</b>	<b>C</b>	<b>M</b>	<b>F</b>	<b>Soft</b>	<b>Med</b>	<b>Hard</b>	<b>VHard</b>	V = Vitrified
<b>73A = Ceramic Abrasive</b>	12	46	150	E	J	N	S	B = Resinoid
<b>48A = Semi-friable Aluminium Oxide</b>	14	54	180	F	K	O	T	BF = Resinoid reinforced
<b>A = Aluminium Oxide</b>	16	60	220	G	L	P	U	E = Shellac
<b>GC = Silicon Carbide</b>	20	80	240	H	M	Q	V	R = Rubber
<b>C = Silicon Carbide</b>	24	100	280	I		R	W	
<b>41A = Aluminium Oxide</b>	30	120					X	
<b>44A = Aluminium Oxide</b>	36							
							Z	



## Technical Information

Abrasive Type	Description
41A	Pink Aluminium oxide is a highly refined form of alumina containing a small proportion of chromium oxide. This addition makes 41A a little tougher than pure white, increasing the strength along the shear planes. This abrasive is available in a range of mounted points and wheels.
44A	Semi-pure brown fused aluminium oxide. General purpose abrasive used in the range of resinoid cut off wheels.
48A	Semi-friable alumina, purity falls part way between conventional regular brown alumina and white alumina. The resulting combination of friability and toughness gives wheels using semi-friable alumina their free cutting characteristics. This, combined with good form holding and a high degree of versatility, makes semi-friable alumina is widely used for cylindrical, centreless, crankshaft and angle head grinding operations.
73A	A ceramic form of aluminium oxide that is harder and sharp than conventional abrasive grains. This ceramic grain has a unique microcrystalline structure. The structure of the grain allows individual particles to break away as they become dull. This produces a very free grinding action that at the same time increases the number of parts ground between dressings by up to 70%. A high concentration blended with premium abrasives. Used for grinding hard abrasive resistant steels and operations where high stock removal rates are required.
79A	Blends of premium abrasives that include a low concentration of ceramic abrasive. Used in toolrooms on high vanadium type steels.
A	This is a particularly tough form of aluminium oxide. Its toughness is due to the presence of 3% of titanium oxide in the abrasive. Fired at low temperature the abrasive retains its natural brown colour. Fired at high temperature further oxidation of the titanium oxide takes place which changes the normal brown colour to a grey-blue. Because of its toughness, regular brown alumina is suitable for grinding high tensile strength materials, specifically off-hand grinding (bench grinding wheels) and sharpening stones.
C, GC	Silicon carbide abrasives are harder than the alumina type abrasives and are also more brittle. Silicon carbide abrasive is used for grinding low tensile grey iron, chilled iron, cast iron, soft bronze, copper, aluminium, stone, marble, rubber, hard facing alloys, and cemented carbides. There are two varieties of silicon carbide, very similar in physical properties and mainly distinguished by the colour. Black silicon carbide, is generally used for roughing operations in coarse grit and resinoid wheels. Light green silicon carbide, is preferred for specific applications such as most precision and carbide tool grinding.
52A	A blend of white and brown alumina, wheels containing this abrasive combine the toughness of brown with the cool, sharper cutting of white alumina. Used for sharpening engraving cutters and grinding hard chrome.
WA	White alumina is a highly refined form of aluminium oxide containing over 99% pure alumina. The grain structure is made up of several crystals that allow the grain to breakdown along the shear planes between the crystals as the grinding pressure increases. This gives wheels containing white alumina a property called 'friability' (the ability to fracture, exposing sharp cutting edges, as opposed to blunting). Used mainly for the grinding of very hard or heat sensitive materials.



## BOND

Flexovit supplies bonded abrasive products made using both resinoid and vitrified bonds.

### Vitrified Bond

Vitrified bonded wheels have a porous structure composed of abrasive particles held together by bond bridges of glass or similar vitreous material. Their strength is developed by firing in kilns at temperatures between 900 to 1250°C. Since vitrified bonded wheels are manufactured at such high temperatures, they are not affected by heat generated during the normal grinding process. Individual bond bridges can, therefore, only be fractured by mechanical forces imposed during grinding.

Grain	Bond	
Aluminum Oxide	VL	Low Temp
	VM	High Temp
Silicon Carbide	VK	Low Temp
	VKP	High Temp

### Resinoid Bond

A number of different organic polymers are used to bond abrasives but generally resinoid bonds are based on thermosetting phenolic resin. Resin bonds are cured by heating in ovens under carefully controlled conditions at selected temperatures between 150°C and 200°C.

Resinoid wheels are tougher and less brittle than vitrified wheels. Their inherent toughness makes them ideally suited to heavy duty operations or high operating speeds, often with the aid of fabric or steel ring reinforcement.

## GRADE

Grade is a measure of the bonding strength of the wheel, usually referred to as 'hardness'. Hardness will vary according to the amount of bond and abrasive in the wheel. Grade is not a measure of the hardness of the abrasive material but of the tenacity of the bond to hold the abrasive grains together.

Very hard abrasive can, theoretically, be bonded into a very 'soft' free cutting, fast wearing wheel, but an increase in the amount of bond will make the wheel act harder.

The grade of all Flexovit wheels are designated by letters of the alphabet and can range from 'E' for very soft to 'Z' for the hardest. A + sign after the letter indicates a hardness slightly greater than the grade.

## Selecting the Right Product

There are nine main factors to be considered when selecting a grinding wheel for any application:

- The material to be ground – its type and hardness
- The stock to be removed
- The workpiece geometry and surface finishes required
- The grinding machine, the type of machine, the power available and its conditions
- Wheel speeds and feeds
- Grinding contact area
- Grinding fluid – whether the operation is wet or dry
- The severity of the grinding operation
- The dressing method

## MATERIAL TO BE GROUND

The type of material affects the selection of abrasive, grit size and grade. Alumina type abrasives are the most suitable for grinding high tensile materials such as steel and ferritic cast irons. The more friable types of alumina are preferred on harder steels and applications having large arcs of contact.

Low tensile strength materials and non-metallic materials are most efficiently ground or cut with silicon carbide abrasive.

The hardness of the material governs the amount of penetration that can be achieved by the abrasive. For this reason finer grit size wheels are required to grind hard materials and soft materials are best ground with medium to coarse grit size wheels.

For most efficient operation the grade must be adjusted to suit the hardness of the material. As a general guide, the harder the material, the softer the grade of wheel required.



## Technical Information

### STOCK TO BE REMOVED & SURFACE FINISH

This affects the choice of abrasive size and bond type.

High stock removal rates, as in fettling operations, require coarse grit wheels, typically 12 to 24 mesh. Fine finishes and tight limits on finished workpiece geometry require finer grit sizes.

Final surface finish is often achieved by 'spark out'. No further infeed is applied and the wheel is allowed to grind until the majority of the grinding sparks cease.

### THE GRINDING MACHINE

The type of machine can effectively define the grinding contact area and the ease with which grinding fluid can be applied to the grinding zone.

The power available on the machine governs the stock removal rate. The greater the power available, the harder the grade of wheel that is required for efficient operation.

Any deterioration in the condition of machine bearings and slideways will lead to vibration and, consequently, premature wheel breakdown. This can, in part, be overcome by using a harder grade wheel and/or a tougher abrasive but the only effective solution is to maintain the machine as recommended by the machine manufacturer.

### SPEEDS & FEEDS

The effect of speeds and feeds on grinding action and, hence, the selection of wheel, can best be summarised in the following table:

EFFECT ON GRINDING ACTION		
Speed	Increased	Decreased
Wheel Speed *	Harder	Softer
Work Speed	Softer	Harder
Traverse Speed	Softer	Harder
Infeed Rate	Softer	Harder

\* The maximum peripheral speed (m/s) specified for the wheel must never be exceeded.

### GRINDING CONTACT AREA

The contact area affects the selection of wheel grade and structure. Large contact areas, as on segmental grinders, generally produce low grinding pressures and require soft grade, open structure wheels. Induced porosity wheels are most efficient for grinding very large contact areas. Conversely, small contact areas, as on cylindrical grinding machines, require harder grade and/or closer structure wheels.

The size of workpiece can also affect the grinding contact area. In general, the larger the workpiece, relative to the grinding wheel diameter, the larger the contact area, requiring softer grade wheels.

### GRINDING FLUID

Dry grinding with vitrified wheels require wheels one or two grades softer than when wet grinding.

### SEVERITY OF THE GRINDING OPERATION

This can affect the choice of abrasive type, grade and even bond type. Where the wheel is subjected to shock loads, as in fettling operations, a resinoid bond should be used. In general, the more severe the grinding operation, the harder the grade of wheel required and the tougher the abrasive that can be used. Severity of grinding operation can be due to heavy infeeds, high work speeds and traverse rates or intermittent grinding contact. The latter is usually due to workpiece geometry, resulting in a dressing action on the wheel.

### GRINDING WHEEL DRESSING & TRUING

Truing and dressing of grinding wheels are often considered to be the same thing, since they are frequently performed as one operation. Truing is performed to ensure concentricity and introduce any profile that may be required on the wheel face. Dressing conditions the wheel surface to give the desired cutting action.



## SINGLE & MULTI-POINT DIAMONDS

Diamonds are the first choice where close tolerances, fine finishes, speed and flexibility are required. Since diamond dressing is primarily a machining operation rather than a crushing operation, the surface formed on the wheel is closer than that obtained from mechanical dressers. This results in a slower cutting wheel with better form holding characteristics and superior finish control.

By varying the depth of cut per pass made by the diamond and changing the traverse rate, different wheel surfaces, and hence different cutting actions, can be achieved.

The following are general recommendations for dressing with single point diamonds.

	ROUGHING	FINISHING
Diamond Infeed mm per pass	0.025 mm	0.012-0.020 mm
Diamond Traverse rate mm /wheel rev.	0.18 mm	0.10 mm

The diamond should always be applied at the centreline of the wheel with a 5°-15° drag angle.

## Diamond Size

The size of diamond is important when selecting a dressing tool and several factors are relevant in this selection, e.g. large, coarse grit wheels require a larger diamond than smaller, fine grit wheels. If a fine finish is required, the use of a diamond which is too large can adversely affect the finish and cancel the effect of fine grit selection. The trend today is away from single point dressers and towards multi-point dressers employing a matrix shape to suit the form required.

A useful formula for determining single point diamond size is:

## Wheel diameter (mm) x Wheel thickness (mm)

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS		
	Diameter x Thickness (mm)	Carat
	<3000	0.25 Carat
	3000-12000	0.50 Carat
>12000	1 Carat	

For best results, always use a coolant when dressing.

## Coolant

Dressing with diamonds should always be carried out using a copious supply of coolant. The coolant should always be turned on fully before the diamond touches the wheel. The diamond life will deteriorate rapidly if it is allowed to become hot and then cooled rapidly as can be experienced with an intermittent coolant flow.

## Rotation of the Dressing Tool

To ensure maximum diamond life, single point and conical cluster diamond dressing tools should be systematically rotated after every four or five dressings to ensure that the keen edge generated from the drag angle is constantly presented to the wheel.



## Technical Information

### Surface Finish

The achievable surface finish in any grinding operation is highly dependant upon the grit size of the grinding wheel. The following chart shows the range of surface finishes achievable when using grinding wheels of different grit sizes on conventional precision grinding applications, together with the minimum form radius that can be ground using each grit size.

Other factors can affect the surface finish achieved. In particular:

- Production grinding applications, with higher stock removal ranges, will give surface finishes at the coarser end of the range
- Plunge grinding applications will often require the selection of a grit size one size finer than shown
- Dressing techniques and the type of material can also affect the surface finish achieved

SURFACE FINISH AND GRIT SIZE									
Surface	Finish	Grain Size							
$\mu$ in CLA	$\mu$ m Ra	46	60	80	100	120	150	180	220
42	1.10	●							
32	0.80	●							
26	0.70	●							
21	0.50		●						
16	0.40		●						
14	0.35		●	●					
11	0.25		●	●					
8	0.20			●	●				
7	0.17			●	●	●			
6	0.14				●	●	●		
5	0.12					●	●	●	
4	0.10						●	●	●
3	0.08							●	●
2	0.05								●
Min Form Radius	Metric mm	0.75	0.50	0.40	0.25	0.20	0.18	0.13	0.10
	Imp ins	.030	.020	.015	.010	.008	.007	.005	.004

#### Usage Key

- strongly recommended

#### Achieving Improved Surface Finishes

By changing the wheel dressing technique, it is possible to achieve finer surface finishes than those shown in the preceding table. As well as reducing the dresser infeed per revolution of the grinding wheel, it is also possible to reduce the infeed and traverse rate when grinding, thus reducing the stock removal rate. Obviously this approach will have limited application in production grinding but it can be very useful in toolroom work.



## SOLVING SURFACE FINISH PROBLEMS

Many problems associated with grinding relate to surface finish defects. The following chart describes some common surface finish problems, shows the probable causes and suggests remedies to cure the problem.

### TROUBLESHOOTING

<b>Regular spaced chatter marks</b> Immediately after dressing	
<b>Cause</b>	Machine vibration
<b>Solution</b>	Check for wear in machine bearings
<b>Regular spaced chatter marks</b> After a period of time	
<b>Cause</b>	Wheel too hard
<b>Solution</b>	Use softer grade of wheel
<b>Chequered pattern</b>	
<b>Cause</b>	Wheel out of balance
<b>Solution</b>	Balance wheel
<b>Chatter marks</b>	
<b>Cause</b>	Wheel out of truth
<b>Solution</b>	Re-dress wheel
<b>Irregular chatter marks</b>	
<b>Cause</b>	Wheel mounting insecure
<b>Solution</b>	Tighten wheel mounting
<b>Cause</b>	Workpiece centres loose
<b>Solution</b>	Adjust centres
<b>Irregular surface scratches</b>	
<b>Cause</b>	Wheel too soft
<b>Solution</b>	Use fine dress. Reduce workspeed. Use harder grade wheel
<b>Cause</b>	Coolant dirty
<b>Solution</b>	Replace coolant. Check filtration
<b>Spiral marks</b>	
<b>Cause</b>	Dressing techniques
<b>Solution</b>	Check diamond is sharp and secure
<b>Cause</b>	Dressing techniques
<b>Solution</b>	Check dress is parallel
<b>Finish too coarse</b>	
<b>Cause</b>	Grit size too coarse
<b>Solution</b>	Use fine, slow traverse dress
<b>Cause</b>	Wheel too soft
<b>Solution</b>	Decrease workspeed. Use harder grade wheel
<b>Cause</b>	Metal pickup on wheel
<b>Solution</b>	Dress more frequently. Use more open, softer grade wheel



## Technical Information

### Mounting

A wheel should only be mounted on to the machine for which it was intended. The speed of the spindle on which the wheel is mounted should not under any circumstances exceed the maximum RPM speed specified for the wheel when it is full size. The wheel should fit freely, but not loosely, on to the spindle or spigot diameter of the flange plates. Wheels, blotting paper washers and flanges should be free from foreign matter. Certain wheels have a positioning mark (Mount Down or Mount Up) marked on them. Care must be taken to ensure that this mark occupies the position stated by the manufacturer.

### REDUCING BUSHES

Where a removable bush is used as a means of reducing the bore of an abrasive wheel, care must be taken to ensure the bushes should not project beyond the side of the wheel and the wheel blotter. The clamping faces of the flange plates **MUST** clamp on the mounting washers attached to the wheel and not on any part of the reducing bush. Reducing bushes should never be used on wheels less than 6mm thick or on products with a back or web of less than 6mm. Never use plastic bushes in wheels used with portable grinding equipment.

### MOUNTING WASHERS

Blotters should be used with all grinding wheels unless there is a specific exemption. Blotters should be slightly larger in diameter than the mounting flanges and free from any scuffs, wrinkles or other damage.

### MOUNTING FLANGES

Mounting flanges are designed to clamp the wheel to the machine and transfer the driving forces from the machine spindle to the grinding wheel. They should be designed to take the driving forces away from the area around the grinding wheel bore and generally should be not less than one third of the grinding wheel diameter.

Flange surfaces should be flat, free from burrs, bumps, bruises and other damage. Flanges should be of equal diameter, have equal bearing surfaces and be properly recessed or undercut.

The rear flange must be positively driven by the machine spindle being either keyed or shrunk onto the spindle.

Flanges must run true to the machine spindle.

Clamping nuts (centre nut locking) should only be tightened sufficiently to hold the wheel securely without slippage and must not be over-tightened. When flanges are clamped by a series of screws, they should be tightened in stages uniformly in a diametric sequence.

In most instances it is appropriate to tighten the nut or screws by hand with the correct tool (spanner or hexagonal socket key) until they stop turning. By adopting this technique it is very rare that the wheel would be under-tightened and impossible to over-tighten the wheel. Bolts for mounting wheels with inserted nuts should be long enough to engage an adequate length of thread, i.e. equal to the thread diameter, but must not protrude through the nut insert.

For recommended designs of flanges, refer to the 'FEPA' Safety.

### CAUTION

After mounting or re-mounting a grinding wheel on a machine, stand well clear, ensuring that there are no persons in line with the wheel and allow the wheel to run free for two minutes. A remounted wheel should always be treated as if it were a new wheel.

### TYPE o6 CUP WHEELS – FIXED MACHINES

The diameter of the flange and paper washer inside the cup must be smaller than the diameter of the cup recess to avoid any risk of radial pressure on the wheel. When used for work heavier than light tool and cutter grinding, the back flange may be larger than that inside the cup but the recess diameter of both flanges must be equal.

### MOUNTED POINTS & WHEELS

The spindle dimensions of the mounted point must be suitable for the collet being used and the spindle overhang corresponding to the machine speed should be observed.

### TYPE 31 GRINDING SEGMENTS

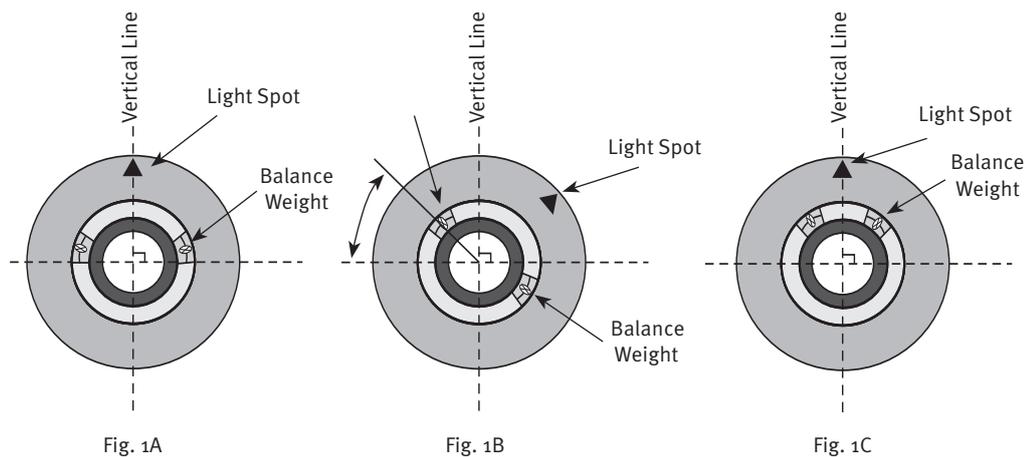
Segments are held by special chucks with suitable provision for adjustment to compensate for segment wear. To prevent breakages segments should not protrude more than 1.5 times their thickness from the clamping chuck face, and should be mounted with markings uppermost.



## Wheel Balance

Most Flexovit grinding wheels are balance corrected to a minimum of ISO Standards. Precision grinding machines usually provide methods of accurately balancing the complete wheel and flange assembly. Modern production machines are now supplied with automatic balancing systems, whereas, tool-room and older production machines still have to be manually balanced, ensuring the best possible grinding performance from the wheel. The balancing procedure can be carried out either on a special balancing stand or in-situ on the machine. The machine manufacturer's instructions should be closely followed. There are many methods of manually balancing the wheel assembly, depending upon the number of balance weights in the wheel arbour, a typical 'two weight' balancing system technique is described below.

### TWO WEIGHT SYSTEMS



- Mount wheel between flange plates
- Remove balance weights from annular groove on mounting flange (can also be set diametrically opposite if preferred – ensuring the weights cancel each other out)
- Dress periphery of wheel until running in perfect truth
- Remove complete wheel assembly from the machine (after allowing sufficient time for the coolant to spin out) and fix assembly onto the balancing mandrel
- Place on balancing unit and allow to turn freely – When stationary mark top centre (light spot) with chalk
- Re-position the balance weights so that the bottom side face of each weight, that is furthest from the light spot, forms a right angle i.e.  $90^\circ$ . See illustration 1A
- Turn wheel assembly so that one balance weight is approximately 45 degrees from the horizontal line and release the wheel. Note the direction in which wheel rotates, the weight may revolve upwards towards the vertical line. In this instance the weight should be moved down away from the light spot (always adjust the weights in the opposite direction of rotation) to begin bringing the wheel into balance. See illustration 1B
- Continue checking the weights, alternating between the left and right hand balance weights in turn. Repeat until the wheel remains stationary in all positions. Move the weights a maximum of 3mm at a time, reducing this amount as the wheel rotates slower. See illustration 1C
- Continue until assembly remains static in all positions. Lock balancing weights in position and remount assembly onto the machine spindle
- **Important:** – Ensure the balancing ways (knife edges or rollers) on the balancing stand are level in all directions. Care must be taken to initially find the true light spot of the wheel.



# Technical Information

## Safety in the Storage & Use of Grinding Wheels

Stringent safety standards are maintained throughout the manufacture of Flexovit Grinding Wheels. To reduce the risk of accidents further, the law requires that certain basic precautions are taken in the storage and use of abrasive wheels.

### RECEIPT

On receipt, grinding wheels should be thoroughly examined to see if they show any signs of damage, such as chips, cracks or discolouration. Damaged wheels must not be used.

### HANDLING

Any mishandling that results in the wheel being subjected to any shock loading can damage all grinding wheels. This can occur if the wheel is inadvertently dropped, knocked over or banged against any other object. This is equally true if the wheel is secured on a pallet, which has been dropped heavily from a forklift truck.

Any grinding wheel subjected to such mishandling should be carefully examined for signs of damage. If in any doubt – do not use.

### STORAGE

Small wheels up to 80mm diameter, together with cones, plugs, mounted points and wheels may be stored in suitable bins, drawers or boxes. Type 02 cylinder wheels, type 06 straight cup 04 wheels, type 12 dish wheels and type 13 saucer wheels should normally be stacked on flat sides with cushioning material between them. Thick rim and hard grade cylinder and straight cup wheels may be stored on their periphery as for plain wheels. Soft grade, straight cup wheels, and all type 11 taper cup wheels, should be stored base to base and rim to rim, to prevent chipping of edges and cracking of walls. Thin plain wheels, such as cutting off wheels or saw sharpening wheels should be stacked on a flat surface of steel, or similar rigid material. Other plain or shaped wheels of appreciable thickness, are best supported on their periphery in racks. The racks should provide cushioned, two point, cradle support to prevent the wheels from rolling.

