

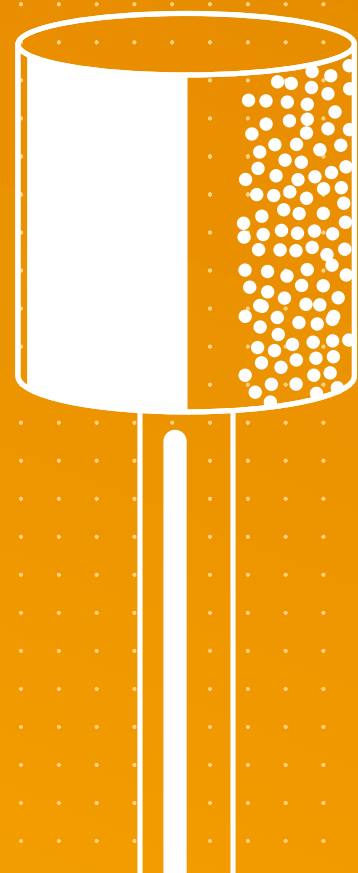
Mounted points

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130	Mounted points, tailor-made solution



Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



Technical Information

Grit sizes, ISO 525

Coarse	4, 5, 6, 7, 8, 10, 12, 14, 16, 20, 24
Medium	30, 36, 46, 54, 60
Fine	70, 80, 90, 100, 120, 150, 180, 220
Very fine	230, 240, 280, 320, 360, 400, 500

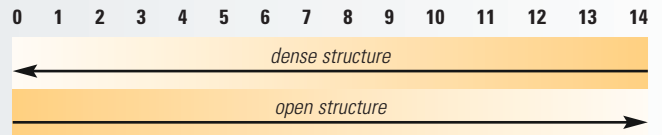
Hardness grade, ISO 525

The hardness is a measure of the strength with which the grits are retained by the bond. It is determined by special measuring instruments. The grades are indicated by letter. The hardness increases in alphabetical order.

extreme soft	very soft	soft	medium	hard	very hard	extreme hard
A	E	H	L	P	T	X
B	F	I	M	Q	U	Y
C	G	Jot	N	R	V	Z
D		K	O	S	W	

Structure

The structure of grinding wheels is determined by the ratio of pore volume to the volume of grit and bond. The international standardized structure numbers start with 0 and end with 14.



Bond

The bond retains the grit in the grinding wheel. The most important bonds are ISO 525:

Vitrified bond

V = vitrified bond

The figure behind the bonding code is a company-internal reference.

Organic bonds

Ba = resin bond

BF = resin bond, reinforced

R = rubber bond or other elastomers

RF = rubber bond, reinforced

Impregnation

The impregnation of vitrified bonds considerably improves the performance of the mounted points when grinding certain steels.

Su = with sulphur

Lu = with resin

W = with wax

F = with grinding oil

Description of Mounted points

Shape	Diameter	Length	Shank	Abrasive	Grit size	Hardness	Bond
ZY	16	32	06	EKR	46	N	V4

Technical Information

Quality

The wide range of abrasive applications, from snagging to polishing, demands mounted points that meet the requirements of stock removal, surface finish and tool life. The crucial formulation of the mounted point quality results from a combination of the technical

application and selection of the most suitable raw materials. The following tables state the type of raw materials used in LUKAS mounted points.

Abrasives

<p>NK</p>  <p>Aluminum oxide</p>	<p>EKR</p>  <p>Aluminum oxide pink</p>	<p>EKW</p>  <p>Aluminum oxide white</p>	<p>EKD</p>  <p>Aluminum oxide dark red</p>
<p>EKbr</p>  <p>Standard aluminum oxide pink, type brown</p>	<p>MK</p>  <p>Mixture EKR/NK</p>	<p>HK</p>  <p>Mixture EKW/NK</p>	<p>HKD</p>  <p>Mixture EKW/EKD</p>
<p>MKD</p>  <p>Mixture NK/EKD</p>	<p>RKD</p>  <p>Mixture EKD/EKR</p>	<p>SiC-ALU</p>  <p>Silicon carbide green</p>	<p>SiCdkl</p>  <p>Silicon carbide dark</p>
<p>NDW</p>  <p>Mixture NK/EKD/EKK white</p>	<p>CERAMIC</p>  <p>Mixture of ceramic grain and monocystal aluminium oxide</p>	<p>HOK</p>  <p>Mixture spherical aluminium oxide grain</p>	

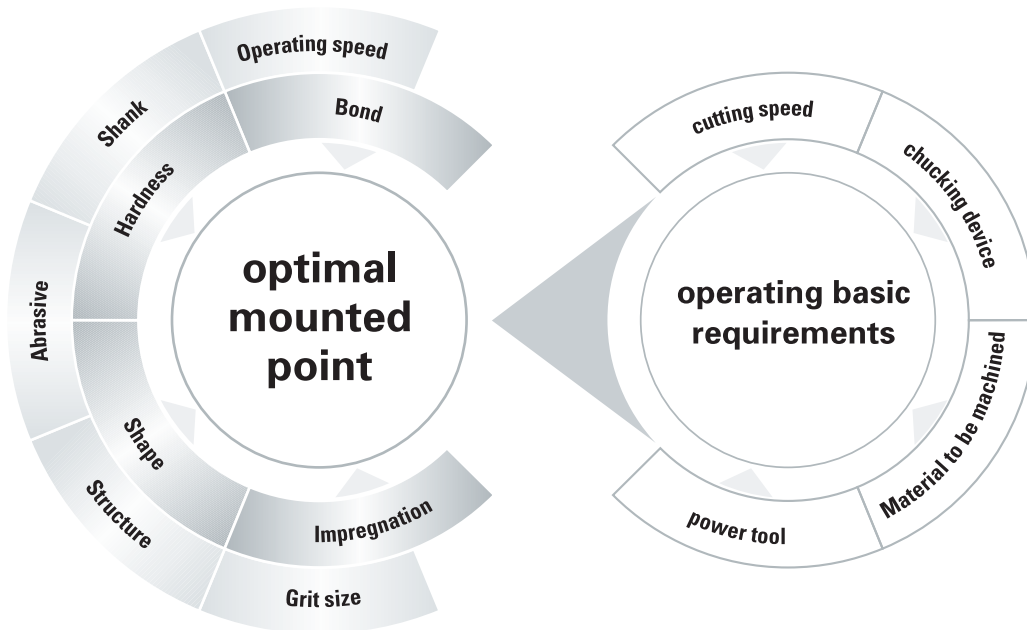
Qualities and areas of application

From the large variety of specifications we have selected various dimensions and shapes in well-proven standard qualities for you. These mounted points are available ex-stock.

			Materials								
best suitable suitable	Reference/ Qualities	Cutting speed vc [m/s]	1	2	3	4	5	6	7	8	9
			steels and cast steels	alloyed, tempered steels	tool steels	rust, acid and heat resistant steels and cast steels	cast iron	aluminium, magnesium and copper alloys	titanium and nickel alloys	plastics, wood, rubber	glass, carbides
	EKR aluminium oxide pink	ca. 30 - 50									
	EKWbr aluminium oxide white, type brown	ca. 25 - 40									
	RKD mixture aluminium oxide deep red / aluminium oxide pink	ca. 30 - 50									
	NK-BA-soft aluminium oxide resin bonded iron and sulphur free	ca. 40 - 50									
	NK-BA-hard aluminium oxide resin bonded	ca. 40 - 50									
	HK mixture aluminium oxide white / aluminium oxide	ca. 40 - 50									
	MK mixture aluminium oxide pink / aluminium oxide	ca. 30 - 50									
	NDW mixture aluminium oxide, aluminium oxide dark red and mono cristall aluminium oxide white	ca. 10 - 30									
	CERAMIC Mixture of ceramic grain and monocrystal aluminium oxide	ca. 30 - 50									
	EKW aluminium oxide white	ca. 20 - 35									
	EKbr aluminium oxide pink, type brown	ca. 40 - 50									
	SiC-ALU silicon carbide green	ca. 25 - 40									
	HOK mixture spherical aluminium oxide grain	ca. 5 - 20									

These quality recommendations apply only when optimum application conditions are used.


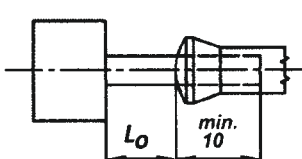


Choice of the optimal grinding tool



Speeds for grinding tools

		Recommended cutting speed v_c [m/s]							
		5	10	20	30	40	50	63	80
		Rotational speed [min ⁻¹]							
Tool-diameter [mm]	2	47.700	95.500	191.000	286.500	382.000	477.500	601.600	763.900
	3	31.800	63.700	127.300	191.000	254.600	318.300	401.100	509.300
	4	23.900	47.700	95.500	143.200	191.000	238.700	300.800	382.000
	5	19.100	38.200	76.400	114.600	152.800	191.000	240.600	305.600
	6	15.900	31.800	63.700	95.500	127.300	159.200	200.500	254.600
	8	11.900	23.900	47.700	71.600	95.500	119.400	150.400	191.000
	10	9.500	19.100	38.200	57.300	76.400	95.500	120.300	152.800
	13	7.300	14.700	29.400	44.100	58.800	73.500	92.600	117.500
	20	4.800	9.500	19.100	28.600	38.200	47.700	60.200	76.400
	25	3.800	7.600	15.300	22.900	30.600	38.200	48.100	61.100
	32	3.000	6.000	11.900	17.900	23.900	29.800	37.600	47.700
	40	2.400	4.800	9.500	14.300	19.100	23.900	30.100	38.200
	50	1.900	3.800	7.600	11.500	15.300	19.100	24.100	30.600
	60	1.600	3.200	6.400	9.500	12.700	15.900	20.100	25.500
	80	1.200	2.400	4.800	7.200	9.500	11.900	15.000	19.100
	100	1.000	1.900	3.800	5.700	7.600	9.500	12.000	15.300

Safety instructions

Schleifkörper keramisch Brousicí tělíska keramická Mounted points - vitrified Muelas cerámicas Meule vitrifiée										
A200002032602 ZY 2032.06 EKR 36 N V4										
Stück pcs.	20	FA1334200								
<table border="1"> <thead> <tr> <th>L_o(mm)</th> <th>max. rpm</th> </tr> </thead> <tbody> <tr> <td>10</td> <td>40.600</td> </tr> <tr> <td>15</td> <td>34.500</td> </tr> <tr> <td>20</td> <td>29.700</td> </tr> </tbody> </table>				L _o (mm)	max. rpm	10	40.600	15	34.500	20
L _o (mm)	max. rpm									
10	40.600									
15	34.500									
20	29.700									
 4 027497 013296			 EN 12413							
EN 12413										

Peripheral speeds, safety

Our mounted points are manufactured with state of the art technology for high peripheral speed and the safety is well in accordance with the EN 12413.

We produce mounted points, vitrified and resin bonded, for a maximum peripheral operating speeds of 50 m/s.

These maximum operating speeds are limited by the following criteria:

1. The mass (weight) of the mounted point
2. The shape of the mounted point
3. The shank diameter
4. The overhang of the shank
5. The shank material
6. The run-out of the mounted point

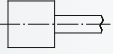
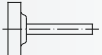
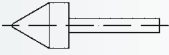
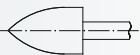

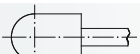

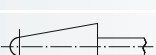


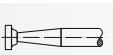
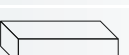


The safety aspect of a grinding wheel is of paramount importance.

When using and storing Mounted Points, note must be taken without fail of the safety-regulations and regulations for prevention of accidents, including the FEPA-safety recommendations.

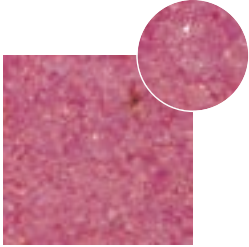
We enclose a safety ticket with all our deliveries, as illustrated above. The maximum speeds shown on these safety tickets refer to the overhang length (open shank length L_0) of the shank i.e. 10, 15 and 20 mm respectively.

No raw materials used in our grinding wheels are a hazard to health and safety.

A summary of available shapes

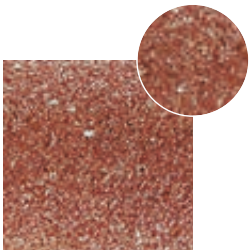
Shape	Type	Shape (Lukas)	Page
	Cylindrical, Typ 1	ZY	106
	Cylindrical, Typ 2	ZY2	112
	Cylindrical pointed nose	WKS	113
	Arch pointed nose	SP	113
	Spherical	KU	115
	Cylindrical round nose	WR	115
	Cup	TO	117
	Conical round nose	KE	117
	American shapes	A	118
	American shapes	B	120
	Miniature-Mounted points	D	120
	Handstones	–	124
	Mounted points, assortments	–	125
	Power Tools	–	381

Qualities:



EKR

aluminium oxide pink



EKWbr

aluminium oxide white,
type brown

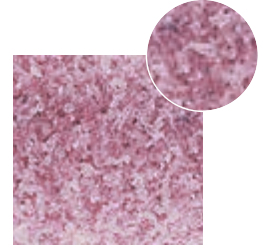


General Information

<p>Properties of workpiece material:</p>	<p>Mounted points in various qualities are needed to cover the wide spectrum of the numerous steel types and their resulting workpieces.</p>	
<p>Industries:</p>	<ul style="list-style-type: none"> • Machine tools • Automotive • Equipment manufacturers 	<ul style="list-style-type: none"> • Vessel manufacturers • Shipyards • and much more
<p>Examples of application:</p>	<ul style="list-style-type: none"> • General rough grinding • Fettling • Rough grinding of weld seams 	<ul style="list-style-type: none"> • Finish grinding of weld seams • Deburring
<p>LUKAS-grinding tools:</p>	<p>The wide selection of LUKAS grinding tools incorporates numerous shapes, sizes and qualities. You will find the correct tool from our standard range to solve most grinding problems irrespective of material to be ground, type of machine or any other influencing factors. These mounted points are designed for high stock removal and long tool life.</p>	

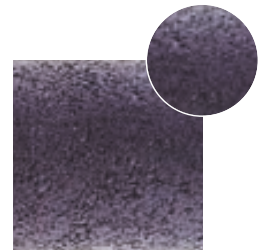


Qualities:



RKD

mixture aluminium oxide
deep red / aluminium
oxide pink



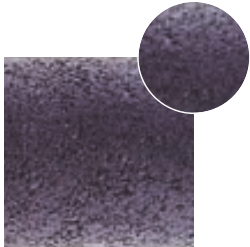
NK-BA-soft

aluminium oxide resin
bonded iron and
sulphur free

General Information

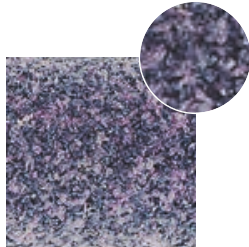
<p>Properties of workpiece material:</p>	<p>Alloyed steels i.e., non-rusting steels are included in the materials which are difficult to machine. They tend to “smear” due to the nickel content, and as a result of poor heat dissipation causes overheating of the material within the grinding contact zone.</p>	
<p>Industries:</p>	<ul style="list-style-type: none"> • Steel construction and fabrication (facades, railings, sanitary equipment) • Vessel manufacturing • Casings and panelling 	<ul style="list-style-type: none"> • Medical technology • Shipyards • Food industry • and much more
<p>Examples of application:</p>	<ul style="list-style-type: none"> • Rough and finish grinding • Deburring • Fettling 	<ul style="list-style-type: none"> • Removing weld seams • Surface finishing
<p>LUKAS-grinding tools:</p>	<p>LUKAS has developed particular high performance qualities for alloyed steels distinguished by exceptional stock removal despite operating under difficult conditions. These tools contain no iron, no sulphur and no halogens; a chemical reaction (corrosion) of the workpiece material in the grinding contact zone is generally therefore avoided.</p>	

Qualities:



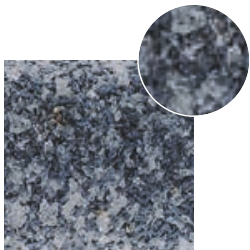
NK Ba-hard

aluminium oxide
resin bonded



MK

mixture aluminium oxide
pink / aluminium oxide



HK

mixture aluminium oxide
white / aluminium oxide

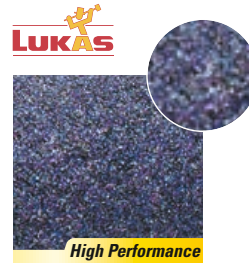


General Information

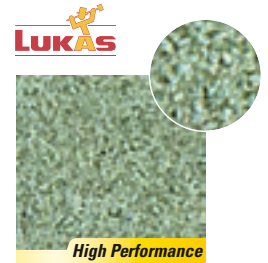
<p>Properties of workpiece material:</p>	<p>The characteristics of the various types of cast materials are normally determined by their carbon content, and the way in which the carbon is removed from the material structure.</p> <p>Cast components are generally “rough” machined. The skin contains inclusions of sand from the casting process; large burrs, runners and risers, holes and cracks must all be removed by grinding. These areas to be ground are often somewhat inaccessible.</p>
<p>Industries:</p>	<ul style="list-style-type: none"> • Manufacturers of cast components i.e. engine blocks, gear box casings, cylinder heads, frames, stands, machine slides, gears, crankshafts, pump and turbine housings, machine tool components • and much more
<p>Examples of application:</p>	<ul style="list-style-type: none"> • Deburring • Fettling • Removing holes and cracks • Finish grinding of repair welds • Polishing
<p>LUKAS-grinding tools:</p>	<p>The LUKAS mounted points specifically formulated to grind cast materials contain special grain combinations and tough bonding systems; such qualities give optimum performance for the applications mentioned above.</p> <p>The aggressiveness of the abrasive grain and the smooth running of the mounted points allow for an ergonomic method of machining requiring minimum force. Mounted points with specially extended shafts are also available on request.</p>



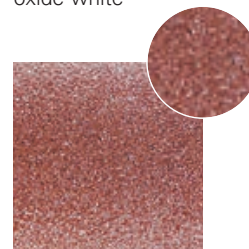
Qualities:



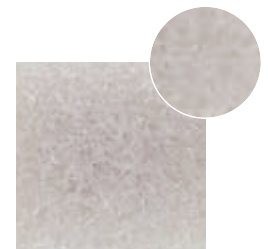
NDW
mixture aluminium oxide,
aluminium oxide dark red and
mono crystal aluminium
oxide white



CERAMIC
Mixture of ceramic grain
and monocrystal
aluminium oxide



EKbr
aluminium oxide pink,
type brown

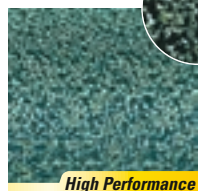


EKW
aluminium oxide white

General Information

Properties of workpiece material:	Precision is a major factor in the tool and mould industry. Tool steels are selected with the appropriate hardness and toughness to suit the application; special mounted point qualities are therefore essential to achieve the tight tolerances required.
Industries:	<ul style="list-style-type: none"> • Toolmakers • Pattern shops • Mould manufacturers • Aerospace
Examples of application:	<ul style="list-style-type: none"> • Re-grinding • Groove grinding • Fine deburring • Finish grinding • Lapping • Coordinate grinding • Ball bearing grinding • Turbine blades
LUKAS-grinding tools:	LUKAS mounted points for tool and mould & die are extremely dimensionally stable and can cut even the hardest materials. Ceramic abrasive grit is extremely friable due to its microcrystal structure. This makes it self-sharpening. Therefore materials which are difficult to cut (e.g. nickel-based alloys) can be machined without any problems. Moreover, the use of special grain qualities ensures a long service life. Our broad and varied range enables you to work in even the narrowest of spaces.

