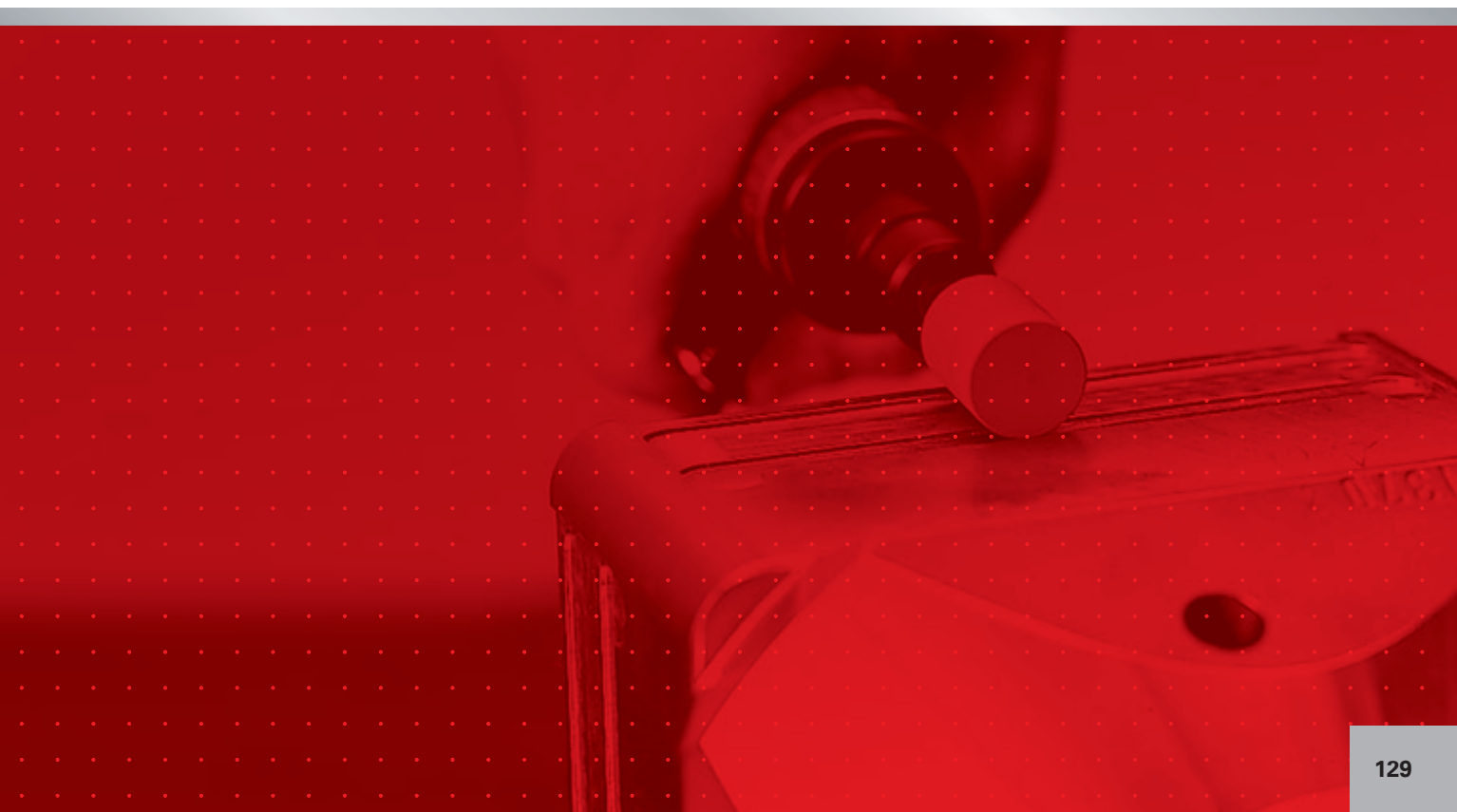
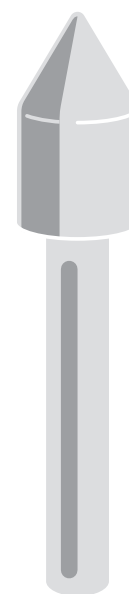


Polishing tools

130 General Information	155 Marbling points and polishing points, group P6
131 Areas of application	157 Polishing roll, group P6
132 A summary of available shapes	158 Polishing disc, group P6
133 Polishing points, group P1	161 Small polishing points, group P7
136 Polishing points, group P2	
140 Felt polishing points, group P3	
144 Abrasive and diamond pastes	
146 Polishing sticks, group P4	
148 Polishing points, group P5	
151 Polishing wheels, group P6	
154 Mounting system for polishing wheels	

Product line marking

The product lines are illustrated by star symbols at the top of the table; please refer to 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.

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.

