

Cutting and Grinding Discs

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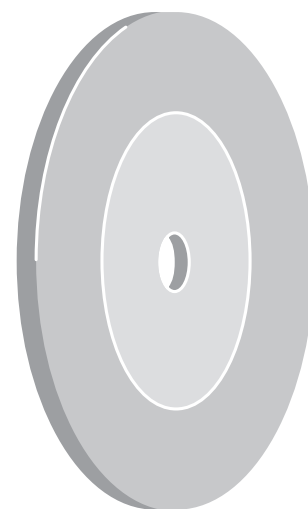
171 Labelling

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185 Grinding discs

Product line marking

The product lines are illustrated by star symbols at the top of the table; please refer to page **14** and **15**.



Technical Information

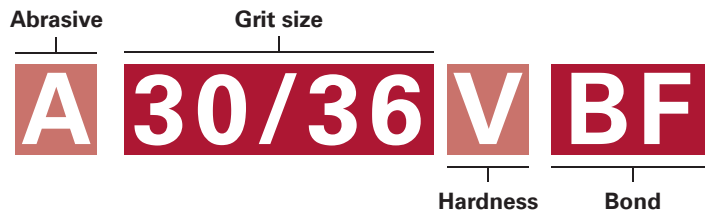
Durability

Resin bonded grinding and cutting wheels for free-hand application must be used within three years of manufacture. Please see metal ring for the expiry date which is specified by month and year; for instance V07/2018.



Labelling system for resin bonded grinding wheels

Example:



Abrasive Type	Grit			Hardness Grade			Bond
	coarse	medium	fine	soft	medium	hard	
A – aluminium oxide	12	36	60	M	R	U	BA – resin bond
C – silicon carbide	up to	up to	bis	Q	S	V	BF – resin bond, fibre-reinforced
Z – zirconia alumina	24	54	120	P	T	Z	

Working speed

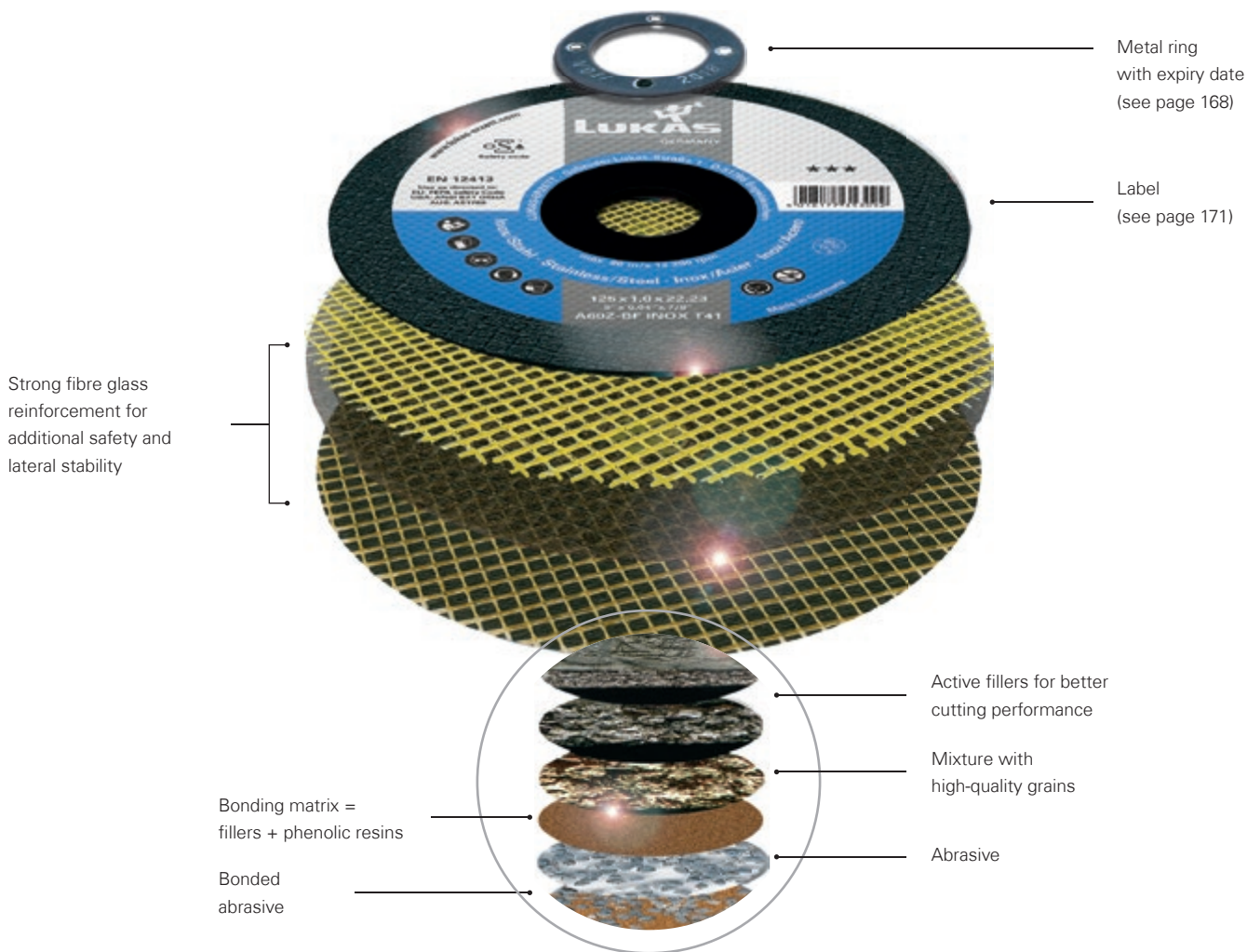
LUKAS grinding discs are developed and tested for specific maximum working speeds and grinding processes.

Prior to mounting the grinding tool on the machine, it must be ensured that the machine's nominal speed (as specified on nameplate) does not exceed the maximum operating speed indicated on the grinding wheel or disc.