Quality:



SIC-ALU

silicon carbide green



General Information

<p>Properties of workpiece material:</p>	<p>Aluminium and its associated alloys have many varied and positive characteristics making it the second most widely used metal after steel. Aluminium has only 1/3 the density of steel. The purer the metal, the weaker it becomes but allows for better shape forming. Unsuitable mounted point qualities are often used which “load”.</p>
<p>Industries:</p>	<ul style="list-style-type: none"> • Transport (railways, ships, automotive, aerospace) • Metal construction (bridges, cranes, silos) • Chemical industry (vessels, pumps, pipes) • Equipment manufacturing • Engine, transmission parts • and much more
<p>Examples of application:</p>	<ul style="list-style-type: none"> • Deburring • Fettingling • Re-working • Surface finishing
<p>LUKAS-grinding tools:</p>	<p>The LUKAS mounted points in the quality SIC – ALU have been developed solely for this application. Due to a special structure, maximum tool life is achieved whilst preventing “loading” of material within the pores. The self-dressing effect is aided by the use of a special impregnation.</p>



Quality:



HOK

mixture spherical aluminium oxide grain

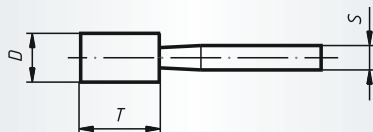
General Information

<p>Properties of workpiece material:</p>	<p>Materials such as rubber or plastic are very elastic and have a very low melting point. They flex and generate heat; this often results in a bad odour and loading.</p>	
<p>Industries:</p>	<ul style="list-style-type: none"> • Machining rubber • Machining plastic 	
<p>Examples of application:</p>	<ul style="list-style-type: none"> • Tyre repair and re-vulcanizing • Repair of conveyor belts 	<ul style="list-style-type: none"> • Preparation of various areas for adhesion • Deburring of rubber or plastic components
<p>LUKAS-grinding tools:</p>	<p>LUKAS abrasive tools for the machining of rubber and plastic contain a special hollow grain (HOK) in a very open ceramic structure. This abrasive media creates permanent small razor-sharp cutting edges which pluck-out the material from the surface. Consequently, these tools are ideally suited for the machining applications as illustrated.</p>	



Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200000408377



Packing unit:

20 pcs. per type

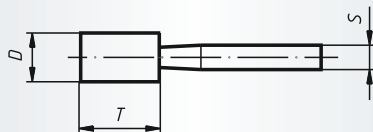
Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for															
ZY 0408.03	CERAMIC 80 L V118	4	8	3 x 30	A200000408377	②	③	④							⑦						■
ZY 0510.03	CERAMIC 80 L V118	5	10	3 x 30	A200000510377	②	③	④							⑦						■
ZY 0613.03	CERAMIC 80 L V118	6	13	3 x 30	A200000613377	②	③	④							⑦						■
ZY 1020.06	CERAMIC 80 L V118	10	20	6 x 40	A200001020677	②	③	④							⑦						■
ZY 1325.06	CERAMIC 46 L V118	13	25	6 x 40	A200001325677	②	③	④							⑦						■
ZY 1632.06	CERAMIC 46 L V118	16	32	6 x 40	A200001632677	②	③	④							⑦						■
ZY 2032.06	CERAMIC 46 L V118	20	32	6 x 40	A200002032677	②	③	④							⑦						■



Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200000306353



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

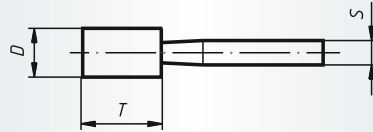
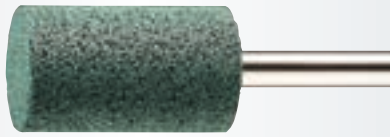
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for															
ZY 0306.03	NDW 100 QU V115	3	6	3 x 50	A200000306353	②	③														■
ZY 0306.03	NDW 100 QU V115	3	6	3 x 30	A2000003063530001	②	③														■
ZY 0408.03	NDW 100 QU V115	4	8	3 x 50	A200000408353	②	③														■
ZY 0408.03	NDW 100 QU V115	4	8	3 x 30	A2000004083530001	②	③														■
ZY 0610.03	NDW 100 QU V115	6	10	3 x 50	A200000610353	②	③														■
ZY 0610.03	NDW 100 QU V115	6	10	3 x 30	A2000006103530001	②	③														■
ZY 0810.03	NDW 100 QU V115	8	10	3 x 50	A200000810353	②	③														■
ZY 0810.03	NDW 100 QU V115	8	10	3 x 30	A2000008103530001	②	③														■
ZY 1013.03	NDW 100 QU V115	10	13	3 x 50	A200001013353	②	③														■
ZY 1013.03	NDW 100 QU V115	10	13	3 x 30	A2000010133530001	②	③														■



High Performance

Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200000408318A



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

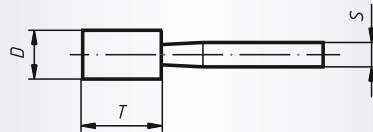
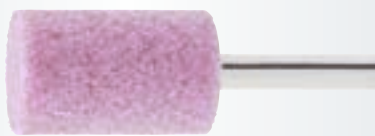
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
ZY 0408.03	SIC-ALU 80 V27 W	4	8	3 x 30	A200000408318A	6	■
ZY 0510.03	SIC-ALU 80 V27 W	5	10	3 x 30	A200000510318A	6	■
ZY 0610.03	SIC-ALU 80 V27 W	6	10	3 x 30	A200000610318A	6	■
ZY 0810.03	SIC-ALU 80 V27 W	8	10	3 x 30	A200000810318A	6	■
ZY 1010.03	SIC-ALU 80 V27 W	10	10	3 x 30	A200001010318A	6	■
ZY 1013.06	SIC-ALU 80 V27 W	10	13	6 x 40	A200001013618A	6	■
ZY 1020.06	SIC-ALU 80 V27 W	10	20	6 x 40	A200001020618A	6	■
ZY 1313.06	SIC-ALU 80 V27 W	13	13	6 x 40	A200001313618A	6	■
ZY 1332.06	SIC-ALU 80 V27 W	13	32	6 x 40	A200001332618A	6	■
ZY 1616.06	SIC-ALU 80 V27 W	16	16	6 x 40	A200001616618A	6	■
ZY 1632.06	SIC-ALU 80 V27 W	16	32	6 x 40	A200001632618A	6	■
ZY 2020.06	SIC-ALU 80 V27 W	20	20	6 x 40	A200002020618A	6	■
ZY 2025.06	SIC-ALU 80 V27 W	20	25	6 x 40	A200002025618A	6	■
ZY 2040.06	SIC-ALU 80 V27 W	20	40	6 x 40	A200002040618A	6	■
ZY 3232.06	SIC-ALU 80 V27 W	32	32	6 x 40	A200003232618A	6	■
ZY 4020.06	SIC-ALU 80 V27 W	40	20	6 x 40	A200004020618A	6	■



Industry

Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200000104302



Packing unit:

20 pcs. per type

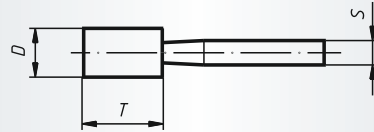
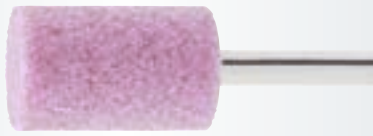
Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
ZY 0104.03	EKR 150 N V4	1,5	4	3 x 30	A200000104302	1 2 3	■
ZY 0104.03	RKD 150 QU V21	1,5	4	3 x 30	A200000104347	2 3 4	■
ZY 0205.03	EKR 120 N V4	2	5	3 x 30	A200000205302	1 2 3	■
ZY 0205.03	EKWBR 120 O/P V7	2	5	3 x 30	A200000205312	1 2	■
ZY 0205.03	RKD 150 QU V21	2	5	3 x 30	A200000205347	2 3 4	■
ZY 0205.06	EKR 120 N V4	2	5	6 x 40	A200000205602	1 2 3	■
ZY 0205.06	RKD 150 QU V21	2	5	6 x 40	A200000205647	2 3 4	■
ZY 0305.03	EKR 120 N V4	2,5	5	3 x 30	A2000002053020001	1 2 3	■
ZY 0306.03	EKR 100 N V4	3	6	3 x 30	A200000306302	1 2 3	■
ZY 0306.03	EKR 120 QU V4	3	6	3 x 30	A2000003063020001	1 2 3	■
ZY 0306.03	EKWBR 100 O/P V7	3	6	3 x 30	A200000306312	1 2	■
ZY 0306.03	RKD 120 QU V21	3	6	3 x 30	A200000306347	2 3 4	■



Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200000306602



Packing unit:

20 pcs. per type

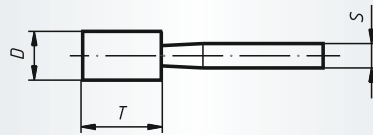
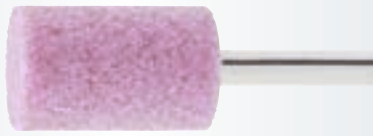
Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
ZY 0306.06	EKR 100 N V4	3	6	6 x 40	A200000306602	1	2	3												
ZY 0306.06	RKD 120 QU V21	3	6	6 x 40	A200000306647		2	3	4											
ZY 0408.03	EKR 80 N V4	4	8	3 x 30	A200000408302	1	2	3												
ZY 0408.03	EKR 100 QU V4	4	8	3 x 30	A2000004083020001	1	2	3												
ZY 0408.03	EKWBR 80 O/P V7	4	8	3 x 30	A200000408312	1	2													
ZY 0408.03	RKD 100 QU V21	4	8	3 x 30	A200000408347		2	3	4											
ZY 0408.06	EKR 80 N V4	4	8	6 x 40	A200000408602	1	2	3												
ZY 0408.06	RKD 100 QU V21	4	8	6 x 40	A200000408647		2	3	4											
ZY 0510.03	EKR 80 N V4	5	10	3 x 30	A200000510302	1	2	3												
ZY 0510.03	EKR 80/100 QU V4	5	10	3 x 30	A2000005103020001	1	2	3												
ZY 0510.03	EKWBR 80 O/P V7	5	10	3 x 30	A200000510312	1	2													
ZY 0510.03	RKD 100 QU V21	5	10	3 x 30	A200000510347		2	3	4											
ZY 0510.06	EKR 80 N V4	5	10	6 x 40	A200000510602	1	2	3												
ZY 0510.06	RKD 100 QU V21	5	10	6 x 40	A200000510647		2	3	4											
ZY 0610.03	EKR 60 N V4	6	10	3 x 30	A200000610302	1	2	3												
ZY 0610.03	EKWBR 60 O/P V7	6	10	3 x 30	A200000610312	1	2													
ZY 0610.03	RKD 80 QU V21	6	10	3 x 30	A200000610347		2	3	4											
ZY 0610.06	EKR 60 N V4	6	10	6 x 40	A200000610602	1	2	3												
ZY 0610.06	RKD 80 QU V21	6	10	6 x 40	A200000610647		2	3	4											
ZY 0610.06	EKW 80 L V1	6	10	6 x 40	A200000610608			3						7		9				
ZY 0810.03	EKR 60 N V4	8	10	3 x 30	A200000810302	1	2	3												
ZY 0810.03	EKR 60/80 QU V4	8	10	3 x 30	A2000008103020001	1	2	3												
ZY 0810.03	EKWBR 60 O/P V7	8	10	3 x 30	A200000810312	1	2													
ZY 0810.03	RKD 80 QU V21	8	10	3 x 30	A200000810347		2	3	4											
ZY 0810.06	EKR 60 N V4	8	10	6 x 40	A200000810602	1	2	3												
ZY 0810.06	RKD 80 QU V21	8	10	6 x 40	A200000810647		2	3	4											
ZY 0810.06	EKW 80 L V1	8	10	6 x 40	A200000810608			3						7		9				
ZY 0816.03	EKR 60 N V4	8	16	3 x 30	A200000816302	1	2	3												
ZY 0816.03	EKWBR 60 O/P V7	8	16	3 x 30	A200000816312	1	2													
ZY 0816.03	RKD 80 QU V21	8	16	3 x 30	A200000816347		2	3	4											
ZY 0816.06	EKR 60 N V4	8	16	6 x 40	A200000816602	1	2	3												
ZY 0816.06	RKD 80 QU V21	8	16	6 x 40	A200000816647		2	3	4											
ZY 0820.06	EKR 60 N V4	8	20	6 x 40	A200000820602	1	2	3												
ZY 1010.03	EKR 60 N V4	10	10	3 x 30	A200001010302	1	2	3												
ZY 1010.03	EKR 60/80 QU V4	10	10	3 x 30	A2000010103020001	1	2	3												
ZY 1010.03	EKWBR. 60 O/P V7	10	10	3 x 30	A200001010312	1	2													
ZY 1010.03	RKD 80 P V21	10	10	3 x 30	A200001010347		2	3	4											
ZY 1010.06	EKR 60 N V4	10	10	6 x 40	A200001010602	1	2	3												
ZY 1010.06	RKD 80 P V21	10	10	6 x 40	A200001010647		2	3	4											
ZY 1010.06	EKW 60 L V1	10	10	6 x 40	A200001010608			3						7		9				
ZY 1013.03	EKR 60 N V4	10	13	3 x 30	A200001013302	1	2	3												
ZY 1013.03	EKWBR 60 O/P V7	10	13	3 x 30	A200001013312	1	2													



Shape ZY, Cylinder, Type 1 (according to DIN 69170)

Ordering example: A200003232627W



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
ZY 3232.06	NK 24 N BA soft	32	32	6 x 40	A200003232627W	2	3	4	6											
ZY 3232.06	NK 24 QU BA hard	32	32	6 x 40	A200003232627	2	3		5											
ZY 3232.06	MK 36 N V10	32	32	6 x 40	A200003232616	2		4	5											
ZY 3240.06	EKR 30 N V4	32	40	6 x 40	A200003240602	1	2	3												
ZY 3240.06	RKD 30 O (6) V21	32	40	6 x 40	A200003240647		2	3	4											
ZY 3240.06	MK 36 N V10	32	40	6 x 40	A200003240616		2		4	5										
ZY 4020.06	EKR 30 N V4	40	20	6 x 40	A200004020602	1	2	3												
ZY 4020.06	RKD 24 O (6) V21	40	20	6 x 40	A200004020647		2	3	4											
ZY 4020.06	NK 24 N BA soft	40	20	6 x 40	A200004020627W		2	3	4	6										
ZY 4020.06	NK 24 QU BA hard	40	20	6 x 40	A200004020627		2	3		5										
ZY 4020.06	HK 30 N V13	40	20	6 x 40	A200004020633				4	5										
ZY 4020.06	MK 36 N V10	40	20	6 x 40	A200004020616		2		4	5										
ZY 4020.06	HOK 0-3 V9	40	20	6 x 40	A202204020626														8	
ZY 4020.08	RKD 24 O (6) V21	40	20	8 x 40	A200004020847		2	3	4											
ZY 4020.08	NK 24 N BA soft	40	20	8 x 40	A200004020827W		2	3	4	6										
ZY 4020.08	NK 24 QU BA hard	40	20	8 x 40	A200004020827		2	3		5										
ZY 4020.08	HK 30 N V13	40	20	8 x 40	A200004020833				4	5										
ZY 4040.06	EKR 30 N V4	40	40	6 x 40	A200004040602	1	2	3												
ZY 4040.06	RKD 24 O (6) V21	40	40	6 x 40	A200004040647		2	3	4											
ZY 4040.08	RKD 24 O (6) V21	40	40	8 x 40	A200004040847		2	3	4											
ZY 4040.08	NK 24 QU BA hard	40	40	8 x 40	A200004040827		2	3		5										
ZY 4040.08	MK 36 N V10	40	40	8 x 40	A200004040816		2		4	5										
ZY 5013.08	NK 24 QU BA hard	50	13	8 x 40	A200005013827		2	3		5										
ZY 5020.06	EKR 30 N V4	50	20	6 x 40	A200005020602	1	2	3												
ZY 5020.06	RKD 24 O (6) V21	50	20	6 x 40	A200005020647		2	3	4											
ZY 5020.06	NK 24 N BA soft	50	20	6 x 40	A200005020627W		2	3	4	6										
ZY 5020.06	NK 24 QU BA hard	50	20	6 x 40	A200005020627		2	3		5										
ZY 5020.08	NK 24 QU BA hard	50	20	8 x 40	A200005020827		2	3		5										
ZY 5025.06	MK 30 N V10	50	25	6 x 40	A200005025616		2		4	5										
ZY 5025.08	NK 24 QU BA hard	50	25	8 x 40	A200005025827		2	3		5										


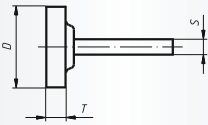
112 Mounted points



High Performance

Shape ZY, Cylinder, Type 2 (according to DIN 69170)

Ordering example: A201301303377


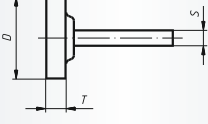
						Packing unit: 20 pcs. per type Further dimensions, qualities and shank lengths on request.				
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for				
ZY2 1303.03	CERAMIC 80 L V118	13	3	3 x 30	A201301303377	②	③	④	⑦	■



Industry

Shape ZY, Cylinder, Type 2 (according to DIN 69170)

Ordering example: A201301303302

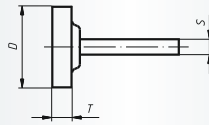
						Packing unit: 20 pcs. per type Further dimensions, qualities and shank lengths on request.				
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for				
ZY2 1303.03	EKR 80 N V4	13	3	3 x 30	A201301303302	①	②	③	■	
ZY2 1303.03	EKWBR 80 O/P V7	13	3	3 x 30	A201301303312	①	②	■		
ZY2 1303.03	RKD 80 QU V21	13	3	3 x 30	A201301303347	②	③	④	■	
ZY2 1303.06	EKR 80 N V4	13	3	6 x 40	A201301303602	①	②	③	■	
ZY2 1604.03	EKR 60 N V4	16	4	3 x 30	A201301604302	①	②	③	■	
ZY2 1604.03	EKWBR 60 O/P V7	16	4	3 x 30	A201301604312	①	②	■		
ZY2 1604.03	RKD 80 QU V21	16	4	3 x 30	A201301604347	②	③	④	■	
ZY2 1604.06	EKR 60 N V4	16	4	6 x 40	A201301604602	①	②	③	■	
ZY2 2006.03	EKR 60 N V4	20	6	3 x 30	A201302006302	①	②	③	■	
ZY2 2006.03	EKWBR 60 O/P V7	20	6	3 x 30	A201302006312	①	②	■		
ZY2 2006.06	EKR 60 N V4	20	6	6 x 40	A201302006602	①	②	③	■	
ZY2 2006.06	EKR 46 QU V4	20	6	6 x 40	A2013020066020001	①	②	③	■	
ZY2 2506.06	EKR 60 N V4	25	6	6 x 40	A201302506602	①	②	③	■	
ZY2 2510.06	EKR 36 N V4	25	10	6 x 40	A201302510602	①	②	③	■	
ZY2 2510.06	NK 24 QU BA. hard	25	10	6 x 40	A201302510627	②	③	⑤	■	
ZY2 3208.06	EKR 46 N V4	32	8	6 x 40	A201303208602	①	②	③	■	
ZY2 3208.06	RKD 36 O (6) V21	32	8	6 x 40	A201303208647	②	③	④	■	
ZY2 3208.06	NK 24 QU BA. hard	32	8	6 x 40	A201303208627	②	③	⑤	■	
ZY2 4006.06	NK 24 N BA. soft	40	10	6 x 40	A201304006627	②	③	④	⑥	■
ZY2 4010.06	EKR 30 N V4	40	10	6 x 40	A201304010602	①	②	③	■	
ZY2 4010.06	RKD 30 O (6) V21	40	10	6 x 40	A201304010647	②	③	④	■	
ZY2 4010.06	NK 24 N BA. soft	40	10	6 x 40	A201304010627W	②	③	④	⑥	■
ZY2 4010.06	NK 24 QU BA. hard	40	10	6 x 40	A201304010627	②	③	⑤	■	
ZY2 4010.06	MK 36 N V10	40	10	6 x 40	A201304010616	②	④	⑤	■	
ZY2 5004.06	NK 24 N BA. soft	50	4	6 x 40	A201305004627W	②	③	④	⑥	■
ZY2 5004.06	NK 24 QU BA. hard	50	4	6 x 40	A201305004627	②	③	⑤	■	
ZY2 5006.06	NK 24 N BA. soft	50	6	6 x 40	A201305006627W	②	③	④	⑥	■