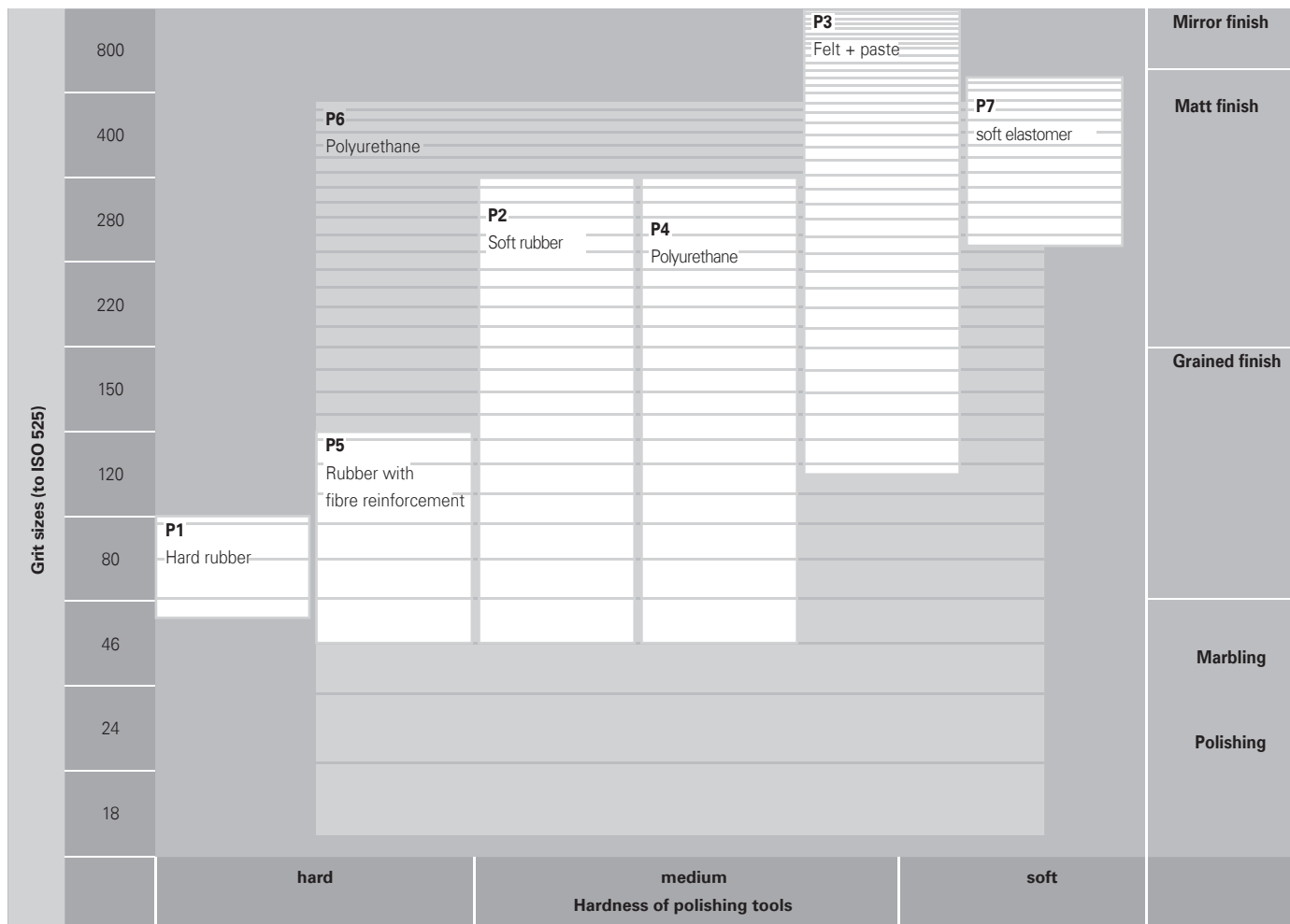
Safety instructions

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

Areas of application



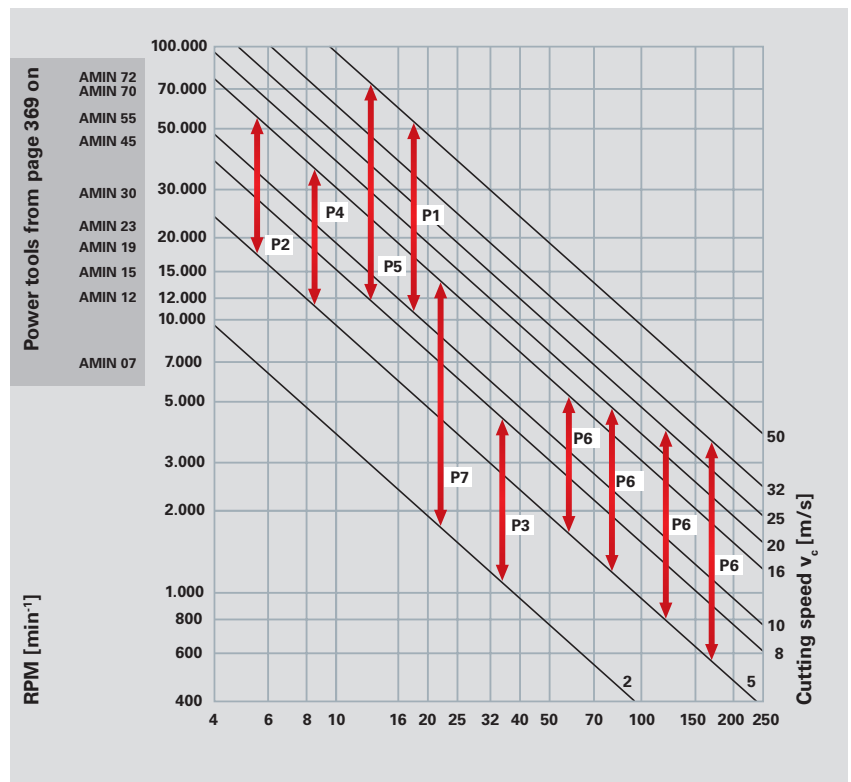
Grinding, Polishing (bonded)

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	Polishing 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 diamond 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. The surface finish achieved lies between group P1 and P2.
P6	Polishing tools are available in various forms – mounted points, marbling points, rolls for satin finishes, polishing wheels and polishing discs. 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.P
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

Grinding, Polishing
(bonded)

shape	Type	Shape (Lukas)	Available product range
	Cylindrical, type 1	ZY	P1, P2, P3, P5, P6
	Cylindrical, type 2	ZY2	P1, P2
	Spherical	KE	P1, P2, P3
	Conical	KU	P2, 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
	Disc	PT	P6

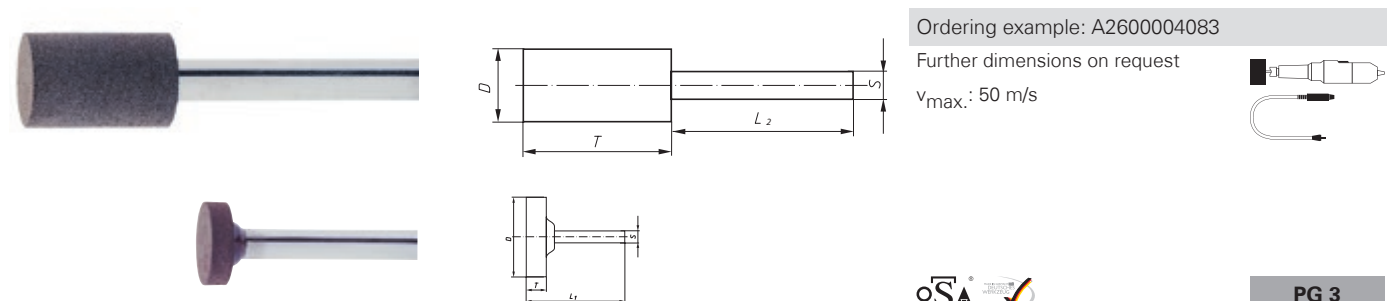


Quality and application P1

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.

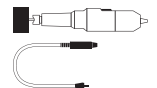
Shape ZY, Cylindrical (according to DIN 69170)