### STORAGE CONDITIONS

During storage, grinding wheels must not be subjected to:

- Exposure to humidity, water or other liquids
- Freezing temperatures
- Any temperature low enough to cause the formation of condensation on the wheels when moving from storage to an area of high temperature

### SHELF LIFE OF RESINOID & VITRIFIED BONDED WHEELS

The outer surfaces of certain organically bonded wheels may be affected by oxidation if they are stored for long periods. These types of wheel should not be stored for more than three years and proper stock control should ensure that older wheels are used first. In use, a three year old Resinoid product will act considerably softer than a brand new wheel (wheel will wear away more quickly).

The glass bonding system used in vitrified wheels is very inert and generally only attacked by certain acids. Cold temperatures can result in a vitrified wheel cracking if wheels are put away wet and are subjected to freezing temperatures. It must be remembered that the longer a product is in storage the chances of it becoming damaged increases. Provided vitrified wheels are stored correctly, thoroughly examined and mounted correctly they will last for many years.

### RING TEST

The ring test depends upon the damping characteristics of a cracked wheel to alter the sound emitted when it is lightly tapped. The test is applicable only to vitrified bonded wheels.

To perform the ring test; support the wheel gently with a finger through the bore section. Using a light non-metallic implement (a file handle is ideal), gently tap the wheel about 45° each side of the vertical centre line. Rotate the wheel 45° and repeat the test.

The sound an undamaged wheel will omit a clear tone. If cracked, there will be a dead dull sound – not a clear ring – and the wheel should NOT be used. The ring test should be carried out in a place where the ring can easily be heard.



## Safe Working Practices

### PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if grinding conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.



### TRAINING OF OPERATORS

Grinding operators should be trained in the safe use of each machine they operate.

### SPEEDS

No abrasive wheel should be operated at a speed in excess of the maximum permissible speed marked on the wheel in RPM when the wheel is new and full size. It is permissible, however, to increase the spindle speed of the machine beyond the RPM stated on the wheel provided the increase is in proportion to the reduction in diameter and that the original peripheral speed is not exceeded (quoted on the wheel in m/s). In high production areas it is now normal for machines to have constant peripheral speed spindles. This is an electronic device that automatically increases the spindle speed of the machine as the wheel diameter wears down and prevents most of the reduction in wheel performance that is experienced when the wheel becomes smaller.

### COOLANTS

The strength of resin bonded grinding wheels can be reduced by coolants. The concentration and alkalinity of coolants should be regularly checked and a pH value of 8 should not be exceeded. Prolonged immersion of a stationary wheel in coolant can produce an out of balance condition. Coolant should be shut off before stopping a wet grinding wheel, and the wheel allowed to run free until all the coolant has been spun out.

### WORK RESTS

Work rests should be kept adjusted as close as possible (Gap between wheel and work rest should not exceed 3mm) to the wheel and maintained in good condition.

### TRUING & DRESSING

Re-dressing of wheels that have become malformed and out of truth in off-hand operations must only be performed by a competent person.

If an out of balance condition, due to the wheel wearing excessively out-of-round, cannot be corrected by truing, the wheel should be removed from the machine.

Wheels should be dressed regularly to avoid loading.

### SIDE GRINDING

Side grinding should only be performed with wheels designed for this purpose (straight cups etc.).

Grinding on the flat sides of wheels designed for peripheral grinding may be dangerous and cause a wheel breakage. This does not preclude their use for certain precision applications such as shoulder and form grinding, where it is recognised that a limited amount of side grinding is performed; however in these operations the operator has control of the pressure through the hand wheels of the machine whereas with bench grinding and off-hand machines the pressure is uncontrolled. Extreme caution should be exercised not to use excessive pressure.

As a general guide, do not use a straight wheel which has a thickness of less than 10% of the wheel diameter for side grinding.



## Technical Information

### STOPPING WHEELS

Wheels should not be brought to rest by applying pressure to the periphery or face of the wheel.

### ORGANIC CUTTING-OFF WHEELS

'Non-reinforced' cutting-off wheels should never be used:

- On a portable grinding machine
- On any machine where the workpiece is fed into the wheel by hand

Cutting-off wheels should only be mounted on machines designed for their use.

Cutting-off wheels should be inspected for warping before use. Warped wheels should not be used.

When grinding, twisting or the exertion of any pressure on the side of the wheel should be avoided.

Workpieces should be rigidly supported and firmly clamped wherever possible.

## Plastic Reduction Bush Availability

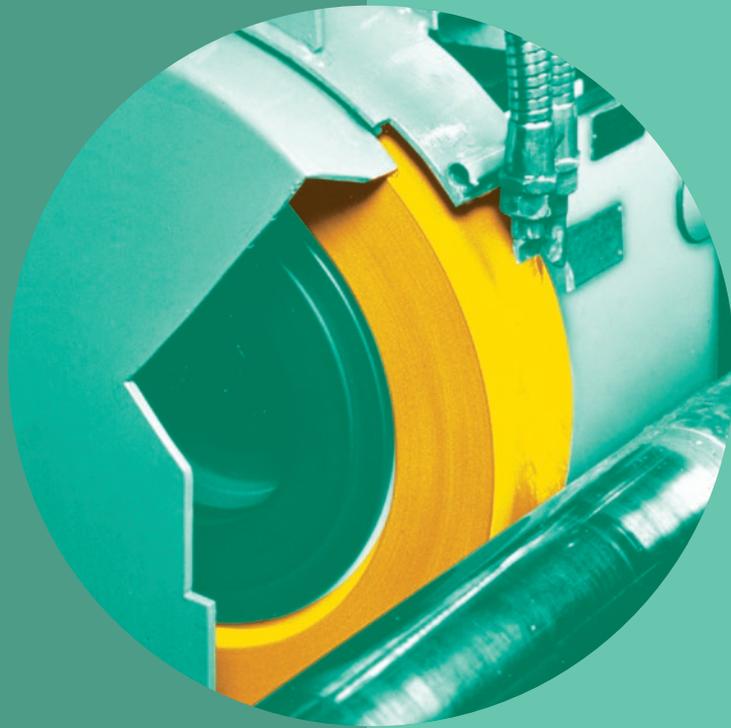
The following Plastic Reduction Brushes are available on request.

### PLASTIC REDUCTION BUSHES

Specification (mm)	Quantity	Article Number	Barcode
Plastic Reducing Ring 20 x 10	1	07660717524	8711479367038
Plastic Reducing Ring 20 x 12	1	07660717525	8711479367045
Plastic Reducing Ring 20 x 12.7	1	07660717526	3157625646995
Plastic Reducing Ring 20 x 13	1	07660717527	8711479367052
Plastic Reducing Ring 20 x 14	1	07660717528	8711479367069
Plastic Reducing Ring 20 x 15	1	07660717529	8711479367076
Plastic Reducing Ring 20 x 16	1	07660717530	3157620728283
Plastic Reducing Ring 20 x 17	1	07660717531	8711479367090
Plastic Reducing Ring 20 x 18	1	07660717532	8711479367106
Plastic Reducing Ring 25 x 20	1	07660717535	8711479366987
Plastic Reducing Ring 32 x 15.88	1	07660717536	3157625647107
Plastic Reducing Ring 32 x 20	1	07660717538	8711479366871
Plastic Reducing Ring 32 x 25	1	07660717540	8711479366895
Plastic Reducing Ring 32 x 25.4	1	07660717541	3157625647114

# Bonded Abrasives

## Grinding Wheels





## 73A

- Abrasive:  
Ceramic aluminium oxide
- High removal rate  
& extends wheel life
- Suitable for very hard steels

# Grinding Wheels

## Plain wheels - Type 01 / 73A

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
150 x 20 x 32	01	73A 60 IVL	35	2	69936648619	3564653678858	Tool & Cutter
180 x 20 x 32	01	73A 60 G12VL	35	2	69936677180	3157626306041	Precision grinding
180 x 20 x 32	01	73A 60 IVL	35	2	69936648413**	3564653600682	Precision grinding
200 x 25 x 32	01	73A 60 IVL	35	2	69936648605	3564653674300	Precision grinding
250 x 25 x 76.2	01	73A 46 GVL	35	1	69936648594*	3564653674096	Precision grinding
250 x 25 x 76.2	01	73A 60 JVL	35	1	69936695938*	3564653674140	Precision grinding
355 x 40 x 127	01	73A 46 GVL	35	1	69936648597	3564653674133	Precision grinding
355 x 50 x 127	01	73A 46 GVL	35	1	69936648411*	3564653600262	Precision grinding
406 x 50 x 127	01	73A 46 HVL	50	1	66243580238*	3157625630802	Precision grinding

\* Made-to-order \*\* Destock

## Plain wheels - Type 01 / WA

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
100 x 13 x 19.05	01	WA 60 KVL	35	2	66243548418	3157625626898	Precision grinding
125 x 16 x 25	01	WA 60 KVL	35	2	66243545514	3157625626515	Precision grinding
125 x 20 x 32	01	WA 60 KVL	35	2	69936648512	3564653669610	Precision grinding
150 x 6 x 32	01	WA 80 KVL	35	2	69936648525	3564653670357	Precision grinding
150 x 10 x 32	01	WA 60 KVL	35	2	69936648524	3564653670302	Precision grinding
150 x 13 x 32	01	WA 60 KVL	35	2	69936648528*	3564653670401	Precision grinding
150 x 16 x 32	01	WA 60 KVL	35	2	69936648531	3564653670548	Precision grinding
150 x 16 x 32	01	WA 80 KVL	35	2	69936648533	3564653670593	Precision grinding
150 x 20 x 32	01	WA 46 KVL	35	2	66243578390	3157625629349	Precision grinding
150 x 20 x 32	01	WA 60 KVL	35	2	69936676902	3564656215043	Precision grinding
150 x 20 x 32	01	WA 80 KVL	35	2	69936648540	3564653670807	Precision grinding
150 x 25 x 32	01	WA 46 KVL	35	2	66243578526*	3157625629363	Precision grinding
150 x 25 x 32	01	WA 60 KVL	35	2	69936648543	3564653670890	Precision grinding
150 x 25 x 32	01	WA 80 KVL	35	2	66243578530	3157625629394	Precision grinding
150 x 25 x 60	01	WA 60 KVL	35	2	69936648541**	3564653670814	Precision grinding
180 x 20 x 32	01	WA 46 HVL	35	2	69936648625*	3564653679725	Precision grinding
180 x 25 x 32	01	WA 60 KVL	35	2	69936648549	3564653671118	Precision grinding
200 x 6 x 32	01	WA 60 KVL	35	2	69936648554	3564653671231	Precision grinding
200 x 10 x 32	01	WA 60 KVL	35	2	69936648550	3564653671125	Precision grinding
200 x 20 x 32	01	WA 46 KVL	35	2	69936676905	3564656215180	Precision grinding
200 x 20 x 32	01	WA 60 IVL	35	2	69936676907	3564656215210	Precision grinding
200 x 20 x 32	01	WA 60 MVL	35	2	69936676908	3564656215241	Precision grinding
200 x 20 x 32	01	WA 80 MVL	35	2	69936648557	3564653671439	Precision grinding
200 x 20 x 50.8	01	WA 46 KVL	35	2	66243530097	3157625626058	Precision grinding
200 x 20 x 50.8	01	WA 60 KVL	35	2	66243530096	3157625626041	Precision grinding
200 x 25 x 20	01	WA 60 KVL	35	2	66243545528	3157625626621	Precision grinding
200 x 25 x 32	01	WA 46 IVL	35	2	69936648558	3564653671491	Precision grinding
200 x 25 x 32	01	WA 46 MVL	35	2	69936676910	3564656215289	Precision grinding
200 x 25 x 32	01	WA 60 IVL	35	2	69936661169	3157625631182	Precision grinding
200 x 25 x 32	01	WA 60 MVL	35	2	69936676912	3564656215326	Precision grinding
200 x 25 x 50.8	01	WA 60 KVL	35	2	66243528422	3157625625914	Precision grinding
200 x 25 x 76.2	01	WA 60 KVL	35	2	69936648564	3564653671682	Precision grinding
200 x 32 x 32	01	WA 46 MVL	35	2	66243578540	3157625629479	Precision grinding
200 x 32 x 32	01	WA 60 KVL	35	2	69936648569	3564653671798	Precision grinding
200 x 32 x 32	01	WA 80 KVL	35	2	66243578552	3157625629493	Precision grinding
200 x 32 x 51	01	WA 60 KVL	35	2	66243578558	3157625629547	Precision grinding
200 x 32 x 76.2	01	WA 60 KVL	35	2	69936648571*	3564653671842	Precision grinding
250 x 13 x 76.2	01	WA 60 KVL	35	1	66243548451	3157625627109	Precision grinding
250 x 25 x 50.8	01	WA 46 KVL	35	1	66243528404	3157625625792	Precision grinding
250 x 25 x 50.8	01	WA 60 KVL	35	1	66243528405	3157625625808	Precision grinding
250 x 25 x 76.2	01	WA 80 KVL	35	1	66243578708	3157625630086	Precision grinding

\* Made-to-order \*\* Destock



### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates



## WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

# Grinding Wheels

## Plain wheels - Type 01 / WA

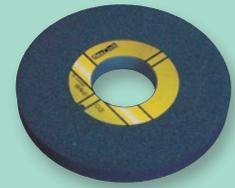
Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
250 x 32 x 32	01	WA 60 MVL	35	1	69936648577	3564653672009	Precision grinding
250 x 40 x 76.2	01	WA 46 JVL	35	1	66243578721	3157625630178	Precision grinding
250 x 50 x 76.2	01	WA 60 KVL	35	1	66243578729	3157625630222	Precision grinding
300 x 13 x 127	01	WA 60 KVL	35	1	66243548621	3157625627901	Precision grinding
300 x 13 x 127	01	WA 80 KVL	35	1	66243548620	3157625627895	Precision grinding
300 x 25 x 76.2	01	WA 46 JVL	35	1	66243578852	3157625630383	Precision grinding
300 x 25 x 76.2	01	WA 60 KVL	35	1	66243578849	3157625630376	Precision grinding
300 x 25 x 127	01	WA 46 KVL	35	1	66243578783	3157625630321	Precision grinding
300 x 25 x 127	01	WA 60 KVL	35	1	66243578731	3157625630246	Precision grinding
300 x 25 x 127	01	WA 80 KVL	35	1	66243578848	3157625630369	Precision grinding
300 x 25 x 127	01	WA 100 JVL	35	1	66243578784*	3157625630338	Precision grinding
300 x 40 x 76	01	WA 60 KVL	35	1	66243545522	3157625626584	Precision grinding
300 x 40 x 127	01	WA 46 MVL	35	1	69936648582	3564653673488	Precision grinding
300 x 40 x 127	01	WA 60 KVL	35	1	69936648583	3157625631144	Precision grinding
355 x 25 x 127	01	WA 46 KVL	35	1	66243579395	3157625630581	Precision grinding
355 x 32 x 127	01	WA 60 KVL	35	1	69936648608	3564653677202	Precision grinding
355 x 40 x 127	01	WA 46 HVL	35	1	69936648610*	3564653677592	Precision grinding
355 x 50 x 127	01	WA 46 KVL	35	1	66243579397	3157625630604	Precision grinding
355 x 50 x 127	01	WA 60 KVL	35	1	69936648612	3564653678001	Precision grinding
406 x 25 x 127	01	WA 60 KVL	35	1	66243580218	3157625630765	Precision grinding
406 x 50 x 127	01	WA 46 HVL	35	1	66243580241	3157625630819	Precision grinding
406 x 50 x 127	01	WA 46 JVL	35	1	66243580243	3157625630826	Precision grinding
406 x 50 x 127	01	WA 60 KVL	35	1	66243580237	3157625630796	Precision grinding

\* Made-to-order

## Plain wheels - Type 01 / 48A

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
250 x 25 x 76.2	01	48A 60 KVM	35	1	66243548710	3157625628601	Precision grinding
250 x 25 x 76.2	01	48A 80 MVM	35	1	66243548713*	3157625628625	Precision grinding
300 x 13 x 127	01	48A 60 LVM	35	1	66243548720	3157625628663	Precision grinding
300 x 25 x 127	01	48A 60 KVM	35	1	66243548729	3157625628755	Precision grinding
300 x 25 x 127	01	48A 60 LVM	35	1	66243548727	3157625628731	Precision grinding
300 x 25 x 127	01	48A 80 KVM	35	1	66243548724	3157625628694	Precision grinding
300 x 40 x 127	01	48A 46 KVM	35	1	66243548737*	3157625628816	Precision grinding
300 x 40 x 127	01	48A 60 KVM	35	1	66243548740	3157625628854	Precision grinding
355 x 25 x 127	01	48A 60 KVM	35	1	66243579410	3157625630697	Precision grinding
355 x 40 x 127	01	48A 46 KVM	35	1	66243579412	3157625630703	Precision grinding

\* Made-to-order



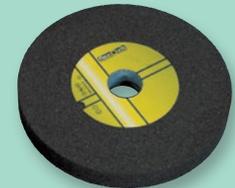
### 48A

- Abrasive: Semi-pure brown fused aluminium oxide
- Ideal for general purpose applications
- For use on steel & steel alloys

## Plain wheels - Type 01 / A

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
125 x 16 x 25	01	A 46 MVM	35	2	66243545510	3157625626492	General Purpose
125 x 20 x 25	01	A 46 MVM	35	2	66243545518	3157625626546	General Purpose
150 x 16 x 32	01	A 36 MVM	35	2	69936648660*	3564653696029	General Purpose
150 x 16 x 32	01	A 60 MVM	35	2	69936648662	3564653696043	General Purpose
150 x 20 x 32	01	A 36 MVM	35	2	69936676891	3564656214886	General Purpose
150 x 20 x 32	01	A 46 MVM	35	2	69936676892	3564656214893	General Purpose
150 x 20 x 32	01	A 60 MVM	35	2	66243578437	3157625629356	General Purpose
150 x 25 x 32	01	A 36 MVM	35	2	66243578532	3157625629417	General Purpose
150 x 25 x 32	01	A 46 MVM	35	2	69936676894	3564656214916	General Purpose
150 x 25 x 32	01	A 60 MVM	35	2	66243578527	3157625629387	General Purpose
180 x 25 x 32	01	A 46 MVM	35	2	69936648668	3564653696173	General Purpose
200 x 20 x 32	01	A 30 MVM	35	2	69936648670	3564653696197	General Purpose
200 x 20 x 32	01	A 46 MVM	35	2	66243578533	3157625629424	General Purpose
200 x 20 x 32	01	A 60 MVM	35	2	66243578536	3157625629448	General Purpose
200 x 25 x 20	01	A 36 MVM	35	2	66243545527	3157625626614	General Purpose
200 x 25 x 20	01	A 46 MVM	35	2	66243545524	3157625626591	General Purpose
200 x 25 x 32	01	A 30 OVM	35	2	69936648672	3564653696227	General Purpose
200 x 25 x 32	01	A 46 LVM	35	2	69936676899	3564656214992	General Purpose
200 x 25 x 32	01	A 60 KVM	35	2	69936648563	3564653671668	General Purpose
200 x 25 x 51	01	A 46 NVM	35	2	66243578539	3157625629462	General Purpose
200 x 25 x 76.2	01	A 60 LVM	35	2	69936648677*	3564653696272	General Purpose
200 x 32 x 32	01	A 36 MVM	35	2	66243578555	3157625629516	General Purpose

\* Made-to-order



### A

- Abrasive: Brown aluminium oxide
- Good cost/performance compromise
- Hard wearing wheels for general purpose applications
- Suitable for grinding most types of steel & soft iron

## Bonded Abrasives



### A

- Abrasive: Brown aluminium oxide
- Good cost/performance compromise
- Hard wearing wheels for general purpose applications
- Suitable for grinding most types of steel & soft iron



### GC

- Abrasive: Green silicon carbide
- Harder & more friable than aluminium oxide abrasive
- Ideal for precision grinding & sharpening applications on metal carbide & non-ferrous metals

# Grinding Wheels

## Plain wheels - Type 01 / A

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
200 x 32 x 32	01	A 60 MVM	35	2	66243578554	3157625629509	General Purpose
200 x 32 x 76.2	01	A 46 MVM	35	2	69936675570	3157625085282	General Purpose
250 x 25 x 32	01	A 60 MVM	35	1	66243578559	3157625629554	General Purpose
250 x 32 x 32	01	A 30 OVM	35	1	69936648679	3564653696319	General Purpose
250 x 32 x 32	01	A 46 LVM	35	1	69936648680	3564653696326	General Purpose
300 x 32 x 51	01	A 60 MVM	35	1	66243578560*	3157625629561	General Purpose
300 x 40 x 35	01	A 30 PVM	35	1	66243580201	3157625630734	General Purpose
300 x 40 x 35	01	A 60 MVM	35	1	66243548626	3157625627932	General Purpose
300 x 40 x 38.1	01	A 30 PVM	35	1	66243580204	3157625630741	General Purpose
300 x 40 x 38.1	01	A 46 MVM	35	1	66243548628	3157625627956	General Purpose
300 x 40 x 38.1	01	A 60 MVM	35	1	66243548627	3157625627949	General Purpose
300 x 40 x 50.8	01	A 24 PVM	35	1	69936648689*	3564653696418	General Purpose
300 x 40 x 127	01	A 24 PVM	35	1	69936648690*	3564653696425	General Purpose
355 x 40 x 50.8	01	A 46 LVM	35	1	69936648609**	3564653677394	General Purpose
355 x 50 x 127	01	A 24 PVM	35	1	69936648693	3564653696470	General Purpose
355 x 50 x 127	01	A 36 LVM	35	1	69936648694	3564653696487	General Purpose
355 x 50 x 127	01	A 46 LVM	35	1	69936648695*	3564653696494	General Purpose
406 x 50 x 127	01	A 24 PVM	50	1	66243545550	3157625626669	General Purpose