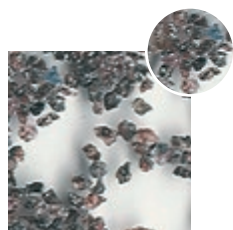
Maximum operating speed	Diameter of Disc [mm] /RPM [min-1]										
	50	76	100	115	125	150	180	230	300	350	400
80 m/s	30.500	20.100	15.300	13.300	12.200	10.200	8.500	6.600	5.100	4.400	3.800
100 m/s	38.200	25.100	19.100	16.650	16.600	12.700	10.600	8.300	6.400	5.400	4.700

Structure and Components

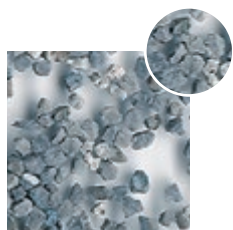


Cutting, Grinding (conventional)

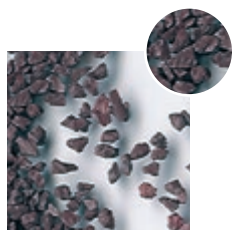
Abrasive



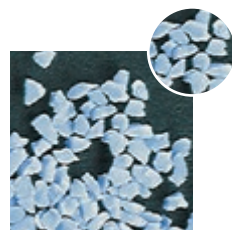
Semi-friable aluminium oxide



Zirconia alumina



Vitrified coated roasted aluminium oxide



Ceramic grain

Safety

With regards to occupational safety and operational convenience, LUKAS responsibility to the customer is taken very seriously. Our products are designed, manufactured and produced in accordance with the most stringent quality standards to provide a maximum of customer value at minimum risk. We are a member of both, the German Abrasive Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

Applied standards:

- Safety Requirements for Bonded Abrasives Products: EN12413
- Safety Requirements for Diamond Blades: EN13236

Safety recommendations

- Don't handle wheels roughly.
- Don't use non-reinforced cut-off wheels on portable machines.
- Don't store wheels in a damp atmosphere or in extreme temperatures.
- Don't mount a damaged wheel.
- Don't ever exceed the maximum operating speed marked on the wheel.
- Don't force a wheel onto a machine spindle.
- Don't use mounting flanges which are incorrect, damaged, dirty or burred.
- Don't tighten the mounting nut or locking flange excessively. To do so can distort the flanges and discs.
- Don't use a machine without a wheel guard.
- Don't use wheels without proper ventilation or dust protection equipment.
- Don't apply side pressure to cut-off wheels. You should not bend the wheel.



- Don't stop the wheel by applying pressure to the periphery or face. Always switch the machine off and allow the wheel to stop revolving.
- Don't allow the wheel to be trapped or pinched in the cut.
- Don't apply excessive pressure onto the wheel so that the driving motor slows down.
- Don't drop or lower a portable machine by the cable or airline onto the floor. A wheel can be easily cracked, if it is put down hard, by the weight of the machine. This is a common cause of wheel breakage.
- Don't grind with a depressed centre grinding wheel at an angle below 30 degrees to the work piece.
- Don't use a machine in a position where you do not have full control of the machine and you are not well balanced.

Clamping System

The use of flanges with unequal diameters is not allowed. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN60745-2-3:2007 and ANSI B.7.1).



Labelling

Safety standard

Manufactured according to EN 12413

Safety recommendations

max. operating speed

A = Aluminium oxide
C = Silicon carbide
AC = Aluminium oxide / Silicon carbide
ZA = zirconia alumina / aluminium oxide

Quality
★★★ High Performance
★★☆ Industry
★☆☆ Base

EAN Code

Application

max. rpm

Application instructions

125 x 1,0 x 22,23
5" x 0,04" x 7/8"
A60Z-BF INOX T41

60 = Grit size
(16/very coarse, 36/medium, 60/Fine)

B = resin bond
F = fibre-reinforced

125 x 1,0 x 22,23 = D x U x H
5" x 0,04" x 7/8" = D x U x H
Diameter x thickness x bore size

Cutting, Grinding (conventional)

Types of resin-bonded grinding wheels

<p>Cutting discs U = (0,8 mm–4,5 mm) (USA: Typ 1)</p> <p>T 41 Straight cutting discs</p> <ul style="list-style-type: none"> • Available in diameters from 50 (2") to 230 mm (9") for freehand applications • from 300 mm (12") to 500 mm (20") for use in stationary machines 	<p>Cutting discs U = (0,8 mm–4,5 mm) (USA: Typ 27)</p> <p>T 42 Depressed centre cutting discs</p> <ul style="list-style-type: none"> • Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use. 	<p>Grinding discs U = (3 mm–10 mm) (USA: Typ 27)</p> <p>T 27 Depressed centre grinding discs</p> <ul style="list-style-type: none"> • Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use.
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Cutting discs

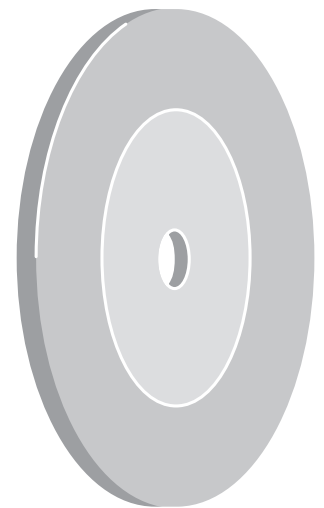
- 174** Qualities and areas of application

- 176** Free-hand cutting disc for angle grinders

- 183** Large cutting disc (greater than 230 mm)

Product line marking

The product lines are illustrated by star symbols at the top of the table; please refer to page **14** and **15**.