Industry

Shape ZY, Cylinder, Type 2 (according to DIN 69170)

Ordering example: A201305006627



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

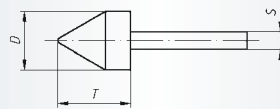
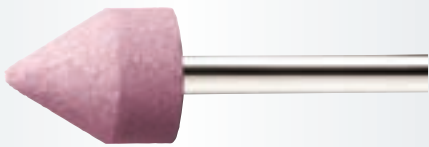
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
ZY2 5006.06	NK 24 QU BA. hard	50	6	6 x 40	A201305006627	② ③ ⑤	■
ZY2 5010.06	EKR 30 N V4	50	10	6 x 40	A201305010602	① ② ③	■
ZY2 5010.06	NK 24 N BA. soft	50	10	6 x 40	A201305010627W	② ③ ④ ⑥	■
ZY2 5010.06	NK 24 QU BA. hard	50	10	6 x 40	A201305010627	② ③ ⑤	■
ZY2 5010.06	HK 30 N V13	50	10	6 x 40	A201305010633	④ ⑤	■
ZY2 5010.08	NK 24 N BA. soft	50	10	8 x 40	A201305010827W	② ③ ④ ⑥	■
ZY2 5010.08	NK 24 QU BA. hard	50	10	8 x 40	A201305010827	② ③ ⑤	■
ZY2 6510.08	NK 24 P BA.15	65	10	8 x 40	A201306510827	② ③ ⑤	■



Industry

Shape WKS, Cylindrical pointed nose

Ordering example: A200402025602



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

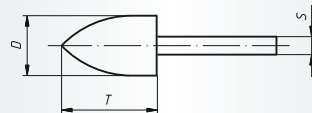
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
WKS 2025.06	EKR 60 N V4	20	25	6 x 40	A200402025602	① ② ③	■



High Performance

Shape SP, Pointed nose (according to DIN 69170)

Ordering example: A200200510377



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

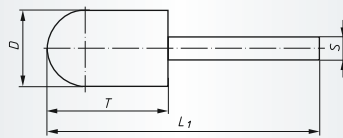
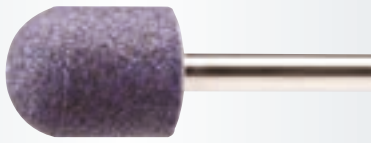
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
SP 0510.03	CERAMIC 80 L V118	5	10	3 x 30	A200200510377	② ③ ④ ⑦	■
SP 0816.03	CERAMIC 80 L V118	8	16	3 x 30	A200200816377	② ③ ④ ⑦	■
SP 1320.06	CERAMIC 46 L V118	13	20	6 x 40	A200201320677	② ③ ④ ⑦	■



High Performance

Shape WR, Cylindrical round nose (according to DIN 69170)

Ordering example: A2014010133530001



Packing unit:
20 pcs. per type
Further dimensions, qualities and shank lengths on request.

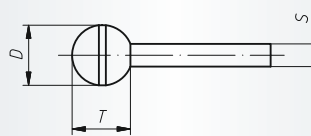
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
WR 1013.03	NDW 100 QU V115	10	13	3 x 30	A2014010133530001	② ③	■
WR 1013.03	NDW 100 QU V115	10	13	3 x 50	A201401013353	② ③	■



High Performance

Shape KU, Spherical (according to DIN 69170)

Ordering example: A201100606377



Packing unit:
20 pcs. per type
Further dimensions, qualities and shank lengths on request.

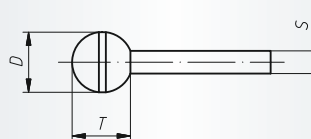
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
KU 0606.03	CERAMIC 80 L V118	6	6	3 x 30	A201100606377	② ③ ④ ⑦	■
KU 1010.06	CERAMIC 46 L V118	10	10	6 x 40	A201101010677	② ③ ④ ⑦	■
KU 1313.06	CERAMIC 46 L V118	13	13	6 x 40	A201101313677	② ③ ④ ⑦	■



High Performance

Shape KU, Spherical (according to DIN 69170)

Ordering example: A2011004043530001



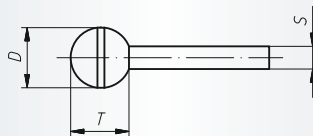
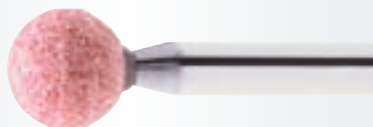
Packing unit:
20 pcs. per type
Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
KU 0404.03	NDW 100 QU V115	4	4	3 x 30	A2011004043530001	② ③	■
KU 0404.03	NDW 100 QU V115	4	4	3 x 50	A201100404353	② ③	■
KU 0606.03	NDW 100 QU V115	6	6	3 x 30	A2011006063530001	② ③	■
KU 0606.03	NDW 100 QU V115	6	6	3 x 50	A201100606353	② ③	■
KU 0808.03	NDW 100 QU V115	8	8	3 x 30	A2011008083530001	② ③	■
KU 0808.03	NDW 100 QU V115	8	8	3 x 50	A201100808353	② ③	■



Shape KU, Spherical (according to DIN 69170)

Ordering example: A201100606302



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

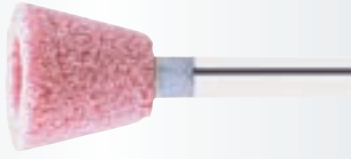
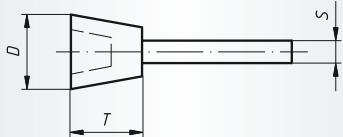
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for												
KU 0606.03	EKR 60 N V4	6	6	3 x 30	A201100606302	1	2	3										
KU 0606.03	EKR 80/100 QU V4	6	6	3 x 30	A2011006063020001	1	2	3										
KU 0606.03	EKWBR. 60 O/P V7	6	6	3 x 30	A201100606312	1	2											
KU 0606.06	EKR 60 N V4	6	6	6 x 40	A201100606602	1	2	3										
KU 0606.06	EKWBR. 60 O/P V7	6	6	6 x 40	A201100606612	1	2											
KU 0808.03	EKR 60 N V4	8	8	3 x 30	A201100808302	1	2	3										
KU 0808.03	EKWBR. 60 O/P V7	8	8	3 x 30	A201100808312	1	2											
KU 0808.06	EKR 60 N V4	8	8	6 x 40	A201100808602	1	2	3										
KU 0808.06	EKR 60/80 QU V4	8	8	6 x 40	A2011008086020001	1	2	3										
KU 1010.03	EKR 60 N V4	10	10	3 x 30	A201101010302	1	2	3										
KU 1010.03	EKWbr. 60 O/P V7	10	10	3 x 30	A201101010312	1	2											
KU 1010.03	RKD 80 P V21	10	10	3 x 30	A201101010347		2	3	4									
KU 1010.06	EKR 60 N V4	10	10	6 x 40	A201101010602	1	2	3										
KU 1313.03	EKR 46 N V4	13	13	3 x 30	A201101313302	1	2	3										
KU 1313.06	EKR 46 N V4	13	13	6 x 40	A201101313602	1	2	3										
KU 1313.06	EKR 46 QU V4	13	13	6 x 40	A2011013136020001	1	2	3										
KU 1616.06	EKR 46 N V4	16	16	6 x 40	A201101616602	1	2	3										
KU 1616.06	RKD 60 P (6) V21	16	16	6 x 40	A201101616647		2	3	4									
KU 2020.06	EKR 36 N V4	20	20	6 x 40	A201102020602	1	2	3										
KU 2020.06	EKR 60 P V21	20	20	6 x 40	A2011020206020001	1	2	3										
KU 2020.06	EKWBR. 46 O/P V7	20	20	6 x 40	A201102020612	1	2											
KU 2525.06	EKR 36 N V4	25	25	6 x 40	A201102525602	1	2	3										
KU 2525.06	RKD 30 QU V21	25	25	6 x 40	A201102525647		2	3	4									
KU 2525.06	NK 24 N Ba. soft	25	25	6 x 40	A201102525627		2	3	4		6							
KU 2525.06	HOK 0-3 V9	25	25	6 x 40	A201902525626												8	
KU 3232.06	EKR 30 N V4	32	32	6 x 40	A201103232602	1	2	3										
KU 3838.06	HOK 0-3 V9	38	38	6 x 40	A201903838626													8



Industry

Shape TO, Cup (according to DIN 69170)

Ordering example: A202002019602


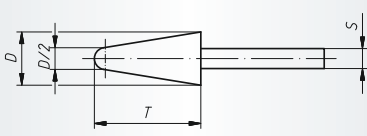
					Packing unit: 20 pcs. per type Further dimensions, qualities and shank lengths on request.								
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for							
TO 2020.06	EKR 60 N V4	20	20	6 x 40	A202002019602	①	②	③					■
TO 2524.06	EKR 60 N V4	25	24	6 x 40	A202002524602	①	②	③					■
TO 3229.06	EKR 60 N V4	32	29	6 x 40	A202003229602	①	②	③					■
TO 4036.06	EKR 60 N V4	40	36	6 x 40	A202004036602	①	②	③					■



High Performance

Shape KE, Conical round nose (according to DIN 69170)

Ordering example: A201501025677

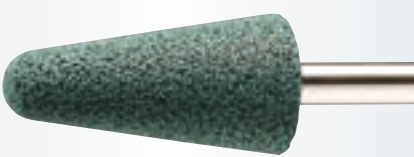
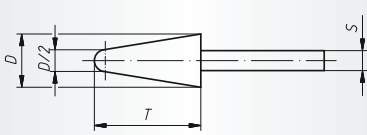
					Packing unit: 20 pcs. per type								
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for							
KE 1025.06	CERAMIC 46 L V118	10	25	6 x 40	A201501025677		②	③	④		⑦		■
KE 1632.06	CERAMIC 46 L V118	16	32	6 x 40	A201501632677		②	③	④		⑦		■



High Performance

Shape KE, Conical round nose (according to DIN 69170)

Ordering example: A201501632618A

					Packing unit: 20 pcs. per type								
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for							
KE 1632.06	SIC-ALU 80 V27 W	16	32	6 x 40	A201501632618A						⑥		■
KE 2040.06	SIC-ALU 80 V27 W	20	40	6 x 40	A201502040618A						⑥		■

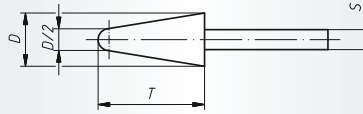
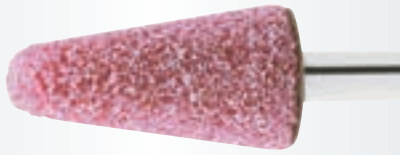
118 Mounted points



Industry

Shape KE, Conical round nose (according to DIN 69170)

Ordering example: A201501025647



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

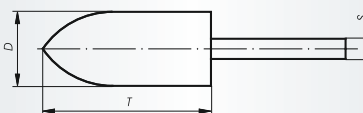
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
KE 1025.06	RKD 60 P (6) V21	10	25	6 x 40	A201501025647		②	③	④											■
KE 1025.06	EKRBR.46/60 P V7	10	25	6 x 40	A201601025606	①														■
KE 1632.06	EKR 46 N V4	16	32	6 x 40	A201501632602	①	②	③												■
KE 1632.06	MK 36 N V10	16	32	6 x 40	A201501632616		②		④	⑤										■
KE 1640.06	EKR 46 N V4	16	40	6 x 40	A201501640602	①	②	③												■
KE 1645.06	RKD 46 O V13	16	45	6 x 40	A2015016456470002		②	③	④											■
KE 1645.06	EKRBR.46/60 P V7	16	45	6 x 40	A201601645606	①														■
KE 2032.06	EKR 36 N V4	20	32	6 x 40	A201502032602	①	②	③												■
KE 2032.06	MK 36 N V10	20	32	6 x 40	A201502032616		②		④	⑤										■
KE 2040.06	EKR 36 N V4	20	40	6 x 40	A201502040602	①	②	③												■
KE 2040.06	RKD 36 O (6) V21	20	40	6 x 40	A201502040647		②	③	④											■
KE 2040.06	MK 36 N V10	20	40	6 x 40	A201502040616		②		④	⑤										■
KE 2570.06	EKR 36 N V4	25	70	6 x 40	A201502570602	①	②	③												■
KE 3250.06	RKD 30 O (6) V21	32	50	6 x 40	A201503250647		②	③	④											■
KE 3250.08	HK 30 N V13	32	50	8 x 40	A201503250833				④	⑤										■



Industry

Shape A, american shapes

Ordering example: A2062022636020001



Packing unit:

20 pcs. per type

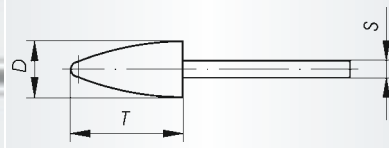
Further dimensions, qualities and shank lengths on request.

Description	Quality	Shape	D inch	T inch	D mm	T mm	S mm	Product-Number	recommended for												
A1 2263.06	EKR 36 N V4		7/8	2 1/2	22	63	6 x 40	A2062022636020001	①	②	③										■
A1 2263.06	HK 36/46 M V13		7/8	2 1/2	22	63	6 x 40	A206202263633				④	⑤								■
A2 2532.06	EKR 36 QU V4		1	1 1/4	25	32	6 x 40	A206202532602	①	②	③										■
AS-3 1645.06	HK 36/46 M V13		5/8	1 3/4	16	45	6 x 40	A206201645633				④	⑤								■
A3 2570.06	EKR 36 N V4		1	2 3/4	25	70	6 x 40	A2062025706020001	①	②	③										■
A3 2570.06	HK 36/46 M V13		1	2 3/4	25	70	6 x 40	A206202570633				④	⑤								■
A3 2570.08	HK 36/46 M V13		1	2 3/4	25	70	8 x 40	A206402570833				④	⑤								■



Shape B, american shapes

Ordering example: A206601616302



Packing unit:

20 pcs. per type

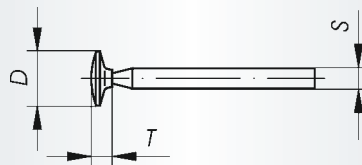
Further dimensions, qualities and shank lengths on request.

Description	Quality	Shape	D inch	T inch	D mm	T mm	S mm	Product-Number	recommended for	
B41 1616.03	EKR 60/80 QU V4		5/8	5/8	16	16	3 x 30	A206601616302	① ② ③	■
B52 1020.03	EKR 46 QU V4		3/8	3/4	10	20	3 x 30	A206601020302	① ② ③	■
B53 0816.03	EKR 60/80 QU V4		5/16	5/8	8	16	3 x 30	A206600816302	① ② ③	■



Miniature-Mounted points

Ordering example: A202900001302



Packing unit:

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

Description	Quality	Shape	D mm	T mm	S mm	Product-Number	recommended for	
D1	EKR 100 N V4		9	2	3 x 30	A202900001302	① ② ③	■
D1	EKBR 100 M V1/6		9	2	3 x 30	A202900001311	② ③	■
D2	EKR 80 N V4		9	3	3 x 30	A202900002302	① ② ③	■
D2	EKBR 80 M V1/6		9	3	3 x 30	A202900002311	② ③	■
D3	EKR 100 N V4		8	2	3 x 30	A202900003302	① ② ③	■
D3	EKBR 100 M V1/6		8	2	3 x 30	A202900003311	② ③	■
D4	EKR 100 N V4		4	1	3 x 30	A202900004302	① ② ③	■
D4	EKBR 100 M V1/6		4	1	3 x 30	A202900004311	② ③	■
D5	EKR 80 N V4		5	3	3 x 30	A202900005302	① ② ③	■
D5	EKBR 80 M V1/6		5	3	3 x 30	A202900005311	② ③	■
D6	EKR 80 N V4		7/4	6	3 x 30	A202900006302	① ② ③	■



High Performance

Mounted points-Assortments

Ordering example: A201000000353



Packing unit:
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 10	3 x 50	NDW	10-pieces	ZY 0408, ZY 0610, ZY 0810, ZY 1013, SP 0510, SP 0810, KU 0404, KU 0606, KU 0808, WR 1013	A201000000353	② ③	■



Industry

Mounted points-Assortments

Ordering example: A204700001402



Packing unit:
1 pc. per type

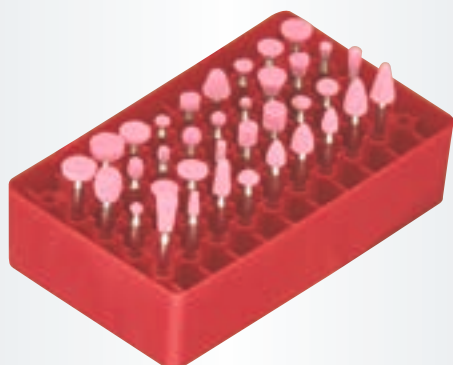
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 14	3 x 30	EKR	14-pieces	ZY 0205, ZY 0306, ZY 0408, ZY 0510, ZY 0610, ZY 0810, ZY 0816, ZY 1010, ZY 1013, ZY 1313, KU 0808, ZY2 1303, ZY2 1604, ZY2 2006	A204700001402	① ② ③	■



Industry

Mounted points-Assortments

Ordering example: A204800003602



Packing unit:
1 pc. per type

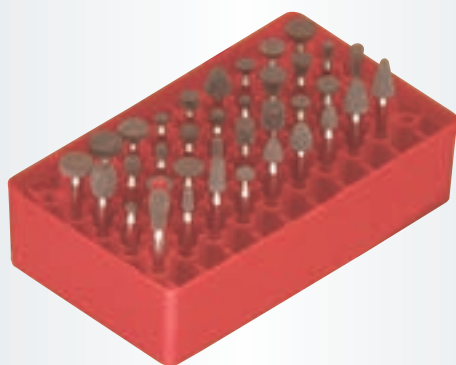
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 36	3 x 30	EKR	36-pieces	D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11, D12, D13, D14, D15, D16, D17, D18, D19, D20, D21, D22, D23, D24, D25, D26, D27, D28, D29, D30, D31, D32, D33, D34, D35, D36	A204800003602	① ② ③	■



Industry

Mounted points-Assortments

Ordering example: A204800003611



Packing unit:
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 36	3 x 30	EKBR	36-pieces	D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11, D12, D13, D14, D15, D16, D17, D18, D19, D20, D21, D22, D23, D24, D25, D26, D27, D28, D29, D30, D31, D32, D33, D34, D35, D36	A204800003611	② ③	■



Industry

Mounted points-Assortments

Ordering example: A204600000202



Packing unit:
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for													
Assortment 45	6 x 40	EKR	45-pieces	ZY 0306, ZY 0510, ZY 0408, ZY 0610, ZY 0810, ZY 0816, ZY 1010, ZY 1020, ZY 1032, ZY2 1303, ZY 1313, ZY 1320, ZY2 1604, ZY 1616, ZY 1620, ZY 1632, ZY2 2006, ZY 2020, ZY 2025, ZY 2032 ZY 2040, ZY2 2506, ZY2 2510, ZY 2520, ZY 2525, ZY 2532, ZY2 3208, ZY 3220, ZY 3232, ZY2 4010, ZY 4020, SP 0816, SP 1020, SP 1320, SP 2032, KE 1632, KE 1640, KE 2032, KE 2040, KU 1010, KU 1313, KU 1616, KU 2020, KU 2525, KU 3232	A204600000202	①	②	③											■

128 Mounted points-Assortments



Industry

Mounted point assortment – STEEL

Ordering example: A20480005602



Packing unit:
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment STAHL	6	EKR	5-pieces	ZY 1632.06, EKR 46 N V4, ZY 2525.06, EKR 36 N V4, WKS 2025.06, EKR 60 N V4, KU 2525.06, EKR 36 N V4, KE 1632.06, EKR 46 N V4	A20480005602	① ② ③	■



Industry

Mounted point assortment – INOX

Ordering example: A20480004627W



Packing unit:
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment INOX	6	NK BA	4-pieces	ZY 1332.06, NK 24 N BA Soft, ZY 2040.06, NK 24 N BA Soft, ZY2 4006.06, NK 24 N BA Soft, KU 2525.06, NKB/NK 24 R BA 98	A20480004627W	② ③ ④ ⑥	■

Always the right tool

Polishing tools P6: The new LUKAS polishing wheels will brighten up your workpieces. See for yourself how fast and steady surfaces of the most different materials can be dash-dot matted or polished in accordance with your requests.