Ordering example: A2600004083

Further dimensions on request

v_{max.}: 50 m/s



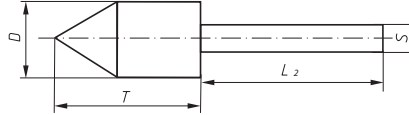
PG 3

Product number	Description	Type	D mm	T mm	S mm	L ₂ mm	recommended for	Information on page 438	PG 3	
A2600004083	P1ZY 0408.03	1	4	8	3	30	1 2 3 4 5 7		■	20
A2600005103	P1ZY 0510.03	1	5	10	3	30	1 2 3 4 5 7		■	20
A2600006103	P1ZY 0610.03	1	6	10	3	30	1 2 3 4 5 7		■	20
A2600007103	P1ZY 0710.03	1	7	10	3	30	1 2 3 4 5 7		■	20
A2600008103	P1ZY 0810.03	1	8	10	3	30	1 2 3 4 5 7		■	20
A2600008166	P1ZY 0816.06	1	8	16	6	40	1 2 3 4 5 7		■	10
A2600008206	P1ZY 0820.06	1	8	20	6	40	1 2 3 4 5 7		■	10
A2600010103	P1ZY 1010.03	1	10	10	3	30	1 2 3 4 5 7		■	20
A2600010133	P1ZY 1013.03	1	10	13	3	30	1 2 3 4 5 7		■	20
A2600010163	P1ZY 1016.03	1	10	16	3	30	1 2 3 4 5 7		■	20
A2600010206	P1ZY 1020.06	1	10	20	6	40	1 2 3 4 5 7		■	10
A2607013033	P1ZY 1303.03	2	13	3	3	30	1 2 3 4 5 7		■	20
A2600013133	P1ZY 1313.03	1	13	13	3	30	1 2 3 4 5 7		■	20
A2600013163	P1ZY 1316.03	1	13	16	3	30	1 2 3 4 5 7		■	20
A2600013206	P1ZY 1320.06	1	13	20	6	40	1 2 3 4 5 7		■	10
A2607016043	P1ZY 1604.03	2	16	4	3	30	1 2 3 4 5 7		■	20
A2600016163	P1ZY 1616.03	1	16	16	3	30	1 2 3 4 5 7		■	20
A2600016206	P1ZY 1620.06	1	16	20	6	40	1 2 3 4 5 7		■	10
A2600016326	P1ZY 1632.06	1	16	32	6	40	1 2 3 4 5 7		■	10
A2607020063	P1ZY 2006.03	2	20	6	3	30	1 2 3 4 5 7		■	20
A2600020206	P1ZY 2020.06	1	20	20	6	40	1 2 3 4 5 7		■	10
A2600020326	P1ZY 2032.06	1	20	32	6	40	1 2 3 4 5 7		■	10
A2607032106	P1ZY 3210.06	2	32	10	6	40	1 2 3 4 5 7		■	10
A2600032166	P1ZY 3216.06	1	32	16	6	40	1 2 3 4 5 7		■	10
A2600040206	P1ZY 4020.06	1	40	20	6	40	1 2 3 4 5 7		■	10

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



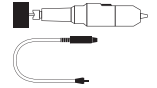
Grinding, Polishing
(bonded)



Ordering example: A2602016326

Further dimensions on request

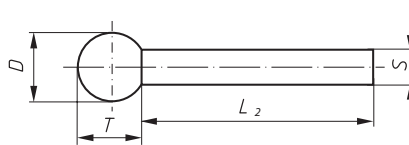
$v_{max.}$: 50 m/s



PG 3

Product number	Description	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2602016326	P1KS 1632.06	16	32	6	40	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input type="checkbox"/>	10

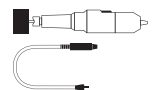
Shape KU, Spherical (according to DIN 69170)



Ordering example: A2605008083

Further dimensions on request

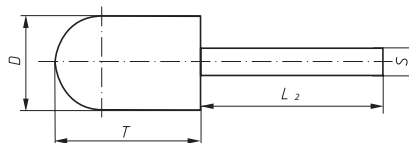
$v_{max.}$: 50 m/s



PG 3

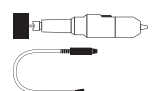
Product number	Description	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2605008083	P1KU 0808.03	8	8	3	30	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input type="checkbox"/>	20
A2605016166	P1KU 1616.06	16	16	6	39	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input type="checkbox"/>	10

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



Ordering example:

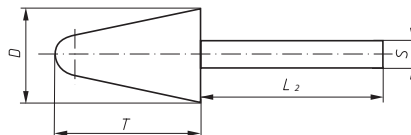
$v_{max.}$: 50 m/s



PG 3

available on request

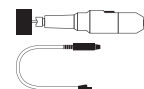
Shape KE, Conical round nose (according to DIN 69170)



Ordering example: A2609020326

Further dimensions on request

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



PG 3

Product number	Description	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2609020326	P1KE 2032.06	20	32	6	40	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input checked="" type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 7	■	10

Grinding, Polishing (bonded)

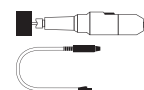
Assortment, Polishing points, 114



Ordering example: A2600114

Further dimensions on request

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



PG 3

Product number	Description	Contents	1 piece each	recommended for Information on page 438		
A2600114	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	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input checked="" type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 7	■	1

Specification and application P2

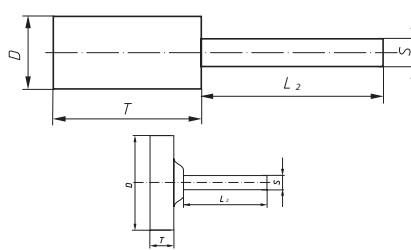
The polishing mounted points of this group are available in the five grit sizes as detailed below, and are available in a variety of shapes and sizes. They are colour coded to prevent any confusion and to avoid any errors in the polishing process. The soft rubber bonding allows for a very soft grinding 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.



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

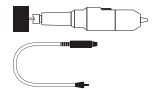
Shape ZY, Cylindrical (according to DIN 69170)



Ordering example: A2610004083080

Further dimensions and grit sizes on request

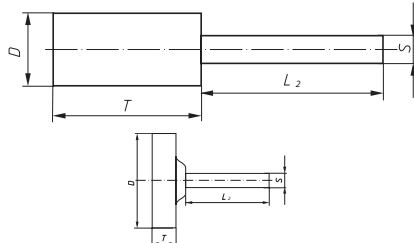
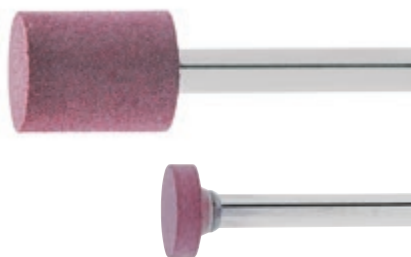
$v_{max.}$: 16 m/s



PG 3

Product number	Description	Grit	Type	D mm	T mm	S mm	L ₂ mm	recommended for		
A2610004083080	P2ZY 0408.03	80	1	4	8	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610004083120	P2ZY 0408.03	120	1	4	8	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610004083220	P2ZY 0408.03	220	1	4	8	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610004083280	P2ZY 0408.03	280	1	4	8	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610005103080	P2ZY 0510.03	80	1	5	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610005103120	P2ZY 0510.03	120	1	5	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610005103220	P2ZY 0510.03	220	1	5	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610005103280	P2ZY 0510.03	280	1	5	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610006103080	P2ZY 0610.03	80	1	6	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610006103120	P2ZY 0610.03	120	1	6	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610006103220	P2ZY 0610.03	220	1	6	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610006103280	P2ZY 0610.03	280	1	6	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610008103046	P2ZY 0810.03	46	1	8	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20

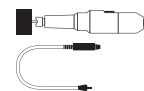
Shape ZY, Cylindrical (according to DIN 69170)



Ordering example: A2610004083080

Further dimensions and grit sizes on request

v_{max.}: 16 m/s



Grinding, Polishing (bonded)