\* Made-to-order \*\* Destock

## Plain wheels - Type 01 / GC

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
90 x 40 x 22.23	01	C 16 RVK	35	5	66243548878	3157625629042	Carbide Tool
125 x 16 x 25	01	GC 80 JVK	35	2	66243545511	3157625626508	Carbide Tool
125 x 20 x 25	01	GC 80 JVK	35	2	66243545517	3157625626539	Carbide Tool
150 x 16 x 32	01	GC 80 JVK	35	2	69936648828	3564653790604	Carbide Tool
150 x 20 x 32	01	GC 60 JVK	35	2	69936676914	3564656215401	Carbide Tool
150 x 20 x 32	01	GC 80 JVK	35	2	69936676915	3564656215425	Carbide Tool
150 x 20 x 32	01	GC 120 JVK	35	2	69936676917	3564656215456	Carbide Tool
150 x 25 x 32	01	GC 60 JVK	35	2	69936648842	3564653791700	Carbide Tool
150 x 25 x 32	01	GC 80 KVK	35	2	69936648843	3564653791717	Carbide Tool
150 x 25 x 32	01	GC 120 JVK	35	2	69936648844	3564653791731	Carbide Tool
180 x 20 x 32	01	GC 80 KVK	35	2	69936648845	3564653791762	Carbide Tool
180 x 25 x 32	01	GC 80 KVK	35	2	69936693065	3564653791793	Carbide Tool
200 x 20 x 32	01	GC 60 KVK	35	2	69936645514	3564656215746	Carbide Tool
200 x 20 x 32	01	GC 80 JVL	35	2	66243578534	3157625629431	Carbide Tool
200 x 20 x 32	01	GC 120 JVK	35	2	69936696265	3564656215555	Carbide Tool
200 x 25 x 20	01	GC 80 JVK	35	2	66243545525	3157625626607	Carbide Tool
200 x 25 x 32	01	GC 60 JVK	35	2	69936676919	3564656215562	Carbide Tool
200 x 25 x 32	01	GC 80 JVK	35	2	69936676920	3564656215579	Carbide Tool
200 x 25 x 32	01	GC 120 JVL	35	2	66243578537	3157625629455	Carbide Tool
200 x 25 x 76.2	01	GC 80 KVK	35	2	69936648849*	3564653791908	Carbide Tool
200 x 32 x 32	01	GC 80 JVK	35	2	66243578551	3157625629486	Carbide Tool

\* Made-to-order

# Grinding Wheels

## Bonded Abrasives

### Plain wheels - Type 01 / GC

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
200 x 32 x 51	01	GC 80 JVK	35	2	66243578557	3157625629523	Carbide Tool
250 x 32 x 32	01	GC 80 KVK	35	1	69936648648	3564653690003	Carbide Tool
300 x 25 x 127	01	GC 80 JVK	35	1	66243578782	3157625630314	Carbide Tool
300 x 40 x 38.1	01	GC 60 JVK	35	1	66243548633	3157625628007	Carbide Tool
300 x 40 x 127	01	GC 60 JVK	35	1	66243548623*	3157625627918	Carbide Tool
300 x 40 x 127	01	GC 80 JVK	35	1	69936648836**	3564653790888	Carbide Tool
355 x 50 x 127	01	GC 60 JVK	35	1	66243579396	3157625630598	Carbide Tool

\* Made-to-order \*\* Destock

### Recessed wheels - Type 05

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
13 x 13 x 4.76 EU 6 x 6	05	WA 60 LVL	35	20	66243578862	3157625630482	Precision grinding
25 x 25 x 6.35 EU 13 x 12	05	WA 60 KVL	35	20	66243578864	3157625630505	Precision grinding
50 x 25 x 12.7 EU 25 x 13	05	WA 60 KVL	35	20	66243578867	3157625630536	Precision grinding
300 x 40 x 127 EU 190 x 13	05	WA 60 KVL	35	1	66243548680	3157625628342	Precision grinding
300 x 40 x 127 EU 190 x 13	05	WA 80 KVL	35	1	66243548684	3157625628366	Precision grinding
300 x 50 x 127 EU 190 x 25	05	WA 60 KVL	35	1	66243548686	3157625628397	Precision grinding
50 x 25 x 12.7 EU 25 x 13	05	73A 60 KVL	35	20	66243578866	3157625630529	Precision grinding
300 x 50 x 127 EU 190 x 25	05	48A 60 KVM	35	1	66243548685*	3157625628373	Precision grinding

\* Made-to-order

### Recessed wheels - Type 07

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode	Main Usage
300 x 50 x 76.2 DU 160 x 10	07	73A 46 GVL	35	1	66243548690	3157625628434	Precision grinding
300 x 50 x 76.2 DU 160 x 10	07	WA 46 IVL	35	1	66243548689	3157625628427	Precision grinding



#### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates



#### 73A

- Abrasive: Ceramic aluminium oxide
- High removal rate & extend wheel life
- Suitable for very hard steels

Dimensions Key: D = Diameter, T = Thickness, B = Bore

## Bonded Abrasives



### A

- Abrasive: Regular aluminium oxide
- For grinding construction steel or low-alloyed steel



### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for grinding all kinds of cutting tools



### 52A

- Abrasive: Blend of white and brown aluminium oxide
- Cool and fast cutting
- Used for sharpening engraving cutters and grinding hard chrome.

### EKW

- Whetstone for sharpening house-hold tools
- By hand with water or by use of a light powered machine

# Grinding Wheels for Creusen machines

## Plain wheels - Type 01

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
150 x 20 x 15	01	A 80 MVM	33	1	66243538522	8711479193033

## Recessed wheels - Type 05

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
150 x 40 x 15 EU 70 x 20	05	WA 100 J VL	35	1	66243538686	8711479196768
150 x 40 x 15 EU 80 x 20	05	WA 80 K VL	35	1	66243538694	8711479197000
150 x 40 x 25 EU 80 x 20	05	WA 80 K VL	35	1	66243538697	8711479197116
150 x 40 x 32 EU 80 x 20	05	WA 80 K VL	33	1	66243538695	8711479197031

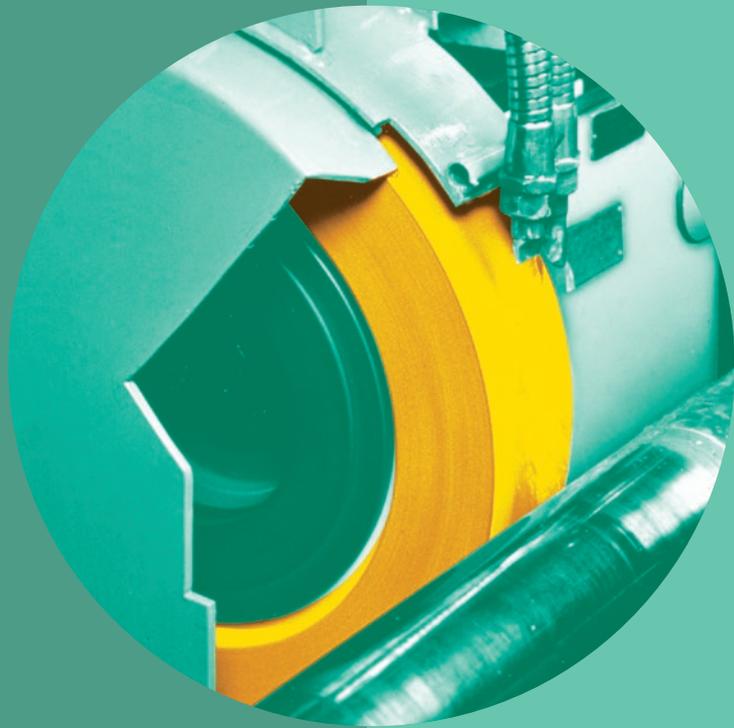
## Waterstone for Creusen machines

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
150 x 40 x 32	01	EKW 150 LV	35	1	66243538852*	8711479200205
200 x 40 x 32	01	EKW 150 LV	33	1	66243538853**	8711479200229

\* Made-to-order \*\* Destock

# Bonded Abrasives

## Dishes



## Bonded Abrasives



### 73A

- Abrasive: Ceramic aluminium oxide
- High removal rate & extend wheel life
- Suitable for very hard steels

### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

## Dishes

### Type 12



Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
150 x 6 x 30.16	12	52A 150 MVL	35	4	66243548718**	3157625628656
80 x 13 x 19.05	12	WA 60 JVL	35	5	66243548725**	3157625628717
200 x 32 x 32	12	WA 46 IVL	35	2	69936683178**	3564653660600

\*\* Destock

# Bonded Abrasives

## Cups



## Bonded Abrasives



### 73A

- Abrasive: Ceramic aluminium oxide
- High removal rate & extend wheel life
- Suitable for very hard steels

### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

### GC

- Abrasive: Green silicon carbide
- Harder & more friable than aluminium oxide abrasive
- Ideal for precision grinding & sharpening applications on metal carbide & non-ferrous metals



### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

**flexovit**

## Cups

### Straight Cups - Type 06

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
100 x 50 x 20 Rim 10 - Back 10	06	73A 70 I+VL	32	2	69936693045	3564653674454

### Straight Cups - Type 06

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
100 x 40 x 32 Rim 13 - Back 13	06	WA 60 KVL	32	2	69936648479	3564653661102
100 x 50 x 19.84 Rim 10 - Back 10	06	WA 120 JVL	32	2	66243548829	3157625628953
100 x 50 x 20 Rim 13 - Back 13	06	WA 60 KVL	32	2	66243545694	3157625626751
100 x 50 x 20 Rim 10 - Back 10	06	WA 80 JVL	32	2	66243578857	3157625630444
125 x 63 x 32 Rim 8 - Back 13	06	WA 80 JVL	35	2	66243545693	3157625626744
180 x 63 x 50.8 Rim 16 - Back 16	06	WA 36 GVL	32	2	69936648496	3564653662055
200 x 40 x 76.2 Rim 40 - Back 13	06	WA 60 JVL	32	2	69936648488	3157625631137
200 x 80 x 78 Rim 16 - Back 20	06	WA 36 GVL	32	2	66243545685	3157625626706

### Straight Cups - Type 06

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
200 x 40 x 76.2 Rim 40 - Back 13	06	GC 60 IVK	32	2	69936648371*	3564653366175

\* Made-to-order

### Taper Cups - Type 11

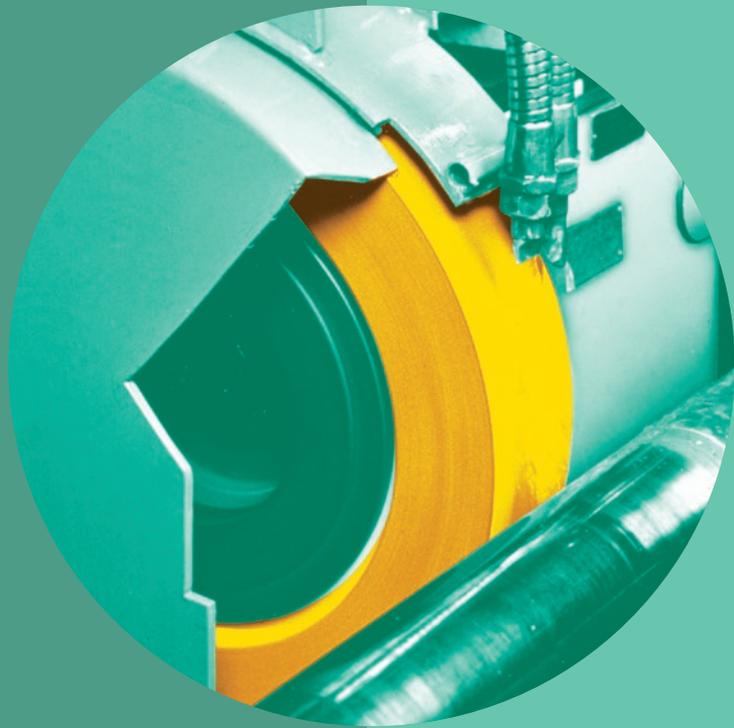
Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
125 x 50 x 32	11	WA 46 IVL	32	2	69936683184*	3564653660983

\* Made-to-order

Dimensions Key: D = Diameter, T = Thickness, B = Bore

# Bonded Abrasives

## Discs



## Bonded Abrasives



### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

## Discs

### Types 35 & 36



Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
203 x 50 x 114.3	36	WA 46 KVL	35	1	66243548738	3157625628823

# Bonded Abrasives

## Cylinder





## WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

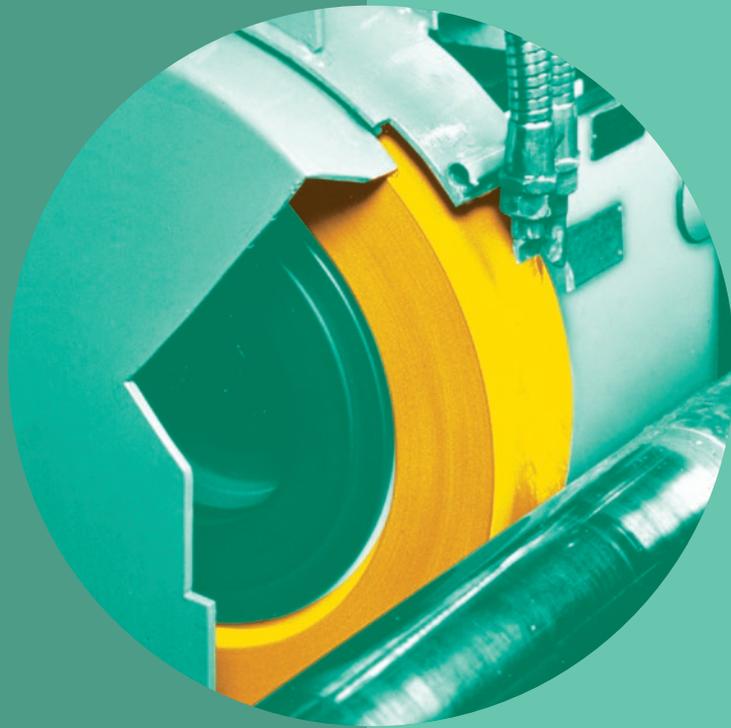
# Cylinder

## Type 02

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
127 x 50 x 101.6	02	WA 46 JVL	25	2	66243548749	3157625628908

# Bonded Abrasives

## Dressing Sticks



## Bonded Abrasives



For sharpening grinding wheels



For sharpening grinding wheels



Ideal for dressing conventional vitrified grinding wheels

## Dressing Sticks

### Conditioning

#### RECTANGULAR



Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode	Used with
13 x 5 x 76	Flexbide	5	66243581709**	3157625647121	Abrasive wheel
25 x 50 x 200	C 24 TV	20	66243580390	3157625630949	Abrasive wheel
13 x 25 x 150	WA 150 HV	20	66243580434**	3157625630963	CBN wheel
13 x 25 x 150	WA 220 HV	20	66243580367	3157625630925	CBN wheel
13 x 25 x 150	WA 320 HV	20	66243580381**	3157625630932	CBN wheel

\*\* Destock

#### SQUARE



Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode	Used with
20 x 200	C 30 TV	20	66243581003**	3157625631069	Abrasive wheel
25 x 200	C 30 TV	20	66243581004**	3157625631076	Abrasive wheel
13 x 100	WA 150 JV	20	66243580335**	3157625630901	CBN wheel
20 x 200	WA 150 HV	20	66243580999**	3157625631045	CBN wheel
13 x 150	C 320 HV	20	66243580984**	3157625631007	CBN wheel

\*\* Destock

### Sharpening

#### SQUARE



Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode	Main Usage
13 x 150	C 80 MV	20	66243580342**	3157625630918	Sharpening
13 x 150	C 100 RV	20	66243580983	3157625630994	Sharpening
13 x 150	C 150 LV	20	66243580982**	3157625630987	Sharpening

\*\* Destock

#### TRIANGULAR



Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode	Main Usage
13 x 150	C 100 RV	20	66243581005**	3157625631083	Sharpening

\*\* Destock

### Crystolon stone

Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode	Main Usage
15 x 30 x 115	SC 20 R	1	66243538877	8711479206184	Profiling
25 x 50 x 150	SC 20 Q	1	66243538878**	8711479206191	Profiling
25 x 50 x 200	GC 60 KV	20	66243580994*	3157625631014	Profiling
25 x 50 x 200	GC 80 KV	20	66243580996	3157625631021	Profiling

\* Made-to-order \*\* Destock

## Diamond Dressing Tools

### MULTI POINT

Type	Shank (mm)	Grit	Carat	Quantity	Article Number	Barcode
MP250	MK1	D426	2.5	1	69014171502*	8711479425769
	Z10 x 50	D426	2.5	1	69014170804*	8711479425783
	MK1	D1001	2.5	1	66260390005*	8711479425813
	Z10 x 50	D1001	2.5	1	66260393806*	8711479425851
	MK1	D2240	2.5	1	69014160913*	8711479425837
	Z10 x 50	D2240	2.5	1	69014173011*	8711479425806
	Z11 x 50	D1001	2.5	1	69014158054*	8711479425776

\* Made-to-order



- Ideal for straight dressing at high speed with low technical demands
- Economical & robust tool

### SINGLE POINT

Type	Shank (mm)	Carat	Quantity	Article Number	Barcode
SP	MK1	0.1	1	69014162116*	8711479425752
	Z10 x 50	0.1	1	66260396717*	8711479425738
	MK1	0.25	1	66260390118*	8711479425714
	Z10 x 50	0.25	1	69014166419*	8711479425691
	Z11 x 50	0.25	1	69014166052*	8711479425653
	MK1	0.5	1	66260399421*	8711479425639
	Z10 x 50	0.5	1	69014173220*	8711479425615
	MK1	1	1	69014164523*	8711479425608
	Z10 x 50	1	1	66260394422*	8711479425684
	Z11 x 50	1	1	69014157953*	8711479425585

\* Made-to-order



- Ideal for applications where it's difficult to measure the performance of the dressing tool
- Suitable for dressing conventional abrasive wheels

### HAND DRESSER

Type	Shank (mm)	Grit	Carat	Quantity	Article Number	Barcode
HD150	13 x 200	18/25 SPC	1.6	1	66260396924*	8711479425561

\* Made-to-order



- High diamond concentration
- High wear resistance & long lifetime
- Suitable for face & side dressing

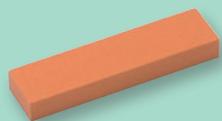


# Bonded Abrasives

## Stones



# Bonded Abrasives



Abrasive files ideal when a close tolerance is more important than the speed of cut

Aluminium oxide

A100 (Coarse India) and  
A240 (Medium India)

for coarse/medium sharpening

A320 (Fijn India) for fine stoning



## Stones

### Bench

#### RECTANGULAR



Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode
1.6 x 13 x 100	A 240	20	66243548555*	3157625627703
5 x 25 x 127	A 240	10	66243548648**	3157625628106
6 x 25 x 100	A 240	5	66243548465**	3157625627178
13 x 25 x 100	A 240	5	66243548468**	3157625627185
13 x 25 x 100	A 320	5	66243548647**	3157625628083
13 x 38 x 150	A 240	50	66243548471*	3157625627208
13 x 45 x 100	A 240	50	66243548457**	3157625627147
16 x 50 x 150	A 240	10	66243548472**	3157625627215
25 x 50 x 150	A 240	5	66243548473**	3157625627222
25 x 50 x 150	A 320	5	66243548650**	3157625628113
25 x 50 x 200	A 240	5	66243548475**	3157625627246
25 x 50 x 200	A 320	5	66243548651**	3157625628137

\* Made-to-order \*\* Destock

#### SQUARE



Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode
8 x 100	A 240	20	66243548533**	3157625627581
8 x 100	A 320	20	66243548728**	3157625628748
10 x 150	A 320	20	66243548739**	3157625628847
13 x 100	A 240	20	66243548554*	3157625627697
13 x 150	A 240	20	66243548556**	3157625627727
13 x 150	A 320	20	66243548743**	3157625628885
16 x 150	A 100	20	66243548564*	3157625627789
16 x 150	A 240	20	66243548557**	3157625627734
16 x 150	A 320	20	66243548748**	3157625628892
20 x 150	A 100	20	66243548562**	3157625627772
20 x 200	C 280	20	66243581002**	3157625631052

\* Made-to-order \*\* Destock

## Shaped

### HALF-ROUND



Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode
8 x 100	A 240	20	66243548544*	3157625627635
10 x 100	A 320	20	66243548731*	3157625628779
10 x 100	A 240	20	66243548546**	3157625627642

\* Made-to-order \*\* Destock



### ROUND



Dimensions (mm) D x L	Specification	Quantity	Article Number	Barcode
3 x 100	A 320	20	66243548705**	3157625628571
6 x 100	A 320	20	66243547795*	3157625626874
6 x 100	A 240	20	66243548524*	3157625627536
8 x 100	A 320	20	66243548709**	3157625628595
8 x 100	A 240	20	66243548529**	3157625627567
10 x 100	A 320	20	66243548712**	3157625628618
13 x 100	A 240	20	66243548536*	3157625627598
13 x 150	A 240	20	66243548538*	3157625627604
16 x 150	A 240	20	66243548541**	3157625627611
20 x 150	A 240	20	66243548542*	3157625627628

\* Made-to-order \*\* Destock



### TRIANGULAR



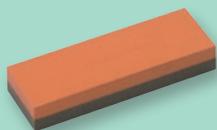
Dimensions (mm) H x L	Specification	Quantity	Article Number	Barcode
6 x 100	A 320	20	66243548652**	3157625628144
8 x 100	A 320	20	66243548653*	3157625628151
8 x 100	A 240	20	66243548483*	3157625627291
10 x 100	A 240	20	66243548442**	3157625627024
10 x 150	A 240	20	66243548485**	3157625627307
10 x 100	A 100	20	66243548566*	3157625627802
13 x 100	A 320	20	66243548699*	3157625628519
13 x 150	A 240	20	66243548496**	3157625627369
16 x 150	A 240	20	66243548441**	3157625627017
16 x 150	A 100	20	66243548565**	3157625627796
16 x 203	A 240	20	66243548513*	3157625627499
20 x 150	A 240	20	66243548511*	3157625627475
20 x 203	A 240	20	66243548514**	3157625627505
25 x 150	A 240	20	66243548512*	3157625627482
25 x 254	A 240	20	66243548517*	3157625627512

\* Made-to-order \*\* Destock



Dimensions Key: W = Width, H = Height, L = Length, D = Diameter

## Bonded Abrasives



Slipstones for  
sharpening knives

## Stones

### Combination

#### RECTANGULAR



Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode
16 x 45 x 100	A 320 / 100	5	66243548567*	3157625627819
20 x 50 x 127	A 320 / 100	5	66243548439**	3157625626973
25 x 50 x 150	A 320 / 100	5	66243548440	3157625626997
25 x 50 x 178	A 320 / 100	5	66243548570	3157625627833
25 x 50 x 200	A 320 / 100	5	66243548571	3157625627857
25 x 50 x 200	C 280 / 100	5	66243548528	3157625627543
25 x 63 x 150	A 320 / 100	5	66243548569**	3157625627826

\* Made-to-order \*\* Destock

#### CYLINDRICAL



Dimensions (mm) D x W	Specification	Quantity	Article Number	Barcode
100 x 38	C 320 / 100	10	66243548549*	3157625627666

\* Made-to-order

#### SLIP STONES



Dimensions (mm) W x H x L	Shape	Specifi- cation	Article Number	Barcode
6 x 45 x 115	ME157880	A 240	66243548574	3157625627871
6 x 45 x 115	ME157880	A 320	66243548758**	3157625628939
8 x 25 x 127	ME157878	A 240	66243548572*	3157625627864
10 x 45 x 115	ME157877	A 240	66243548641**	3157625628052