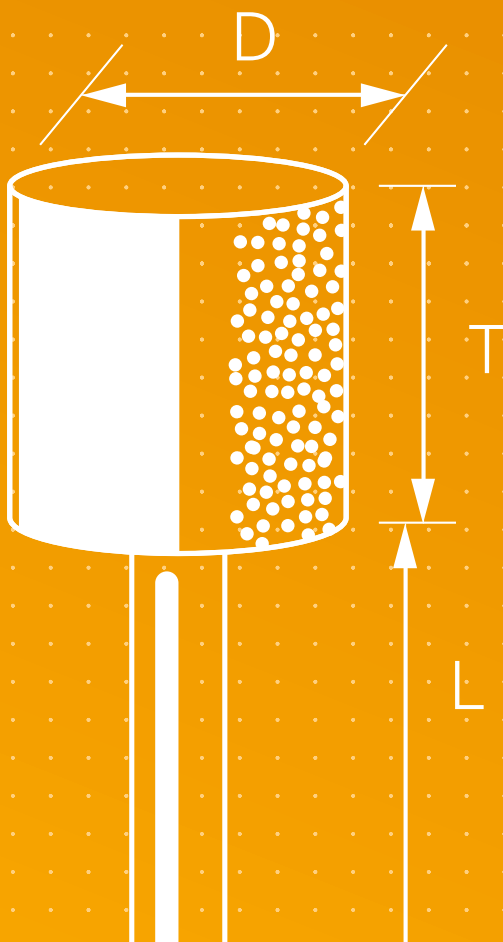
Holger Roland
Production



Grinding wheels – special for your particular application

131 Examples of our efficiency

131 Enquiry parameters



We are pleased to be able to offer you a “tailor-made” grinding wheel quality e.g.:

- Wheels in special qualities
- Wheels with special dimensions
- Wheels with special profiles
- Mounted points with imperial dimensions and/or imperial shafts
- Mounted points with internal threads and threaded shafts to suit
- Cup wheels
- Grinding wheels – plain and tapered
- Mounted points with extended shafts
- Mounted points with threaded shafts and extended shafts to suit
- Handstones and dressing sticks
- and much more

Please advise us of your application problem with all relevant information – the quicker this is done, the quicker we can react!
The relevant information required is:

- Shape, dimensions, shaft, bore size of the abrasive wheel (a sketch or technical drawing would be of great assistance)
- Material to be ground
- Type of application (e.g. fettling, deburring)
- Surface finish requirements
- Machine R.P.M
- anticipated order quantity
- wheel currently being used (type, quality...)
- etc.

Always the right tool

**For Highest Performance
and Best Ergonomics!**



Polishing tools

134 General Information

137 Polishing points, group P1

140 Polishing points, group P2

144 Felt polishing points, group P3

148 Grinding- and diamond pastes,
sprays and thinners

151 Flexible polishing sticks, group P4

153 Polishing points, group P5

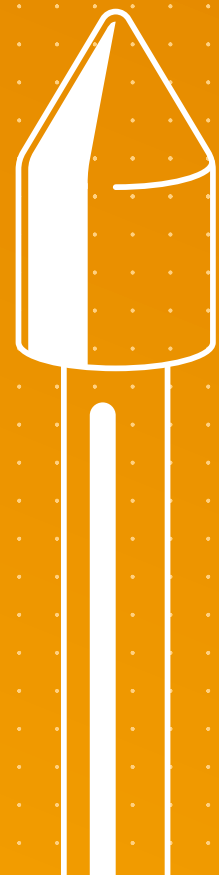
155 Polishing points and wheels,
marbling points, group P6

161 Small polishing points, group P7

381 Power tools

Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



General Information

Should you wish to enhance your product with the desired optical polish or where a defined technical surface finish value must be achieved, there are many good reasons why LUKAS polishing tools can be used on your particular workpiece. Current examples of applications where the highest precision and tolerances must be achieved can be found in the car industry, pump and turbine manufacture and the aerospace industry. Polished surfaces guarantee hygienic and clean working conditions in the food and pharmaceutical industries. The tool and mould manufacturers polish surfaces to a mirror finish in order to achieve a precise replication of the profile to the finished product.

Due to the ever increasing demand for high precision, LUKAS have developed a wide range of polishing tools using different raw materials in various grit sizes and hardnesses.

LUKAS polishing tools are divided into groups – P1 to P7 – to suit specific applications. These tools include polishing wheels, points and sticks to cover a wide variety of applications.

On the following page, you will find an illustration giving a general overview of such applications.

Safety instructions

LUKAS polishing points under groups P1 and P5 are manufactured according to EN 12413 and are allowed to run at max. 50m/s. However, group P2 is only allowed max. 16m/s. The permissible peripheral speed of the product group P6 depends upon the hardness grade which in the case of MWP is max. 20m/s. The optimal working speed however generally lies below the maximum allowed; this reduces the heat generated and increases tool life. LUKAS polishing mounted points are supplied with a safety ticket which stipulates maximum R.P.M. for different shaft overhang lengths.

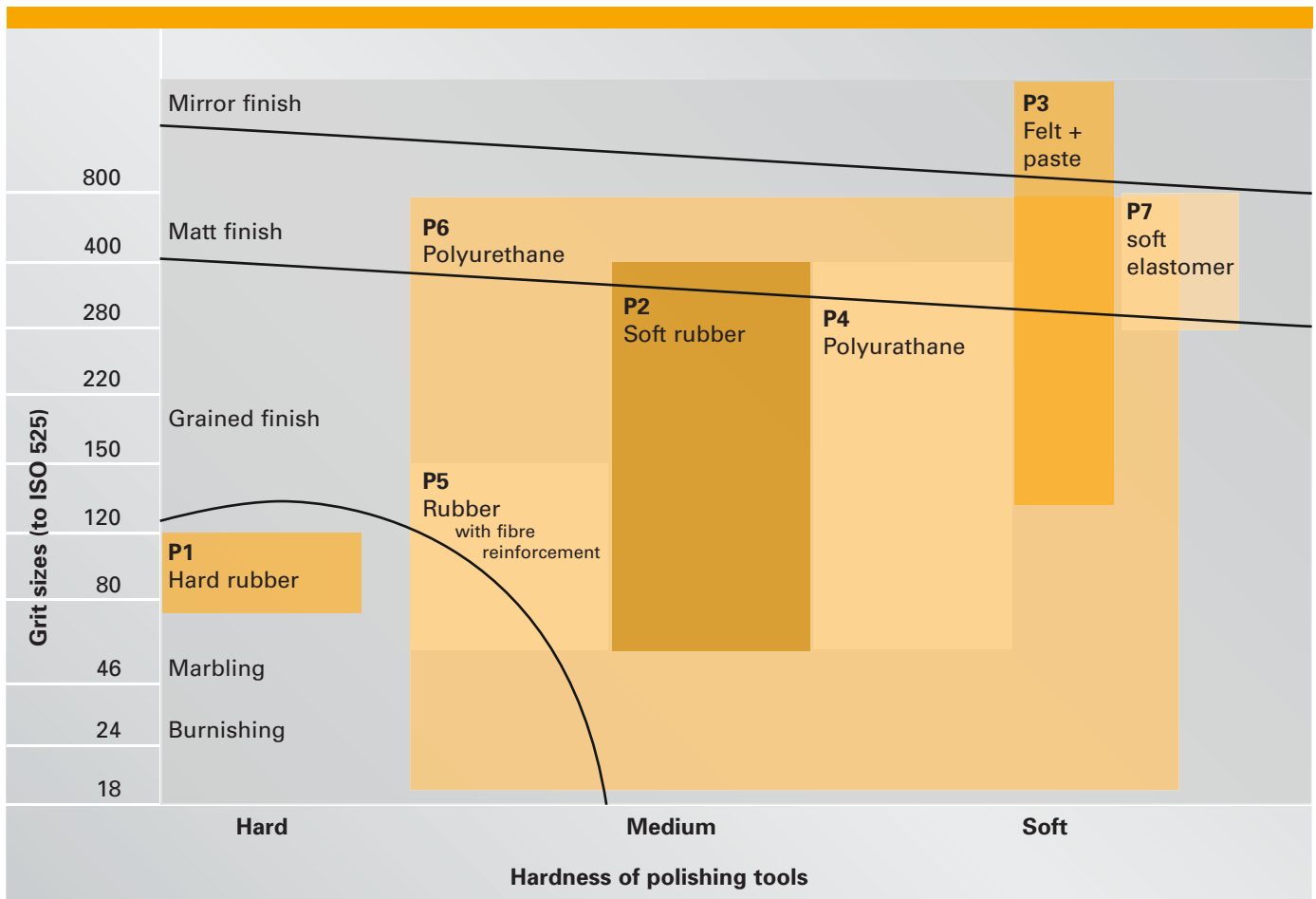
For the safe use of polishing points and wheels, please take note of the following operating instructions:

- FEPA safety recommendations for the correct use of abrasive products
- FEPA safety instructions for bonded abrasives

Application example of P2

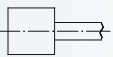

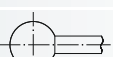
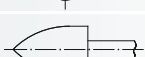
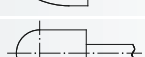
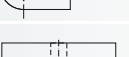

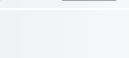




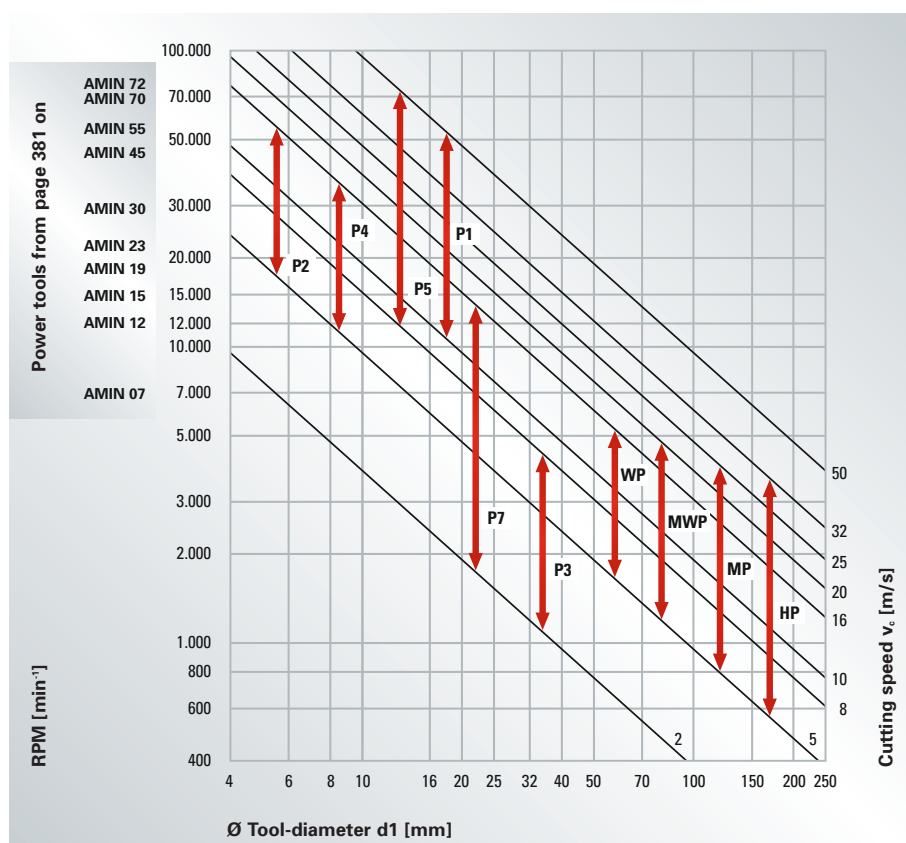
Areas of application



P1	polishing points consist of a hard rubber bonding with a grit size 100. They are suited for fine finishing applications and for the preparation of surfaces which require further polishing operations
P2	polishig points and wheels are manufactured using a soft rubber bond in grit sizes 46 to 280. Grained and matt finishes on small surface areas can be produced; to achieve the required result, different grit sizes used in sequence should be applied.
P3	felt polishing tools are used in conjunction with a SIC or diamong polishing paste to give the best results even up to a mirror finish.
P4	polishing sticks are manufactured from polyurethane (PU). Areas of application and the results are similar to those detailed in group P2. Polishing sticks are used manually.
P5	polishing points contain a fibre reinforcement to increase tool life. Achievable surface finish lies between group P1 and P2.
P6	polishing tools are available in various forms – mounted points, marbling points, rolls for satin finishes and polishing wheels. The hardness of the polyurethane bonding (PU) can be divided into 4 categories – from soft to hard. Available grit sizes in SIC 24 to 400. These tools give the opportunity of a much wider field of application including larger surfaces. The main application is on stationary polishing machines e.g. centerless polishing of tubes.
P7	polishing mounted points with shaft diameter 2,35 mm using SIC grain in sizes 240 or 400 in a silicon bond. These small tools are very soft and are exceptionally suited for the polishing of jewellery and other small parts.

A summary of available shapes

Shape	Type	Shape (Lukas)	Available product range
	Cylindrical, Typ 1	ZY	P1, P2, P3, P5, P6
	Cylindrical, Typ 2	ZY2	P1, P2
	Spherical	KE	P1, P2, P3
	Conical	KU	P1, P2, P3, P5
	Arch pointed nose	SP	P2, P3, P5
	Cylindrical round nose	WR	P1, P2
	Wheel	SE1	P3, P6
	Roll	PW	P6
	Stick	SF, SR, SV	P4
	Disc	R	P7
	Lense	L	P7



Quality and application P1

These polishing points are available in one grit combination only. The surface finish is similar to a finish with grit size 100. The hard-rubber bond makes these points particularly suitable for finishing castings, hard and soft tool steels and also alloyed steel. There is


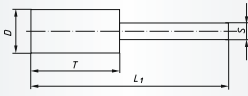

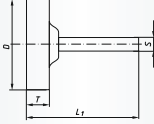
no loading with these points. If applied with low pressure, they have a long and economical tool life.



Industry

Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2600004083

 <p>Type 1</p>		<p>Packing unit: Shank 3 mm = 20 pcs. per type, Shank 6 mm = 10 pcs. per type Further dimensions on request v_{max}: 50 m/s</p>
 <p>Type 2</p>		

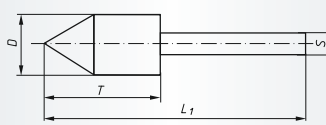
Description	Type	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for								
P1ZY 0408.03	1	4	8	3	38	A2600004083	1	2	3	4	5	7			■
P1ZY 0510.03	1	5	10	3	40	A2600005103	1	2	3	4	5	7			■
P1ZY 0610.03	1	6	10	3	40	A2600006103	1	2	3	4	5	7			■
P1ZY 0710.03	1	7	10	3	40	A2600007103	1	2	3	4	5	7			■
P1ZY 0810.03	1	8	10	3	40	A2600008103	1	2	3	4	5	7			■
P1ZY 0816.06	1	8	16	6	56	A2600008166	1	2	3	4	5	7			■
P1ZY 0820.06	1	8	20	6	60	A2600008206	1	2	3	4	5	7			■
P1ZY 1010.03	1	10	10	3	40	A2600010103	1	2	3	4	5	7			■
P1ZY 1013.03	1	10	13	3	43	A2600010133	1	2	3	4	5	7			■
P1ZY 1016.03	1	10	16	3	46	A2600010163	1	2	3	4	5	7			■
P1ZY 1020.06	1	10	20	6	60	A2600010206	1	2	3	4	5	7			■
P1ZY 1303.03	2	13	3	3	33	A2607013033	1	2	3	4	5	7			■
P1ZY 1313.03	1	13	13	3	43	A2600013133	1	2	3	4	5	7			■
P1ZY 1316.03	1	13	16	3	46	A2600013163	1	2	3	4	5	7			■
P1ZY 1320.06	1	13	20	6	60	A2600013206	1	2	3	4	5	7			■
P1ZY 1604.03	2	16	4	3	34	A2607016043	1	2	3	4	5	7			■
P1ZY 1616.03	1	16	16	3	46	A2600016163	1	2	3	4	5	7			■
P1ZY 1620.06	1	16	20	6	60	A2600016206	1	2	3	4	5	7			■
P1ZY 1632.06	1	16	32	6	72	A2600016326	1	2	3	4	5	7			■
P1ZY 2006.03	2	20	6	3	36	A2607020063	1	2	3	4	5	7			■
P1ZY 2020.06	1	20	20	6	60	A2600020206	1	2	3	4	5	7			■
P1ZY 2032.06	1	20	32	6	72	A2600020326	1	2	3	4	5	7			■
P1ZY 3210.06	2	32	10	6	50	A2607032106	1	2	3	4	5	7			■
P1ZY 3216.06	1	32	16	6	56	A2600032166	1	2	3	4	5	7			■
P1ZY 4020.06	1	40	20	6	60	A2600040206	1	2	3	4	5	7			■



Industry

Shape KS, conical pointed nose (according to DIN 69170)

Ordering example: A2602016326



Packing unit:

10 pcs. per type

Further dimensions on request

$v_{max.}$: 50 m/s

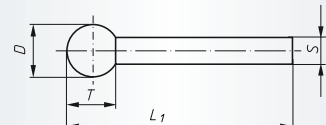
Description	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for
P1KS 1632.06	16	32	6	72	A2602016326	1 2 3 4 5 7



Industry

Shape KU, Spherical (according to DIN 69170)

Ordering example: A2605008083



Packing unit:

Shank 3 mm = 20 pcs. per type,

Shank 6 mm = 10 pcs. per type

Further dimensions on request

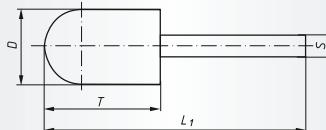
$v_{max.}$: 50 m/s

Description	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for
P1KU 0808.03	8	8	3	38	A2605008083	1 2 3 4 5 7
P1KU 1616.06	16	16	6	55	A2605016166	1 2 3 4 5 7



Industry

Shape WR, Cylindrical round nose (according to DIN 69170)



Packing unit:

10 pcs. per type

$v_{max.}$: 50 m/s

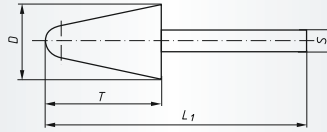
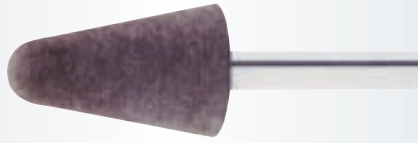
						available on request
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Industry

Shape KE, Conical round nose (according to DIN 69170)

Ordering example: A2609020326



Packing unit:
10 pcs. per type
Further dimensions on request
 $v_{max.}$: 50 m/s

Description	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P1KE 2032.06	20	32	6	72	A2609020326	1 2 3 4 5 7	■



Industry

Assortment, Polishing points, 114

Ordering example: A2600114



Packing unit:
1 pc. per type
Further dimensions on request
 $v_{max.}$: 50 m/s

Description	Contents	1 piece each	Product-Number	recommended for	
Assortment 114	14-pieces	P1ZY 0408.03; P1ZY 0510.03; P1ZY 0610.03; P1ZY 0710.03; P1ZY 0810.03; P1ZY 1010.03; P1ZY 1013.03; P1ZY 1016.03; P1ZY 1303.03; P1ZY 1313.03; P1ZY 1316.03; P1ZY 1604.03; P1ZY 1616.03; P1ZY 2006.03	A2600114	1 2 3 4 5 7	■

Specification and application P2

The polishing mounted points of this group are available in the five grit sizes as detailed below, and are available in a variety of shapes and sizes. They are colour coded to prevent any confusion and to avoid any errors in the polishing process. The soft rubber bonding allows for a very soft grinding effect. Polishing points of this group P2 are mainly used on a pre-machined surface where a fine

polished finish is required. Polishing wheels in this group are also available with a max. diameter 200mm. Exact dimensions and prices are available on request.