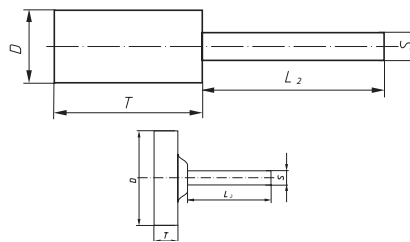
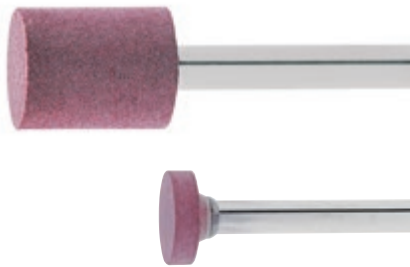
PG 3

Product number	Description	Grit	Type	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2610008103080	P2ZY 0810.03	80	1	8	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610008103120	P2ZY 0810.03	120	1	8	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610008103220	P2ZY 0810.03	220	1	8	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610008103280	P2ZY 0810.03	280	1	8	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610008166080	P2ZY 0816.06	80	1	8	16	6	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610008166120	P2ZY 0816.06	120	1	8	16	6	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610008166220	P2ZY 0816.06	220	1	8	16	6	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610008166280	P2ZY 0816.06	280	1	8	16	6	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610010103046	P2ZY 1010.03	46	1	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610010103080	P2ZY 1010.03	80	1	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610010103120	P2ZY 1010.03	120	1	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610010103220	P2ZY 1010.03	220	1	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610010103280	P2ZY 1010.03	280	1	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610010206080	P2ZY 1020.06	80	1	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610010206120	P2ZY 1020.06	120	1	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610010206220	P2ZY 1020.06	220	1	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610010206280	P2ZY 1020.06	280	1	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610013133080	P2ZY 1313.03	80	1	13	13	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610013133120	P2ZY 1313.03	120	1	13	13	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610013133220	P2ZY 1313.03	220	1	13	13	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610013133280	P2ZY 1313.03	280	1	13	13	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610013163120	P2ZY 1316.03	120	1	13	16	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610013206046	P2ZY 1320.06	46	1	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610013206080	P2ZY 1320.06	80	1	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610013206120	P2ZY 1320.06	120	1	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610013206220	P2ZY 1320.06	220	1	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610013206280	P2ZY 1320.06	280	1	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016163120	P2ZY 1616.03	120	1	16	16	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2610016206080	P2ZY 1620.06	80	1	16	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016206120	P2ZY 1620.06	120	1	16	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016206220	P2ZY 1620.06	220	1	16	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016206280	P2ZY 1620.06	280	1	16	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016326080	P2ZY 1632.06	80	1	16	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016326120	P2ZY 1632.06	120	1	16	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610016326220	P2ZY 1632.06	220	1	16	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020206046	P2ZY 2020.06	46	1	20	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020206080	P2ZY 2020.06	80	1	20	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

Shape ZY, Cylindrical (according to DIN 69170)



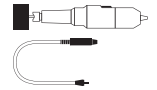
Grinding, Polishing
(bonded)



Ordering example: A2610004083080

Further dimensions and grit sizes on request

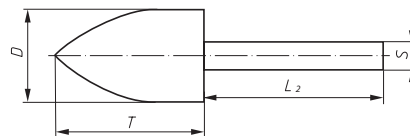
$v_{max.}$: 16 m/s



PG 3

Product number	Description	Grit	Type	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2610020206120	P2ZY 2020.06	120	1	20	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020206220	P2ZY 2020.06	220	1	20	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020206280	P2ZY 2020.06	280	1	20	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020326080	P2ZY 2032.06	80	1	20	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020326120	P2ZY 2032.06	120	1	20	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020326220	P2ZY 2032.06	220	1	20	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610020326280	P2ZY 2032.06	280	1	20	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2617025106120	P2ZY 2510.06	120	2	25	10	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2617032106120	P2ZY 3210.06	120	2	32	10	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2617032106220	P2ZY 3210.06	220	2	32	10	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610032206120	P2ZY 3220.06	120	1	32	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610032326120	P2ZY 3232.06	120	1	32	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610032326280	P2ZY 3232.06	280	1	32	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2617040106120	P2ZY 4010.06	120	2	40	10	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2610040206120	P2ZY 4020.06	120	1	40	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

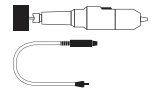
Shape SP, Arch pointed nose (according to DIN 69170)



Ordering example: A2611013206120

Further dimensions and grit sizes on request

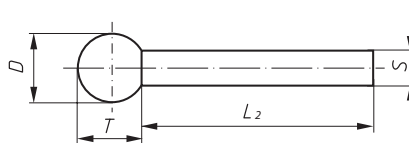
$v_{max.}$: 16 m/s



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2611013206120	P2SP 1320.06	120	13	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2611020326220	P2SP 2032.06	220	20	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

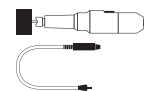
Shape KU, Spherical (according to DIN 69170)



Ordering example: A2615008083120

Further dimensions and grit sizes on request

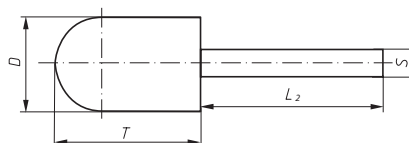
v_{max.}: 16 m/s



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2615008083120	P2KU 0808.03	120	8	8	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2615010103120	P2KU 1010.03	120	10	10	3	30	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	20
A2615016166120	P2KU 1616.06	120	16	16	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2615016166220	P2KU 1616.06	220	16	16	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

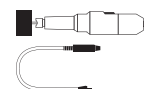
Shape WR, Cylindrical round nose (according to DIN 69170)



Ordering example: A2618016326120

Further dimensions and grit sizes on request

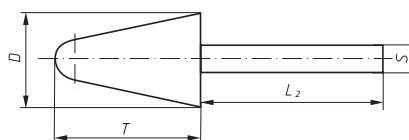
v_{max.}: 16 m/s



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2618016326120	P2WR 1632.06	120	16	32	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

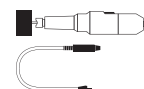
Shape KE, Conical round nose (according to DIN 69170)



Ordering example: A2619010206080

Further dimensions and grit sizes on request

v_{max.}: 16 m/s



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2619010206080	P2KE 1020.06	80	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10
A2619010206120	P2KE 1020.06	120	10	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	10

Felt polishing points, group P3

LUKAS felt polishing points are available in two specifications:

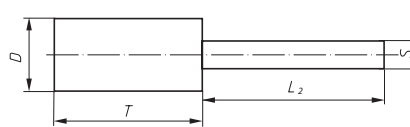
- H3 as per DIN 61200
- H3-S super hard and particularly effective when used in conjunction with diamond paste

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.