\* Made-to-order \*\* Destock

## Hand stones

### WHET STONES

Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode
20 x 50 x 100	EW 280/ER 120 V	1	66243538860	8711479205842
25 x 50 x 125	EW 280/ER 120 V	1	66243538857	8711479205811
25 x 50 x 150	EW 280/ER 120 V	1	66243538858	8711479100161
25 x 50 x 200	EW 280/ER 120 V	1	66243538859	8711479205835
20 x 50 x 100	CG 320/CD 120 V	1	66243538861	8711479205873
20 x 50 x 125	CG 320/CD 120 V	1	66243538862	8711479205880
25 x 50 x 150	CG 320/CD 120 V	1	66243567213	4007739006361
25 x 50 x 200	CG 320/CD 120 V	1	66243567224	4007739400022
25 x 75 x 250	CG 360/CG 100 V	1	66243538865	8711479205927
13 x 33/10 x 230	SCYTHE SHARPENER CD 100 V	1	66243567215*	8711479359514

\* Made-to-order

### GOUGE WHETSTONE

Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode
6/1.5 x 45 x 115	CG 180 V	1	66243567002**	8711479373138
115 x 45 x 6/1.5	CG 320 V	1	66243567251**	8711479364235

\*\* Destock

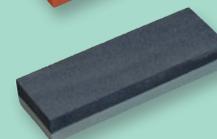
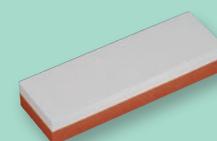
### NATURAL WHETSTONE

Dimensions (mm) W x H x L	Quantity	Article Number	Barcode
NR 4 FINE BELGIAN BLOCK	1	7660738917	8711479206030
NR 5 FINE BELGIAN	1	7660738918	8711479206047

### HAND STONES

Dimensions (mm) W x H x L	Specification	Quantity	Article Number	Barcode
50 x 50 x 150	SCG 16/20 KE	1	66243538868	8711479206061
25 x 50 x 200	SCG 16/20 KE	1	66243538869	8711479206078
50 x 50 x 200	SCG 16/20 KE	1	66243538870	8711479206085
50 x 50 x 150	CD 60 PV	1	66243538872	8711479206108
25 x 50 x 200	CD 60 PV	1	66243538917	4007739400169
50 x 50 x 200	CD 60 LV	1	66243567196	8711479177712
50 x 50 x 150	SD 120 LV	1	66243538875**	8711479206146
50 x 50 x 200	SD 120 LV	1	66243538876	8711479206160

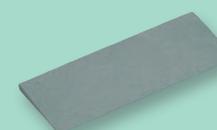
\*\* Destock



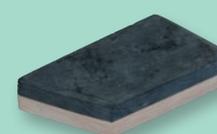
**Whetstones**  
for all kinds of cutting tools



**Scythe scharpener**  
Oval whetstone for sharpening scythes, domestic tools and garden tools.



**Gouge whetstone**  
For wood bits, gouge bits and forming tools



**Natural whetstones**  
Soft natural whetstone

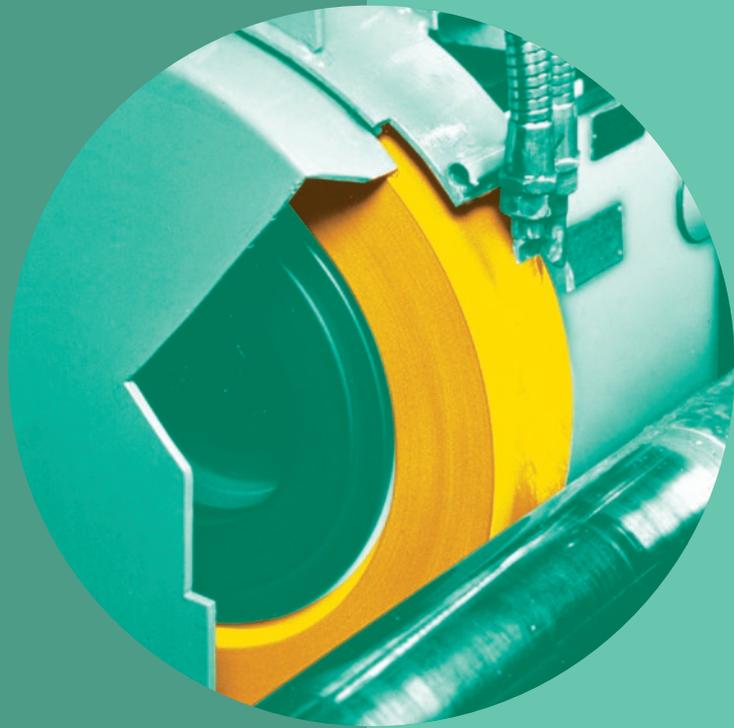


**Hand stones**  
For smoothing floors and walls



# Bonded Abrasives

## Segments





Surface grinding segments are generally used to grind flat stock or flat surfaces within a workpiece. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

- Grinding large moulds & dies
- Sharpening knives, blades, cutlery

#### WA

- Abrasive: High purity white aluminium oxide
- Cool & burn free cutting
- Ideal for heat-sensitive applications with light to moderate feed rates

Other sizes available on request

# Segments

## Type 31



Dimensions (mm) W x H x L	Shape	Specification	Quantity	Article Number	Barcode
50 x 25 x 110	31	73A 60 FVL	2	69936657500**	3157625631168
103 x 38 x 150	31	WA 30 H11VM	2	66243548693*	3157625628458
103 x 38 x 200	31	WA 30 I11VM	2	66243548694	3157625628465
117 x 44 x 150	31	WA 30 I11VM	2	66243548696**	3157625628489

\* Made-to-order \*\* Destock

# Bonded Abrasives

## Mounted Points & Wheels





## 41A

- Abrasive: Pink aluminium oxide
- For deburring, blending and finishing

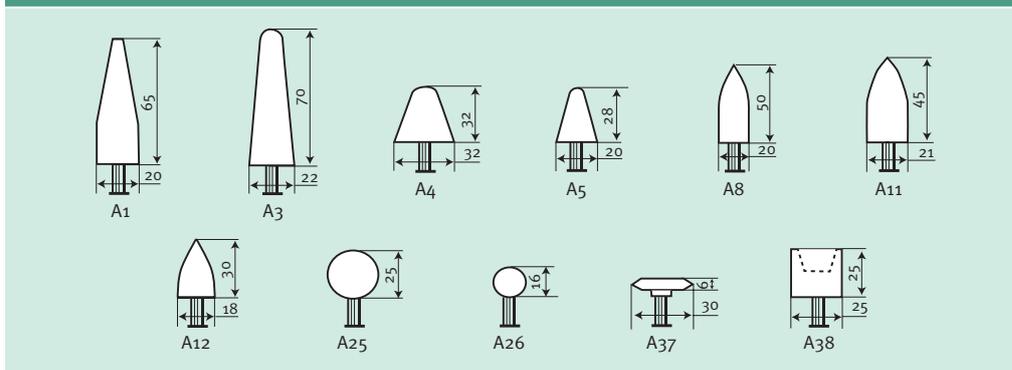
# Mounted Points & Wheels

## Mounted Points (Type A)

Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
20 x 65	6 x 40	A1	41A 36 PV	15000	20	66243538967	8711479165047
25 x 32	6 x 40	A2	41A 36 PV	20000	20	66243538973*	8711479165092
22 x 70	6 x 40	A3	41A 36 PV	14000	20	66243538971	8711479165085
22 x 70	6 x 40	A3	41A 60 PV	14000	20	66243538539	8711479164385
32 x 32	6 x 40	A4	41A 36 PV	17000	20	66243566869	8711479165269
20 x 28	6 x 40	A5	41A 46 PV	30000	20	66243538968	8711479165054
20 x 50	6 x 40	A8	41A 36 PV	18000	20	66243538966	8711479165030
21 x 45	6 x 40	A11	41A 36 PV	18000	20	66243538969	8711479165061
18 x 30	6 x 40	A12	41A 46 PV	30000	20	66243538962	8711479164972
25	6 x 40	A25	41A 36 PV	25000	20	66243538939	8711479164804
16	6 x 40	A26	41A 46 PV	54000	20	66243538960	8711479164941
30 x 6	6 x 40	A37	41A 60 PV	30000	20	66243566866	8711479165238
25 x 25	6 x 40	A38	41A 36 PV	25000	20	66243566862	8711479165153

\* Made-to-order

### MOUNTED POINTS SHAPE KEY



## Mounted Points (Type W)



Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
10 x 13	6 x 40	W176	41A 60 PV	54000	20	66243538891	8711479164101
10 x 20	6 x 40	W177	41A 60 PV	41000	20	66243538496	8711479164118
10 x 32	6 x 40	W179	41A 60 PV	25000	20	66243538943	8711479164842
13 x 20	6 x 40	W186	41A 60 PV	48000	20	66243538942	8711479164835
13 x 25	6 x 40	W187	41A 60 PV	30000	20	66243538957	8711479164903
16 x 20	6 x 40	W195	41A 46 PV	47000	20	66243538893	8711479164125
16 x 25	6 x 40	W196	41A 46 PV	35000	20	66243538533	8711479164354
16 x 32	6 x 40	SPEC.	41A 46 PV	25000	20	66243538894	8711479164132
20 x 20	6 x 40	W204	41A 46 PV	42000	20	66243538554	8711479164989
20 x 25	6 x 40	W205	41A 46 PV	32000	20	66243538896	8711479164149
20 x 32	6 x 40	W206	41A 46 PV	30000	20	66243538497	8711479164156
20 x 40	6 x 40	W207	41A 46 PV	24000	20	66243538898	8711479164163
25 x 25	6 x 40	W220	41A 36 PV	25000	20	66243538899	8711479164170
25 x 40	6 x 40	W221	41A 36 PV	19000	20	66243538900	8711479164187
32 x 20	6 x 40	W228	41A 36 PV	24000	20	66243538901	8711479164194
32 x 32	6 x 40	W230	41A 36 PV	17000	20	66243538503	8711479164200
40 x 13	6 x 40	W236	41A 36 PV	25000	20	66243566871	8711479165283
40 x 25	6 x 40	W237	41A 36 PV	19000	20	66243538910	8711479164224
40 x 40	6 x 40	W238	41A 36 PV	12000	20	66243538510	8711479164231

Dimensions Key: D = Diameter, L = Length, S = Spindle

# Bonded Abrasives

## Organic Cut-Off Wheels





# Organic Cut-Off Wheels

## Plain – Type 41

- Non-reinforced products for toolroom applications

Dimensions (mm) D x T x B	Shape	Specification	Quantity	Article Number	Barcode
125 x 1 x 20	41	44A 60 PB	25	66243547738*	3157625626768
508 x 5 x 25.4	41	A24S BF7	10	66243450473	8711479298233
508 x 5.4 x 25.4	41	A242 QBF	10	66243450474	8711479118487

\* Made-to-order

## Depressed Centre – Type 42

- Reinforced

Dimensions (mm) D x T x B	Shape	Specification	Quantity	Article Number	Barcode
400 x 5 x 76.2	42	ZA 24 Z0BF4	20	66243547742*	3157625626799
508 x 5.5 x 76.2	42	A24SBF7	8	66243450461	3564659127459

\* Made-to-order

# Bonded Abrasives

## Foundry



## Bonded Abrasives



Non-reinforced organic stones

- For use on portable grinding machines or machines with a flexible shaft.



Reinforced organic cups

- A – Suitable for grinding metal
- C – Suitable for grinding stone

## Foundry

### Plain – Type 01

Dimensions (mm) D x T x B	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
51 x 16 x 10	01	A 30 TB	50	100	66243450432	8711470000651
65 x 13 x 10	01	A 24 RBF	50	100	66243471152	3157625631274
76 x 13 x 10	01	A 30 TB	50	20	66243450434	8711479262487

### Taper Cups – Type 11

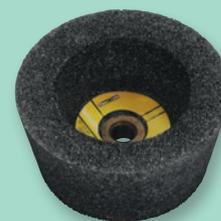
Dimensions (mm) D x T x Th	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
100/80 x 50 x M14 Rim 20 - Back 20	11	A 16 PB	50	18	66243567204**	8711479404801
100/80 x 50 x M14 Rim 20 - Back 20	11	A 16 QB	50	18	66243538886**	8711479397127
100/80 x 50 x 5/8UNC Rim 20 - Back 20	11	A 16 QB	50	18	66243538821*	8711479396816
100/80 x 50 x M14 Rim 20 - Back 20	11	A 30 NB	50	18	07660738783	8711479416446
100/80 x 50 x M14 Rim 20 - Back 20	11	A 36 PB	50	18	66243566925	8711479404030
100/80 x 50 x 5/8UNC Rim 20 - Back 20	11	A 36 PB	50	18	66243566965*	8711479404061
125/100 x 50 x M14 Rim 25 - Back 20	11	A 16 PB	50	10	66243567216	8711479406287
125/100 x 50 x M14 Rim 25 - Back 20	11	A 16 QB	50	10	66243567220**	8711479406348
125/100 x 50 x 5/8UNC Rim 25 - Back 20	11	A 16 QB	50	10	66243567004**	8711479404351
125/100 x 50 x 5/8UNC Rim 25 - Back 20	11	A 30 QB	50	10	66243566975*	8711479404191
125/100 x 50 x M14 Rim 25 - Back 20	11	A 36 PB	50	10	66243538823	8711479396823
125/100 x 50 x M14 Rim 25 - Back 20	11	C 20 PB	50	10	66243538887	8711479397134
125/100 x 51 x M14 Rim 25 - Back 20	11	C 20 QB	50	10	66243567222**	8711479406362
127/100 x 50 x 5/8UNC Rim 25 - Back 20	11	A 36 MB	50	10	66243567226*	8711479407116
150/120 x 50 x 5/8UNC Rim 40 - Back 20	11	A 16 PB	50	8	66243567205*	8711479404818
150/120 x 50 x 5/8UNC Rim 40 - Back 20	11	A 16 QB	50	8	66243566960*	8711479404047
150/120 x 50 x 5/8UNC Rim 40 - Back 20	11	A 16 RB	50	8	66243567061	8711479404528
150/120 x 50 x 5/8UNC Rim 40 - Back 20	11	A 36 PB	50	8	66243567012	8711479404368
150/120 x 50 x 5/8UNC Rim 40 - Back 20	11	C 16 QB	50	8	66243538897*	8711479397158
150/120 x 50 x M14 Rim 40 - Back 20	11	C 20 PB	50	8	66243567221**	8711479406355

\* Made-to-order \*\* Destock

## Taper Cups – Type 11



Dimensions (mm) D x T x Th	Shape	Specification	MOS (m/s)	Quantity	Article Number	Barcode
110 x 95 x 22.2	11	C 20 VE	50	1	66243538706	8711479197345
110 x 95 x M14	11	C 20 VE	50	1	66243538707	8711479197352
110 x 95 x 22.2	11	C 60 VE	50	1	66243538712	8711479197505
110 x 95 x M14	11	C 60 VE	50	1	66243538713	8711479197512



Reinforced organic cups

- C – Suitable for grinding stone



# Bonded Abrasives

## Organic Mounted Points & Wheels





- A**
- Abrasive: Aluminium oxide
  - For use on all steel types, cast iron & superalloys.

## Organic Mounted Points & Wheels

### Type A & B

Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
20 x 63	6 x 40	A1	A36 QB	19800	50	07660739154*	8711479394126
20 x 28	6 x 40	A5	A36 QB	45000	50	07660739227**	8711479394140
21 x 45	6 x 40	A11	A36 QB	19860	50	07660739229	8711479394164
40 x 10	6 x 40	A36	A36 QB	23520	50	07660739231*	8711479394188
13	6 x 40	B121	A46 QB	59680	50	07660739563*	8711479393983

\* Made-to-order \*\* Destock

### Organic Mounted Wheels A 30 R

Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
10 x 20	6 x 40	100	A30 R	82200	25	07660738812	8711479147685
10 x 30	6 x 40	100	A30 R	56900	25	07660738814	8711479147708
10 x 40	6 x 40	100	A30 R	47500	25	07660738816	8711479147722
15 x 20	6 x 40	100	A30 R	58500	25	07660738819	8711479147760
15 x 30	6 x 40	100	A30 R	39600	25	07660738820	8711479147777
20 x 20	6 x 40	100	A30 R	44800	25	07660738827	8711479147838
20 x 30	6 x 40	100	A30 R	30000	25	07660738831	8711479147920
20 x 40	6 x 40	100	A30 R	24200	25	07660738840	8711479148026
20 x 50	6 x 40	100	A30 R	19100	25	07660738830*	8711479147883
25 x 25	6 x 40	100	A30 R	30100	25	66243450527	8711479148170
25 x 30	6 x 40	100	A30 R	24200	25	07660738849	8711479148224
30 x 30	6 x 40	100	A30 R	20100	25	07660738859	8711479148323
40 x 30	6 x 40	110	A30 R	15200	25	07660738879	8711479148637
40 x 40	6 x 40	100	A30 R	12200	25	07660738881	8711479148651
50 x 25	6 x 40	110	A30 R	15200	25	66243472934	8711479148729

\* Made-to-order

### Organic mounted wheels W A36QB

Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
10 x 32	6 x 40	W179	A36 QB	45000	50	07660739232*	8711479394201
13 x 40	6 x 40	W188	A36 QB	30370	50	66243567290**	8711479408090
20 x 25	6 x 40	W205	A36 QB	34500	50	66243567291**	8711479408106
25 x 25	6 x 40	W220	A36 QB	25500	50	66243567292	8711479408113
32 x 13	6 x 40	W227	A36 QB	25500	50	66243567246*	8711479407611
32 x 32	6 x 40	W230	A36 QB	24000	50	66243567296	8711479408120

\* Made-to-order \*\* Destock

## Organic mounted wheels A 46 Q - ironfree

Dimensions (mm) D x L	Spindle (mm) S x L	Shape	Specification	RPM	Quantity	Article Number	Barcode
10 x 20	6 x 40	100	A46 QB	82200	50	07660738813	8711479147692
10 x 25	6 x 40	100	A46 QB	69800	50	07660739277*	8711479393884
10 x 30	6 x 40	100	A46 QB	56900	50	07660738815	8711479147715
10 x 32	6 x 40	100	A46 QB	56900	50	07660739323*	8711479393860
13 x 40	6 x 40	100	A46 QB	36600	50	07660739350**	8711479393907
15 x 30	6 x 40	100	A46 QB	39600	50	07660738821	8711479147784
16 x 25	6 x 40	100	A46 QB	46200	50	07660739543	8711479393921
16 x 50	6 x 40	100	A46 QB	23800	50	07660739545*	8711479393945
20 x 20	6 x 40	100	A46 QB	44800	50	07660738825	8711479147814
20 x 25	6 x 40	100	A46 QB	37400	50	07660739538	8711479393969
20 x 40	6 x 40	100	A46 QB	24200	50	07660738838	8711479147999
25 x 25	6 x 40	100	A46 QB	30100	50	07660738844	8711479148187
25 x 40	6 x 40	100	A46 QB	19400	50	07660739106	8711479394027
30 x 20	6 x 40	110	A46 QB	30200	50	07660738858	8711479148279
32 x 20	6 x 40	100	A46 QB	28400	50	07660739120	8711479394041
32 x 32	6 x 40	100	A46 QB	19800	50	07660739148	8711479394065
40 x 13	6 x 40	100	A46 QB	23800	50	07660739149	8711479394089
50 x 25	6 x 40	110	A46 QB	15200	50	07660738882	8711479148682

\* Made-to-order \*\* Destock

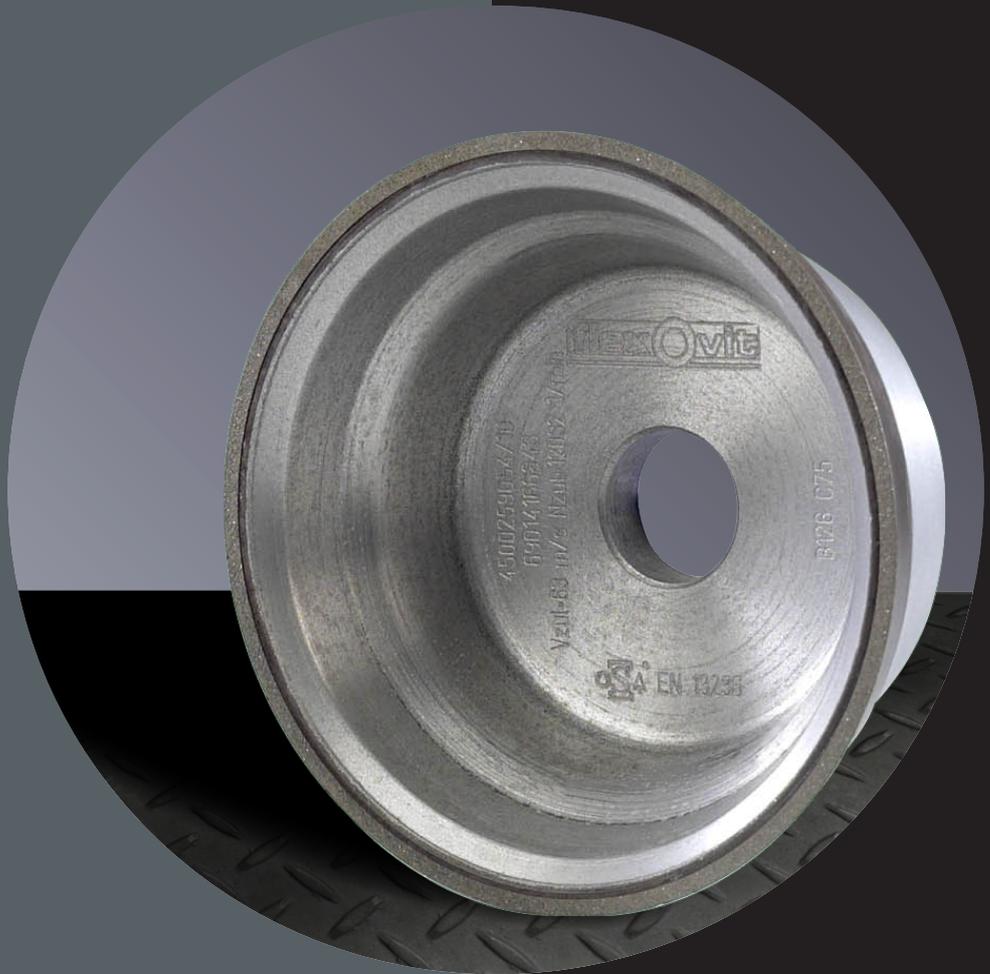


### A 46 Q

- Abrasive: Aluminium oxide
- For use on all steel types, cast iron & superalloys.
- Specially suited for stainless steel applications



# Super Abrasives



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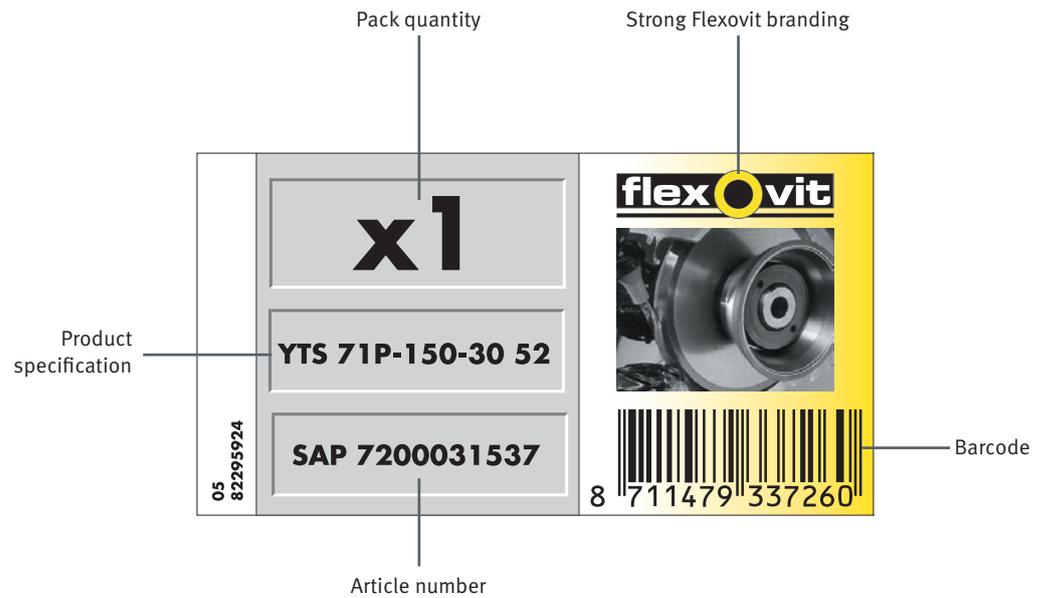


## Technical Information

The Flexovit Super Abrasive range provides technical solutions for the most popular applications encountered in two selected areas:

- S/A wheels: These are suitable for sharpening applications often encountered in a tool room environment and the metal industry
- S/A dressers: These can be used for dressing grinding wheels

## Understanding the Product



# Super Abrasives

## Grinding Wheels





# Grinding Wheels

## Selecting the Right Product

### ABRASIVES

#### Diamond (D)

Diamond abrasives are the optimum tools to grind carbide and other non-metallic materials. Using such products reduces costs as the wheels have long operating lives, provide high stock removal rates and give excellent all round results.