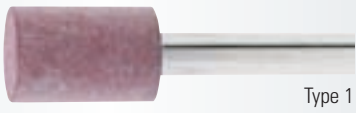
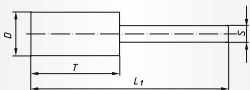

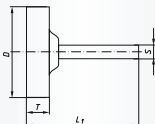
					
Color	black	pale grey	red	brown	green
Grit size	46	80	120	220	280



Industry

Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610004083080

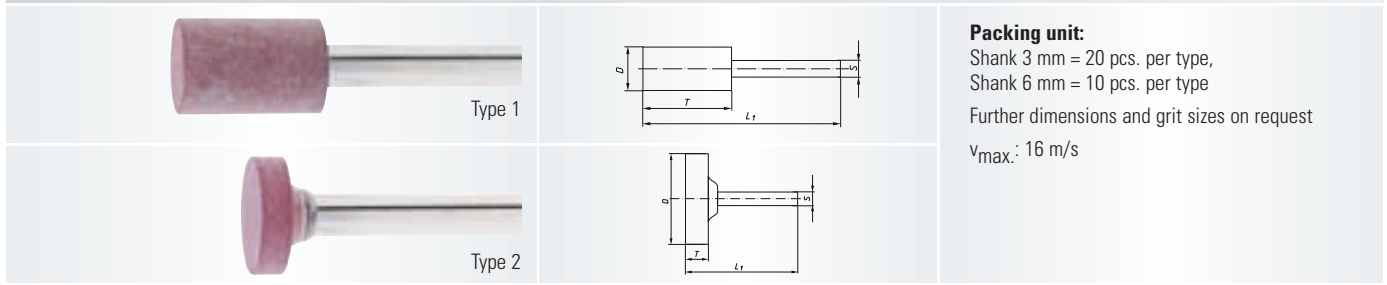
		Packing unit: Shank 3 mm = 20 pcs. per type, Shank 6 mm = 10 pcs. per type Further dimensions and grit sizes on request $v_{max.}: 16 \text{ m/s}$
		

Description	Grit	Type	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for
P2ZY 0408.03	80	1	4	8	3	38	A2610004083080	1 2 3 4 5 6 7 8
P2ZY 0408.03	120	1	4	8	3	38	A2610004083120	1 2 3 4 5 6 7 8
P2ZY 0408.03	220	1	4	8	3	38	A2610004083220	1 2 3 4 5 6 7 8
P2ZY 0408.03	280	1	4	8	3	38	A2610004083280	1 2 3 4 5 6 7 8
P2ZY 0510.03	80	1	5	10	3	40	A2610005103080	1 2 3 4 5 6 7 8
P2ZY 0510.03	120	1	5	10	3	40	A2610005103120	1 2 3 4 5 6 7 8
P2ZY 0510.03	220	1	5	10	3	40	A2610005103220	1 2 3 4 5 6 7 8
P2ZY 0510.03	280	1	5	10	3	40	A2610005103280	1 2 3 4 5 6 7 8
P2ZY 0610.03	80	1	6	10	3	40	A2610006103080	1 2 3 4 5 6 7 8
P2ZY 0610.03	120	1	6	10	3	40	A2610006103120	1 2 3 4 5 6 7 8
P2ZY 0610.03	220	1	6	10	3	40	A2610006103220	1 2 3 4 5 6 7 8
P2ZY 0610.03	280	1	6	10	3	40	A2610006103280	1 2 3 4 5 6 7 8
P2ZY 0810.03	46	1	8	10	3	40	A2610008103046	1 2 3 4 5 6 7 8



Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610008103080



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

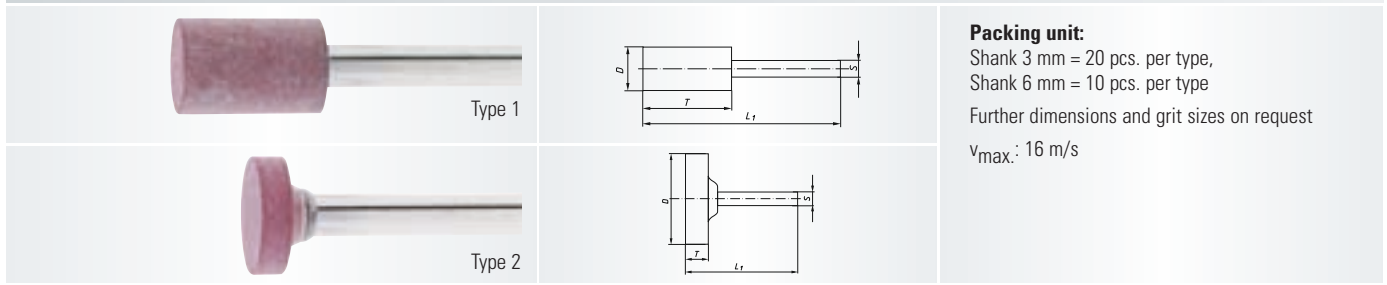
v_{max.}: 16 m/s

Description	Grit	Type	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2ZY 0810.03	80	1	8	10	3	40	A2610008103080	1 2 3 4 5 6 7 8	■
P2ZY 0810.03	120	1	8	10	3	40	A2610008103120	1 2 3 4 5 6 7 8	■
P2ZY 0810.03	220	1	8	10	3	40	A2610008103220	1 2 3 4 5 6 7 8	■
P2ZY 0810.03	280	1	8	10	3	40	A2610008103280	1 2 3 4 5 6 7 8	■
P2ZY 0816.06	80	1	8	16	6	56	A2610008166080	1 2 3 4 5 6 7 8	■
P2ZY 0816.06	120	1	8	16	6	56	A2610008166120	1 2 3 4 5 6 7 8	■
P2ZY 0816.06	220	1	8	16	6	56	A2610008166220	1 2 3 4 5 6 7 8	■
P2ZY 0816.06	280	1	8	16	6	56	A2610008166280	1 2 3 4 5 6 7 8	■
P2ZY 1010.03	46	1	10	10	3	40	A2610010103046	1 2 3 4 5 6 7 8	■
P2ZY 1010.03	80	1	10	10	3	40	A2610010103080	1 2 3 4 5 6 7 8	■
P2ZY 1010.03	120	1	10	10	3	40	A2610010103120	1 2 3 4 5 6 7 8	■
P2ZY 1010.03	220	1	10	10	3	40	A2610010103220	1 2 3 4 5 6 7 8	■
P2ZY 1010.03	280	1	10	10	3	40	A2610010103280	1 2 3 4 5 6 7 8	■
P2ZY 1020.06	80	1	10	20	6	60	A2610010206080	1 2 3 4 5 6 7 8	■
P2ZY 1020.06	120	1	10	20	6	60	A2610010206120	1 2 3 4 5 6 7 8	■
P2ZY 1020.06	220	1	10	20	6	60	A2610010206220	1 2 3 4 5 6 7 8	■
P2ZY 1020.06	280	1	10	20	6	60	A2610010206280	1 2 3 4 5 6 7 8	■
P2ZY 1313.03	80	1	13	13	3	43	A2610013133080	1 2 3 4 5 6 7 8	■
P2ZY 1313.03	120	1	13	13	3	43	A2610013133120	1 2 3 4 5 6 7 8	■
P2ZY 1313.03	220	1	13	13	3	43	A2610013133220	1 2 3 4 5 6 7 8	■
P2ZY 1313.03	280	1	13	13	3	43	A2610013133280	1 2 3 4 5 6 7 8	■
P2ZY 1316.03	120	1	13	16	3	46	A2610013163120	1 2 3 4 5 6 7 8	■
P2ZY 1320.06	46	1	13	20	6	60	A2610013206046	1 2 3 4 5 6 7 8	■
P2ZY 1320.06	80	1	13	20	6	60	A2610013206080	1 2 3 4 5 6 7 8	■
P2ZY 1320.06	120	1	13	20	6	60	A2610013206120	1 2 3 4 5 6 7 8	■
P2ZY 1320.06	220	1	13	20	6	60	A2610013206220	1 2 3 4 5 6 7 8	■
P2ZY 1320.06	280	1	13	20	6	60	A2610013206280	1 2 3 4 5 6 7 8	■
P2ZY 1616.03	120	1	16	16	3	46	A2610016163120	1 2 3 4 5 6 7 8	■
P2ZY 1620.06	80	1	16	20	6	60	A2610016206080	1 2 3 4 5 6 7 8	■
P2ZY 1620.06	120	1	16	20	6	60	A2610016206120	1 2 3 4 5 6 7 8	■
P2ZY 1620.06	220	1	16	20	6	60	A2610016206220	1 2 3 4 5 6 7 8	■
P2ZY 1620.06	280	1	16	20	6	60	A2610016206280	1 2 3 4 5 6 7 8	■
P2ZY 1632.06	80	1	16	32	6	72	A2610016326080	1 2 3 4 5 6 7 8	■
P2ZY 1632.06	120	1	16	32	6	72	A2610016326120	1 2 3 4 5 6 7 8	■
P2ZY 1632.06	220	1	16	32	6	72	A2610016326220	1 2 3 4 5 6 7 8	■
P2ZY 2020.06	46	1	20	20	6	60	A2610020206046	1 2 3 4 5 6 7 8	■
P2ZY 2020.06	80	1	20	20	6	60	A2610020206080	1 2 3 4 5 6 7 8	■
P2ZY 2020.06	120	1	20	20	6	60	A2610020206120	1 2 3 4 5 6 7 8	■
P2ZY 2020.06	220	1	20	20	6	60	A2610020206220	1 2 3 4 5 6 7 8	■



Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610020206280



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

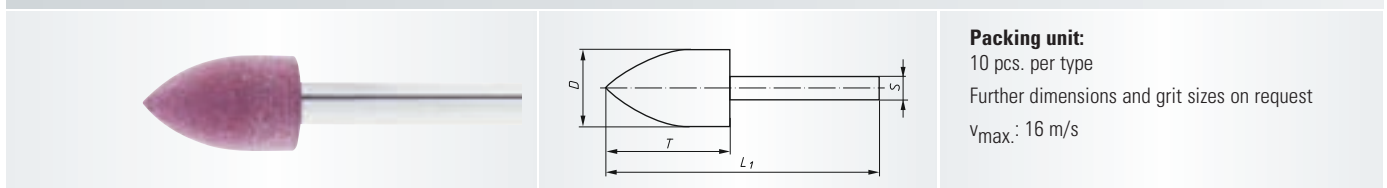
$v_{max.}$: 16 m/s

Description	Grit	Type	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2ZY 2020.06	280	1	20	20	6	60	A2610020206280	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	80	1	20	32	6	72	A2610020326080	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	120	1	20	32	6	72	A2610020326120	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	220	1	20	32	6	72	A2610020326220	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	280	1	20	32	6	72	A2610020326280	1 2 3 4 5 6 7 8	■
P2ZY 2510.06	120	2	25	10	6	50	A2617025106120	1 2 3 4 5 6 7 8	■
P2ZY 3210.06	120	2	32	10	6	50	A2617032106120	1 2 3 4 5 6 7 8	■
P2ZY 3210.06	220	2	32	10	6	50	A2617032106220	1 2 3 4 5 6 7 8	■
P2ZY 3220.06	120	1	32	20	6	60	A2610032206120	1 2 3 4 5 6 7 8	■
P2ZY 3232.06	120	1	32	32	6	72	A2610032326120	1 2 3 4 5 6 7 8	■
P2ZY 3232.06	280	1	32	32	6	72	A2610032326280	1 2 3 4 5 6 7 8	■
P2ZY 4010.06	120	2	40	10	6	50	A2617040106120	1 2 3 4 5 6 7 8	■
P2ZY 4020.06	46	1	40	20	6	60	A2610040206046	1 2 3 4 5 6 7 8	■
P2ZY 4020.06	120	1	40	20	6	60	A2610040206120	1 2 3 4 5 6 7 8	■



Shape SP, Arch pointed nose (according to DIN 69170)

Ordering example: A2611013206120



Packing unit:

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$: 16 m/s

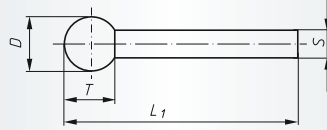
Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2SP 1320.06	120	13	20	6	60	A2611013206120	1 2 3 4 5 6 7 8	■
P2SP 2032.06	220	20	32	6	72	A2611020326220	1 2 3 4 5 6 7 8	■



Industry

Shape KU, Spherical (according to DIN 69170)

Ordering example: A2615008083120



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

v_{max} : 16 m/s

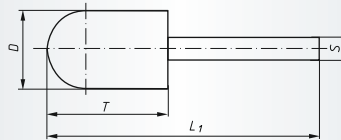
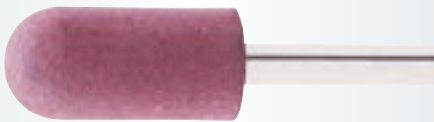
Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2KU 0808.03	120	8	8	3	38	A2615008083120	1 2 3 4 5 6 7 8	■
P2KU 1010.03	120	10	10	3	40	A2615010103120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	120	16	16	6	56	A2615016166120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	220	16	16	6	56	A2615016166220	1 2 3 4 5 6 7 8	■



Industry

Shape WR, Cylindrical round nose (according to DIN 69170)

Ordering example: A2618016326120



Packing unit:

10 pcs. per type

Further dimensions and grit sizes on request

v_{max} : 16 m/s

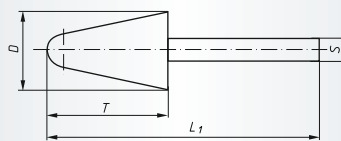
Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2WR 1632.06	120	16	32	6	72	A2618016326120	1 2 3 4 5 6 7 8	■



Industry

Shape KE, Conical round nose (according to DIN 69170)

Ordering example: A2619010206080



Packing unit:

10 pcs. per type

Further dimensions and grit sizes on request

v_{max} : 16 m/s

Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P2KE 1020.06	80	10	20	6	60	A2619010206080	1 2 3 4 5 6 7 8	■
P2KE 1020.06	120	10	20	6	60	A2619010206120	1 2 3 4 5 6 7 8	■

Specification and application P3

LUKAS felt polishing points are available in two specifications:

- H3 as per DIN 61200
- H3S super hard and particularly effective when used in conjunction with diamond paste

The optimal peripheral speed for LUKAS felt polishing points is 2–8 m/s.

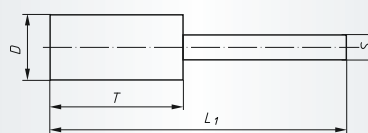
The LUKAS assortment of felt polishing tools reflects years of experience in this field and encompasses the most common shapes and sizes. Due to the extreme flexibility, felt polishing points together with LUKAS diamond paste are ideally suited for polishing exceptionally complex shapes e.g. pressure and injection moulds, drawing- press- and cutting tools, dies, bearings, spindles, rolls, gauges etc.



Industry

Shape ZY, Cylindrical

Ordering example: A3700006103



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type
Further dimensions on request

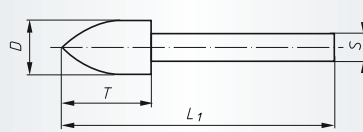
Description	Quality	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P3ZY 0610.03	H3	6	10	3	50	A3700006103	1 2 3 4 5 6 7 9	■
P3ZY 0610.03	H3-S	6	10	3	50	A37000061030001	1 2 3 4 5 6 7 9	■
P3ZY 0810.03	H3	8	10	3	50	A3700008103	1 2 3 4 5 6 7 9	■
P3ZY 0810.03	H3-S	8	10	3	50	A37000081030001	1 2 3 4 5 6 7 9	■
P3ZY 1012.03	H3	10	12	3	50	A3700010123	1 2 3 4 5 6 7 9	■
P3ZY 1012.03	H3-S	10	12	3	50	A37000101230001	1 2 3 4 5 6 7 9	■
P3ZY 1015.06	H3	10	15	6	55	A3700010156	1 2 3 4 5 6 7 9	■
P3ZY 1015.06	H3-S	10	15	6	55	A37000101560001	1 2 3 4 5 6 7 9	■
P3ZY 1215.03	H3	12	15	3	55	A3700012153	1 2 3 4 5 6 7 9	■
P3ZY 1215.03	H3-S	12	15	3	55	A37000121530001	1 2 3 4 5 6 7 9	■
P3ZY 1220.06	H3	12	20	6	60	A3700012206	1 2 3 4 5 6 7 9	■
P3ZY 1220.06	H3-S	12	20	6	60	A37000122060001	1 2 3 4 5 6 7 9	■
P3ZY 1620.06	H3	16	20	6	60	A3700016206	1 2 3 4 5 6 7 9	■
P3ZY 2025.06	H3	20	25	6	65	A3700020256	1 2 3 4 5 6 7 9	■
P3ZY 2025.06	H3-S	20	25	6	65	A37000202560001	1 2 3 4 5 6 7 9	■
P3ZY 2530.06	H3	25	30	6	70	A3700025306	1 2 3 4 5 6 7 9	■
P3ZY 3040.06	H3	30	40	6	80	A3700030406	1 2 3 4 5 6 7 9	■



Industry

Shape SP, Arch pointed nose

Ordering example: A3701006103



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type
Further dimensions on request

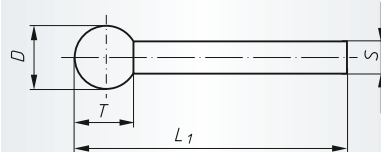
Description	Quality	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P3SP 0610.03	H3	6	10	3	50	A3701006103	1 2 3 4 5 6 7 9	■
P3SP 0810.03	H3	8	10	3	50	A3701008103	1 2 3 4 5 6 7 9	■
P3SP 1012.03	H3	10	12	3	52	A3701010123	1 2 3 4 5 6 7 9	■
P3SP 1015.06	H3	10	15	6	55	A3701010156	1 2 3 4 5 6 7 9	■
P3SP 1220.06	H3	12	20	6	60	A3701012206	1 2 3 4 5 6 7 9	■
P3SP 2025.06	H3	20	25	6	65	A3701020256	1 2 3 4 5 6 7 9	■
P3SP 2530.06	H3	25	30	6	70	A3701025306	1 2 3 4 5 6 7 9	■
P3SP 3040.06	H3	30	40	6	80	A3701030406	1 2 3 4 5 6 7 9	■