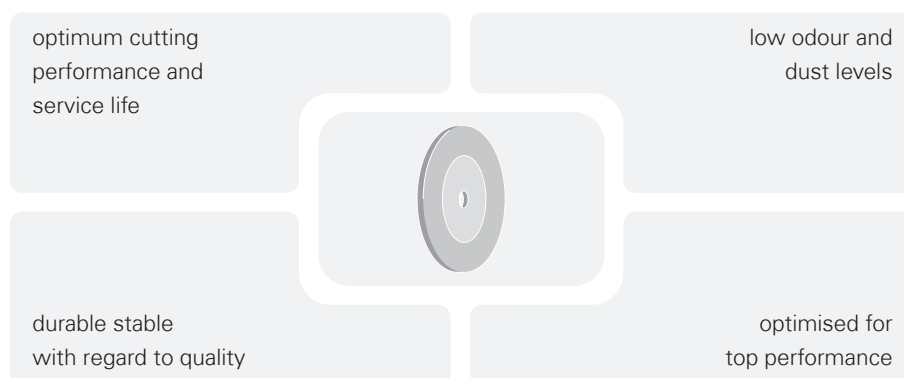


Cutting discs

Cutting, Grinding
(conventional)

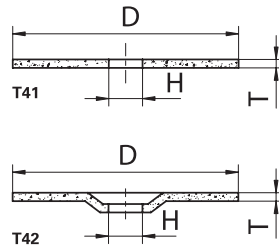
Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Cast material	Cast material
Free-hand cutting disc for angle grinders (100 mm – 230 mm) 	★★★	Page 176–177 	Page 180 			
	★★★☆☆	Page 178 	Page 181 			
	★★☆☆	Page 179–180 	Page 182–183 			
Large cutting disc (greater than 230 mm) 	★★★☆☆					
	★★☆☆	Page 183 				

Progress



- maximum service life and cutting performance due to innovative bonding technology
- high cutting speed at low cutting temperature
- low odour and dust levels during daily usage
- ergonomic work position and maximum durability without use of excessive force
- maximum shelf life with high levels of stability with regard to quality thanks to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process, made in Germany using up-to-date production processes and optimised formulations
- perfect for a wide variety of Inox and steel materials
- precise cutting

Cutting discs for stainless steel – PROGRESS



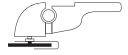
Ordering example: AT007226V9802

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine free

v_{max.}: 80 m/s

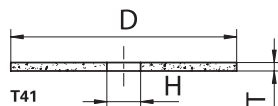


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT007226V9802	T41 100x1,0	A60Z-BF Inox	100	1,0	16,00	15.300	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007231V9802	T41 115x1,0	A60Z-BF Inox	115	1,0	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007235V9802	T41 115x1,6	A46Z-BF Inox	115	1,6	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007211V9802	T41 115x2,5	A30Z-BF Inox	115	2,5	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007233V9802	T41 125x1,0	A60Z-BF Inox	125	1,0	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007237V9802	T41 125x1,6	A46Z-BF Inox	125	1,6	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007213V9802	T41 125x2,5	A30Z-BF Inox	125	2,5	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007239V9802	T41 150x1,2	A60Z-BF Inox	150	1,2	22,23	10.200	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007241V9802	T41 150x1,6	A46Z-BF Inox	150	1,6	22,23	10.200	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007243V9802	T41 180x1,6	A46Z-BF Inox	180	1,6	22,23	8.500	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007245V9802	T41 230x2,0	A46Z-BF Inox	230	2,0	22,23	6.600	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007219V9802	T41 230x2,5	A30Z-BF Inox	230	2,5	22,23	6.600	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT005301V9802	T42 115x0,8	A60Z-BF Inox	115	0,8	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007212V9802	T42 115x2,5	A30Z-BF Inox	115	2,5	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT005302V9802	T42 125x0,8	A60Z-BF Inox	125	0,8	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	50
AT007214V9802	T42 125x2,5	A30Z-BF Inox	125	2,5	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007244V9802	T42 180x1,6	A46Z-BF Inox	180	1,6	22,23	8.500	① ② ③ ④ ⑤ ⑥ ⑦	■	25
AT007220V9802	T42 230x2,5	A30Z-BF Inox	230	2,5	22,23	6.600	① ② ③ ④ ⑤ ⑥ ⑦	■	25

Cutting, Grinding
(conventional)

Cutting disc set – PROGRESS



Ordering example: AT007231V9807010

T41 = flat

Iron, sulphur and chlorine free

 $v_{max.}: 80 \text{ m/s}$


PG 7

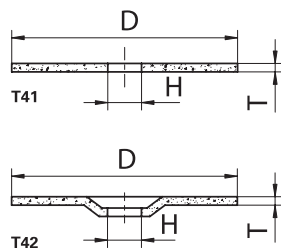
Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT007231V9807010	T41 115x1,0	A60Z-BF Inox	115	1,0	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	10
AT007233V9807010	T41 125x1,0	A60Z-BF Inox	125	1,0	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	10

Handy take-away pack for construction sites

- in safety packaging
- moisture proof

 Cutting, Grinding
(conventional)

Cutting discs for stainless steel – PROMAX



Ordering example: AT001657V9802

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine free

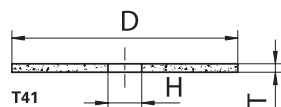
v_{max.}: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT005841V9802	T41 115x1,0	A60X-BF Inox	115	1,0	22,23	13.300	1 2 3 4 5 6 7	■	50
AT003346V9802	T41 115x1,6	A46X-BF Inox	115	1,6	22,23	13.300	1 2 3 4 5 6 7	■	50
AT001657V9802	T41 115x2,0	A36U-BF Inox	115	2,0	22,23	13.300	1 2 3 4 5 6 7	■	25
AT005842V9802	T41 125x1,0	A60X-BF Inox	125	1,0	22,23	12.200	1 2 3 4 5 6 7	■	50
AT003348V9802	T41 125x1,6	A46X-BF Inox	125	1,6	22,23	12.200	1 2 3 4 5 6 7	■	50
AT001687V9802	T41 125x2,0	A36U-BF Inox	125	2,0	22,23	12.200	1 2 3 4 5 6 7	■	25
AT003327V9802	T41 150x1,6	A46X-BF Inox	150	1,6	22,23	10.200	1 2 3 4 5 6 7	■	25
AT001743V9802	T41 180x2,0	A36U-BF Inox	180	2,0	22,23	8.500	1 2 3 4 5 6 7	■	25
AT005864V9802	T41 230x1,9	A46X-BF Inox	230	1,9	22,23	6.600	1 2 3 4 5 6 7	■	25
AT001782V9802	T41 230x2,0	A36U-BF Inox	230	2,0	22,23	6.600	1 2 3 4 5 6 7	■	25
AT001696V9802	T42 125x2,5	A30U-BF Inox	125	2,5	22,23	12.200	1 2 3 4 5 6 7	■	25
AT005571V9802	T42 180x1,6	A46X-BF Inox	180	1,6	22,23	8.500	1 2 3 4 5 6 7	■	25
AT005877V9802	T42 230x1,9	A46X-BF Inox	230	1,9	22,23	6.600	1 2 3 4 5 6 7	■	25
AT004464V9802	T42 230x3,0	A30U-BF Inox	230	3,0	22,23	6.600	1 2 3 4 5 6 7	■	25