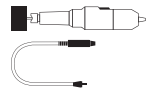
Grinding, Polishing (bonded)

Shape ZY, Cylindrical



Ordering example: A3700006103

Further dimensions on request



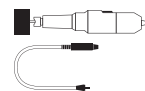
								PG 3								
Product number	Description	Quality	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438									
A3700006103	P3ZY 0610.03	H3	6	10	3	40	1	2	3	4	5	6	7	9	■	20
A37000061030001	P3ZY 0610.03	H3-S	6	10	3	40	1	2	3	4	5	6	7	9	■	20
A3700008103	P3ZY 0810.03	H3	8	10	3	40	1	2	3	4	5	6	7	9	■	20
A37000081030001	P3ZY 0810.03	H3-S	8	10	3	40	1	2	3	4	5	6	7	9	■	20
A3700010123	P3ZY 1012.03	H3	10	12	3	38	1	2	3	4	5	6	7	9	■	20
A37000101230001	P3ZY 1012.03	H3-S	10	12	3	38	1	2	3	4	5	6	7	9	■	20
A3700010156	P3ZY 1015.06	H3	10	15	6	40	1	2	3	4	5	6	7	9	■	10
A37000101560001	P3ZY 1015.06	H3-S	10	15	6	40	1	2	3	4	5	6	7	9	■	10
A3700012153	P3ZY 1215.03	H3	12	15	3	40	1	2	3	4	5	6	7	9	■	20
A37000121530001	P3ZY 1215.03	H3-S	12	15	3	40	1	2	3	4	5	6	7	9	■	20
A3700012206	P3ZY 1220.06	H3	12	20	6	40	1	2	3	4	5	6	7	9	■	10
A37000122060001	P3ZY 1220.06	H3-S	12	20	6	40	1	2	3	4	5	6	7	9	■	10
A3700016206	P3ZY 1620.06	H3	16	20	6	40	1	2	3	4	5	6	7	9	■	10
A3700020256	P3ZY 2025.06	H3	20	25	6	40	1	2	3	4	5	6	7	9	■	10
A37000202560001	P3ZY 2025.06	H3-S	20	25	6	40	1	2	3	4	5	6	7	9	■	10
A3700025306	P3ZY 2530.06	H3	25	30	6	40	1	2	3	4	5	6	7	9	■	10
A3700030406	P3ZY 3040.06	H3	30	40	6	40	1	2	3	4	5	6	7	9	■	10

Shape SP, Arch pointed nose



Ordering example: A3701006103

Further dimensions on request



PG 3

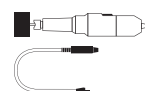
Product number	Description	Quality	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A3701006103	P3SP 0610.03	H3	6	10	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3701008103	P3SP 0810.03	H3	8	10	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3701010123	P3SP 1012.03	H3	10	12	3	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3701010156	P3SP 1015.06	H3	10	15	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3701012206	P3SP 1220.06	H3	12	20	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3701020256	P3SP 2025.06	H3	20	25	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3701025306	P3SP 2530.06	H3	25	30	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3701030406	P3SP 3040.06	H3	30	40	6	40	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10

Shape KU, Spherical



Ordering example: A3703006063

Further dimensions on request



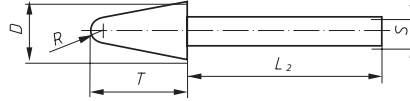
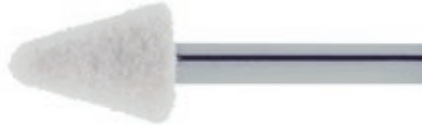
PG 3

Product number	Description	Quality	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A3703006063	P3KU 0605.03	H3	6	5,5	3	39,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3703008083	P3KU 0807.03	H3	8	7,5	3	42,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3703010103	P3KU 1009.03	H3	10	9	3	41	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3703010106	P3KU 1009.06	H3	10	9	6	41	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3703012126	P3KU 1211.06	H3	12	11	6	39	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3703020206	P3KU 2019.06	H3	20	19	6	41	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10

Shape KE, Conical round nose

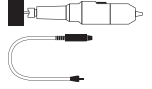


Grinding, Polishing
(bonded)



Ordering example: A3705010123

Further dimensions on request



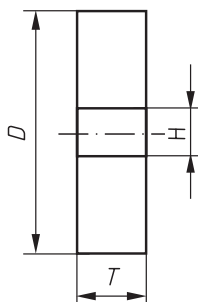
PG 3

Product number	Description	Quality	D mm	T mm	S mm	L ₂ mm	R mm	recommended for Information on page 438		
A3705010123	P3KE 1012.03	H3	10	12	3	38	2,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	20
A3705010156	P3KE 1015.06	H3	10	15	6	40	2,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A37050101560001	P3KE 1015.06	H3-S	10	15	6	40	2,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3705016206	P3KE 1620.06	H3	16	20	6	40	3	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3705020256	P3KE 2025.06	H3	20	25	6	40	3,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3705025306	P3KE 2530.06	H3	25	30	6	40	4,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10
A3705030406	P3KE 3040.06	H3	30	40	6	40	6,5	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■	10

Application example P3

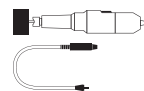


Shape S1, Wheels



Ordering example: A3750040106

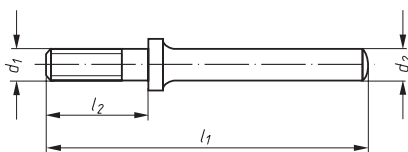
Further dimensions on request



PG 3

Product number	Description	Quality	D mm	T mm	H mm	recommended for	Information on page 438		
A3750040106	P3S1 4010.06	H3	40	10	6	1 2 3 4 5 6 7 9	■	10	
A3750050106	P3S1 5010.06	H3	50	10	6	1 2 3 4 5 6 7 9	■	10	
A3750050206	P3S1 5020.06	H3	50	20	6	1 2 3 4 5 6 7 9	■	10	
A3750060106	P3S1 6010.06	H3	60	10	6	1 2 3 4 5 6 7 9	■	10	
A3750060206	P3S1 6020.06	H3	60	20	6	1 2 3 4 5 6 7 9	■	10	

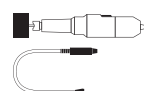
Arbors for felt polishing wheels



Ordering example: A1630780

The delivery includes for each stud

- 2 washers Ø 18 mm
- 2 washers Ø 30 mm
- 1 hex nut



PG 8

Product number	Description	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	n max. (1/min)	recommended for	Information on page 438	
A1630780	ASB 780	M6	20	6	63	7.000		■	5
A1630781	ASB 781	M6	30	6	73	7.000		■	5

Specification and application of diamond pastes

Diamond paste Super-E

Thanks to the high concentration of diamond grains, you can polish even the hardest materials quickly and economically. The optimal shape of the monocrystalline diamonds and the very narrow grain-size distribution guarantee perfect polishing results. Because of its agglomerate-free production and high viscosity – which can be thinned to any degree with water, oil or alcohol – our diamond paste is also ideal for use in machines. The paste was specially developed for mould making.