Industry

Shape KU, Spherical

Ordering example: A3703006063



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type
Further dimensions on request

Description	Quality	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P3KU 0605.03	H3	6	5,5	3	45	A3703006063	1 2 3 4 5 6 7 9	■
P3KU 0807.03	H3	8	7,5	3	50	A3703008083	1 2 3 4 5 6 7 9	■
P3KU 1009.03	H3	10	9	3	50	A3703010103	1 2 3 4 5 6 7 9	■
P3KU 1009.06	H3	10	9	6	50	A3703010106	1 2 3 4 5 6 7 9	■
P3KU 1211.06	H3	12	11	6	50	A3703012126	1 2 3 4 5 6 7 9	■
P3KU 2019.06	H3	20	19	6	60	A3703020206	1 2 3 4 5 6 7 9	■

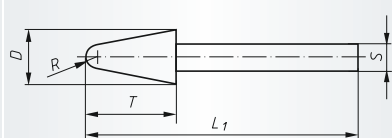
146 Felt polishing points, group P3



Industry

Shape KE, Conical round nose

Ordering example: A3705010123



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type
Further dimensions on request

Description	Quality	D mm	T mm	S mm	L ₁ mm	R mm	Product-Number	recommended for	
P3KE 1012.03	H3	10	12	3	50	2,5	A3705010123	1 2 3 4 5 6 7 9	■
P3KE 1015.06	H3	10	15	6	55	2,5	A3705010156	1 2 3 4 5 6 7 9	■
P3KE 1015.06	H3-S	10	15	6	55	2,5	A37050101560001	1 2 3 4 5 6 7 9	■
P3KE 1620.06	H3	16	20	6	60	3	A3705016206	1 2 3 4 5 6 7 9	■
P3KE 2025.06	H3	20	25	6	65	3,5	A3705020256	1 2 3 4 5 6 7 9	■
P3KE 2530.06	H3	25	30	6	70	4,5	A3705025306	1 2 3 4 5 6 7 9	■
P3KE 3040.06	H3	30	40	6	80	6,5	A3705030406	1 2 3 4 5 6 7 9	■

Application example P3

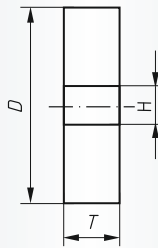




Industry

Shape S1, Wheels

Ordering example: A3750040106



Packing unit:
10 pcs. per type
Further dimensions on request

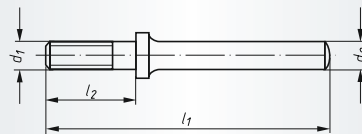
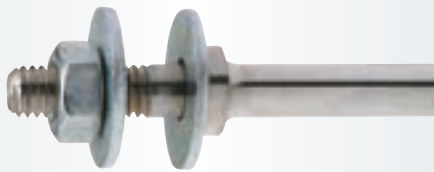
Description	Quality	D mm	T mm	H mm	Product-Number	recommended for	
P3S1 4010.06	H3	40	10	6	A3750040106	1 2 3 4 5 6 7 9	■
P3S1 5010.06	H3	50	10	6	A3750050106	1 2 3 4 5 6 7 9	■
P3S1 5020.06	H3	50	20	6	A3750050206	1 2 3 4 5 6 7 9	■
P3S1 6010.06	H3	60	10	6	A3750060106	1 2 3 4 5 6 7 9	■
P3S1 6020.06	H3	60	20	6	A3750060206	1 2 3 4 5 6 7 9	■



Industry

Arbors for felt polishing wheels

Ordering example: A1630780



Packing unit:
5 pcs. per type
The delivery includes for each stud
• 2 washers Ø 18 mm
• 2 washers Ø 30 mm
• 1 hex nut

Description	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	n max. (1/min)	Product-Number	
ASB 780	M6	20	6	63	7.000	A1630780	■
ASB 781	M6	30	6	73	7.000	A1630781	■

Specification and application of diamond paste

Type	Quality	Recommended applications
Super-M	oil/alcohol soluble, medium concentration, HP diamond grit	for the occasional use as first and second polishing stages on hard materials
Super-W	oil/alcohol soluble, higher concentration, HP diamond grit	for the more frequent polishing operations on hard materials – from the second polishing stage
Super-F	oil/alcohol soluble, high concentration, HP diamond grit, high percentage of the same mesh size	for regular polishing on hard materials – where a reduction in the polishing cycle time is required – on extremely hard surface coatings – from the second polishing stage

List of grit sizes

Grit Size	Application	Tool material	Cutting speed
30 μ 23 μ 15 μ	Fine polish	Steel, cast iron, bronze, brass, copper, safety glass, laminated wood, plywood	v = 1–3 m/s
9 μ	Pre-polish	Cast iron, bronze, brass, copper, safety glass, laminated wood, plywood, hardwood	v = 1–3 m/s
6 μ 3 μ 1 μ 0,25 μ	Mirror polish	Soft wood, felt (hard or soft), paper, cotton wool	v = 5–20 m/s

Examples of diamond pastes and diamond sprays





Industry

Grinding compound

Ordering example: A3760120



Packing unit:
1 pc. per type
Contents: 250 g

Description	Quality	Grit	µm	Product-Number	recommended for	
SP-1	medium	120	88 – 125	A3760120	1 2 3 4 5 6 7	■
SP-2	fine	180	55 – 88	A3760180	1 2 3 4 5 6 7	■
SP-3	very fine	320	20 – 40	A3760320	1 2 3 4 5 6 7	■

Ingredient: silicon carbide paste, oil-soluble, can be used with thinners, cleaned with oil, spirit or petrol.

Application: For polishing pre-ground surfaces; particularly suited for hard metallic surfaces e.g. steel, iron, cast iron, bronze, brass and copper



Industry

Diamond pastes

Ordering example: A34105062



Packing unit:
1 pc. per type
Contents: 5 g

Description	Quality	Grit µ	Color of paste	Product-Number	recommended for	
M-062	Super-M	3	green	A34105062	1 2 3 4 5 6 7 9	■
M-063	Super-M	6	yellow	A34105063	1 2 3 4 5 6 7 9	■
M-064	Super-M	9	red	A34105064	1 2 3 4 5 6 7 9	■
M-065	Super-M	15	pale brown	A34105065	1 2 3 4 5 6 7 9	■
M-066	Super-M	30	dark brown	A34105066	1 2 3 4 5 6 7 9	■
W-082	Super-W	3	green	A34103082	1 2 3 4 5 6 7 9	■
W-083	Super-W	6	yellow	A34103083	1 2 3 4 5 6 7 9	■
W-084	Super-W	9	red	A34103084	1 2 3 4 5 6 7 9	■
W-085	Super-W	15	pale brown	A34103085	1 2 3 4 5 6 7 9	■
F-091	Super-F	1	blau	A34101091	1 2 3 4 5 6 7 9	■
F-092	Super-F	3	green	A34101092	1 2 3 4 5 6 7 9	■
F-093	Super-F	6	yellow	A34101093	1 2 3 4 5 6 7 9	■
F-094	Super-F	9	red	A34101094	1 2 3 4 5 6 7 9	■
F-095	Super-F	15	pale brown	A34101095	1 2 3 4 5 6 7 9	■

150 Diamond sprays and thinner



Industry

Diamond sprays

Ordering example: A34104070



Packing unit:
1 pc. per type
Contents: 150 ml = 126 g

Description	Grit μ	Color	Product-Number	recommended for	
GS-070	0,25	pale grey	A34104070	1 2 3 4 5 6 7 9	■
GS-071	1	blue	A34104071	1 2 3 4 5 6 7 9	■
GS-072	3	green	A34104072	1 2 3 4 5 6 7 9	■
GS-073	6	yellow	A34104073	1 2 3 4 5 6 7 9	■
GS-074	9	red	A34104074	1 2 3 4 5 6 7 9	■



Industry

Thinner

Ordering example: A341063003



Packing unit:
1 pc. per type
Contents: 100 ml

Description	Color	Product-Number	recommended for	
MWF 3003	green	A341063003	1 2 3 4 5 6 7 9	■

Specification and application P4

Tools within this group are bonded with polyurethane (PU) and are manufactured in various hardnesses. They contain a mixture of abrasive grain (aluminium oxide, silicon carbide) and fillers. To optically differentiate between qualities, these tools are colour coded. Products in this group have a relatively dense structure.

Pores resulting from the manufacturing process are of no detriment. A range of flexibility from soft to hard relating to the cross section are available. These polishing sticks are mainly used manually for mould manufacture.

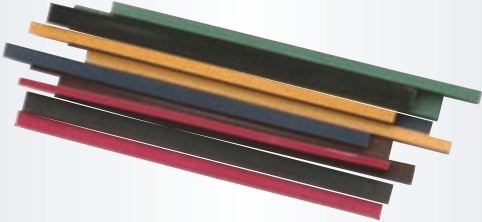
Color	Qualities	Color	Qualities	Color	Qualities
pale grey	SIC 80 soft	pale green	SIC 240 soft	pale red	EKW 150 soft
grey	SIC 80 hard	green	SIC 240 hard	red	EKW 150 hard
pale blue	SIC 150 soft	beige	EKW 80 soft	pale brown	EKW 240 soft
blue	SIC 150 hard	dark beige	EKW 80 hard	brown	EKW 240 hard



Industry

Polishing sticks, flat

Ordering example: P4SF 0612.070 SIC 80 soft



Packing unit:
10 pcs. per type
Further dimensions on request
All items are available within a few days
ex-intermediate stock.

Description	H mm	B mm	L mm			recommended for	
P4SF 0612.070	6	12	70			1 2 3 4 5 6 7	▲
P4SF 0612.140	6	12	140			1 2 3 4 5 6 7	▲
P4SF 0816.070	8	16	70			1 2 3 4 5 6 7	▲
P4SF 0816.140	8	16	140			1 2 3 4 5 6 7	▲
P4SF 0816.210	8	16	210			1 2 3 4 5 6 7	▲
P4SF 1020.070	10	20	70			1 2 3 4 5 6 7	▲
P4SF 1020.140	10	20	140			1 2 3 4 5 6 7	▲
P4SF 1020.210	10	20	210			1 2 3 4 5 6 7	▲
P4SF 1020.280	10	20	280			1 2 3 4 5 6 7	▲

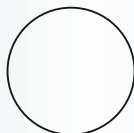
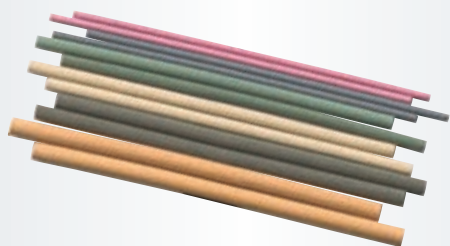
152 Polishing sticks, group P4



Industry

Polishing sticks, round

Ordering example: P4SR 0006.070 EKW 80 hard



Packing unit:

10 pcs. per type

Further dimensions on request

All items are available within a few days ex-intermediate stock.

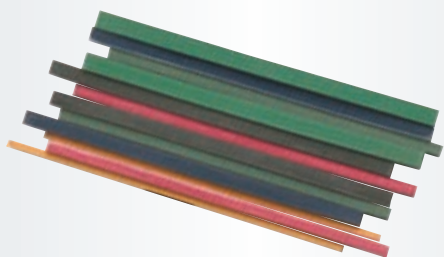
Description	Ø mm	L mm	recommended for							
P4SR 0006.070	6	70								▲
P4SR 0006.140	6	140								▲
P4SR 0010.070	10	70								▲
P4SR 0010.140	10	140								▲
P4SR 0010.210	10	210								▲
P4SR 0012.070	12	70								▲
P4SR 0012.140	12	140								▲
P4SR 0012.210	12	210								▲
P4SR 0012.280	12	280								▲
P4SR 0015.070	15	70								▲
P4SR 0015.140	15	140								▲
P4SR 0015.210	15	210								▲
P4SR 0015.280	15	280								▲



Industry

Polishing sticks, square

Ordering example: P4SV 0606.070 SIC 80 hard



Packing unit:

10 pcs. per type

Further dimensions on request

All items are available within a few days ex-intermediate stock.

Description	H mm	B mm	L mm	recommended for							
P4SV 0606.070	6	6	70								▲
P4SV 0606.140	6	6	140								▲
P4SV 1010.070	10	10	70								▲
P4SV 1010.140	10	10	140								▲
P4SV 1010.210	10	10	210								▲
P4SV 1212.140	12	12	140								▲
P4SV 1212.210	12	12	210								▲
P4SV 1515.070	15	15	70								▲
P4SV 1515.140	15	15	140								▲
P4SV 1515.210	15	15	210								▲
P4SV 1515.280	15	15	280								▲

Specification and application P5

The polishing points of this group are characterized by their special structure and bonding i.e. fibre reinforced. This makes them ideally suited for fine finishing of aluminium and associated alloys, non-ferrous metals and low and high alloyed steels.

Due to the fibre reinforcement, these tools have exceptional edge-retention capabilities and resilience. Polishing points in group P5 are available in grit sizes detailed below; they are identified with a red marking.

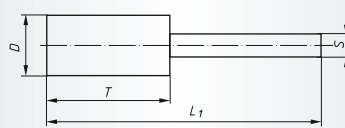
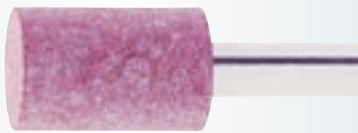
			
Color	black	pale grey	red
Grit	46	80	120



Industry

Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620004083080



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

v_{max} : 50 m/s

Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P5ZY 0408.03	80	4	8	3	38	A2620004083080	1 2 3 4 5 6 7	■
P5ZY 0408.03	120	4	8	3	38	A2620004083120	1 2 3 4 5 6 7	■
P5ZY 0510.03	80	5	10	3	40	A2620005103080	1 2 3 4 5 6 7	■
P5ZY 0510.03	120	5	10	3	40	A2620005103120	1 2 3 4 5 6 7	■
P5ZY 0610.03	80	6	10	3	40	A2620006103080	1 2 3 4 5 6 7	■
P5ZY 0610.03	120	6	10	3	40	A2620006103120	1 2 3 4 5 6 7	■
P5ZY 0810.03	80	8	10	3	40	A2620008103080	1 2 3 4 5 6 7	■
P5ZY 0810.03	120	8	10	3	40	A2620008103120	1 2 3 4 5 6 7	■
P5ZY 0816.06	46	8	16	6	56	A2620008166046	1 2 3 4 5 6 7	■
P5ZY 0816.06	80	8	16	6	56	A2620008166080	1 2 3 4 5 6 7	■
P5ZY 0816.06	120	8	16	6	56	A2620008166120	1 2 3 4 5 6 7	■
P5ZY 1010.03	80	10	10	3	40	A2620010103080	1 2 3 4 5 6 7	■
P5ZY 1010.03	120	10	10	3	40	A2620010103120	1 2 3 4 5 6 7	■
P5ZY 1020.06	46	10	20	6	60	A2620010206046	1 2 3 4 5 6 7	■
P5ZY 1020.06	80	10	20	6	60	A2620010206080	1 2 3 4 5 6 7	■
P5ZY 1020.06	120	10	20	6	60	A2620010206120	1 2 3 4 5 6 7	■
P5ZY 1313.03	120	13	13	3	43	A2620013133120	1 2 3 4 5 6 7	■
P5ZY 1316.03	80	13	16	3	46	A2620013163080	1 2 3 4 5 6 7	■
P5ZY 1320.06	80	13	20	6	60	A2620013206080	1 2 3 4 5 6 7	■

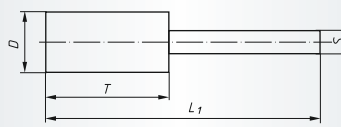
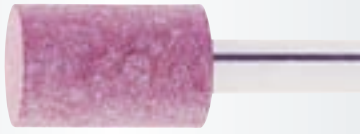
154 Polishing points, group P5



Industry

Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620013206080



Packing unit:

Shank 3 mm = 20 pcs. per type,
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request
 $v_{max.}$: 50 m/s

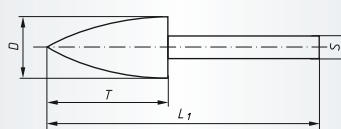
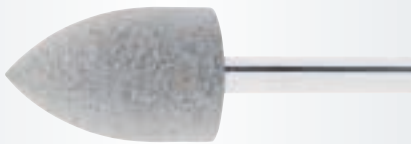
Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P5ZY 1320.06	120	13	20	6	60	A2620013206120	1 2 3 4 5 6 7	■
P5ZY 1620.06	80	16	20	6	60	A2620016206080	1 2 3 4 5 6 7	■
P5ZY 1620.06	120	16	20	6	60	A2620016206120	1 2 3 4 5 6 7	■
P5ZY 1632.06	46	16	32	6	72	A2620016326046	1 2 3 4 5 6 7	■
P5ZY 1632.06	80	16	32	6	72	A2620016326080	1 2 3 4 5 6 7	■
P5ZY 2020.06	80	20	20	6	60	A2620020206080	1 2 3 4 5 6 7	■
P5ZY 2032.06	46	20	32	6	72	A2620020326046	1 2 3 4 5 6 7	■
P5ZY 2032.06	120	20	32	6	72	A2620020326120	1 2 3 4 5 6 7	■
P5ZY 3232.06	80	32	32	6	72	A2620032326080	1 2 3 4 5 6 7	■
P5ZY 4016.06	120	40	16	6	56	A2620040166120	1 2 3 4 5 6 7	■



Industry

Shape SP, Arch pointed nose (according to DIN 69170)

Ordering example: A2621020326080



Packing unit:

10 pcs. per type

Further dimensions and grit sizes on request
 $v_{max.}$: 50 m/s

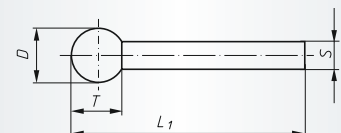
Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P5SP 2032.06	80	20	32	6	72	A2621020326080	1 2 3 4 5 6 7	■



Industry

Shape KU, Spherical (according to DIN 69170)

Ordering example: A2625008083080



Packing unit:

20 pcs. per type

Further dimensions and grit sizes on request
 $v_{max.}$: 50 m/s

Description	Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P5KU 0808.03	80	8	8	3	38	A2625008083080	1 2 3 4 5 6 7	■

Specification and application P6

Products in group P6 are manufactured with a polyurethane bond (PU) in different hardnesses.

These tools

- can be easily profiled
- quickly generate an excellent surface finish
- produce little heat during the polishing process
- do not load
- require no dressing
- contain no softener
- do not increase in hardness after long storage
- are ideal for both stationary and manual application

These polishing tools are used to improve surface finish and geometry. The main applications are the polishing and finishing of steel, brass, precious metals, sintered metals and plastic. The product range includes polishing points, marbling wheels, rolls for satin finishes, and wheels from 60 mm to 300 mm diameter. They can be used with or without coolant.

When wet polishing, the coolant must be maintained at a neutral (ph) value. For dressing, a dressing stick (page 124) or diamond dressing tool can be used.

Due to long tool life and a good edge retention, the tools are ideally suited for automated processes e.g. centerless polishing of tubes or marbling of high alloyed steel plates.

The following grades are available:

WP = soft, very flexible

MWP = medium to soft

MP = medium for general application

HP = hard, resilient for flat surfaces

SHP = super hard, for stationary applications

The bonding is mixed with silicon carbide „SIC“ or aluminium oxide „A“ grain in the FEPA grit sizes 24 to 400.