#### Cubic Boron Nitride (CBN)

Cubic Boron Nitride is the most suitable solution for grinding HSS and nickel based alloys. To reduce wheel wear and overheating, CBN wheels are the logical choice as they perform better in sharpening operations.

### SURFACE FINISH & GRIT SIZE

Grit size influences the surface finishing and the stock removal rate of the product.

- Grit 126: rough operation
- Grit 91/107: semi-finishing operation
- Grit 64: finishing operation

### CONCENTRATION

50: for large surface areas (2.2 carats/cm<sup>3</sup>)

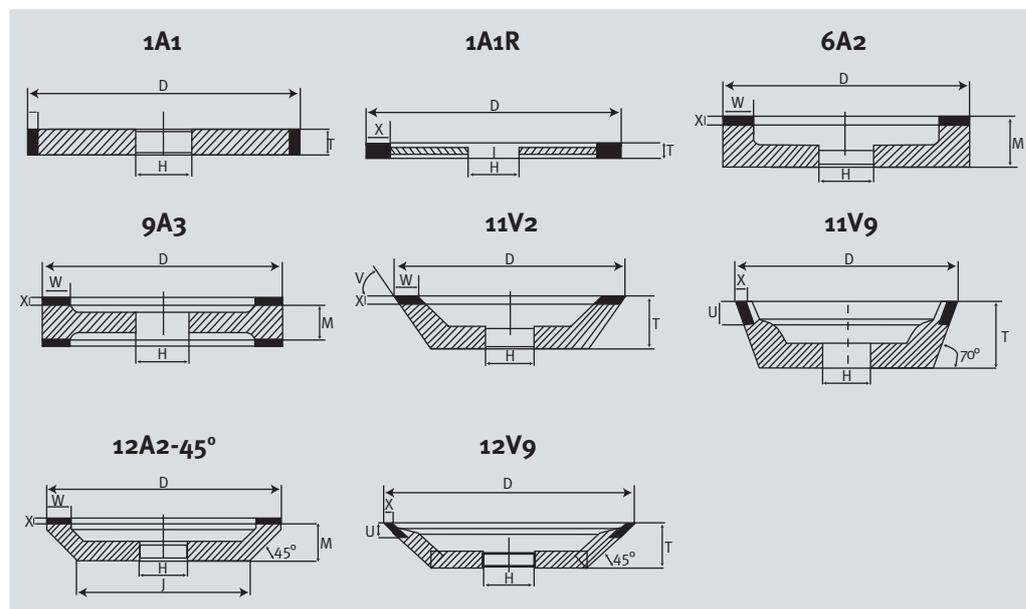
75: suitable for most standard applications (3.3 carats/cm<sup>3</sup>)

The concentration influences the stock removal rate and the geometry of the workpiece.

### BOND

Resin is extremely versatile and can be used for both wet and dry applications

### WHEEL SHAPES





## Getting the Best from your Super Abrasive Wheels

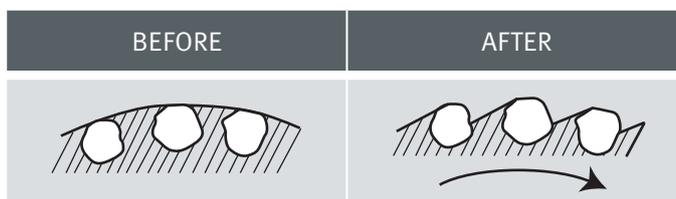
### WHEEL SPEED

MAXIMUM OPERATING SPEED		
	 Dry	 Wet
Diamond wheels	15m/s	25m/s
CBN	15 to 25m/s	25 to 35m/s

Both CBN and Diamond wheels can be used with or without coolant.

### OPEN-UP THE WHEEL FACE

To open-up the Diamond or CBN wheel face, you need to use an abrasive stick that will develop a cutting edge on the product. This operation removes some of the resin bond that covers the abrasive grains and means that the grinding process does not commence with dull abrasive grains.



DIAMOND OR CBN
grit 126 and coarser....use a 150 mesh abrasive stick
grit 54 - 107....use a 220 mesh abrasive stick
grit 46 and finer....use a 320 mesh abrasive stick

Recommendation: For better performance, put the abrasive stick in water or soluble oil before carrying out the operation as this avoids dust creation.



# Grinding Wheels

## Diamond

### 1A1

Grit	Specification	D	T	H	X	Quantity	Article Number	Barcode
91	D91C75R	100	4	20	3	1	69014173419*	8711479425332

\* Made-to-order

### 6A2

Grit	Specification	D	M	H	W	X	Quantity	Article Number	Barcode
91	D91C50R	100	18	20	12	2	1	66260396522*	8711479425349
		150	18	20	15	2	1	69014169823*	8711479425356

\* Made-to-order

### 12A2 45°

Grit	Specification	D	M	H	W	X	Quantity	Article Number	Barcode
64	D64C75R	100	23	20	5	2	1	66260399024*	8711479425363
126	D126C75R	100	23	20	5	2	1	69014173127*	8711479425387
64	D64C75R	125	23	20	6	3	1	66260389829*	8711479425417
126	D126C75R	125	23	20	6	3	1	69014166130*	8711479425424

\* Made-to-order

### 9A3

Grit	Specification	D	M	H	W	X	Quantity	Article Number	Barcode
64	D64C50R	175	30	20	5	2	1	69014169434*	8711479425431
126	D126C75R	175	30	20	5	2	1	66260398236*	8711479425448

\* Made-to-order

### 11V2

Grit	Specification	D	T	H	W	X	Quantity	Article Number	Barcode
126	D126C75R	100	25	20	5	3	1	69014162637*	8711479425455

\* Made-to-order

### 11V9

Grit	Specification	D	T	H	X	U	Quantity	Article Number	Barcode
64	D64C75R	75	30	20	2	10	1	66260396538*	8711479425462
126	D126C75R	75	30	20	2	10	1	66260392839*	8711479425479
64	D64C75R	100	35	20	2	10	1	69014167641*	8711479425486
126	D126C75R	100	35	20	2	10	1	69014166642*	8711479425493

\* Made-to-order



## 12V9

Grit	Specification	D	T	H	X	U	Quantity	Article Number	Barcode
126	D126C75R	75	20	20	2	6	1	69014167444*	8711479425509
64	D64C75R	75	20	20	2	6	1	66260399045*	8711479425516
126	D126C75R	100	20	20	2	6	1	69014183741*	8711479425523
91	D91C75R	100	20	20	2	6	1	66260391649*	8711479425547

\* Made-to-order

## 1A1R

Grit	Specification	D	T	H	X	Quantity	Article Number	Barcode
126	D126C75R	100	1	20	5	1	66260396050*	8711479425554
		125	1	20	5	1	69014165351*	8711479425578
		150	1	20	5	1	69014165852*	8711479425592

\* Made-to-order

## CBN

### 12A2 45°

Grit	Specification	D	M	H	W	X	Quantity	Article Number	Barcode
126	B126C50R	100	23	20	5	2	1	66260395028*	8711479425622
		125	23	20	6	3	1	69014177031*	8711479425646

\* Made-to-order

## 11V9

Grit	Specification	D	T	H	X	U	Quantity	Article Number	Barcode
126	B126C75R	75	30	20	2	10	1	66260396540*	8711479425677
		100	35	20	2	10	1	69014166843*	8711479425707

\* Made-to-order

## 12V9

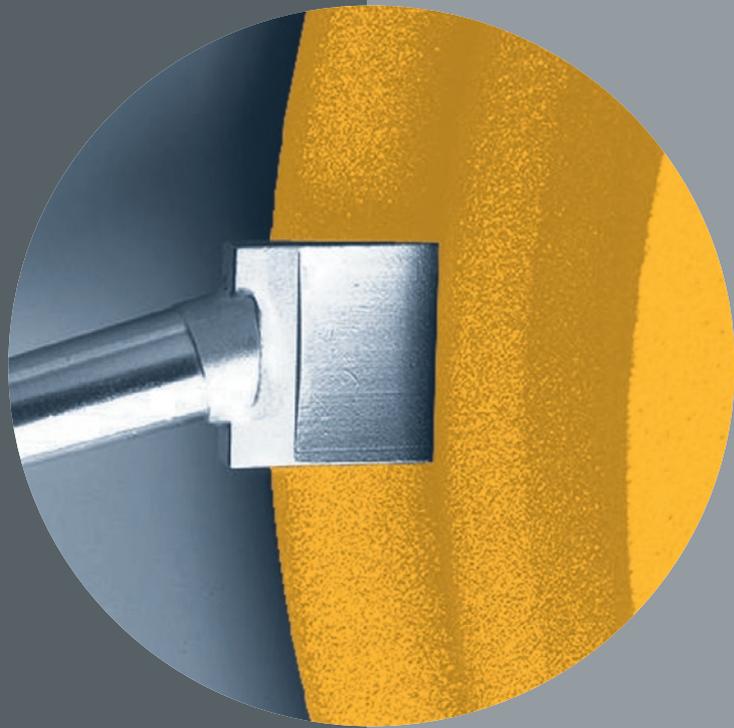
Grit	Specification	D	T	H	X	U	Quantity	Article Number	Barcode
107	B107C75R	75	20	20	2	6	1	66260396646*	8711479425721
		100	20	20	2	6	1	66260396448*	8711479425745

\* Made-to-order



# Super Abrasives

## Diamond Dressing Tools





# Diamond Dressing Tools

## Selecting the Right Product

Dressing is the process of sharpening the cutting edges of grinding wheels to develop new sharp edges on the abrasive grains. The best tool to use when dressing vitrified wheels in cylindrical, external, and internal grinding applications is a single point.

### SINGLE POINT

To dress vitrified wheels both tapered and straight shank points are available. The choice of shank depends on the type of dresser holder.

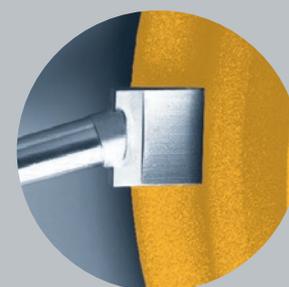
#### Choice of a single point

Which tool to choose depends mainly on the dimensions of the wheel to be dressed. In order to calculate this it is best to use the following method:

#### Wheel diameter (mm) x Wheel thickness (mm)

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS		
<p>The diagram shows a circular grinding wheel with a central hole. A vertical double-headed arrow on the left is labeled 'Diameter'. A horizontal double-headed arrow on the right is labeled 'Thickness'.</p>	Diameter x Thickness (mm)	Carat
	<3000	0.25 Carat
	3000-12000	0.50 Carat
>12000	1 Carat	

For best results, always use a coolant when dressing.



## Diamond Dressing Tools

### MULTI POINT

Type	Shank (mm)	Grit	Carat	Quantity	Article Number	Barcode
MP250	MK1	D426	2.5	1	69014171502*	8711479425769
	Z10 x 50	D426	2.5	1	69014170804*	8711479425783
	MK1	D1001	2.5	1	66260390005*	8711479425813
	Z10 x 50	D1001	2.5	1	66260393806*	8711479425851
	MK1	D2240	2.5	1	69014160913*	8711479425837
	Z10 x 50	D2240	2.5	1	69014173011*	8711479425806
	Z11 x 50	D1001	2.5	1	69014158054*	8711479425776

\* Made-to-order

### SINGLE POINT

Type	Shank (mm)	Carat	Quantity	Article Number	Barcode
SP	MK1	0.1	1	69014162116*	8711479425752
	Z10 x 50	0.1	1	66260396717*	8711479425738
	MK1	0.25	1	66260390118*	8711479425714
	Z10 x 50	0.25	1	69014166419*	8711479425691
	Z11 x 50	0.25	1	69014166052*	8711479425653
	MK1	0.5	1	66260399421*	8711479425639
	Z10 x 50	0.5	1	69014173220*	8711479425615
	MK1	1	1	69014164523*	8711479425608
	Z10 x 50	1	1	66260394422*	8711479425684
	Z11 x 50	1	1	69014157953*	8711479425585

\* Made-to-order

### HAND DRESSER

Type	Shank (mm)	Grit	Carat	Quantity	Article Number	Barcode
HD150	13 x 200	18/25 SPC	1.6	1	66260396924*	8711479425561

\* Made-to-order



# Carbide Burrs and Steel Brushes



Tungsten Carbide Burrs 290  
Steel Brushes 307

flexOvit

## Carbide Burrs and Steel Brushes



# Tungsten Carbide Burrs

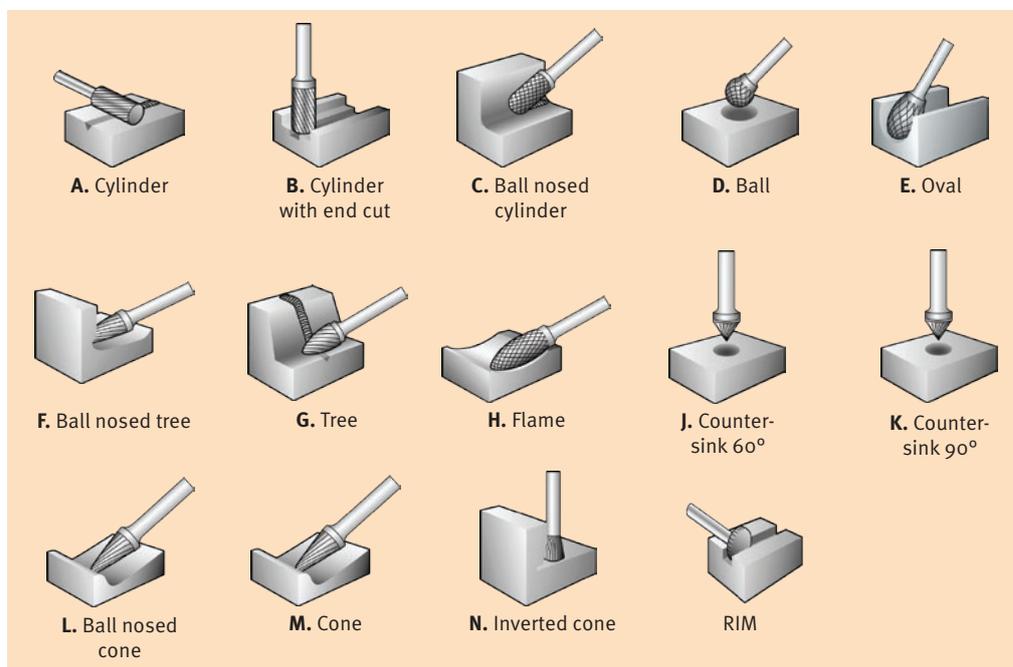
Flexovit tungsten carbide burrs are manufactured on state of the art CNC machines to give high consistency and quality. All Flexovit tungsten carbide burrs feature fast stock removal and long service life, providing optimum efficiency. With the right choice of fluting style and speed, the carbide burrs can be used to grind and finish the most diverse types of material, such as:

Aluminium	Brass	Titanium alloys
Cast Iron	Copper	Zinc alloys
Alloy steel	Bronze	Plastic
Nickel	Stainless steel	

Carbide burrs can be used with both electrically-powered and pneumatically-powered hand-held grinders. Each carbide burr is packed individually in a plastic case.

## Understanding the Product

### APPLICATION BY SHAPE



### CUT STYLES STANDARD AVAILABLE

DC	Double cut (worldwide most standard product)
DC/HD	Double cut/heavy duty. Negative rake, extra strong tooth formation for reduced chipping and longer tool life
ALU	Aluminium
FD	Fine diamond cut

### SHAPE

A	Cylinder	H	Flame
B	Cylinder with end cut	J	Countersink 60°
C	Ball nosed cylinder	K	Countersink 90°
D	Ball	L	Ball nosed cone
E	Oval	M	Cone
F	Ball nosed tree	N	Inverted Cone
G	Tree		RIM

# Carbide Burrs and Steel Brushes



## DIMENSIONS & DESCRIPTION OF THE BURR

16.0	x	25.0	x	60L65	Cut style and shape
Diameter of the head		Length of the head		Diameter of the shank and overall Length of the burr (OL)	Shape of the head
D1		L1		D2 + L2	

## RECOMMENDED OPERATING SPEEDS

Maximum Operating speed RPM		Burr head diameter/mm						
		3mm (1/8")	6mm (1/4")	10mm (3/8")	12mm (1/2")	16mm (5/8")	20mm (3/4")	25mm (1")
Aluminium, Plastics	Speed range	60-80	15-60	10-50	7-30	6-20	5-17	4-13
	Recommended "starting point"	65	40	25	20	15	10	8
Brass, Copper, Cast iron, Bronze	Speed range	45-80	22.5-60	15-40	11-30	9-20	8-17	6-13
	Recommended "starting point"	65	45	30	25	20	12	10
Unhardened Steels	Speed range	60-80	45-60	30-40	22.5-30	18-20	15-17	10-13
	Recommended "starting point"	80	50	30	25	20	15	10
Hardened Steels, S/Steels, Nimonic Alloys, Titanium	Speed range	60-80	30-45	19-30	15-22.5	12-18	10-15	7.5-11
	Recommended "starting point"	80	40	25	20	15	10	8

Recommended speeds are for standard shank length of 45mm (1 3/4") maximum overhang 10mm (3/8")  
Maximum recommended speed for extra long burrs is 15,000 RPM

# Carbide Burrs and Steel Brushes



## Selecting the Right Product

						
Availability	Standard	Standard	Standard	Standard	Make to order	Make to order
Cutstyle	DC Double cut	DC/HD Double cut heavy duty	ALU Aluminium cut	FD (fine diamond)	CD cut (coarse)	PC plain cut
Qualities	Universal cutting style Fast material removal Smooth finish Granular chip break	Better stock removal Stronger tooth formation (decreased tooth wedge angle) Longer tool life Reduced chipping	For deburring of aluminium alloys and plastic Wide tooth formation Easy chip flow	Granular chip break Fine finish applications Use on heat treated and tough alloy steel	General purpose deburring	General purpose application Produces scratch free surface
Steel	●	●		●	●	●
Hardened Steel	●			●		●
Stainless Steel	●	●		●	●	●
Cast Iron	●	●		●	●	●
Titanium	●	●	●	●		●
Nickel	●	●		●		●
Copper/Copper alloys	●	●		●	●	●
Aluminium			●			
Plastics			●			
Cement				●		●

It may be necessary to adjust the rates shown to achieve optimum performance	Running below the optimum speed will encourage chipping
Harder materials require slower speeds	Running above optimum speed will cause tooth wear
Smaller burrs require faster speeds	Allowing the tool to become too hot may cause the braze to melt and detach the head of the shank
Extra long burrs (>150mm long) require slower speeds. (Max. 15000 rpm)	Using tools and collets that have become worn will encourage chipping
Apply constant movement and light pressure when in use	Do not sink the burr for more than one third of its periphery

### USAGE KEY

● recommended

# Tungsten Carbide Burrs

## Cylinder – Shape A

### DOUBLE CUT

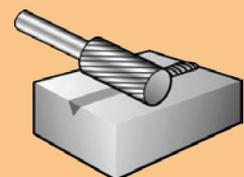
Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 19.0 x 6 x 50	A CYLINDER DC	1	07660704965	8711479177903
6.0 x 25.0 x 6 x 50	A CYLINDER DC	1	07660717907	8711479179013
8.0 x 19.0 x 6 x 65	A CYLINDER DC	1	07660707872	8711479178351
10.0 x 19.0 x 6 x 65	A CYLINDER DC	1	07660717863	8711479178009
10.0 x 25.0 x 6 x 70	A CYLINDER DC	1	07660717908	8711479179020
11.0 x 25.0 x 6 x 70	A CYLINDER DC	1	66261175652	8711479178702
12.0 x 19.0 x 6 x 65	A CYLINDER DC	1	07660719140	8711479180552
12.0 x 25.0 x 6 x 70	A CYLINDER DC	1	07660704969	8711479178115
12.7 x 25.0 x 8 x 70	A CYLINDER DC	1	66261175639	8711479178566
16.0 x 25.0 x 6 x 70	A CYLINDER DC	1	07660718981	8711479179037
16.0 x 25.0 x 8 x 70	A CYLINDER DC	1	66261175675	8711479179044

### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 19.0 x 6 x 169	A CYLINDER DC	1	07660717911	8711479179778
12.0 x 25.0 x 6 x 175	A CYLINDER DC	1	07660718089	8711479179785

### ALUMINIUM

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 19.0 x 6 x 65	A CYLINDER ALU	1	07660717905	8711479179983
12.0 x 25.0 x 6 x 70	A CYLINDER ALU	1	07660717887	8711479178603



## Carbide Burrs and Steel Brushes

Dimensions Key: D<sup>1</sup> = Head Diameter, L<sup>1</sup> = Head Length, D<sup>2</sup> = Shank Diameter, L<sup>2</sup> = Shank Length



# Tungsten Carbide Burrs

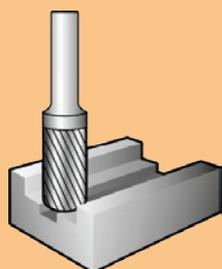
## End Cut Cylinder – Shape B

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 19.0 x 6 x 50	B CYLINDER DC	1	07660717900	8711479179075
6.0 x 25.0 x 6 x 50	B CYLINDER DC	1	07660718401	8711479179082
8.0 x 19.0 x 6 x 65	B CYLINDER DC	1	07660717901	8711479179099
10.0 x 19.0 x 6 x 65	B CYLINDER DC	1	07660717860	8711479177965
10.0 x 25.0 x 6 x 70	B CYLINDER DC	1	69014150736	8711479178276
11.0 x 25.0 x 6 x 70	B CYLINDER DC	1	66261175613	8711479178252
12.0 x 19.0 x 6 x 65	B CYLINDER DC	1	07660704974	8711479180576
12.0 x 25.0 x 6 x 70	B CYLINDER DC	1	07660717879	8711479178344
12.0 x 25.0 x 8 x 70	B CYLINDER DC	1	66261175677	8711479179105
16.0 x 25.0 x 6 x 70	B CYLINDER DC	1	66261175678	8711479179112
16.0 x 25.0 x 8 x 70	B CYLINDER DC	1	66261175679	8711479179129

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 13.0 x 3 x 38	B CYLINDER DC	1	07660717889	8711479178641





## Ball Nosed Cylinder – Shape C

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
5.0 x 16.0 x 6 x 50	C BALL DC	1	66261175601	8711479177927
6.0 x 19.0 x 6 x 50	C BALL DC	1	07660704963	8711479177880
6.0 x 25.0 x 6 x 50	C BALL DC	1	07660704972	8711479177934
8.0 x 19.0 x 6 x 65	C BALL DC	1	07660704966	8711479177941
10.0 x 19.0 x 6 x 65	C BALL DC	1	07660717859	8711479177958
10.0 x 25.0 x 6 x 70	C BALL DC	1	07660708053	8711479178283
11.0 x 25.0 x 6 x 70	C BALL DC	1	66261175603	8711479178016
12.0 x 19.0 x 6 x 65	C BALL DC	1	07660704975	87114791780583
12.0 x 25.0 x 6 x 70	C BALL DC	1	07660704970	8711479178122
12.0 x 25.0 x 8 x 70	C BALL DC	1	69014150731*	8711479178368
16.0 x 25.0 x 6 x 70	C BALL DC	1	07660707571	8711479178153
16.0 x 25.0 x 8 x 70	C BALL DC	1	66261175608	8711479178160

\* Made-to-order

### ALUMINIUM

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 19.0 x 6 x 50	C BALL ALU	1	07660719368	8711479178429
10.0 x 19.0 x 6 x 65	C BALL ALU	1	07660717885	8711479178542
12.0 x 25.0 x 6 x 70	C BALL ALU	1	7660717886	8711479178559

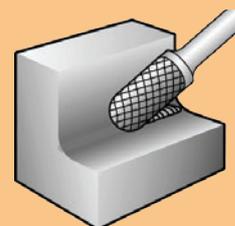
### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 12.0 x 6 x 169	C BALL DC	1	07660717912	8711479179792
10.0 x 19.0 x 6 x 169	C BALL DC	1	07660718982	8711479179808
12.0 x 25.0 x 6 x 169	C BALL DC	1	66261175651	8711479178696

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 13.0 x 3 x 38	C BALL DC	1	07660704960	8711479177804
3.0 x 13.0 x 3 x 50	C BALL DC	1	07660717873	8711479177910
3.0 x 13.0 x 3 x 75	C BALL DC	1	07660717874*	8711479178177

\* Made-to-order





## Tungsten Carbide Burrs

### Ball Nosed Cylinder – Shape D

#### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
5.0 x 4.7 x 6 x 50	D BALL DC	1	66261175655	8711479178757
6.0 x 5.4 x 6 x 50	D BALL DC	1	07660717884	8711479178528
8.0 x 7.2 x 6 x 52	D BALL DC	1	07660707884	8711479178405
10.0 x 9.0 x 6 x 53	D BALL DC	1	07660704971	8711479178207
11.0 x 9.9 x 6 x 54	D BALL DC	1	69014150743	8711479178658
12.0 x 10.8 x 6 x 55	D BALL DC	1	07660717865	8711479178061
12.0 x 10.8 x 8 x 55	D BALL DC	1	07660717909	8711479179167
16.0 x 14.4 x 6 x 60	D BALL DC	1	07660707878	8711479179174
16.0 x 14.4 x 8 x 60	D BALL DC	1	66261175646	8711479178610

#### ALUMINIUM

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 9.0 x 6 x 53	D BALL ALU	1	66261175771*	8711479180040
12.0 x 10.8 x 6 x 55	D BALL ALU	1	07660719170	8711479180057

\* Made-to-order

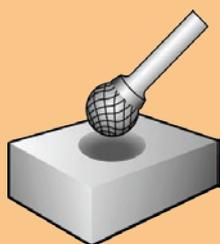
#### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 5.0 x 6 x 155	D BALL DC	1	66261175745	8711479179815
8.0 x 7.2 x 6 x 126	D BALL DC	1	66261175824*	8711479180903
10.0 x 9.0 x 6 x 159	D BALL DC	1	66261175746	8711479179822
12.0 x 10.8 x 6 x 161	D BALL DC	1	07660719180	8711479179839
16.0 x 14.4 x 6 x 164	D BALL DC	1	66261175814	8711479180453

\* Made-to-order

#### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 2.7 x 3 x 38	D BALL DC	1	07660717895	8711479178825





## Oval – Shape E

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 10.0 x 6 x 50	E OVAL DC	1	07660717902	8711479179204
10.0 x 16.0 x 6 x 60	E OVAL DC	1	07660717862	8711479177996
12.0 x 22.0 x 6 x 67	E OVAL DC	1	07660717867	8711479178092
12.0 x 22.0 x 8 x 67	E OVAL DC	1	66261175659*	8711479178795

\* Made-to-order

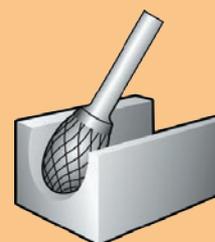
### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 16.0 x 6 x 169	E OVAL DC	1	07660718983	8711479179853
12.7 x 22.0 x 6 x 172	E OVAL DC	1	66261175749	8711479179860

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 6.0 x 3 x 38	E OVAL DC	5	07660717896*	8711479178832

\* Made-to-order





# Tungsten Carbide Burrs

## Ball Nosed Tree – Shape F

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 16.0 x 6 x 50	F BALL DC	1	07660717875	8711479178269
10.0 x 19.0 x 6 x 65	F BALL DC	1	07660717864	8711479178023
11.0 x 25.0 x 6 x 70	F BALL DC	1	07660719272	8711479179228
12.0 x 25.0 x 6 x 70	F BALL DC	1	07660704967	8711479178047
12.0 x 25.0 x 8 x 70	F BALL DC	1	07660707873	8711479178498
16.0 x 25.0 x 6 x 70	F BALL DC	1	07660717869	8711479178146

### ALUMINIUM

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 19.0 x 6 x 50	F BALL ALU	1	07660719144*	8711479178436
10.0 x 19.0 x 6 x 65	F BALL ALU	1	07660717883	8711479178450
12.0 x 25.0 x 6 x 70	F BALL ALU	1	07660717882	8711479178443
12.0 x 25.0 x 8 x 70	F BALL ALU	1	66261175776	8711479180132

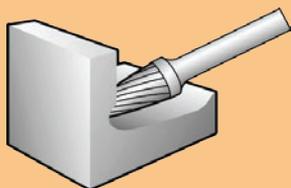
\* Made-to-order

### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 19.0 x 6 x 169	F BALL DC	1	69014157733	8711479179884
12.0 x 25.0 x 6 x 175	F BALL DC	1	07660718403	8711479179891

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 13.0 x 3 x 38	F BALL DC	1	07660717880	8711479178382





## Tree – Shape G

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 16.0 x 6 x 50	G TREE DC	1	07660717870	8711479178184
8.0 x 19.0 x 6 x 65	G TREE DC	1	07660719135	8711479178337
10.0 x 19.0 x 6 x 65	G TREE DC	1	07660717881	8711479178412
12.0 x 19.0 x 6 x 65	G TREE DC	1	66261175692	8711479179273
12.0 x 25.0 x 6 x 70	G TREE DC	1	07660717866	8711479178085
12.0 x 25.0 x 8 x 70	G TREE DC	1	07660718989	8711479178030
16.0 x 25.0 x 6 x 70	G TREE DC	1	07660717891	8711479178672
16.0 x 25.0 x 8 x 70	G TREE DC	1	66261175693	8711479179280

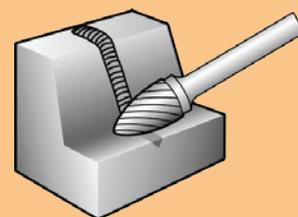
### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 19.0 x 6 x 169	G TREE DC	1	66261175755*	8711479179907
12.0 x 25.0 x 6 x 175	G TREE DC	1	66261175756*	8711479179914

\* Made-to-order

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 10.0 x 3 x 38	G TREE DC	1	07660717893	8711479178788
3.0 x 13.0 x 3 x 38	G TREE DC	1	07660717897	8711479178856





# Tungsten Carbide Burrs

## Flame – Shape H

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
8.0 x 19.0 x 6 x 65	H FLAME DC	1	07660717878	8711479178320
12.0 x 32.0 x 6 x 77	H FLAME DC	1	07660707570	8711479178139
12.0 x 32.0 x 8 x 77	H FLAME DC	1	66261175696	8711479179303
16.0 x 36.0 x 6 x 80	H FLAME DC	1	66261175697	8711479179310
16.0 x 36.0 x 8 x 80	H FLAME DC	1	66261175698*	8711479179327

\* Made-to-order

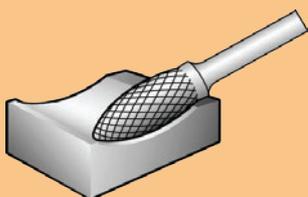
### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
8.0 x 19.0 x 6 x 169	H FLAME DC	1	66261175757	8711479179921
12.0 x 32.0 x 6 x 172	H FLAME DC	1	66261175758	8711479179938

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 8.0 x 3 x 38	H FLAME DC	1	07660719134*	8711479178863

\* Made-to-order



## Countersink 60° – Shape J

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 8.0 x 6 x 55	J COUNTERSINK 60° DC	1	66261175602*	8711479177972
12.0 x 11.0 x 6 x 60	J COUNTERSINK 60° DC	1	66261175634	8711479178504
16.0 x 14.5 x 6 x 60	J COUNTERSINK 60° DC	1	66261175700	8711479179358

\* Made-to-order

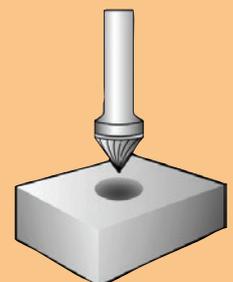
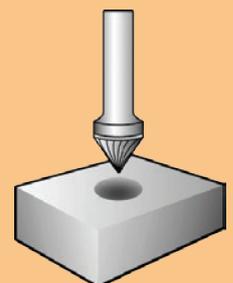


## Countersink 90° – Shape K

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 5.0 x 6 x 55	K COUNTERSINK 90° DC	1	66261175635	8711479178511
12.0 x 6.0 x 6 x 54	K COUNTERSINK 90° DC	1	66261175606*	8711479178078
16.0 x 8.0 x 6 x 60	K COUNTERSINK 90° DC	1	66261175704	8711479179396

\* Made-to-order





# Tungsten Carbide Burrs

## Ball Nosed Cone – Shape L

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 19.0 x 6 x 50	L BALL DC	1	07660704964	8711479177897
8.0 x 22.0 x 6 x 69	L BALL DC	1	07660717903	8711479179426
10.0 x 27.0 x 6 x 75	L BALL DC	1	07660717871	8711479178214
12.0 x 30.0 x 6 x 75	L BALL DC	1	07660717872	8711479178221
16.0 x 33.0 x 6 x 78	L BALL DC	1	07660719138	8711479179433
16.0 x 33.0 x 8 x 78	L BALL DC	1	66261175708	8711479179440

### ALUMINIUM

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 27.0 x 6 x 75	L BALL ALU	1	07660718404	8711479180163
12.0 x 30.0 x 6 x 75	L BALL ALU	1	07660717876	8711479178306

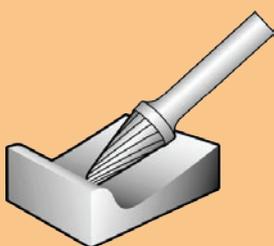
### EXTRA LONG

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
10.0 x 27.0 x 6 x 177	L BALL DC	1	66261175760*	8711479179952
12.0 x 30.0 x 6 x 180	L BALL DC	1	66261175761*	8711479179969

\* Made-to-order

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 13.0 x 3 x 38	L BALL DC	1	07660717898	8711479178887





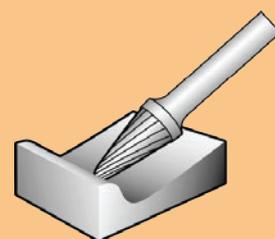
## Cone – Shape M

### DOUBLE CUT

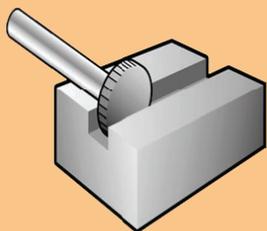
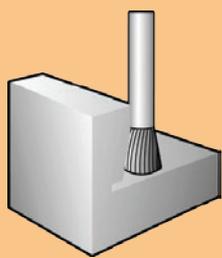
Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 13.0 x 6 x 50	M CONE DC	1	07660717877	8711479178313
6.0 x 19.0 x 6 x 50	M CONE DC	1	07660704962	8711479177859
6.0 x 25.0 x 6 x 50	M CONE DC	1	07660717858	8711479177866
10.0 x 16.0 x 6 x 65	M CONE DC	1	07660717861	8711479177989
12.0 x 19.0 x 6 x 65	M CONE DC	1	66261175820	8711479180668
12.0 x 22.0 x 6 x 70	M CONE DC	1	07660717868	8711479178108
12.0 x 22.0 x 8 x 70	M CONE DC	1	66261175709	8711479326059
12.0 x 25.0 x 6 x 70	M CONE DC	1	07660719273	8711479180651
16.0 x 22.0 x 6 x 73	M CONE DC	1	07660719137	8711479178573

### MINIATURE – DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
3.0 x 11.0 x 3 x 38	M CONE DC	1	07660717857	8711479177828
3.0 x 16.0 x 3 x 38	M CONE DC	1	07660717856	8711479177811



## Carbide Burrs and Steel Brushes



# Tungsten Carbide Burrs

## Inverted Cone – Shape N

### DOUBLE CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
6.0 x 7.0 x 6 x 50	N INVERTED DC	1	66261175654*	8711479178740
9.5 x 9.5 x 6 x 53	N INVERTED DC	1	66261175711*	8711479179464

\* Made-to-order

## RIM

### PLAIN CUT

Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Specification	Quantity	Article Number	Barcode
12.0 x 2.6 x 6 x 48	RIM PC	1	66261175816	8711479180613
25.0 x 5.2 x 8 x 50	RIM PC	1	66261175817	8711479180620



## Burr Sets

SET TYPE	Specification	Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Type	Shape	Quantity	Article Number	Barcode
BURR SET	DOUBLE CUT TUNGSTEN	10 x 19 x 6 x 65	DC	A	1	66261175595	8711479329418
		12 x 25 x 6 x 70	DC	A			
		10 x 19 x 6 x 65	DC	C			
		12 x 25 x 6 x 70	DC	C			
		12 x 30 x 6 x 75	DC	L			
		10 x 16 x 6 x 60	DC	E			
		10 x 19 x 6 x 65	DC	G			
		12 x 25 x 6 x 70	DC	G			
		12 x 10.8 x 6 x 55	DC	D			
12 x 25 x 6 x 70	DC	F					
MINIATURE BURR SET	DOUBLE CUT MINI	3 x 13 x 3 x 38	DC	A	1	07660719280	8711479333682
		3 x 13 x 3 x 38	DC	B			
		3 x 11 x 3 x 38	DC	M			
		3 x 13 x 3 x 38	DC	C			
		3 x 8 x 3 x 38	DC	L			
		3 x 8 x 3 x 38	DC	H			
		3 x 6 x 3 x 38	DC	E			
		3 x 13 x 3 x 38	DC	G			
		3 x 2.7 x 3 x 38	DC	D			
3 x 13 x 3 x 38	DC	F					
BURR SET	32 BURRS	6 x 16 x 6 x 50	DC	F	1	07660705108	8711479356148
		10 x 19 x 6 x 65	DC	F			
		12 x 25 x 6 x 70	DC	F			
		10 x 19 x 6 x 65	DC	L			
		12 x 30 x 6 x 75	DC	L			
		6 x 19 x 6 x 50	DC	C			
		8 x 19 x 6 x 65	DC	C			
		10 x 19 x 6 x 65	DC	C			
		12 x 25 x 6 x 70	DC	C			
		10 x 19 x 6 x 65	DC	G			
		12 x 25 x 6 x 70	DC	G			
		6 x 19 x 6 x 50	DC	M			
		12 x 22 x 6 x 70	DC	M			
		6 x 19 x 6 x 50	DC	A			
		8 x 19 x 6 x 65	DC	A			
		10 x 19 x 6 x 65	DC	A			
		10 x 19 x 6 x 65	DC	B			
		12 x 25 x 6 x 70	DC	A			
		12 x 25 x 6 x 70	DC	B			
		10 x 9 x 6 x 53	DC	D			
		12 x 10.8 x 6 x 55	DC	D			
		12 x 32 x 6 x 77	DC	H			
		12 x 22 x 6 x 67	DC	E			
		12 x 25 x 6 x 70	ALU	F			
		10 x 19 x 6 x 65	ALU	F			
		12 x 25 x 6 x 70	ALU	C			
		12 x 25 x 6 x 70	DC/HD	F			
		12 x 25 x 6 x 70	DC/HD	C			
		10 x 19 x 6 x 65	DC/HD	A			
		12 x 25 x 6 x 70	DC/HD	A			
		12 x 30 x 6 x 75	DC/HD	L			
		12 x 25 x 6 x 70	DC/HD	G			

Dimensions Key: D<sup>1</sup> = Head Diameter, L<sup>1</sup> = Head Length, D<sup>2</sup> = Shank Diameter, L<sup>2</sup> = Shank Length



# Tungsten Carbide Burrs

## Intro starter 4 piece Kits

SET TYPE	Specification	Dimensions (mm) D <sup>1</sup> x L <sup>1</sup> x D <sup>2</sup> x L <sup>2</sup>	Shape	Quantity	Article Number	Barcode
SOFT STEELS	DC/HD	12 x 25 x 6 x 70	C	1	66254414511	3157629226629
		10 x 9 x 6 x 53	D	1		
		12 x 25 x 6 x 70	F	1		
		12 x 30 x 6 x 75	L	1		
STAINLESS & HARD STEELS	FD	12 x 25 x 6 x 70	C	1	66254414515	3157629226087
		10 x 9 x 6 x 53	D	1		
		12 x 25 x 6 x 70	F	1		
		12 x 30 x 6 x 75	L	1		
ALUMINIUM & PLASTIC	ALU	12 x 25 x 6 x 70	C	1	66254414476	3157629226346
		10 x 9 x 6 x 53	D	1		
		12 x 25 x 6 x 70	F	1		
		12 x 30 x 6 x 75	L	1		
BRASS, BRONZE, COPPER	DC	12 x 25 x 6 x 70	C	1	66254414489	3157629234471
		10 x 9 x 6 x 53	D	1		
		12 x 25 x 6 x 70	F	1		
		12 x 30 x 6 x 75	L	1		

# Steel Brushes



# Carbide Burrs and Steel Brushes



## Wire Quality

### NOSCW

NOrmal Steel Crimped Wire

### NOSKW

NOrmal Steel Knotted Wire

### NOSSW

NOrmal Steel Straight Wire

### STSCW

STainless Steel Crimped Wire

### STSKW

STainless Steel Knotted Wire

### STSSW

STainless Steel Straight Wire

### BRACW

BRAss Crimped Wire

# Technical Information

Flexovit is able to offer a broad range of industrial wire brushes which are used in industry of surface processing. The range encompasses crimped and knotted wire power wheel brushes, bevelled brushes, cup brushes, End brushes, Hand brushes.

Our high quality products only contain wire qualities which have been selected.

## WIRE QUALITY

Tempered Quality steel wire		Stainless Steel Wire		Brass Wire		
Crimped	Straight	Crimped	Straight	Crimped		
						
Removing dust and smoothing low-grade and non alloys steels		Brushing and smoothing chome-nickel steels, including stainless steel		For brushing, cleaning and smoothing brass, copper and bronz		
NOSCW	NOSKW	NOSSW	STSCW	STSKW	STSSW	BRACW

## SHAPE

Code	Description	Tool	Application
WHB	Wheel Brushes Crimped		Supplied as standard with arbour hole as indicated. The arbour holes can be reduced with reducing rings. Wheel brushes with short wire are more aggressive. Larger width requires more horse power.
	Wheel Brushes Twist Knotted		The brush is ideally suited for brushing out welded joints and to brush sharp corners.
BEB	Bevel brushes		Specially for brushing hard-to-reach places such as edges and corners.
CPB	Cup brushes Crimped		Brush ideal for cleaning jobs and to produce large clean surfaces. Removal of rust, corrosion, paint and primers.
	Cup brushes Knotted		An aggressive brush which is excellent for heavy-duty cleaning and finishing of large surfaces. Extremely suitable for removing barnacles, scale, paint, rust and corrosion. Cleaning of weld seams and spot-welds.
WHB/ENB	Shaft mounted brushes		Suitable for industrial use. Especially for hard-to-reach areas. All shaft mounted brushes are equipped with a 6mm shank.
HCB/SPB	Hand brushes		With wooden core and available in different working widths. For use on narrow section work pieces, light deburring, cleaning and profiled surfaces.
TUB	Pipe brushes		With handle or thread. For deburring and cleaning tubes. Pipe brushes with different thread.