Features:

- high grain concentration
- perfect grain shape
- free from agglomerates
- narrow grain-size distribution
- monocrystalline
- high viscosity

Benefits/uses:

- polishes the hardest materials quickly and economically
- optimised for machine application
- highly effective
- ideal for mould making
- thin with water, oil or alcohol



Grinding compound



Ordering example: A3760120

Contents: 250 g



PG 13

Product number	Description	Quality	Grit	µm	recommended for Information on page 438		
A3760120	SP-1	medium	120	88 - 125	1 2 3 4 5 6 7	■	1
A3760180	SP-2	fine	180	55 - 88	1 2 3 4 5 6 7	■	1
A3760320	SP-3	very fine	320	20 - 40	1 2 3 4 5 6 7	■	1

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

Diamond pastes



Ordering example: A3410119105



PG 13

Product number	Description	Quality	Grit size µ	Colour of paste	Contents	recommended for Information on page 438		
A3410119105	E-091	Super-E	1	blue	5 g	1 2 3 4 5 6 7 9	■	1
A3410119110	E-091	Super-E	1	blue	10 g	1 2 3 4 5 6 7 9	■	1
A3410119205	E-092	Super-E	3	green	5 g	1 2 3 4 5 6 7 9	■	1
A3410119210	E-092	Super-E	3	green	10 g	1 2 3 4 5 6 7 9	■	1
A3410119305	E-093	Super-E	6	yellow	5 g	1 2 3 4 5 6 7 9	■	1
A3410119310	E-093	Super-E	6	yellow	10 g	1 2 3 4 5 6 7 9	■	1
A3410119405	E-094	Super-E	9	red	5 g	1 2 3 4 5 6 7 9	■	1
A3410119410	E-094	Super-E	9	red	10 g	1 2 3 4 5 6 7 9	■	1
A3410119505	E-095	Super-E	15	pale brown	5 g	1 2 3 4 5 6 7 9	■	1
A3410119510	E-095	Super-E	15	pale brown	10 g	1 2 3 4 5 6 7 9	■	1

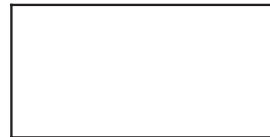
Specification and application P4

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.

Colour	Quality	Colour	Quality	Colour	Quality
pale grey	SiC 80 soft	pale green	SiC 240 soft	pale red	EKW 150 soft
gray	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

Polishing sticks, flat



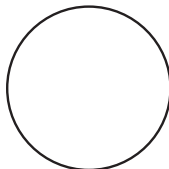
Ordering example: P4SF 0612.070

Further dimensions on request

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

Description	H mm	B mm	L mm	recommended for Information on page 438	PG 3	
					▲	📦
P4SF 0612.070	6	12	70	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 0612.140	6	12	140	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 0816.070	8	16	70	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 0816.140	8	16	140	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 0816.210	8	16	210	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 1020.070	10	20	70	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 1020.140	10	20	140	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 1020.210	10	20	210	① ② ③ ④ ⑤ ⑥ ⑦	▲	10
P4SF 1020.280	10	20	280	① ② ③ ④ ⑤ ⑥ ⑦	▲	10

Polishing sticks, round



Ordering example: P4SR 0006.70

Further dimensions on request

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



PG 3

Description	Ø mm	L mm	recommended for Information on page 438		
P4SR 0006.070	6	70	1 2 3 4 5 6 7	▲	10
P4SR 0006.140	6	140	1 2 3 4 5 6 7	▲	10
P4SR 0010.140	10	140	1 2 3 4 5 6 7	▲	10
P4SR 0010.210	10	210	1 2 3 4 5 6 7	▲	10
P4SR 0010.070	10	70	1 2 3 4 5 6 7	▲	10
P4SR 0012.070	12	70	1 2 3 4 5 6 7	▲	10
P4SR 0012.140	12	140	1 2 3 4 5 6 7	▲	10
P4SR 0012.210	12	210	1 2 3 4 5 6 7	▲	10
P4SR 0012.280	12	280	1 2 3 4 5 6 7	▲	10
P4SR 0015.070	15	70	1 2 3 4 5 6 7	▲	10
P4SR 0015.140	15	140	1 2 3 4 5 6 7	▲	10
P4SR 0015.210	15	210	1 2 3 4 5 6 7	▲	10
P4SR 0015.280	15	280	1 2 3 4 5 6 7	▲	10

Polishing sticks, square



Ordering example: P4SV 0606.070

Further dimensions on request

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



PG 3

Description	H mm	B mm	L mm	recommended for Information on page 438		
P4SV 0606.070	6	6	070	1 2 3 4 5 6 7	▲	10
P4SV 0606.140	6	6	140	1 2 3 4 5 6 7	▲	10
P4SV 1010.070	10	10	70	1 2 3 4 5 6 7	▲	10
P4SV 1010.140	10	10	140	1 2 3 4 5 6 7	▲	10
P4SV 1010.210	10	10	210	1 2 3 4 5 6 7	▲	10
P4SV 1212.140	12	12	140	1 2 3 4 5 6 7	▲	10
P4SV 1212.210	12	12	210	1 2 3 4 5 6 7	▲	10
P4SV 1515.070	15	15	070	1 2 3 4 5 6 7	▲	10
P4SV 1515.140	15	15	140	1 2 3 4 5 6 7	▲	10
P4SV 1515.210	15	15	210	1 2 3 4 5 6 7	▲	10
P4SV 1515.280	15	15	280	1 2 3 4 5 6 7	▲	10

Specification and application P5

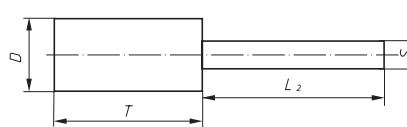
The polishing points of this group are characterized by their special structure and bonding i.e. fibre reinforced. This makes them ideally suited for fine finishing of aluminium and associated alloys, non-ferrous metals and low and high alloyed steels. Due to the fibre reinforcement, these tools have exceptional edge-fray

resistance and stability. Polishing points in group P5 are available in grit sizes detailed below; they are identified with a red marking.



Colour	black	pale grey	red
Grit	46	80	120

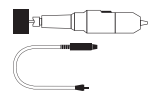
Shape ZY, Cylindrical (according to DIN 69170)



Ordering example: A2620004083080

Further dimensions and grit sizes on request

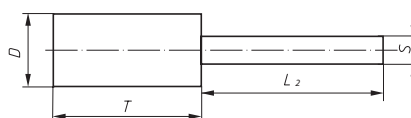
$v_{max.}: 50 \text{ m/s}$



PG 3

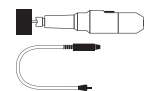
Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2620004083080	P5ZY 0408.03	80	4	8	3	30	1 2 3 4 5 6 7	■	20
A2620004083120	P5ZY 0408.03	120	4	8	3	30	1 2 3 4 5 6 7	■	20
A2620005103080	P5ZY 0510.03	80	5	10	3	30	1 2 3 4 5 6 7	■	20
A2620005103120	P5ZY 0510.03	120	5	10	3	30	1 2 3 4 5 6 7	■	20
A2620006103080	P5ZY 0610.03	80	6	10	3	30	1 2 3 4 5 6 7	■	20
A2620006103120	P5ZY 0610.03	120	6	10	3	30	1 2 3 4 5 6 7	■	20
A2620008103080	P5ZY 0810.03	80	8	10	3	30	1 2 3 4 5 6 7	■	20
A2620008103120	P5ZY 0810.03	120	8	10	3	30	1 2 3 4 5 6 7	■	20
A2620008166046	P5ZY 0816.06	46	8	16	6	30	1 2 3 4 5 6 7	■	10
A2620008166080	P5ZY 0816.06	80	8	16	6	30	1 2 3 4 5 6 7	■	10