Application examples marbling points P6



Application recommendations polishing tools P6

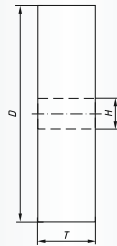
	Removing rust, cleaning, tarnish removal	Cylindrical and surface grinding	Sharpening, dressing	Marbling, matt finishing		Deburring, cleaning up and rounding off				Burnishing				Pre-finishing				Polishing	
	MWP	SHP	SHP	WP	MWP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP
Gold, silver Nickel, aluminium Copper Brass																		400	400
														240	240				
												150		150					
												120	120						
						80			80	80		80							
					46	46				46		46							
Constructional steel	46																		
Stainless steel, titanium			400															400	400
			240												240	240			240
									150			150			150	150			
			120								120	120			120				
			80		80	80	80		80	80	80	80	80						
					46		46				46	46	46	46					
				24					24										
Hardened steel, Carbide		240															240		
		150											150						
		120											120						
		80					80												
							46												
Glass															400				
															240				
															150				
							80												
Rubber																		46	
Wood																		80	
Paint	46																		
Solder	240																		
Tin																			80
																			46

Grit sizes



Polishing Wheels, Form SE1

Ordering example: A29100600060041



Packing unit:

1 pc. per type

Further dimensions and grit sizes on request

v_{max} : MWP = 20 m/s

WP = 16 m/s

SHP = 32 m/s

Description	Quality/ Grit	D mm	T mm	H mm	Product-Number	recommended for	
P6SE1 06006 B.06	SC 80 MWP	60	6	6	A29100600060041	1 2 3 4 5 6 7 9	■
P6SE1 06006 B.06	SC 150 MWP	60	6	6	A29100600060061	1 2 3 4 5 6 7 9	■
P6SE1 10010 B.25	SC 80 MWP	100	10	25	A29101000100041	1 2 3 4 5 6 7 9	■
P6SE1 10010 B.25	SC 150 MWP	100	10	25	A29101000100061	1 2 3 4 5 6 7 9	■
P6SE1 10020 B.25	SC 46 MWP	100	20	25	A29101000200021	1 2 3 4 5 6 7 9	■
P6SE1 10020 B.25	SC 80 MWP	100	20	25	A29101000200041	1 2 3 4 5 6 7 9	■
P6SE1 10020 B.25	SC 150 MWP	100	20	25	A29101000200061	1 2 3 4 5 6 7 9	■
P6SE1 10020 B.25	SC 400 MWP	100	20	25	A29101000200091	1 2 3 4 5 6 7 9	■
P6SE1 12510 B.25	SC 80 MWP	125	10	25	A29101250100041	1 2 3 4 5 6 7 9	■
P6SE1 12510 B.25	SC 150 MWP	125	10	25	A29101250100061	1 2 3 4 5 6 7 9	■
P6SE1 12520 B.25	SC 80 MWP	125	20	25	A29101250200041	1 2 3 4 5 6 7 9	■
P6SE1 12520 B.25	SC 150 MWP	125	20	25	A29101250200061	1 2 3 4 5 6 7 9	■
P6SE1 15010 B.25	SC 150 MWP	150	20	25	A29101500100061	1 2 3 4 5 6 7 9	■
P6SE1 15010 B.25	SC 150 SHP	150	10	25	A29101500100069	1 2 3 4 5 6 7 9	■
P6SE1 15015 B.20	SC 120 SHP	150	15	20	A29101500150059	1 2 3 4 5 6 7 9	■
P6SE1 15020 B.25	SC 80 MWP	150	20	25	A29101500200041	1 2 3 4 5 6 7 9	■
P6SE1 15020 B.25	SC 150 MWP	150	20	25	A29101500200061	1 2 3 4 5 6 7 9	■
P6SE1 15020 B.25	SC 80 WP	150	20	25	A29101500200040	1 2 3 4 5 6 7 9	■
P6SE1 15025 B.20	SC 46 MWP	150	25	20	A29101500250021	1 2 3 4 5 6 7 9	■
P6SE1 15025 B.25	SC 150 MWP	150	25	25	A29101500250061	1 2 3 4 5 6 7 9	■
P6SE1 15025 B.25	SC 80 WP	150	25	25	A29101500250040	1 2 3 4 5 6 7 9	■
P6SE1 17520 B.25	SC 80 MWP	175	20	25	A29101750200041	1 2 3 4 5 6 7 9	■
P6SE1 17520 B.25	SC 150 MWP	175	20	25	A29101750200061	1 2 3 4 5 6 7 9	■
P6SE1 20025 B.25	SC 80 MWP	200	25	25	A29102000250041	1 2 3 4 5 6 7 9	■
P6SE1 20025 B.25	SC 150 MWP	200	25	25	A29102000250061	1 2 3 4 5 6 7 9	■
P6SE1 20025 B.32	SC 46 MP	200	25	32	A29102000250024	1 2 3 4 5 6 7 9	■

These polishing wheels are supplied in a medium bond in the two grit sizes 80 and 150. Upon request these polishing wheels can also be delivered with the bonding HP (v_{max} 32 m/s) or MP (v_{max} 25 m/s).

Safety instructions:

Grinding and polishing wheels on stationary machines are to be used only from both sides with the appropriate flanges. The diameter of flange must be 2/3 of the wheel diameter. The flanges are provided with a recess (1–2 mm depth) up to 5–10 mm from the outer edge.

158 Mounting system for polishing wheels



Industry

Mounting system for polishing wheels

Ordering example: A6981008000




Packing unit:
1 pc. per type


Description	Product-Number		
Mounting system MCA + K25	A6981008000		■

The mounting system for polishing wheels consists of a plastic sleeve (MCA) and a mounting arbor with 8 mm diameter shaft (K25) which is solely applicable to shape SE1 in the dimensions 10010 B 25 and 10020 B 25. It is not permitted to use this

mounting system for polishing wheels with larger diameters. Maximum peripheral wheel speed using this mounting method is 10m/s; this means a maximum spindle speed of 1900 R.P.M. with a wheel diameter of 100 mm.



Always the right tool



Assortment of mounted points:
I am delighted that LUKAS now offers a special line of products for retailers. Amazing packaging with most of fast moving tools to work steel and stainless steel.

Andrea Bittner
Sales Department

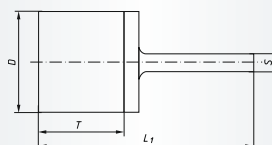
www.lukas-erzett.com



Industry

Marbling points, Shape ZY, Cylinder

Ordering example: A29200200306021



Packing unit:

1 pc. per type

Further dimensions and grit sizes on request

v_{max}: 10 m/s

Description	Quality/ Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P6MA ZY 2030.06	SC 46 MWP	20	30	6	65	A29200200306021	1 2 3 4 5 6 7 9	■
P6MA ZY 3030.06	SC 46 MWP	30	30	6	65	A29200300306021	1 2 3 4 5 6 7 9	■
P6MA ZY 4030.06	SC 46 MWP	40	30	6	65	A29200400306046	1 2 3 4 5 6 7 9	■
P6MA ZY 5030.06	SC 46 MWP	50	30	6	65	A29200500306046	1 2 3 4 5 6 7 9	■
P6MA ZY 6030.06	SC 46 MWP	60	30	6	65	A29200600306046	1 2 3 4 5 6 7 9	■

The marbling points can be used to work stainless steels, aluminium and non-ferrous metals (peacock-eye, clouds).

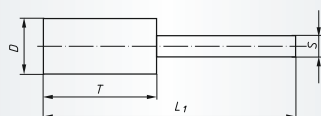
The marbling points do not load with abrasive dust and their quality lasts up to the plastic cap.



Industry

Polishing points, Shape ZY, Cylindrical

Ordering example: A29300160203028



Packing unit:

10 pcs. per type

Further dimensions and grit sizes on request

v_{max}: 20 m/s

Description	Quality/ Grit	D mm	T mm	S mm	L ₁ mm	Product-Number	recommended for	
P6ZY 1320.03	SC 80 HP	13	20	3	50	A29300130203048	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 46 HP	16	20	3	50	A29300160203028	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 80 HP	16	20	3	50	A29300160203048	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 150 HP	16	20	3	50	A29300160203068	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 240 HP	16	20	3	50	A29300160203078	1 2 3 4 5 6 7 9	■
P6ZY 2020.06	SC 46 HP	20	20	6	60	A29300200206028	1 2 3 4 5 6 7 9	■
P6ZY 2020.06	SC 150 HP	20	20	6	60	A29300200206068	1 2 3 4 5 6 7 9	■
P6ZY 2520.06	SC 80 HP	25	20	6	60	A29300250206048	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 46 HP	30	30	6	70	A29300300306028	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 150 HP	30	30	6	70	A29300300306068	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 240 HP	30	30	6	70	A29300300306078	1 2 3 4 5 6 7 9	■
P6ZY 4040.06	SC 46 HP	40	40	6	80	A29300400406028	1 2 3 4 5 6 7 9	■
P6ZY 4040.06	SC 150 HP	40	40	6	80	A29300400406068	1 2 3 4 5 6 7 9	■
P6ZY 5040.06	SC 46 HP	50	40	6	80	A29300500406028	1 2 3 4 5 6 7 9	■
P6ZY 5040.06	SC 150 HP	50	40	6	80	A29300500406068	1 2 3 4 5 6 7 9	■
P6ZY 6040.06	SC 46 HP	60	40	6	80	A29300600406028	1 2 3 4 5 6 7 9	■
P6ZY 6040.06	SC 150 HP	60	40	6	80	A29300600406068	1 2 3 4 5 6 7 9	■

The polishing points are most suitable to work metal parts which are difficult or not accessible with grinding wheels.

Applications:

Bores, Hollow weldings, Moulding tools

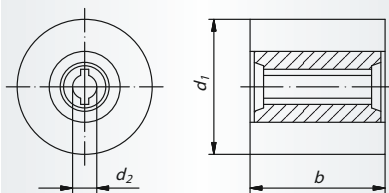
160 Polishing roll, group P6



Industry

Polishing roll, P6PW

Ordering example: A29401000500041



Packing unit:

1 pc. per type

Further dimensions and grit sizes on request

Machine to suit: ESM 1310

$v_{max.}$: 16 m/s

Description	Quality/ Grit	d ₁ mm	b mm	d ₂ mm	Product-Number	recommended for	
P6PW 100050	SC 80 MWP	100	50	19	A29401000500041	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 46 WP	100	100	19	A29401001000020	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 80 WP	100	100	19	A29401001000040	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 24 MWP	100	100	19	A29401001000011	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 46 MWP	100	100	19	A29401001000021	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 80 MWP	100	100	19	A29401001000041	1 2 3 4 5 6 7 9	■



Industry

Conditioning machine ESM 1310

Ordering example: A3995ESM1310



Packing unit:

1 pc. per type

Weight: approx. 2,9 kg

Description	Idle speed min ⁻¹	Power input W	Max. tool diameter	Tool width mm Ø mm	Hole size mm	Product-Number	
ESM 1310	1.300 - 3.050	1.300	120	100	19	A3995ESM1310	■

Specification and application P7

LUKAS polishing points, discs and lenses have been especially developed for intricate mechanical and laboratory use. Other applications include model building and jewellery production; such highly regarded tools contain a soft elastomer bond.


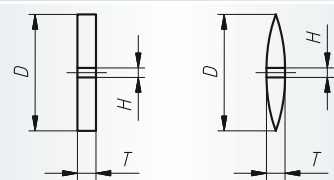


The smallest dimensions in various shapes allow for the fine machining of intricate workpieces and structures.



Industry

Polishing discs and polishing lenses in a soft elastomer bonding

Ordering example: A2950000101007


				Packing unit: 100 pcs. per type Further dimensions and grit sizes on request v_{max} : 16 m/s Suitable mounting arbors on request				
Description	Quality	Shape	D mm	T mm	H mm	Product-Number	recommended for	
P7- R22 M	SICGR 240		22	3,5	1,8	A2950000101007	1 2 3 4 5 6 7 9	■
P7- L22 M	SICGR 240		22	3,4	1,8	A2950000105007	1 2 3 4 5 6 7 9	■



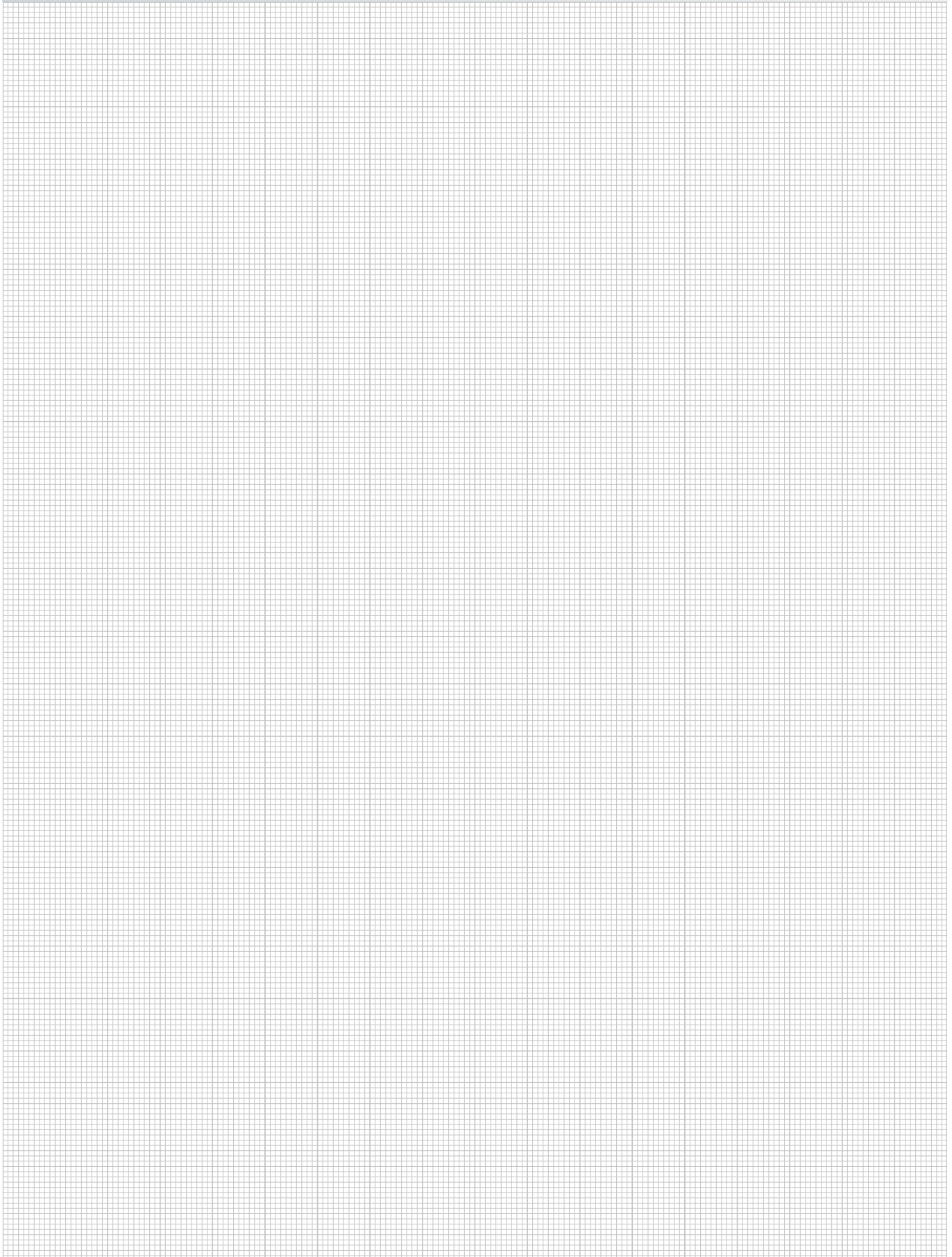
Industry

Assortment of small polishing points with soft elastomer bond mounted on shaft 2.35 mm

Ordering example: A29551301582077

		Packing unit: 1 pc. per type Individual tools available on request v_{max} : 16 m/s				
Description	Quality	Contents	Shank mm	Product-Number	recommended for	
P7-Assortment M	SICGR 240	12-pieces	2,35	A29551301582077	1 2 3 4 5 6 7 9	■
P7-Assortment F	SICGR 400	12-pieces	2,35	A29551301582071	1 2 3 4 5 6 7 9	■

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid lines are light gray and form a consistent pattern across the page.

Tungsten Carbide Granulate-tipped Tools

164 General Information

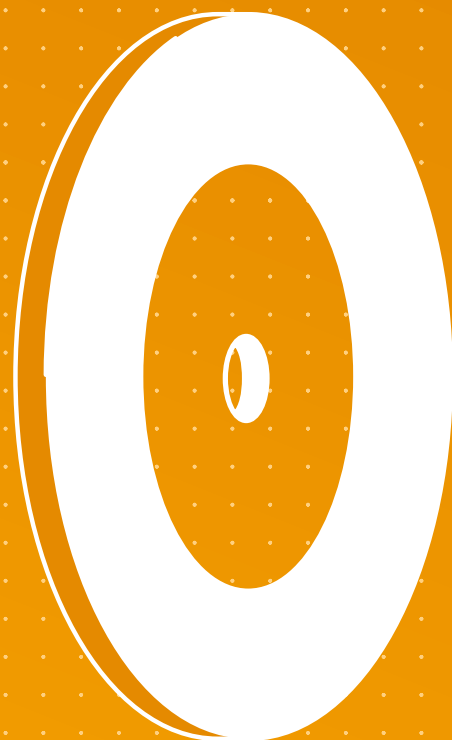
165 HGW-discs

165 HGW-core drills



Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



Technical Information

HGW is supplied in a wide range of grit sizes – very coarse to extra fine – and in both a dense or open structure. Please select the individual grit sizes from the table below.



Application examples

Coarse grit is used to grind soft materials; the harder the material, the finer the grit.
A special manufacturing process is used to bond the grit to the core.
Special coatings are available, but are dependent upon a wide variety of technical parameters. Please send your enquiry.

Safety regulations

We strongly recommend that use is made of machines with variable speeds in order to optimize cutting speeds; this will lie between 10-50 m/sec. depending on the material to be ground.