## Brushing speed

Peripheral speed is a decisive factor in achieving optimum performance from a brush, the table opposite will enable you to determine the relevant peripheral speed by simply reading down and across the appropriate diameter and drive shaft operating speed columns.

Brush-diameter (mm)	Peripheral speeds (m/s)												
	20	40	50	80	100	125	150	180	200	250	300	350	
min <sup>-1</sup>													
800				3.35	4.19	5.23	6.28	7.53	8.37	10.47	12.56	14.75	
900			2.35	3.77	4.71	5.88	7.06	8.48	9.41	11.77	14.12	16.47	
1150			3.01	4.81	6.01	7.52	9.02	10.83	12.03	15.04	18.04	21.04	
1200	1.26	2.51	3.14	5.02	6.28	7.85	9.41	11.3	12.55	15.69	18.83	21.97	
1400	1.46	2.93	3.66	5.86	7.32	9.15	10.98	13.18	14.64	18.31	21.97	25.63	
1500	1.57	3.14	3.92	6.28	7.85	9.81	11.77	14.13	15.69	19.61	23.54	27.46	
1800	1.88	3.77	4.71	7.54	9.41	11.77	14.12	16.95	18.83	23.54	28.24	32.95	
2000	2.09	4.19	5.23	8.37	10.26	13.08	15.69	18.84	20.92	26.15	31.38	36.61	
2500	2.62	5.23	6.54	10.47	13.08	16.35	19.61	23.55	26.15	32.67	39.23	45.76	
2800	2.93	5.86	7.32	11.72	14.64	18.31	21.97	26.37	29.29	36.61	43.93	51.25	
3000	3.14	6.28	7.85	12.56	15.69	19.62	23.54	28.26	31.38	39.23	47.07	54.92	
3200	3.35	6.7	8.37	13.4	16.74	20.92	25.1	30.14	33.47	41.84	50.21	58.58	
3500	3.66	7.33	9.15	14.65	18.31	22.89	27.46	32.97	36.61	45.76	54.92	64.07	
4000	4.19	8.37	10.46	16.75	20.92	26.16	31.38	37.68	41.84	52.33	62.76	73.22	
4500	4.7	9.42	11.77	18.84	23.54	29.43	35.3	42.4	47.07	58.84	70.61	82.43	
5000	5.23	10.47	13.08	20.93	26.15	32.7	39.23	47.1	52.33	65.38	78.5		
5400	5.65	11.3	14.12	22.94	28.24	35.31	42.36	50.67	56.48	70.61	84.78		
6000	6.28	12.56	15.69	25.12	31.38	39.24	47.07	56.52	62.76	78.5			
7000	7.33	14.66	18.31	29.31	36.61	45.78	54.92	65.94	73.22	91.58			
8000	8.37	16.75	20.92	33.94	41.48	52.32	62.76	75.36	83.73				
9000	9.42	18.84	23.54	37.68	47.07	58.86	70.61	84.78	94.2				
10000	10.47	20.93	26.17	41.86	52.33	65.4	78.5	94.2					
12500	13.08	26.17	32.71	52.33	65.42	81.75	98.13						
15000	15.7	31.4	39.25	62.8									
17500	18.32	36.63	45.79	73.26									
20000	20.93	41.87	52.33	83.73									
22500	23.55	47.1	58.88	94.2									
25000	26.17	52.33	65.42	104.66									



## Technical Information



### MAXIMUM PERIPHERAL SPEED WHEEL BRUSHES

Diameter (mm)	Max RPM
80	10000
100	8000
125	6000
150	6000
180	6000
200	4500
250	3600
250 - 1 row	3500
300	3000



### BORSTEL TYPE

Diameter	RPM	BORSTEL TYPE		
		CUP BRUSHES	BEVEL BRUSHES	TWIST KNOT WHEEL BRUSHES
100	11.000	60/65/75	100	100
115	11.000	60/65/75	100/115	115
125	10.000	60/65/75	115	125
150	9.300	75	-	-
180	8.500	80/100	-	150/180
230	6.500	125/150	-	200



### MAXIMUM PERIPHERAL SPEED SHAFT MOUNTED WIRE BRUSHES

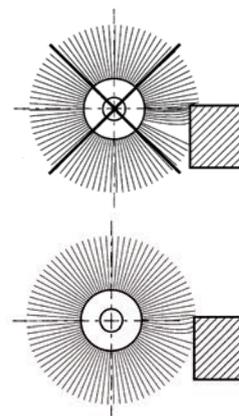
Diameter (mm)	Max RPM
20	20000
30	20000
40	18000
50	15000
60	15000
70	15000
80	12000

The maximum RPM ratings are safety ratings not recommended operating speeds. The optimum operating speed is determined by the application and in most cases lower operating speeds will prove more efficient and achieve the best result. As a general guide we recommend the following peripheral speeds when working on the materials listed with:

	Crimped wire	Twist Knotted
STEEL	30m/s	35-40m/s
NON FERROUS	18-20m/s	
PLASTIC	15m/s	

### BRUSHING PRESSURE

- The tips of a wire brush do the work. Operate the brush with the lightest pressure so only the tips of the wire come in contact with the work.
- If heavy pressure is used, wires will be over stressed, resulting in a wiping action, and if this is continued, the life of the brush will be shortened due to wire fatigue.
- Apply the work to the face of the brush ensuring as much of the brush face as possible is in full contact. Applying the work to the side or edge of the brushing tool will result in wire breakage and shortened brush life.
- Reversing the wheel brush rotation periodically will tend to increase the life of the brush. This results in the sharpening of the wire tips or ends, ensuring faster cutting action.





## SIZE OF WIRE

- Use the finest size of wire suitable for the application
- Finer wire size will perform better and last longer than heavier

## TROUBLE SHOOTING GUIDE

Several factors can influence a brush application. If the selected brush does not achieve the expected result, the following table may provide solutions for the most common problems faced by a user. For further information, please contact our technical department.

PROBLEM	RECOMMENDED ACTIONS
Brush is too aggressive	<ul style="list-style-type: none"> <li>• Increase trim length</li> <li>• Reduce wire diameter</li> <li>• Work at lower speed</li> </ul>
Brush is not aggressive enough	<ul style="list-style-type: none"> <li>• Reduce trim length</li> <li>• Increase wire diameter</li> <li>• Work at higher speed</li> </ul>
Action of brush does not totally remove scale	<ul style="list-style-type: none"> <li>• Reduce trim length</li> <li>• Increase wire diameter</li> </ul>
Finish to coarse	<ul style="list-style-type: none"> <li>• Increase trim length</li> <li>• Reduce wire diameter</li> <li>• Work at higher speed</li> <li>• Choose a nylon abrasive brush</li> </ul>
Finish to smooth	<ul style="list-style-type: none"> <li>• Reduce trim length</li> <li>• Increase wire diameter</li> </ul>
Action of brush is not uniform	<ul style="list-style-type: none"> <li>• Reduce brushing pressure</li> <li>• Automate operations to avoid human inaccuracy</li> </ul>
Wire breaks more than usual	<ul style="list-style-type: none"> <li>• Reduce brushing pressure</li> <li>• Reduce wire diameter</li> <li>• Work at lower speed</li> </ul>
Life of the brush is too short	<ul style="list-style-type: none"> <li>• Reduce wire diameter</li> <li>• Increase brush diameter</li> <li>• Reduce brushing pressure</li> </ul>

## SAFETY & STORAGE

Safety goggles or full face shields with side shields must be worn by all operators and others in the immediate area of power brush operations.

Guards	Keep all machine guards in place
Speeds	Observe all speed restrictions indicated on brushes
Protective equipment	Appropriate protective clothing and equipment must be used.

Brushes should be carefully checked when removed from the original carton. Do not use if rusted or damaged.

Store brushes in the original carton. Wire brushes should not be exposed to heat, high humidity, acids, fumes or liquids that can result in deterioration of the wire filaments, and subsequently, premature failure of the wires. Also, check for distortion of brush fill that can cause imbalance and excessive vibration when the brush is running.

Check maximum spindle speed. Do not mount and operate the brush if spindle RPM exceeds the maximum safe free speed for which the brush is rated. Spindle length should be sufficient to permit a full nut mounting.

Before starting the machine, rotate the wire brush with a gloved hand to determine that the brush has been correctly mounted and turns freely.



## Steel brushes

### Flanges, adaptors & wheel brushes

#### SETS METAL REDUCING FLANGES FOR CIRCULAR BRUSHES

Size (mm) R <sup>3</sup> x A <sup>2</sup>	Specification	Pack.	Article Number	Barcode
20 x 13	Set of 2 metal reducing flange	1	63642589194*	3157629185964
20 x 16	Set of 2 metal reducing flange	1	07660739594*	3157629176054
30 x 13	Set of 2 metal reducing flange	1	07660739595*	3157629176061
30 x 16	Set of 2 metal reducing flange	1	07660739596*	3157629176078
30 x 20	Set of 2 metal reducing flange	1	07660739597	3157629176085
30 x 25.4	Set of 2 metal reducing flange	1	07660739598*	3157629176092
50.8 x 30	Set of 2 metal reducing flange	1	66261163886	3157629176139
50.8 x 32	Set of 2 metal reducing flange	1	07660739604*	3157629176108
80 x 30	Set of 2 metal reducing flange	1	63642589198*	3157629185971
80 x 32	Set of 2 metal reducing flange	1	07660739608*	3157629176115
80 x 50.8	Set of 2 metal reducing flange	1	07660739609*	3157629176122
100 x 30	Set of 2 metal reducing flange	1	63642589199*	3157629185988
100 x 32	Set of 2 metal reducing flange	1	63642589200*	3157629185995
100 x 50.8	Set of 2 metal reducing flange	1	63642589201*	3157629186008
120 x 30	Set of 2 metal reducing flange	1	63642589202*	3157629186015
120 x 32	Set of 2 metal reducing flange	1	63642589203*	3157629186237
120 x 50.8	Set of 2 metal reducing flange	1	63642589204*	3157629186244

\* Made-to-order

## Bench Grinders and Deburring Machines

### Wheel Brush (WHB)

#### NORMAL STEEL CRIMPED (NOSCW) - 1 ROW

Shape	D	B	A	R	Wire Ø	ROW	L	Wire	Pack.	Article Number	Barcode
WHB	100	11	12	20	0.30	1R	T22	NOSCW	1	07660739390	3157629174555
WHB	125	11	12	20	0.30	1R	T34	NOSCW	1	07660739391	3157629174562
WHB	150	13	12	32	0.30	1R	T34	NOSCW	1	07660739374	3157629174463
WHB	180	13	12	50.8	0.30	1R	T33	NOSCW	1	07660739387	3157629174531
WHB	200	13	12	50.8	0.30	1R	T43	NOSCW	1	07660739388	3157629174548

#### NORMAL STEEL CRIMPED (NOSCW) - 2/3 ROWS

Shape	D	B	A	R	Wire Ø	ROW	L	Wire	Pack.	Article Number	Barcode
WHB	100	20	20	30	0.20	2R	T24	NOSCW	1	07660739365	3157629174395
WHB	125	24	20	30	0.20	2R	T36	NOSCW	1	07660739366	3157629174401
WHB	150	29	32	51	0.20	3R	T27	NOSCW	1	07660739367	3157629174418
WHB	180	22	32	51	0.20	2R	T42	NOSCW	1	07660739368	3157629174425
WHB	200	26	32	80	0.20	2R	T40	NOSCW	1	07660739369	3157629174432
WHB	80	15	20	20	0.30	2R	T20	NOSCW	1	07660739370	3157629174449
WHB	100	20	20	30	0.30	2R	T24	NOSCW	1	07660739397	3157629174579
WHB	100	28	20	30	0.30	3R	T24	NOSCW	1	07660739371	3157629174456
WHB	125	24	20	30	0.30	2R	T36	NOSCW	1	07660739398	3157629174586
WHB	150	18	32	51	0.30	2R	T27	NOSCW	1	07660739399	3157629174593
WHB	150	29	32	51	0.30	2R	T27	NOSCW	1	07660739376	3157629174487
WHB	180	22	32	51	0.30	2R	T42	NOSCW	1	66261175466	3157629176238
WHB	180	28	32	51	0.30	2R	T42	NOSCW	1	07660739377	3157629174494
WHB	200	26	32	80	0.30	2R	T40	NOSCW	1	07660739400	3157629174609
WHB	200	36	32	80	0.30	3R	T40	NOSCW	1	07660739401	3157629174616
WHB	250	32	50.8	100	0.30	2R	T50	NOSCW	1	07660739402	3157629174623
WHB	300	32	50.8	100	0.30	2R	T60	NOSCW	1	07660739382	3157629174524
WHB	150	29	32	51	0.50	3R	T27	NOSCW	1	07660739404	3157629174647
WHB	180	28	32	51	0.50	3R	T42	NOSCW	1	07660739405	3157629174654
WHB	200	26	32	80	0.50	2R	T40	NOSCW	1	07660739406	3157629174661
WHB	250	38	50.8	100	0.50	3R	T50	NOSCW	1	07660739407	3157629174678

**Dimensions Key:** D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire length

## Carbide Burrs and Steel Brushes



#### Wheel brushes

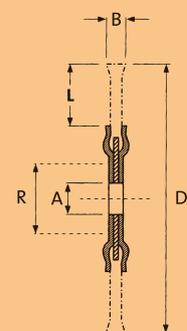
Supplied as standard with arbor hole as indicated. The arbor holes can be reduced further using flanges and/or Reducing rings.



- Steel wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless Steel wire for brushing clean and grinding chrome-nickel steels, including stainless steels.
- Brass Wire for brushing clean and smoothing brass, copper and bronze.

Short Steel Wire makes the brushes more aggressive than the one with Long wire.

Our multiple row wheel brushes are supplied with one set of metal flanges + a complete set of plastic reducing rings.



# Carbide Burrs and Steel Brushes



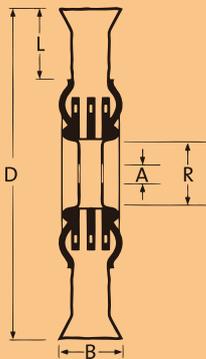
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# Steel brushes

## Bench Grinders and Deburring Machines

### Wheel Brush (continued)

#### STAINLESS STEEL CRIMPED (STSCW)

Shape	D	B	A	R	Wire Ø	ROW	L	Wire	Pack.	Article Number	Barcode
WHB	150	18	32	50.8	0.20	2R	T27	STSCW	1	66261175401*	3157629176177
WHB	125	24	20	30	0.30	2R	T36	STSCW	1	07660739410	3157629174692
WHB	150	18	32	51	0.30	2R	T27	STSCW	1	07660739411	3157629174708
WHB	150	29	32	51	0.30	2R	T27	STSCW	1	07660739412	3157629174715
WHB	180	22	32	51	0.30	2R	T42	STSCW	1	07660739413	3157629174722
WHB	180	28	32	51	0.30	3R	T42	STSCW	1	07660739409	3157629174685
WHB	200	26	32	80	0.30	2R	T40	STSCW	1	07660739414	3157629174739

\* Made-to-order

#### BRASS CRIMPED (BRACW)

Shape	D	B	A	R	Wire Ø	ROW	L	Wire	Pack.	Article Number	Barcode
WHB	150	29	32	51	0.20	3R	T27	BRACW	1	66261071670*	8711479444135

\* Made-to-order

## Angle Grinders

### Wheel Brush (WHB)

#### NORMAL STEEL TWIST KNOTED (NOSKW)

Shape	D	B	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	100	11	22.2	0.35	T22	NOSKW	1	07660739554*	3157629175828
WHB	115	11	22.2	0.35	T23	NOSKW	1	07660739555	3157629175835
WHB	125	13	22.2	0.35	T28	NOSKW	1	07660739556	3157629175842
WHB	178	15	22.2	0.35	T35	NOSKW	1	07660739558	3157629175866
WHB	115	11	M14	0.35	T23	NOSKW	1	07660739559	3157629175873
WHB	125	13	M14	0.35	T28	NOSKW	1	07660739557	3157629175859
WHB	100	11	22.2	0.50	T22	NOSKW	1	07660739562	3157629175927
WHB	115	11	22.2	0.50	T23	NOSKW	1	07660739566	3157629175958
WHB	125	13	22.2	0.50	T28	NOSKW	1	07660739567	3157629175965
WHB	150	12	22.2	0.50	T34	NOSKW	1	07660739569	3157629175989
WHB	178	15	22.2	0.50	T35	NOSKW	1	07660739570	3157629175996
WHB	115	11	M14	0.50	T23	NOSKW	1	07660739565	3157629175941
WHB	125	13	M14	0.50	T28	NOSKW	1	07660739568	3157629175972
WHB	178	15	M14	0.50	T44	NOSKW	1	07660739574	3157629176016

\* Made-to-order

#### STAINLESS STEEL TWIST KNOTED (STSKW)

Shape	D	B	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	115	11	22.2	0.50	T23	STSKW	1	07660739580	3157629176023
WHB	125	13	22.2	0.50	T23	STSKW	1	66261071591	8711479444036
WHB	178	15	22.2	0.50	T35	STSKW	1	07660739583	3157629176047

## Carbide Burrs and Steel Brushes



#### Wheel brushes Flat

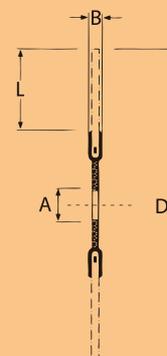
This brush is ideally suited for brushing out welded joints and sharp corners. To be used on angle grinder.

Wheels exist in various:

- Diameter
- Bore (22.2 M14, M10, 5/8")
- Wire type and thickness

- Steel wire for removing rust and smoothing low-grade and non-alloy steels

- Stainless Steel wire for brushing clean and grinding chrome-nickel steels, including stainless steels.



**Dimensions Key:** D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire length

# Carbide Burrs and Steel Brushes

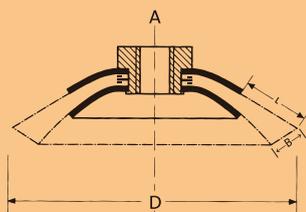


## Bevel Brushes

For getting into places which are difficult to reach.

Brushes exist in various:

- Diameter
- Wire type and thickness
- Steel wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and smoothing chrome-nickel steels, including stainless steel.



The twist knot bevel brushes have a left- hand knot direction.

# Steel brushes

## Angle Grinders

### Bevel brushes (BEB)

#### NORMAL STEEL TWIST KNOTED (NOSKW)

Shape	D	B	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
BEB	100	13	M14	0.50	T20	NOSKW	1	07660739564	3157629175934
BEB	115	15	M14	0.50	T27,5	NOSKW	1	07660739572	3157629176009

#### STAINLESS STEEL TWIST KNOTED (STSKW)

Shape	D	B	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
BEB	100	10	M14	0.50	T20	STSKW	1	07660739560	3157629175897
BEB	115	15	M14	0.50	T27,5	STSKW	1	07660739561	3157629175903

#### NORMAL STEEL CRIMPED (NOSCW)

Shape	D	B	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
BEB	100	13	M14	0.30	T20	NOSCW	1	07660739361	3157629174371
BEB	115	15	M14	0.30	T20	NOSCW	1	07660739362	3157629174388

## Angle Grinders

## Cup Brushes (CPB)

### NORMAL STEEL TWIST KNOTED (NOSKW)

Shape	D	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
CPB	65	M10	0.35	T20	NOSKW	1	07660707289	3157629173565
CPB	65	M14	0.35	T20	NOSKW	1	07660739507	3157629175491
CPB	80	M14	0.35	T25	NOSKW	1	07660739508	3157629175507
CPB	100	M14	0.35	T25	NOSKW	1	07660739510	3157629175514
CPB	120	M14	0.35	T25	NOSKW	1	07660739512	3157629175521
CPB	65	M14	0.50	T20	NOSKW	1	07660739517	3157629175545
CPB	80	M14	0.50	T25	NOSKW	1	07660739518	3157629175552
CPB	80	5/8"	0.50	T25	NOSKW	1	07660739519	3157629175569
CPB	100	M14	0.50	T25	NOSKW	1	07660739520	3157629175576
CPB	100	5/8"	0.50	T25	NOSKW	1	07660739521	3157629175583
CPB	120	M14	0.50	T25	NOSKW	1	07660739522	3157629175606
CPB	80	M14	0.80	T25	NOSKW	1	07660739524	3157629175637
CPB	80	5/8"	0.80	T25	NOSKW	1	07660739525*	3157629175644
CPB	100	M14	0.80	T25	NOSKW	1	07660739526	3157629175651
CPB	120	M14	0.80	T25	NOSKW	1	07660739528	3157629175668

\* Made-to-order

### STAINLESS STEEL TWIST KNOTED (STSKW)

Shape	D	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
CPB	65	M14	0.50	T20	STSKW	1	07660739530	3157629175675
CPB	80	M14	0.50	T25	STSKW	1	07660739531	3157629175682
CPB	100	M14	0.50	T25	STSKW	1	07660739532	3157629175699

Dimensions Key: D = Diameter, B = Width, L = Wire length

## Carbide Burrs and Steel Brushes

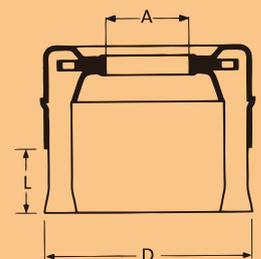


### Cup Brushes Straight

An aggressive brush which is excellent for heavy-duty cleaning and finishing of large surfaces. Extremely suitable for removing barnacles, paint, rust and oxidation. From 80mm diameter equipped with a protective ring to prevent the bristles splaying outwards under heavy pressure. Once the bristles have worn down to the protective ring, it can be removed.

Brushes exist in various:

- Diameter
- Bore (22.2 M14, M10, 5/8")
- Wire type and thickness



All the twist knot cup brushes have a right hand knot direction.

## Carbide Burrs and Steel Brushes



### Cup brushes Crimped

This brush is ideal for cleaning jobs and finishing large surfaces. Easy to use due to its flexible bristles.

- Steel wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and smoothing chrome-nickel steels, including stainless steel.