Shape ZY, Cylindrical (according to DIN 69170)



Ordering example: A2620004083080

Further dimensions and grit sizes on request

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


Grinding, Polishing (bonded)



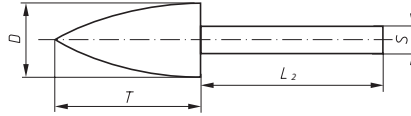
PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438									
A2620008166120	P5ZY 0816.06	120	8	16	6	40	1	2	3	4	5	6	7		■	10
A2620010103080	P5ZY 1010.03	80	10	10	3	30	1	2	3	4	5	6	7		■	20
A2620010103120	P5ZY 1010.03	120	10	10	3	30	1	2	3	4	5	6	7		■	20
A2620010206046	P5ZY 1020.06	46	10	20	6	40	1	2	3	4	5	6	7		■	10
A2620010206080	P5ZY 1020.06	80	10	20	6	40	1	2	3	4	5	6	7		■	10
A2620010206120	P5ZY 1020.06	120	10	20	6	40	1	2	3	4	5	6	7		■	10
A2620013133120	P5ZY 1313.03	120	13	13	3	30	1	2	3	4	5	6	7		■	20
A2620013163080	P5ZY 1316.03	80	13	16	3	30	1	2	3	4	5	6	7		■	20
A2620013206080	P5ZY 1320.06	80	13	20	6	40	1	2	3	4	5	6	7		■	10
A2620013206120	P5ZY 1320.06	120	13	20	6	40	1	2	3	4	5	6	7		■	10
A2620016206080	P5ZY 1620.06	80	16	20	6	40	1	2	3	4	5	6	7		■	10
A2620016206120	P5ZY 1620.06	120	16	20	6	40	1	2	3	4	5	6	7		■	10
A2620016326046	P5ZY 1632.06	46	16	32	6	40	1	2	3	4	5	6	7		■	10
A2620016326080	P5ZY 1632.06	80	16	32	6	40	1	2	3	4	5	6	7		■	10
A2620020206080	P5ZY 2020.06	80	20	20	6	40	1	2	3	4	5	6	7		■	10
A2620020326046	P5ZY 2032.06	46	20	32	6	40	1	2	3	4	5	6	7		■	10
A2620020326120	P5ZY 2032.06	120	20	32	6	40	1	2	3	4	5	6	7		■	10
A2620032326080	P5ZY 3232.06	80	32	32	6	40	1	2	3	4	5	6	7		■	10
A2620040166120	P5ZY 4016.06	120	40	16	6	40	1	2	3	4	5	6	7		■	10

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



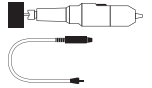
Grinding, Polishing
(bonded)



Ordering example: A2621020326080

Further dimensions and grit sizes on request.

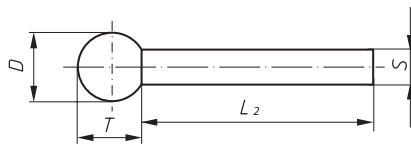
$v_{max.}$: 50 m/s



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2621020326080	P5SP 2032.06	80	20	32	6	40	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input checked="" type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 6 <input checked="" type="checkbox"/> 7	■	10

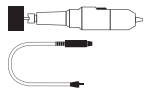
Shape KU, Spherical (according to DIN 69170)



Ordering example: A2625008083080

Further dimensions and grit sizes on request.

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



PG 3

Product number	Description	Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A2625008083080	P5KU 0808.03	80	8	8	3	30	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input checked="" type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 6 <input checked="" type="checkbox"/> 7	■	20

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. They can be used with or without coolant.

For dressing, a dressing stick (page 124) or diamond dressing tool can be used.

Due to long tool life and a good edge-fray resistance, 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", Aluminium oxide white or aluminium oxide "A" grain in the FEPA grit sizes 24 to 1200.

Application examples marbling points P6



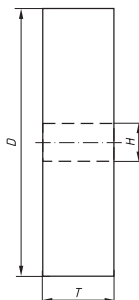
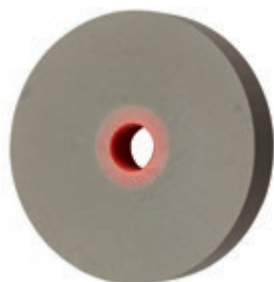
Application recommendations polishing tools P6

Grinding, Polishing
(bonded)

	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			
														120	120				
						80			80	80				80					
					46	46				46				46					
Constructional steel	46																		
Stainless steel, Titanium			400															400	400
			240															240	240
									150									150	150
			120											120	120			120	
			80		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												80						
Solder	240																		
Tin														80					
														46					