Cutting disc set – PROMAX



Ordering example: AT005841V9807010

T41 = flat

Iron, sulphur and chlorine free

v_{max.}: 80 m/s



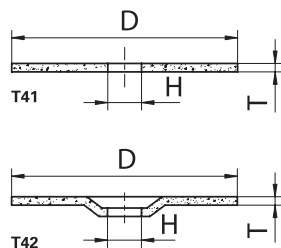
PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT005841V9807010	T41 115x1,0	A60X-BF Inox	115	1,0	22,23	13.300	1 2 3 4 5 6 7	■	10
AT005842V9807010	T41 125x1,0	A60X-BF Inox	125	1,0	22,23	12.200	1 2 3 4 5 6 7	■	10

Handy take-away pack for construction sites

- in safety packaging
- moisture proof

Cutting, Grinding (conventional)

Cutting discs for stainless steel – PREMIUMFLEX


Ordering example: AT000647V9802

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine free

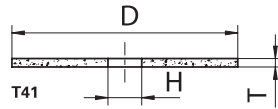
 $v_{max.}: 80 \text{ m/s}$

PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438									
AT003108V9802	T41 100x1,0	A60S-BF Inox	100	1,0	16,00	15.300	1	2	3	4	5	6	7		■	50
AT004643V9802	T41 115x1,0	A60S-BF Inox	115	1,0	22,23	13.300	1	2	3	4	5	6	7		■	50
AT000647V9802	T41 115x1,6	A46T-BF Inox	115	1,6	22,23	13.300	1	2	3	4	5	6	7		■	50
AT002672V9802	T41 125x1,0	A60S-BF Inox	125	1,0	22,23	12.200	1	2	3	4	5	6	7		■	50
AT000674V9802	T41 125x1,6	A46T-BF Inox	125	1,6	22,23	12.200	1	2	3	4	5	6	7		■	50
AT000700V9802	T41 150x1,6	A46T-BF Inox	150	1,6	22,23	10.200	1	2	3	4	5	6	7		■	25
AT000716V9802	T41 180x1,6	A46T-BF Inox	180	1,6	22,23	8.500	1	2	3	4	5	6	7		■	25
AT000742V9802	T41 230x1,9	A46T-BF Inox	230	1,9	22,23	6.600	1	2	3	4	5	6	7		■	25
AT003568V9802	T41 230x3,0	A24/30S-BF Inox	230	3,0	22,23	6.600	1	2	3	4	5	6	7		■	25
AT001442V9802	T42 115x2,5	A24/30S-BF Inox	115	2,5	22,23	13.300	1	2	3	4	5	6	7		■	25
AT004157V9802	T42 125x2,5	A24/30S-BF Inox	125	2,5	22,23	12.200	1	2	3	4	5	6	7		■	25
AT000718V9802	T42 180x1,6	A46T-BF Inox	180	1,6	22,23	8.500	1	2	3	4	5	6	7		■	25
AT000744V9802	T42 230x1,9	A46T-BF Inox	230	1,9	22,23	6.600	1	2	3	4	5	6	7		■	25
AT005451V9802	T42 230x2,5	A24/30S-BF Inox	230	2,5	22,23	6.600	1	2	3	4	5	6	7		■	25
AT004168V9802	T42 230x3,0	A24/30S-BF Inox	230	3,0	22,23	6.600	1	2	3	4	5	6	7		■	25

Cutting, Grinding (conventional)

Cutting disc set – PREMIUMFLEX

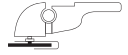


Bestell-Bespiel: AT002672V9807010

T41 = flat

Iron, sulphur and chlorine free

v_{max.}: 80 m/s



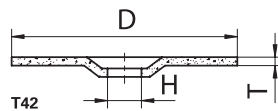
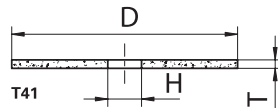
PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT004643V9807010	T41 115x1,0	A60S-BF Inox	115	1,0	22,23	13.300	① ② ③ ④ ⑤ ⑥ ⑦	■	10
AT002672V9807010	T41 125x1,0	A60S-BF Inox	125	1,0	22,23	12.200	① ② ③ ④ ⑤ ⑥ ⑦	■	10

Handy take-away pack for construction sites

- in safety packaging
- moisture proof

Cutting discs for steel – PROGRESS

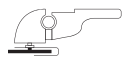


Ordering example: AT007271V9802

T41 = flat

T42 = depressed centre

v_{max.}: 80 m/s

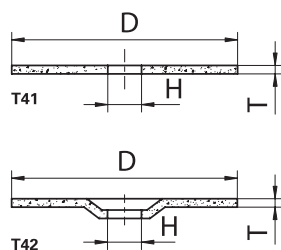


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT007276V9802	T41 115x1,0	A60Z-BF Steel	115	1,0	22,23	13.300	① ② ③ ⑤	■	50
AT007271V9802	T41 115x1,6	A46Z-BF Steel	115	1,6	22,23	13.300	① ② ③ ⑤	■	50
AT007278V9802	T41 125x1,0	A60Z-BF Steel	125	1,0	22,23	12.200	① ② ③ ⑤	■	50
AT007273V9802	T41 125x1,6	A46Z-BF Steel	125	1,6	22,23	12.200	① ② ③ ⑤	■	50
AT007284V9802	T41 230x1,9	A46Z-BF Steel	230	1,9	22,23	6.600	① ② ③ ⑤	■	25