Industry

Tungsten Carbide Granulate-tipped disc, HGWT

Ordering example: A18031151E



Packing unit:
1 pc. per type
Further dimensions and grits on request

Description	Grit size	Type	Ø mm	Bore mm	n max. (1/min)	Product-Number	recommended for	
HGWT 115	0,3 – 0,5 E	dished	115	22,2	10.500	A18031151E		8 9 ■
HGWT 115	0,8 – 1,2 E	dished	115	22,2	10.500	A18031152E		8 9 ■
HGWT 115	1,2 – 1,8 E	dished	115	22,2	10.500	A18031153E		8 9 ■
HGWT 125	2,5 – 3,0 E	dished	125	22,2	9.600	A18031255E		8 9 ■



Industry

Core Drill-Set

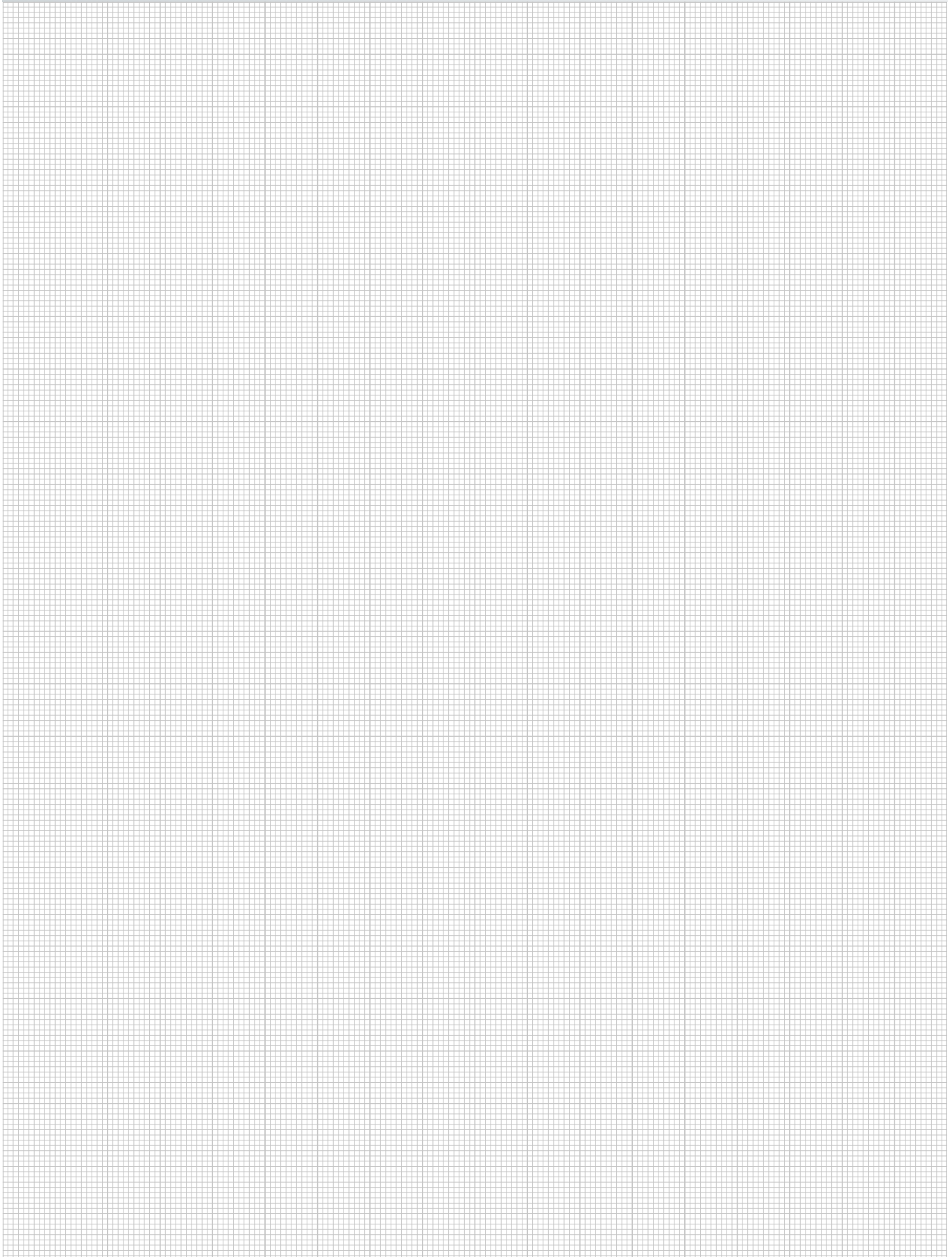
Ordering example: A18300012E



Packing unit:
1 pc. per type

Description	Grit size	Description	Product-Number	recommended for	
HGWB-SET	0,8 – 1,2 E	4 core drills Ø 33, 53, 63 and 73 mm, including base plate, carbide centre point and hexagonal shank (SW9)	A18300012E		8 9 ■

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes.

Technical Brushes

168 General Information

169 Cylindrical brush, shaft mounted

169 Cylindrical brush of abrasive nylon

170 Conical brush

170 End brush, shaft mounted

171 Pipe brush

171 Pipe brush of abrasive nylon

172 Twist knotted wheel brush

172 Cylindrical wheel brush

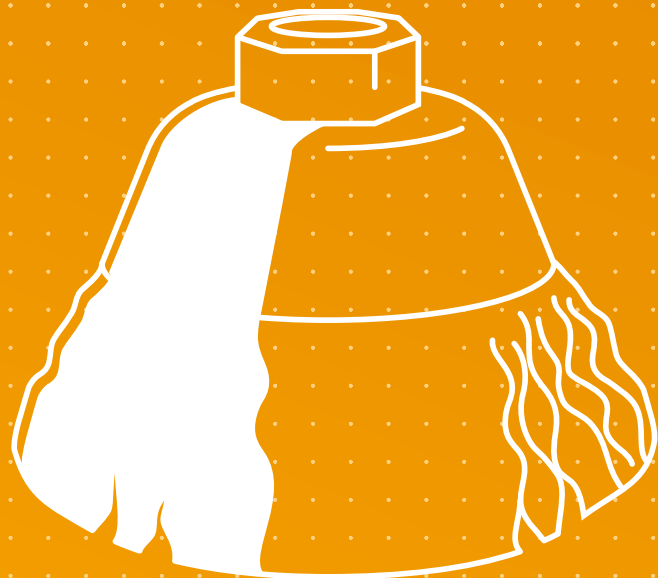
173 Cup wheel brush, thread mounted

173 Hand brush

381 Power tools

Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



General Information

Filament Quality and Style

Quality steel wire

Using quality steel wire with a high tensile strength; this gives long and economical tool life.

Stainless steel wire

This wire is used where residues from normal steel wire would affect surfaces such as stainless steel, aluminium and other non-ferrous metals.

Nylon filaments, abrasive impregnated

Abrasive impregnated nylon filaments are very flexible and follow the contour of the workpiece without being too aggressive; in use, new abrasive is exposed to the workpiece at all times thus resulting in a constant performance and long life.

Style

Brushes are manufactured in both steel wire qualities with crimped 'or twist knotted style. Brushes with twist knotted steel wire meet the most extreme demands and normally achieve longer tool life compared to crimped wire brushes.

Brushes are also manufactured from crimped wire embedded in a resin bond. This style features higher performance and is ideally suited to achieve uniform surfaces and precise edges.

Application

Our wire brushes accommodate most of the ever increasing number of applications, like deburring, descaling, derusting, surface cleaning, fettling, roughening and paint stripping.

Brushes manufactured with abrasive impregnated nylon filaments are ideally suited to remove stain from metal surfaces, for graining of soft wood, car body repair jobs, stripping of paint residues.

Working mode and machines

Technical brushes are flexible tools which follow the contour of the workpiece.

In order to achieve best results, only the tip of the filament should be in contact with the workpiece. The elasticity of the brush depends on the exposed length of the filaments; for wire brushes, the wire diameter is an important factor. Brushes with very long filaments are extremely flexible and must be used with low pressure only. High pressure reduces the life of the brush and creates higher wear.

Technical brushes can be used on stationary and off-hand machines.

Operating speeds

Wire brushes act harder with increasing speed and softer with lower speed:

Machining of steel	approx. 30 m/s
Machining of non-ferrous metals	approx. 18–20 m/s
Machining of plastic	approx. 15 m/s

Twist knotted wire brushes may be operated at higher speeds, for instance:

Machining of steel:	approx. 40 m/s.
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Brushes made from nylon filaments achieve best results at operating speeds between 18 and 20 m/s, depending on the material to be machined.

Safety instructions


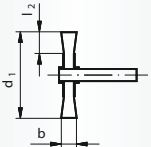
Technical brushes are manufactured under strict quality control (according to EN 1083-2). It is recommended to wear safety clothing when working with technical brushes.



Industry

BS, Cylindrical brush, Shank 6 mm

Ordering example: A350104010111


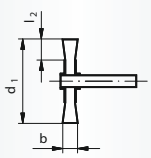
Description		Quality	Type	d ₁ mm	b mm	l ₂ mm	Wire ø	n max. (1/min)	Product-Number	recommended for							
										Packing unit: 10 pcs. per type							
BSSW 04010	steel	crimped	40	10	9	0,2	18.000	A350104010111	1				5			8	■
BSVW 04011	stainless	crimped	40	11	9	0,2	18.000	A351004036		2	3	4				7	■
BSSW 05010	steel	crimped	50	10	12	0,2	15.000	A350005026	1				5			8	■
BSSW 05014	steel	crimped	50	14	12	0,2	15.000	A350105014111	1				5			8	■
BSVW 05014	stainless	crimped	50	14	12	0,2	15.000	A350105014211		2	3	4				7	■
BSSW 06018	steel	crimped	60	16	12	0,2	15.000	A350006036	1				5			8	■
BSSW 06018	steel	crimped	60	16	17	0,3	15.000	A350106018113	1				5			8	■
BSVW 06018	stainless	crimped	60	16	17	0,2	15.000	A351006036		2	3	4				7	■
BSSW 07018	steel	crimped	70	16	19	0,2	15.000	A350007036	1				5			8	■
BSSW 07018	steel	crimped	70	16	19	0,3	15.000	A350107018113	1				5			8	■
BSVW 07018	stainless	crimped	70	16	19	0,3	15.000	A350107018213		2	3	4				7	■
BSVW 07018	stainless	crimped	70	16	19	0,2	15.000	A351007036		2	3	4				7	■
BSSZ 07508	steel	knotted	75	12	15	0,5	25.000	A350107508135	1				5				■
BSVZ 07508	stainless	knotted	75	12	15	0,5	25.000	A350107508235		2	3	4					■



Industry

BSN, Cylindrical brush of abrasive nylon, Shank 6 mm

Ordering example: A350105010048

Description		Type	d ₁ mm	b mm	l ₂ mm	n max. (1/min)	Product-Number	recommended for								
																
								Packing unit: 10 pcs. per type								
BSNG 05010	coarse		50	10	12	15.000	A350105010048		2		4	6	7	8		■
BSNF 05010	fine		50	10	12	15.000	A350105010049		2		4	6	7	8		■
BSNG 07012	coarse		70	12	20	15.000	A350107012048		2		4	6	7	8		■
BSNF 07012	fine		70	12	20	15.000	A350107012049		2		4	6	7	8		■
BSNG 10007	coarse		100	8	22	4.500	A350110007048		2		4	6	7	8		■
BSNF 10008	fine		100	8	22	4.500	A350110008050		2		4	6	7	8		■



BK, Conical brushes

Ordering example: A350610012213

Description		Quality	Type	d ₁ mm	b mm	l ₂ mm	Thread	Wire ø	n max. (1/min)	Product-Number	Packing unit: 10 pcs. per type										
											recommended for										
BKWV 10012	stainless	crimped	100	10	20	M 14	0,3	12.500	A350610012213		2	3	4		7						
BKSW 10012	steel	crimped	100	10	20	M 14	0,35	12.500	A350610012114	1				5							
BKVZ 10013	stainless	knotted	100	13	20	M 14	0,5	12.500	A350610013235		2	3	4		7						
BKSZ 10013	steel	knotted	100	13	20	M 14	0,5	12.500	A350610013135	1				5							



BP, End brush, Shank 6 mm

Ordering example: A350101006

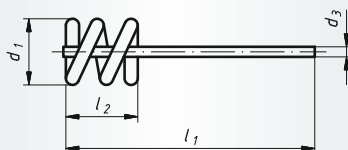
Description		Quality	Type	d ₁ mm	b mm	l ₂ mm	l ₁ mm	Wire ø	n max. (1/min)	Product-Number	Packing unit: 10 pcs. per type										
											recommended for										
BPSW 01020	steel	crimped	10	10	20	60	0,3	20.000	A350101006	1				5			8				
BPVW 01020	stainless	crimped	10	10	20	60	0,3	20.000	A351101006		2	3	4		7						
BPSW 01725	steel	crimped	16	17	22	65	0,3	20.000	A350101506	1				5			8				
BPVW 01725	stainless	crimped	16	17	22	65	0,3	20.000	A351101506		2	3	4		7						
BPSZ 02029	steel	knotted	19	20	28	72	0,35	20.000	A350502029134	1				5							
BPVZ 02029	stainless	knotted	19	20	28	72	0,25	20.000	A350502029232		2	3	4		7						
BPSW 02525	steel	crimped	22	25	25	68	0,3	18.000	A350102206	1				5			8				
BPVW 02525	stainless	crimped	22	25	25	68	0,3	18.000	A351102206		2	3	4		7						
BPSZ 02329	steel	knotted	22	23	28	72	0,35	20.000	A350502329134	1				5							
BPSW 03025	steel	crimped	29	30	25	68	0,3	18.000	A350102806	1				5			8				
BPVW 03025	stainless	crimped	29	30	25	68	0,3	18.000	A351102806		2	3	4		7						



Industry

RBSD, pipe brush, crimped wire

Ordering example: A359901025



Packing unit:
10 pcs. per type

Description	Quality	Type	d ₁ mm	l ₂ mm	d ₃ mm	l ₁ mm	Wire Ø	n max. (1/min)	Product-Number	recommended for	
RBSD 1025	steel	crimped	10	25	3,8	90	0,12	2.000	A359901025	① ② ③ ⑤ ⑧	■
RBSD 1325	steel	crimped	13	25	3,8	90	0,12	2.000	A359901325	① ② ③ ⑤ ⑧	■
RBSD 1625	steel	crimped	16	25	3,8	90	0,12	2.000	A359901625	① ② ③ ⑤ ⑧	■
RBSD 2525	steel	crimped	25	25	3,8	90	0,2	2.000	A359902525	① ② ③ ⑤ ⑧	■

Ideal for

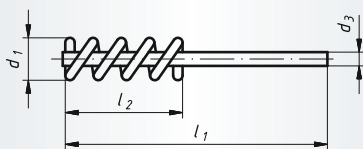
- | | |
|------------------|---------------------------|
| deburring of | polishing and cleaning of |
| • bores | • injectors/nozzles |
| • cross-holes | • small bores |
| • O-ring grooves | • threaded bores |



Industry

RBSN, pipe brush of abrasive nylon, silicon carbide

Ordering example: A359901065120



Packing unit:
10 pcs. per type

Description	Quality	d ₁ mm	l ₂ mm	d ₃ mm	l ₁ mm	Wire Ø	n max. (1/min)	Product-Number	recommended for	
RBSN 1065	C 120	10	65	3,7	125	0,6	2.000	A359901065120	② ④ ⑥ ⑦ ⑧	■
RBSN 1365	C 120	13	65	3,7	125	0,6	2.000	A359901365120	② ④ ⑥ ⑦ ⑧	■
RBSN 1665	C 120	16	65	5,2	125	0,6	2.000	A359901665120	② ④ ⑥ ⑦ ⑧	■
RBSN 2565	C 120	25	65	5,5	125	0,6	2.000	A359902565120	② ④ ⑥ ⑦ ⑧	■

Ideal for

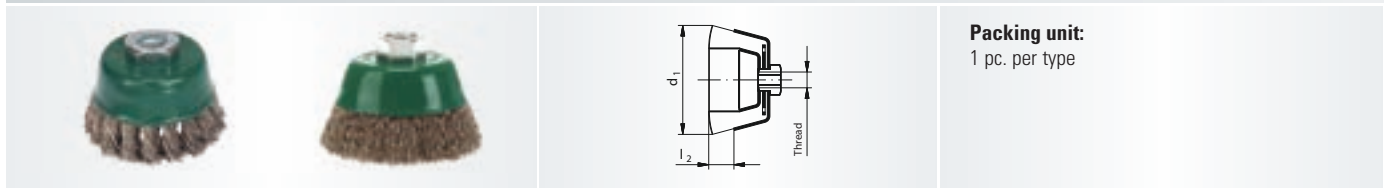
- | | |
|------------------|---------------------------|
| deburring of | polishing and cleaning of |
| • bores | • injectors/nozzles |
| • cross-holes | • small bores |
| • O-ring grooves | • threaded bores |



Industry

BTG, Cup brush with thread

Ordering example: A350406021213



Packing unit:
1 pc. per type

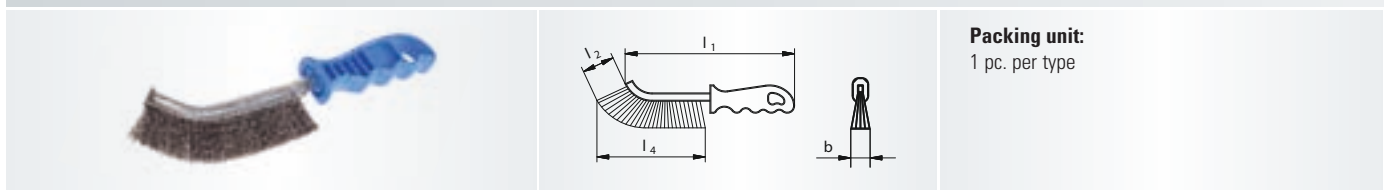
Description	Quality	Type	d ₁ mm	l ₂ mm	Thread	Wire ø	n max. (1/min)	Product-Number	recommended for	
BTWV 06021 G	stainless	crimped	60	20	M 14	0,3	12.000	A350406021213	2 3 4 7	■
BTSW 06020 G	steel	crimped	60	20	M 14	0,35	12.000	A350406020114	1 5	■
BTSZ 06520 G	steel	knotted	65	20	M 14	0,5	12.500	A350406520135	1 5	■
BTVZ 06520 G	stainless	knotted	65	20	M 14	0,35	12.500	A350406520234	2 3 4 7	■
BTSZ 08020 G	steel	knotted	80	20	M 14	0,5	9.000	A350408020135	1 5	■
BTSW 08025 G	steel	crimped	80	25	M 14	0,35	8.500	A350408025114	1 5	■
BTSW 10030 G	steel	crimped	100	30	M 14	0,35	9.000	A350410030114	1 5	■



Industry

BHU, Hand brush for universal application

Ordering example: A350726525113



Packing unit:
1 pc. per type

Description	Quality	b mm	l ₂ mm	l ₁ mm	l ₄ mm	Wire ø	Product-Number	recommended for	
BHUS 26528	steel	15	28	265	130	0,35	A350726525113	1 5	■
BHUV 26525	stainless	15	28	265	130	0,3	A350726525213	2 3 4 7	■

Material classification

1	STEELS AND CAST STEELS Rm up to 800 N/mm ²	5	CAST IRON
	<ul style="list-style-type: none"> • common structural steels • free cutting steels • case hardened steels • fine grained structural steels • extruded steels • toughened structural steels • boiler plate • nitrided steels • cast steels • heat treated steels • heat resistant structural steels 	6	ALUMINIUM, MAGNESIUM AND COPPER ALLOYS
			<ul style="list-style-type: none"> • over 300 HB • 200-300 HB • up to 200 HB • over 15% Si • 10-15% Si • 0,5-10% Si • below 0,5% Si
2	ALLOYED, TEMPERED STEELS Rm 800 up to 1200 N/mm ²	7	TITANIUM AND NICKEL ALLOYS
	<ul style="list-style-type: none"> • case hardened steels • spring steels • fine grained structural steels • nitrided steels • heat treated steels • wear resistant steels • bearing steels 		<ul style="list-style-type: none"> • Rm 900 up to 1500 N/mm² • Rm up to 900 N/mm²
3	TOOL STEELS Rm up to 1300 N/mm ²	8	PLASTICS, WOOD, RUBBER
	<ul style="list-style-type: none"> • 60 - 65 HRC • high-speed steels • non-alloyed tool steels • cold working tool steels • hot working tool steels 	9	GLASS / CARBIDES
4	RUST, ACID AND HEAT RESISTANT STEELS AND CAST STEELS	10	STONE / TILES / GAS CEMENT
	<ul style="list-style-type: none"> • austenitic • ferritic • ferritic-austenitic • heat-resistant • martensitic • stainless, sulphurized 	11	CONCRETE / REINFORCED CONCRETE
		12	CERAMIC / FLOOR TILES
		13	MARBLE
		14	GRANITE
		15	FRESHLY POURED CONCRETE
		16	ASPHALT

- best suitable
- suitable
- delivery ex-stock
- ▲ delivery on request

Safety Symbols

(Depending on the product these symbols may vary)



Wear eye protection



Wear hearing protection



Wear a respirator



Read the instructions



Wear gloves



Only permitted with a back-up pad



Not permitted for wet grinding



Not permitted for face grinding



Do not use if damaged



Not permitted for hand-held or manually-guided grinding