Brushes exist in various:

- Diameter
- Bore (22.2 M14, M10, 5/8")
- Wire type and thickness

## Steel brushes

### Angle Grinders

### Cup Brushes (continued)

#### NORMAL STEEL CRIMPED (NOSCW)

Shape	D	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
CPB	60	M14	0.20	T16	NOSCW	1	07660739534	3157629175705
CPB	75	M14	0.20	T20	NOSCW	1	07660739535	3157629175712
CPB	60	M14	0.30	T16	NOSCW	1	07660739541	3157629175743
CPB	75	M14	0.30	T20	NOSCW	1	66261175457	3157629176214
CPB	80	M14	0.30	T25	NOSCW	1	66261175417	3157629176184
CPB	100	M14	0.30	T30	NOSCW	1	07660739544	3157629175767
CPB	125	22.2	0.30	T35	NOSCW	1	66261175419	3157629176191
CPB	125	M14	0.30	T35	NOSCW	1	66261175421	3157629176207
CPB	150	M14	0.30	T55	NOSCW	1	07660739548	3157629175774
CPB	80	M14	0.50	T25	NOSCW	1	07660739550	3157629175781
CPB	100	M14	0.50	T30	NOSCW	1	07660739551	3157629175798

#### CUP BRUSHES - STAINLESS STEEL CRIMPED (STSCW)

Shape	D	A	Wire Ø	L	Wire	Pack.	Article Number	Barcode
CPB	60	M14	0.30	T16	STSCW	1	07660739552	3157629175804
CPB	80	M14	0.30	T25	STSCW	1	07660739553	3157629175811

## Portable Hand Drill

### Circular Brushes on shank (WHB)

#### NORMAL STEEL CRIMPED (NOSCW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	20	4	6	0.20	T3	NOSCW	10	07660739284	3157629173718
WHB	20	9	6	0.20	T3	NOSCW	10	07660739295	3157629173848
WHB	30	6	6	0.20	T6.5	NOSCW	10	07660739296	3157629173855
WHB	30	9	6	0.20	T6.5	NOSCW	10	07660739285	3157629173725
WHB	40	9	6	0.20	T9	NOSCW	10	07660739286	3157629173732
WHB	40	13.5	6	0.20	T9	NOSCW	10	07660739287	3157629173749
WHB	50	10	6	0.20	T12.5	NOSCW	10	07660739288	3157629173756
WHB	50	15	6	0.20	T12.5	NOSCW	10	07660739289	3157629173763
WHB	60	10	6	0.20	T17.5	NOSCW	10	07660739290	3157629173787
WHB	60	15	6	0.20	T17.5	NOSCW	10	07660739291	3157629173794
WHB	70	10	6	0.20	T19	NOSCW	10	07660739292	3157629173817
WHB	70	15	6	0.20	T19	NOSCW	10	07660739293	3157629173824
WHB	80	10	6	0.20	T19	NOSCW	10	07660739298	3157629173862
WHB	80	20	6	0.20	T19	NOSCW	10	07660739294	3157629173831
WHB	50	10	6	0.30	T12.5	NOSCW	10	07660739301	3157629173886
WHB	50	15	6	0.30	T12.5	NOSCW	10	07660739302	3157629173893
WHB	60	10	6	0.30	T17.5	NOSCW	10	07660739303	3157629173909
WHB	60	15	6	0.30	T17.5	NOSCW	10	07660739304	3157629173916
WHB	60	20	6	0.30	T17.5	NOSCW	10	07660739308	3157629188156
WHB	70	10	6	0.30	T19	NOSCW	10	07660739305	3157629173923
WHB	70	15	6	0.30	T19	NOSCW	10	07660739306	3157629173947
WHB	80	20	6	0.30	T19	NOSCW	10	07660739307	3157629173954

#### STAINLESS STEEL CRIMPED (STSCW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	30	9	6	0.20	T6.5	STSCW	10	07660739312	3157629173961
WHB	40	9	6	0.20	T9	STSCW	10	07660739313	3157629173978
WHB	40	13.5	6	0.20	T9	STSCW	10	07660739314	3157629173985
WHB	50	10	6	0.20	T12.5	STSCW	10	07660739315	3157629173992
WHB	50	15	6	0.20	T12.5	STSCW	10	07660739316	3157629174005
WHB	60	10	6	0.20	T17.5	STSCW	10	07660739317	3157629174012
WHB	60	15	6	0.20	T17.5	STSCW	10	07660739318	3157629174029
WHB	70	10	6	0.20	T19	STSCW	10	07660739319	3157629174036
WHB	70	15	6	0.20	T19	STSCW	10	07660739320	3157629174043
WHB	80	20	6	0.20	T19	STSCW	10	07660739321	3157629174067
WHB	60	10	6	0.30	T17.5	STSCW	10	07660739324	3157629174074
WHB	60	15	6	0.30	T17.5	STSCW	10	07660739325	3157629174081
WHB	70	10	6	0.30	T19	STSCW	10	07660739326	3157629174098
WHB	70	15	6	0.30	T19	STSCW	10	07660739327	3157629174104
WHB	80	20	6	0.30	T19	STSCW	10	07660739328	3157629174111

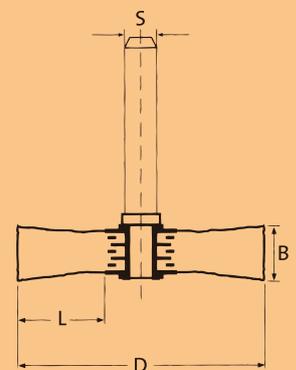
Dimensions Key: D = Diameter, B = Width, L = Wire length



#### Shaft mounted brushes

Suitable for industrial use. All shaft mounted brushes are equipped with a 6mm diameter shaft. Suitable for electric portable drilling machines or pillar drilling machines.

- Still wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and smoothing chrome-nickel steels, including stainless steel.
- Brass wire for brushing clean and smoothing brass, copper and bronze.



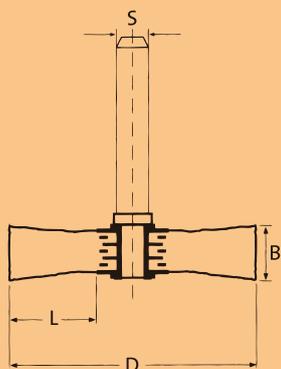
## Carbide Burrs and Steel Brushes



### Shaft mounted brushes

Suitable for industrial use. All shaft mounted brushes are equipped with a 6mm diameter shaft. Suitable for electric portable drilling machines or pillar drilling machines.

- Still wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and smoothing chrome-nickel steels, including stainless steel.
- Brass wire for brushing clean and smoothing brass, copper and bronze.



## Steel brushes

### Portable Hand Drill

### Circular Brushes on shank (continued)

#### BRASS CRIMPED (BRACW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	30	9	6	0.20	t6.5	BRACW	10	07660739329	3157629174128
WHB	40	9	6	0.20	T9	BRACW	10	07660739330	3157629174135
WHB	50	15	6	0.20	T12.5	BRACW	10	07660739331	3157629174142
WHB	70	15	6	0.20	T19	BRACW	10	07660739333	3157629174166
WHB	80	20	6	0.20	T19	BRACW	10	07660739334	3157629174173

#### NORMAL STEEL TWIST KNOTED (NOSKW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
WHB	70	15	6	0.35	T15	NOSKW	12	07660739299	3157629173879
WHB	70	15	6	0.50	T15	NOSKW	12	66261175458	3157629176221

# Carbide Burrs and Steel Brushes



## End Brushes on shank (ENB)

### NORMAL STEEL CRIMPED (NOSCW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	12	60	6	0.20	T20	NOSCW	12	66261175340*	3157629176146
ENB	17	65	6	0.20	T22	NOSCW	12	66261175341*	3157629176153
ENB	12	60	6	0.30	T20	NOSCW	12	07660739343	3157629174227
ENB	17	65	6	0.30	T22	NOSCW	12	07660739344	3157629174234
ENB	24	68	6	0.30	T25	NOSCW	12	07660739263	3157629173701
ENB	30	68	6	0.30	T25	NOSCW	12	07660739345	3157629174241

\* Made-to-order

### STAINLESS STEEL CRIMPED (STCSW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	12	60	6	0.30	T20	STCSW	12	07660739346	3157629174258
ENB	17	65	6	0.30	T22	STCSW	12	07660739347	3157629174265
ENB	24	68	6	0.30	T25	STCSW	12	07660739348	3157629174272
ENB	30	68	6	0.30	T25	STCSW	12	07660739349	3157629174289

### NORMAL STEEL TWIST KNOTTED (NOSKW) - HIGH SPEED

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	19	68	6	0.35	T28	NOSKW	12	07660739356	3157629174333
ENB	22	68	6	0.35	T28	NOSKW	12	07660739357	3157629174357
ENB	28	68	6	0.50	T28	NOSKW	12	07660739358	3157629174364

### STAINLESS STEEL TWIST KNOTTED (STSKW) - HIGH SPEED

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	19	68	6	0.25	T28	STSKW	12	07660739341	3157629174197
ENB	22	68	6	0.25	T28	STSKW	12	07660739342	3157629174203

### BRASS CRIMPED (BRACW)

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	24	68	6	0.30	T25	BRACW	12	07660739351	3157629174296

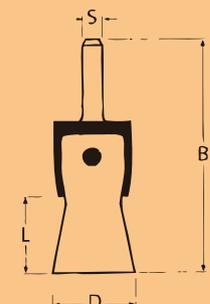
### SPECIALTIES

Shape	D	B	SHANK	Wire Ø	L	Wire	Pack.	Article Number	Barcode
ENB	50	63	6	0.30	T20	NOSCW	5	07660739352	3157629174302
ENB	70	68	6	0.30	T25	NOSCW	5	07660739353	3157629174319
ENB	10	120	6	0.30	T20	NOSCW	10	07660739355	3157629174326

#### Shaft mounted brushes

Suitable for industrial use. All shaft mounted brushes are equipped with a 6mm diameter shaft. Suitable for electric portable drilling machines or pillar drilling machines.

- Designed to reach hard-to-reach areas and internal surfaces.
- Still wire for removing rust and smoothing low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and smoothing chrome-nickel steels, including stainless steel.
- Brass wire for brushing clean and smoothing brass, copper and bronze.
- Twisted wire. These brushes spread themselves out at a certain speed. Ideal for use in pipes.



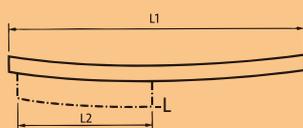
Dimensions Key: D = Diameter, B = Width, L = Wire length

# Carbide Burrs and Steel Brushes



## Hand brushes

- Steel wire for removing rust and deburring low-grade and non-alloy steels.
- Stainless steel wire for brushing clean and deburring from chrome-nickel steels, including stainless steel.
- Brass wire for use on copper, brass and bronze.



# Steel brushes

## Hand Brushes

### Hand Brushes (HCB)

#### WOOD HAND - NORMAL STRAIGHT STEEL (NOSSW)

Shape	L1	L2	L	Wire Ø	ROW	Wire	Pack.	Article Number	Barcode
HCB	290	140	25	0.30	1R	NOSSW	12	07660739476	3157629175255
HCB	290	140	25	0.30	2R	NOSSW	12	07660739477	3157629175262
HCB	290	140	25	0.30	3R	NOSSW	12	07660739478	3157629175279
HCB	290	140	25	0.30	4R	NOSSW	12	07660739479	3157629175286
HCB	290	140	25	0.30	5R	NOSSW	12	07660739480	3157629175293
HCB	290	140	25	0.30	6R	NOSSW	12	07660739481	3157629175309

#### WOOD HAND - STAINLESS STEEL STRAIGHT (STSSW)

Shape	L1	L2	L	Wire Ø	ROW	Wire	Pack.	Article Number	Barcode
HCB	290	140	25	0.30	2R	STSSW	12	07660739485	3157629175354
HCB	290	140	25	0.30	3R	STSSW	12	07660739486	3157629175361
HCB	290	140	25	0.30	4R	STSSW	12	07660739487	3157629175378
HCB	290	140	25	0.30	5R	STSSW	12	07660739488	3157629175385

#### WOOD HAND - STAINLESS STEEL CRIMPED (STSCW)

Shape	L1	L2	L	Wire Ø	ROW	Wire	Pack.	Article Number	Barcode
HCB	290	140	25	0.30	2R	STSCW	12	07660739489	3157629175392
HCB	290	140	25	0.30	3R	STSCW	12	07660739490	3157629175408
HCB	290	140	25	0.30	4R	STSCW	12	07660739491	3157629175415
HCB	290	140	25	0.30	5R	STSCW	12	07660739492	3157629175422

#### WOOD HAND - BRASS CRIMPED (BRACW)

Shape	L1	L2	L	Wire Ø	ROW	Wire	Pack.	Article Number	Barcode
HCB	290	140	25	0.30	2R	BRACW	12	07660739494	3157629175439
HCB	290	140	25	0.30	3R	BRACW	12	07660739495	3157629175446
HCB	290	140	25	0.30	4R	BRACW	12	07660739496	3157629175453
HCB	290	140	25	0.30	5R	BRACW	12	07660739497	3157629175477
HCB	290	140	25	0.30	6R	BRACW	12	07660739498	3157629175484

Dimensions Key: L1 = Total length, L2 = Working length, L = Wire length

# Carbide Burrs and Steel Brushes



## Multi Hand Brushes

### PLASTIC HAND - NORMAL CRIMPED (NOSCW)

Shape	L1	L2	L	Wire Ø	Wire	Pack.	Article Number	Barcode
HCB	265	140	25	0.30	NOSCW	6	07660739482	3157629175316

### PLASTIC HAND - STAINLESS STEEL CRIMPED (STSCW)

Shape	L1	L2	L	Wire Ø	Wire	Pack.	Article Number	Barcode
HCB	265	140	25	0.30	STSCW	6	07660739483	3157629175323

### PLASTIC HAND - BRASS CRIMPED (BRACW)

Shape	L1	L2	L	Wire Ø	Wire	Pack.	Article Number	Barcode
HCB	265	140	25	0.30	BRACW	6	07660739484	3157629175347

### Multi Hand Brushes

The multi hand brushes are particularly suitable for use in places which are difficult to reach.

## Special Hand Brushes

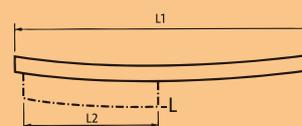
### SPARK PLUG BRUSHES

Shape	L1	L2	L	Wire Ø	ROW	Wire	Pack.	Article Number	Barcode
SPB	200	18	45	0.20	3x6R	BRACW	24	07660739217	3157629173596
SPB	195	26	50	0.20	5x8R	BRACW	24	07660739218	3157629173602



### FILE CARD BRUSHES

Shape	L1	L2	L	Wire	Pack.	Article Number	Barcode
SPB	235	25	100	NOSSW	24	07660739224	3157629173619
SPB	235	40	115	NOSSW	24	07660739225	3157629173626



Dimensions Key: L1 = Total length, L2 = Working length, L = Wire length

## Carbide Burrs and Steel Brushes



### Fitting brush

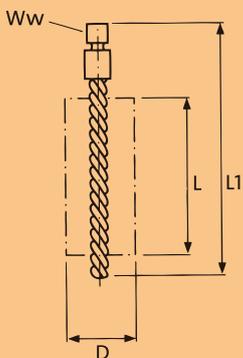
Special brushes for fast and effective cleaning and removal of oxide films in tubes and solder fittings made of copper or brass.

- Pipe fitting cleaning brushes for internal cleaning.
- Pipe fitting cleaning brushes for outside cleaning.



### Pipe brushes

With shank 6mm or screw fitting (M6, 1/2). For aggressive internal cleaning. Specially designed for boiler tube cleaning, for the removal of rust and scale.



## Steel brushes

### Hand Brushes

### Special Hand Brushes (continued)

#### FITTING BRUSH INTERNAL

Shape	D	L	L1	Wire Ø	Wire	Pack.	Article Number	Barcode
SPB	13	25	160	0.20	NOSCW	12	07660739234	3157629173633
SPB	16	25	160	0.20	NOSCW	12	07660739235	3157629173657
SPB	23	32	160	0.20	NOSCW	12	07660739237	3157629173664

#### FITTING BRUSH EXTERNAL

Shape	D	Wire Ø	Pack.	Article Number	Barcode
SPB	12	0.30	12	07660739240	3157629173671
SPB	15	0.30	12	07660739241	3157629173688
SPB	22	0.30	12	07660739242	3157629173695

## Pipe Brushes

### PIPE BRUSHES SHANK 6MM

Shape	D	L	L1	Shank	Wire Ø	Wire	Pack.	Article Number	Barcode
TUB	16	80	115	6	0.20	NOSCW	10	07660739419	3157629174753
TUB	18	80	115	6	0.20	NOSCW	10	07660739420	3157629174777
TUB	25	80	115	6	0.20	NOSCW	10	07660739422	3157629174784

### PIPE BRUSHES SHANK THREAD M6

Shape	D	L	L1	W/w	Wire Ø	Wire	Pack.	Article Number	Barcode
TUB	10	80	115	M6	0.20	NOSCW	10	07660739424	3157629174791
TUB	12	80	115	M6	0.20	NOSCW	10	07660739425	3157629174807
TUB	16	80	115	M6	0.20	NOSCW	10	07660739426	3157629174814
TUB	20	80	115	M6	0.20	NOSCW	10	07660739440	3157629174951
DOU	1000						1	07660739474**	3157629188163

\*\* Destock

# Carbide Burrs and Steel Brushes



## PIPE BRUSHES 1/2"

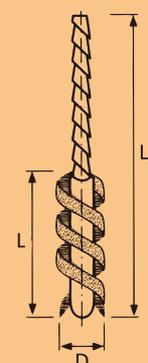
Shape	D	L	L1	W/w	Wire Ø	Wire	Pack.	Article Number	Barcode
TUB	20	100	160	1/2"BSW	0.20	NOSCW	10	07660739428	3157629174821
TUB	25	100	160	1/2"BSW	0.20	NOSCW	5	07660739429	3157629174838
TUB	30	100	160	1/2"BSW	0.30	NOSCW	5	07660739430	3157629174845
TUB	32	100	160	1/2"BSW	0.30	NOSCW	5	07660739431	3157629174852
TUB	38	100	160	1/2"BSW	0.30	NOSCW	5	07660739432	3157629174869
TUB	44	100	160	1/2"BSW	0.30	NOSCW	5	07660739433	3157629174876
TUB	50	100	160	1/2"BSW	0.40	NOSCW	5	07660739434	3157629174883
TUB	63	100	160	1/2"BSW	0.40	NOSCW	5	07660739435	3157629174906
TUB	69	100	160	1/2"BSW	0.40	NOSCW	5	07660739436	3157629174913
TUB	75	100	160	1/2"BSW	0.40	NOSCW	5	07660739437	3157629174937
TUB	82	100	160	1/2"BSW	0.40	NOSCW	5	07660739438	3157629174944
DOU	1000						1	07660739475	3157629188187

## PIPE BRUSHES WITH HANDLE NORMAL STEEL CRIMPED

Shape	D	L	L1		Wire Ø	Wire	Pack.	Article Number	Barcode
ACB	6	100	300	+ handle	0.10	NOSCW	20	07660739442	3157629174968
ACB	8	100	300	+ handle	0.10	NOSCW	20	07660739443	3157629174975
ACB	10	100	300	+ handle	0.10	NOSCW	20	07660739449	3157629175002
ACB	12	100	300	+ handle	0.10	NOSCW	20	07660739450	3157629175019
ACB	15	100	300	+ handle	0.10	NOSCW	20	07660739451	3157629175026
ACB	18	100	300	+ handle	0.10	NOSCW	20	07660739454	3157629175064
ACB	20	100	300	+ handle	0.20	NOSCW	20	07660739452	3157629175033
ACB	25	100	300	+ handle	0.20	NOSCW	20	07660739453	3157629175057

## PIPE BRUSHES WITH HANDLE STAINLESS STEEL CRIMPED

Shape	D	L	L1		Wire Ø	Wire	Pack.	Article Number	Barcode
ACB	12	100	300	+ handle	0.10	STSCW	20	07660739446	3157629174982
ACB	15	100	300	+ handle	0.10	STSCW	20	07660739447	3157629174999



Dimensions Key: D = Diameter, L = Working length, L1 = Total length

## Carbide Burrs and Steel Brushes

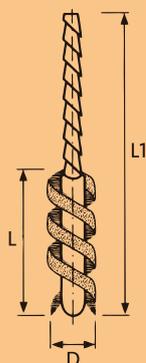


### Pipe brushes

With shank 6mm or screw fitting (M6, 1/2"). For aggressive internal cleaning. Specially designed for boiler tube cleaning, for the removal of rust and scale.

Aperture cleaning brushes, crimped brass wire or Nylon. Cleaning, dedusting, deburring, removing lacquer.

Ideally suited brush for cleaning nozzles, gas bottle, pipes, tubes...



## Steel brushes

### Hand Brushes

### Pipe Brushes (continued)

#### PIPE BRUSHES WITH HANDLE BRASS WIRE

Shape	D	L	L1		Wire Ø	Wire	Pack.	Article Number	Barcode
ACB	6	100	300	+ handle	0.10	BRACW	20	07660739455	3157629175071
ACB	8	100	300	+ handle	0.10	BRACW	20	07660739456	3157629175088
ACB	10	100	300	+ handle	0.10	BRACW	20	07660739457	3157629175095
ACB	12	100	300	+ handle	0.10	BRACW	20	07660739458	3157629175101
ACB	15	100	300	+ handle	0.10	BRACW	20	07660739459	3157629175118
ACB	18	100	300	+ handle	0.10	BRACW	20	07660739462	3157629175149
ACB	20	100	300	+ handle	0.15	BRACW	20	07660739460	3157629175125
ACB	25	100	300	+ handle	0.15	BRACW	20	07660739461	3157629175132

#### PIPE BRUSHES WITH HANDLE NYLON WIRE

Shape	D	L	L1		Wire Ø	Wire	Pack.	Article Number	Barcode
ACB	6	100	300	+ handle	0.20	NYLSW	20	07660739463	3157629175156
ACB	8	100	300	+ handle	0.20	NYLSW	20	07660739464	3157629175163
ACB	10	100	300	+ handle	0.20	NYLSW	20	07660739465	3157629175187
ACB	12	100	300	+ handle	0.20	NYLSW	20	07660739466	3157629175194
ACB	15	100	300	+ handle	0.20	NYLSW	20	07660739467	3157629175217
ACB	18	100	300	+ handle	0.25	NYLSW	20	07660739470	3157629175248
ACB	20	100	300	+ handle	0.25	NYLSW	20	07660739468	3157629175224
ACB	25	100	300	+ handle	0.25	NYLSW	20	07660739469	3157629175231

# Carbide Burrs and Steel Brushes



**Brooms**  
Steelwire brooms and scrubbers

## Miscellaneous

### BROOM STEELWIRE

Shape	B	D	ROW	L	Wire	Pack.	Article Number	Barcode
SPB	300	60	6x20	T75	NOSFW	1	07660739213	3157629173572

### SCRUBBER STEELWIRE

Shape	B	D	ROW	L	Wire	Pack.	Article Number	Barcode
SPB	210	60	6x17	T30	NOSSW	1	07660739215	3157629173589

**Dimensions Key:** B = Width, D = Depth, L = Wire length



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