Cutting discs for steel – PROMAX

★★☆☆



Ordering example: AT001656V9802

T41 = flat

T42 = depressed centre

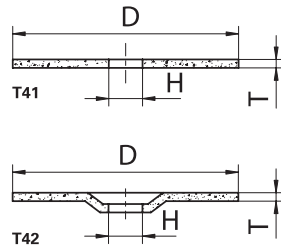
 $v_{max.}: 80 \text{ m/s}$

PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for					PG 7	50
							Information on page 438						
AT005840V9802	T41 115x1,0	A60X-BF Steel	115	1,0	22,23	13.300	1	2	3	5	■	50	
AT013301V9802	T41 115x1,6	A46X-BF Steel	115	1,6	22,23	13.300	1	2	3	5	■	50	
AT001656V9802	T41 115x2,0	A36U-BF Steel	115	2,0	22,23	13.300	1	2	3	5	■	25	
AT005835V9802	T41 125x1,0	A60X-BF Steel	125	1,0	22,23	12.200	1	2	3	5	■	50	
AT013302V9802	T41 125x1,6	A46X-BF Steel	125	1,6	22,23	12.200	1	2	3	5	■	50	
AT001686V9802	T41 125x2,0	A36U-BF Steel	125	2,0	22,23	12.200	1	2	3	5	■	25	
AT011086V9802	T41 125x2,5	A30X-BF Steel	125	2,5	22,23	12.200	1	2	3	5	■	25	
AT013303V9802	T41 150x1,6	A46X-BF Steel	150	1,6	22,23	10.200	1	2	3	5	■	25	
AT013305V9802	T41 180x1,6	A46X-BF Steel	180	1,6	22,23	8.500	1	2	3	5	■	25	
AT001742V9802	T41 180x2,0	A36U-BF Steel	180	2,0	22,23	8.500	1	2	3	5	■	25	
AT005867V9802	T41 230x1,9	A46X-BF Steel	230	1,9	22,23	6.600	1	2	3	5	■	25	
AT001781V9802	T41 230x2,0	A36U-BF Steel	230	2,0	22,23	6.600	1	2	3	5	■	25	
AT001785V9802	T41 230x3,0	A30U-BF Steel	230	3,0	22,23	6.600	1	2	3	5	■	25	
AT001665V9802	T42 115x2,5	A30U-BF Steel	115	2,5	22,23	13.300	1	2	3	5	■	25	
AT001695V9802	T42 125x2,5	A30U-BF Steel	125	2,5	22,23	12.200	1	2	3	5	■	25	
AT001724V9802	T42 150x2,5	A30U-BF Steel	150	2,5	22,23	10.200	1	2	3	5	■	25	
AT001750V9802	T42 180x3,0	A30U-BF Steel	180	3,0	22,23	8.500	1	2	3	5	■	25	
AT001790V9802	T42 230x2,5	A30U-BF Steel	230	2,5	22,23	6.600	1	2	3	5	■	25	

Cutting, Grinding (conventional)

Cutting discs for steel – PREMIUMFLEX

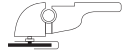


Ordering example: AT000638V9802

T41 = flat

T42 = depressed centre

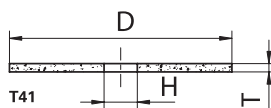
v_{max.}: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438							
AT006440V9802	T41 115x1,0	A60S-BF Steel	115	1,0	22,23	13.300	1	2	3	5			■	50
AT000648V9802	T41 115x1,6	A46T-BF Steel	115	1,6	22,23	13.300	1	2	3	5			■	50
AT000656V9802	T41 115x2,5	A24R-BF Steel	115	2,5	22,23	13.300	1	2	3	5			■	25
AT006710V9802	T41 125x1,0	A60S-BF Steel	125	1,0	22,23	12.200	1	2	3	5			■	50
AT000675V9802	T41 125x1,6	A46T-BF Steel	125	1,6	22,23	12.200	1	2	3	5			■	50
AT000679V9802	T41 125x2,5	A24R-BF Steel	125	2,5	22,23	12.200	1	2	3	5			■	25
AT000707V9802	T41 150x2,5	A24R-BF Steel	150	2,5	22,23	10.200	1	2	3	5			■	25
AT000717V9802	T41 180x1,6	A46T-BF Steel	180	1,6	22,23	8.500	1	2	3	5			■	25
AT000728V9802	T41 180x3,0	A24R-BF Steel	180	3,0	22,23	8.500	1	2	3	5			■	25
AT000743V9802	T41 230x1,9	A46T-BF Steel	230	1,9	22,23	6.600	1	2	3	5			■	25
AT000967V9802	T41 230x2,0	A36T-BF Steel	230	2,0	22,23	6.600	1	2	3	5			■	25
AT000750V9802	T41 230x3,0	A24R-BF Steel	230	3,0	22,23	6.600	1	2	3	5			■	25
AT000638V9802	T42 100x2,5	A24R-BF Steel	100	2,5	16	15.300	1	2	3	5			■	25
AT000662V9802	T42 115x2,5	A24R-BF Steel	115	2,5	22,23	13.300	1	2	3	5			■	25
AT000688V9802	T42 125x2,5	A24R-BF Steel	125	2,5	22,23	15300	1	2	3	5			■	25
AT000732V9802	T42 180x3,0	A24R-BF Steel	180	3,0	22,23	8.500	1	2	3	5			■	25
AT000745V9802	T42 230x1,9	A46T-BF Steel	230	1,9	22,23	6.600	1	2	3	5			■	25
AT000754V9802	T42 230x3,0	A24R-BF Steel	230	3,0	22,23	6.600	1	2	3	5			■	25

Cutting, Grinding
(conventional)

Stationary cutting discs for stainless steel – PREMIUMFLEX


Ordering example: AT010003

T41 = flat

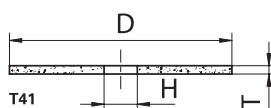
Iron, sulphur and chlorine free

 $v_{max.}: 80 \text{ m/s}$

PG 7

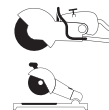
Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT010003	T41 300x3,5	A30S-BF Inox	300	3,5	32,00	5.100	1 2 3 4 5 6 7	■	10
AT020208	T41 350x2,6	A30S-BF Inox	350	2,6	25,40	4.400	1 2 3 4 5 6 7	■	10

Cutting, Grinding (conventional)

Cutting discs for steel – PREMIUMFLEX


Ordering example: AT010052

T41 = flat

 $v_{max.}: 100 \text{ m/s}$

PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AT010052	T41 300x4,0	A24R-BF	300	4,0	20,00	6.400	1 2 3 5	■	10
AT010055	T41 350x4,0	A24R-BF	350	4,0	20,00	5.400	1 2 3 5	■	10
AT010057	T41 350x4,0	A24R-BF	350	4,0	25,40	5.400	1 2 3 5	■	10

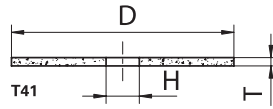
Stationary cutting discs for steel – PREMIUMFLEX



Ordering example: AT001774

T41 = flat

v_{max.}: 80 m/s bzw. 100 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438											
AT010028	T41 300x2,6	A36S-BF Steel	300	2,6	25,40	6.400 / 80 m/s	① ② ③ ⑤										■	10
AT001774	T41 300x3,5	A30T-BF Steel	300	3,5	22,23	6.400 / 100 m/s	① ② ③ ⑤										■	10
AT001776	T41 300x3,5	A30T-BF Steel	300	3,5	25,40	6.400 / 100 m/s	① ② ③ ⑤										■	10
AT010020	T41 300x3,5	A30T-BF Steel	300	3,5	32,00	6.400 / 100 m/s	① ② ③ ⑤										■	10
AT010029	T41 350x2,6	A36S-BF Steel	350	2,6	25,40	5.400 / 80 m/s	① ② ③ ⑤										■	10
AT010022	T41 350x3,5	A30T-BF Steel	350	3,5	25,40	5.400 / 100 m/s	① ② ③ ⑤										■	10
AT010023	T41 350x3,5	A30T-BF Steel	350	3,5	32,00	5.400 / 100 m/s	① ② ③ ⑤										■	10
AT010030	T41 400x3,2	A36S-BF Steel	400	3,2	25,40	4.700 / 80 m/s	① ② ③ ⑤										■	5
AT010026	T41 400x4,0	A30T-BF Steel	400	4,0	32,00	4.700 / 100 m/s	① ② ③ ⑤										■	5

Cutting, Grinding (conventional)

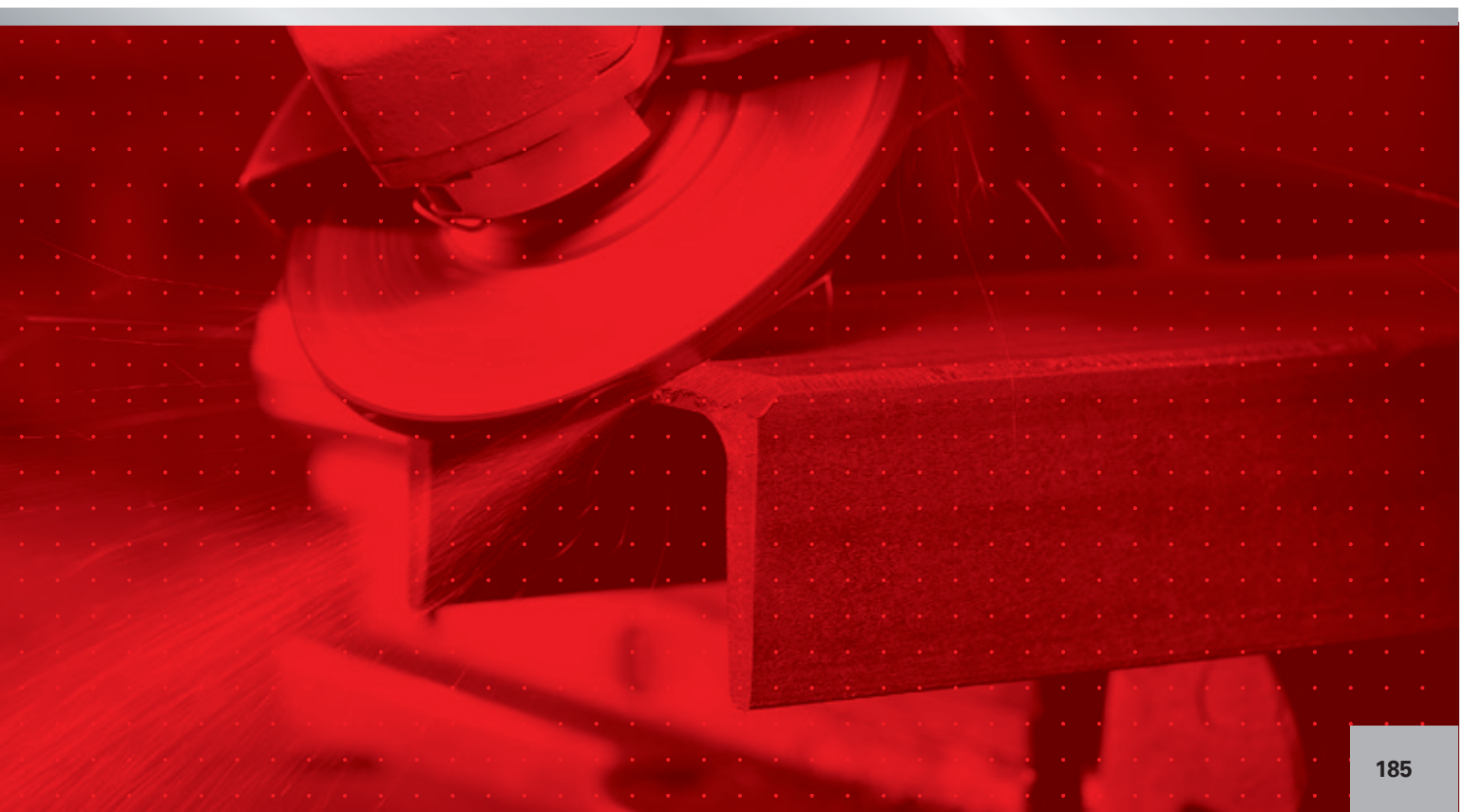
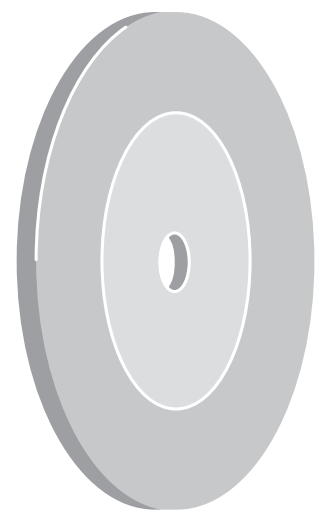
Grinding discs

186 Qualities and areas of application

188 Free-hand grinding discs for angle grinders

Product line marking

The product lines are illustrated by star symbols at the top of the table; please refer to page **14** and **15**.

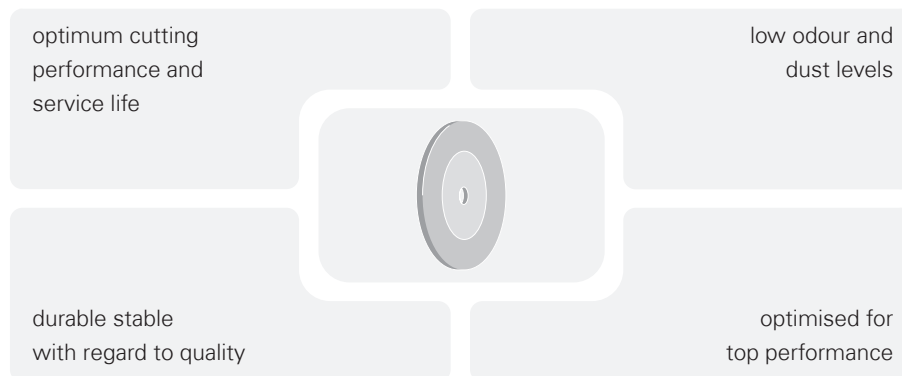


Grinding discs

Type	Product line	Material					
		INOX/Steel	Steel	Aluminium	Stone/ Cast material	Cast material	
Free-hand grinding discs for angle grinders 	★★★	Page 188 	Page 190 				
	★★☆	Page 189 	Page 190 		Page 192 	Page 191 	
	★☆☆	Page 189 	Page 191 		Page 193 	Page 192 	

Cutting, Grinding (conventional)

Progress



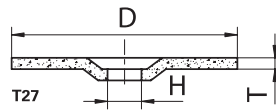
- maximum service life and cutting performance due to innovative bonding technology
- high cutting speed at low cutting temperature
- low odour and dust levels during daily usage
- ergonomic work position and maximum durability without use of excessive force
- maximum shelf life with high levels of stability with regard to quality thanks to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process, made in Germany using up-to-date production processes and optimised formulations
- perfect for a wide variety of inox and steel materials
- precise cutting



Cutting and grinding
without tool change.

Safe. Precise. Perfect.

Grinding and cutting discs to machine stainless steel –
PROGRESS COOL JOBBER

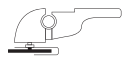


Ordering example: AS015675V9802

T27 = depressed centre

Iron, sulphur and chlorine free

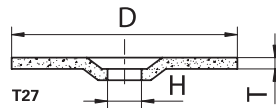
$v_{max.}$: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS015675V9802	T27 115x2,0	A36V-BF Inox COOL JOBBER	115	2,0	22,23	13.300	1 2 3 4 6	■	25
AS015676V9802	T27 125x2,0	A36V-BF Inox COOL JOBBER	125	2,0	22,23	12.200	1 2 3 4 6	■	25

Grinding discs to machine stainless steel – **PROGRESS**

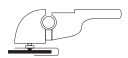


Ordering example: AS013491V9802

T27 = depressed centre

Iron, sulphur and chlorine free

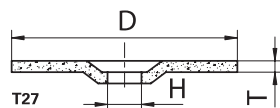
$v_{max.}$: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS013491V9802	T27 115x7,0	A24U-BF Inox	115	7,0	22,23	13.300	1 2 3 4 6	■	10
AS013492V9802	T27 125x7,0	A24U-BF Inox	125	7,0	22,23	12.200	1 2 3 4 6	■	10
AS013496V9802	T27 230x7,0	A24U-BF Inox	230	7,0	22,23	6.600	1 2 3 4 6	■	10

Grinding discs for stainless steel – PROMAX



Ordering example: AS003100V9802

T27 = depressed centre

Iron, sulphur and chlorine free

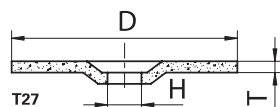
 $v_{max.}: 80 \text{ m/s}$


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS003100V9802	T27 115x6,0	A24X-BF Inox	115	6,0	22,23	13.300	1 2 3 4 6	■	10
AS003101V9802	T27 125x6,0	A24X-BF Inox	125	6,0	22,23	12.200	1 2 3 4 6	■	10
AS003103V9802	T27 180x6,0	A24X-BF Inox	180	6,0	22,23	8.500	1 2 3 4 6	■	10
AS003104V9802	T27 230x6,0	A24X-BF Inox	230	6,0	22,23	6.600	1 2 3 4 6	■	10

Cutting, Grinding (conventional)

Grinding discs for stainless steel – PREMIUMFLEX



Ordering example: AS000105V9802

T27 = depressed centre

Iron, sulphur and chlorine free

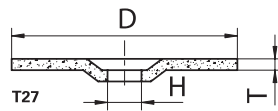
 $v_{max.}: 80 \text{ m/s}$


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS002037V9802	T27 100x6,0	A24/30S-BF Inox	100	6,0	16,00	15.300	1 2 3 4	■	10
AS000105V9802	T27 115x6,0	A24/30S-BF Inox	115	6,0	22,23	13.300	1 2 3 4	■	10
AS000106V9802	T27 125x6,0	A24/30S-BF Inox	125	6,0	22,23	12.200	1 2 3 4	■	10
AS000107V9802	T27 150x6,0	A24/30S-BF Inox	150	6,0	22,23	10.200	1 2 3 4	■	10
AS000108V9802	T27 180x6,0	A24/30S-BF Inox	180	6,0	22,23	8.500	1 2 3 4	■	10
AS000109V9802	T27 230x6,0	A24/30S-BF Inox	230	6,0	22,23	6.600	1 2 3 4	■	10

Grinding discs for steel – PROGRESS

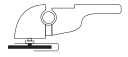
★★★



Ordering example: AS012451V9802

T27 = depressed centre

$v_{max.}$: 80 m/s

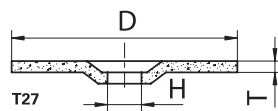


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS012451V9802	T27 115x7,0	A24X-BF Steel	115	7,0	22,23	13.300	① ② ③		■ 10
AS012453V9802	T27 125x7,0	A24X-BF Steel	125	7,0	22,23	12.200	① ② ③		■ 10
AS012458V9802	T27 150x7,0	A24X-BF Steel	150	7,0	22,23	10.200	① ② ③		■ 10
AS012466V9802	T27 180x7,0	A24X-BF Steel	180	7,0	22,23	8.500	① ② ③		■ 10
AS012468V9802	T27 230x7,0	A24X-BF Steel	230	7,0	22,23	6.600	① ② ③		■ 10

Grinding discs for steel – PROMAX

★★☆



Ordering example: AS001679V9802

T27 = depressed centre

$v_{max.}$: 80 m/s

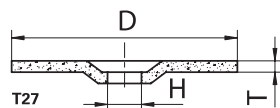


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS001679V9802	T27 115x6,0	A24/30T-BF Steel	115	6,0	22,23	13.300	① ② ③ ⑤		■ 10
AS001710V9802	T27 125x6,0	A24/30T-BF Steel	125	6,0	22,23	12.200	① ② ③ ⑤		■ 10
AS001811V9802	T27 230x6,0	A24/30T-BF Steel	230	6,0	22,23	6.600	① ② ③ ⑤		■ 10

Grinding discs for steel – PREMIUMFLEX

★☆☆



Ordering example: AS000667V9802

T27 = depressed centre

 $v_{max.}: 80 \text{ m/s}$

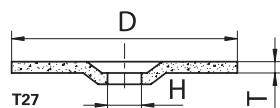

PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS000667V9802	T27 115x6,0	A24/30S-BF Steel	115	6,0	22,23	13.300	① ② ③	■	10
AS000690V9802	T27 125x4,0	A24/30S-BF Steel	125	4,0	22,23	12.200	① ② ③	■	10
AS000692V9802	T27 125x6,0	A24/30S-BF Steel	125	6,0	22,23	12.200	① ② ③	■	10
AS000712V9802	T27 150x6,0	A24/30S-BF Steel	150	6,0	22,23	10.200	① ② ③	■	10
AS000737V9802	T27 180x7,0	A24/30S-BF Steel	180	7,0	22,23	8.500	① ② ③	■	10
AS000762V9802	T27 230x6,0	A24/30S-BF Steel	230	6,0	22,23	6.600	① ② ③	■	10

 Cutting, Grinding
(conventional)

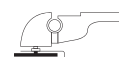
Grinding discs for cast iron – PROMAX

★★☆☆



Ordering example: AS001711V9802

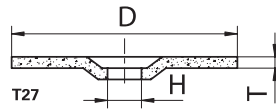
T27 = depressed centre

 $v_{max.}: 80 \text{ m/s}$


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS001711V9802	T27 125x6,0	ZA24R-BF Cast	125	6,0	22,23	12.200	① ② ③ ⑤	■	10
AS001773V9802	T27 180x6,0	ZA24R-BF Cast	180	6,0	22,23	8.500	① ② ③ ⑤	■	10
AS001812V980201	T27 230x6,0	ZA24R-BF Cast	230	6,0	22,23	6.600	① ② ③ ⑤	■	10

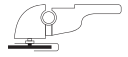
Grinding discs for cast iron – PREMIUMFLEX



Ordering example: AS000867V9802

T27 = depressed centre

$v_{max.}$: 80 m/s

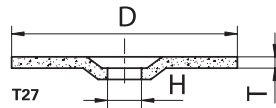


PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS000867V9802	T27 180x8,0	AC24P-BF Cast	180	8,0	22,23	8.500		5	10

Cutting, Grinding
(conventional)

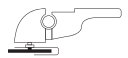
Grinding discs for stone and cast iron – Promax



Ordering example: AS000320V9802

T27 = depressed centre

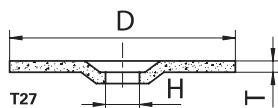
$v_{max.}$: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS000320V9802	T27 180x6,0	C24R-BF Stone	180	6,0	22,23	8.500		5	7

Grinding discs for stone and cast iron – PREMIUMFLEX



Ordering example: AS001600V9802

T41 = flat

v_{max.}: 80 m/s



PG 7

Product number	Description	Quality	Ø D mm	T mm	H mm	n max. (1/min)	Recommended for Information on page 438		
AS001600V9802	T27 230x6,0	AC24S-BF Stone	230	6,0	22,23	6.600	5 10 11 12	■	10

Cutting, Grinding (conventional)