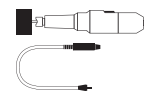
Grit sizes

Polishing wheels, Shape SE 1



Ordering example: A29100600060041

Further dimensions and grit sizes on request

 $v_{max.}$: MWP = 20 m/s
 WP = 16 m/s
 SHP = 32 m/s


PG 4

Product number	Description	Quality / Grit	D mm	T mm	H mm	recommended for Information on page 438		
A29100600060041	P6SE1 06006 B.06	SC 80 MWP	60	6	6	1 2 3 4 5 6 7 9	■	1
A29100600060061	P6SE1 06006 B.06	SC 150 MWP	60	6	6	1 2 3 4 5 6 7 9	■	1
A29101000100041	P6SE1 10010 B.25	SC 80 MWP	100	10	25	1 2 3 4 5 6 7 9	■	1
A29101000200021	P6SE1 10020 B.25	SC 46 MWP	100	20	25	1 2 3 4 5 6 7 9	■	1
A29101000200041	P6SE1 10020 B.25	SC 80 MWP	100	20	25	1 2 3 4 5 6 7 9	■	1
A29101000200061	P6SE1 10020 B.25	SC 150 MWP	100	20	25	1 2 3 4 5 6 7 9	■	1
A29101000200091	P6SE1 10020 B.25	SC 400 MWP	100	20	25	1 2 3 4 5 6 7 9	■	1
A29101250100041	P6SE1 12510 B.25	SC 80 MWP	125	10	25	1 2 3 4 5 6 7 9	■	1
A29101250100061	P6SE1 12510 B.25	SC 150 MWP	125	10	25	1 2 3 4 5 6 7 9	■	1
A29101250200041	P6SE1 12520 B.25	SC 80 MWP	125	20	25	1 2 3 4 5 6 7 9	■	1
A29101250200061	P6SE1 12520 B.25	SC 150 MWP	125	20	25	1 2 3 4 5 6 7 9	■	1
A29101500100061	P6SE1 15010 B.25	SC 150 MWP	150	10	25	1 2 3 4 5 6 7 9	■	1
A29101500100069	P6SE1 15010 B.25	SC 150 SHP	150	10	25	1 2 3 4 5 6 7 9	■	1
A29101500150059	P6SE1 15015 B.20	SC 120 SHP	150	15	20	1 2 3 4 5 6 7 9	■	1
A29101500200040	P6SE1 15020 B.25	SC 80 WP	150	20	25	1 2 3 4 5 6 7 9	■	1
A29101500200041	P6SE1 15020 B.25	SC 80 MWP	150	20	25	1 2 3 4 5 6 7 9	■	1
A29101500200061	P6SE1 15020 B.25	SC 150 MWP	150	20	25	1 2 3 4 5 6 7 9	■	1
A29101500250021	P6SE1 15025 B.20	SC 46 MWP	150	25	20	1 2 3 4 5 6 7 9	■	1
A29101500250040	P6SE1 15025 B.25	SC 80 WP	150	25	25	1 2 3 4 5 6 7 9	■	1
A29101500250061	P6SE1 15025 B.25	SC 150 MWP	150	25	25	1 2 3 4 5 6 7 9	■	1
A29101500250074	P6SE1 15025 B.20	SC 240 MP	150	25	20	1 2 3 4 5 6 7 9	■	1
A29102000250041	P6SE1 20025 B.25	SC 80 MWP	200	25	25	1 2 3 4 5 6 7 9	■	1
A29102000250061	P6SE1 20025 B.25	SC 150 MWP	200	25	25	1 2 3 4 5 6 7 9	■	1

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.

Mounting system for polishing wheels

★★☆

Ordering example: A6981008000



Grinding, Polishing
(bonded)

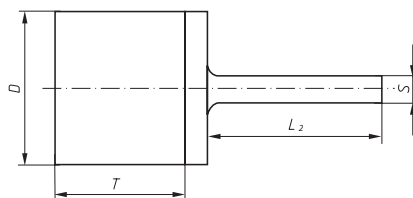


PG 7

Product number	Description	recommended for		
A6981008000	Mounting system MCA+ K25	Information on page 438		1

The mounting system for polishing wheels consists of a plastic sleeve (MCA) and a mounting arbor with 8 mm diameter shank (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.

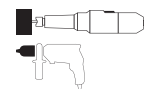
Marbling points, Shape ZY, Cylinder



Ordering example: A29200200306021

Further dimensions and grit sizes on request

$v_{max.}: 10 \text{ m/s}$



PG 4

Product number	Description	Quality / Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438		
A29200200306021	P6MA ZY 2030.06	SC 46 MWP	20	30	6	35	1 2 3 4 5 6 7 9	■	1
A29200300306021	P6MA ZY 3030.06	SC 46 MWP	30	30	6	35	1 2 3 4 5 6 7 9	■	1
A29200400306046	P6MA ZY 4030.06	SC 46 MWP	40	30	6	35	1 2 3 4 5 6 7 9	■	1
A29200500306046	P6MA ZY 5030.06	SC 46 MWP	50	30	6	35	1 2 3 4 5 6 7 9	■	1
A29200500306034	P6MA ZY 5030.06	SC 60 MP	50	30	6	35	1 2 3 4 5 6 7 9	■	1
A29200600306046	P6MA ZY 6030.06	SC 46 MWP	60	30	6	35	1 2 3 4 5 6 7 9	■	1

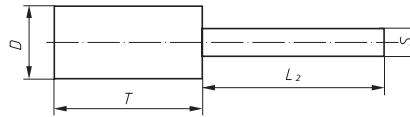
The marbling points can be used to work stainless steels, aluminium and non-ferrous metals (peacock-eye, clouds).

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

Polishing points, Shape ZY, Cylindrical



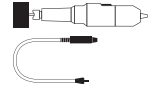
Grinding, Polishing
(bonded)



Ordering example: A29300080103048

Further dimensions and grit sizes on request.

v_{max.}: 20 m/s



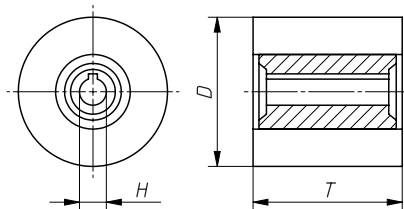
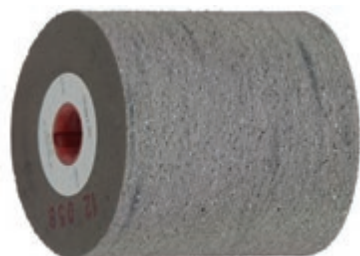
PG 4

Product number	Description	Quality / Grit	D mm	T mm	S mm	L ₂ mm	recommended for Information on page 438										
A29300080103048	P6ZY 0810.03	SC 80 HP	8	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300080103068	P6ZY 0810.03	SC 150 HP	8	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300080103078	P6ZY 0810.03	SC 240 HP	8	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300080163048	P6ZY 0816.03	SC 80 HP	8	16	3	30	1	2	3	4	5	6	7	9	■	10	
A29300080163068	P6ZY 0816.03	SC 150 HP	8	16	3	30	1	2	3	4	5	6	7	9	■	10	
A29300080163078	P6ZY 0816.03	SC 240 HP	8	16	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100103048	P6ZY 1010.03	SC 80 HP	10	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100103068	P6ZY 1010.03	SC 150 HP	10	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100103078	P6ZY 1010.03	SC 240 HP	10	10	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100203048	P6ZY 1020.03	SC 80 HP	10	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100203068	P6ZY 1020.03	SC 150 HP	10	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300100203078	P6ZY 1020.03	SC 240 HP	10	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300130203048	P6ZY 1320.03	SC 80 HP	13	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300160203028	P6ZY 1620.03	SC 46 HP	16	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300160203048	P6ZY 1620.03	SC 80 HP	16	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300160203068	P6ZY 1620.03	SC 150 HP	16	20	3	30	1	2	3	4	5	6	7	9	■	10	
A29300160203078	P6ZY 1620.03	SC 240 HP	16	20	3	40	1	2	3	4	5	6	7	9	■	10	
A69300160203094	P6ZY 1620.03	SC 400 MP	16	20	3	40	1	2	3	4	5	6	7	9	■	10	
A693001602030H0	P6ZY 1620.03	SC 800 WP	16	20	3	40	1	2	3	4	5	6	7	9	■	10	
A29300200206028	P6ZY 2020.06	SC 46 HP	20	20	6	40	1	2	3	4	5	6	7	9	■	10	
A29300200206068	P6ZY 2020.06	SC 150 HP	20	20	6	40	1	2	3	4	5	6	7	9	■	10	
A69300200306044	P6ZY 2030.06	SC 80 MP	20	30	6	40	1	2	3	4	5	6	7	9	■	10	
A29300250206048	P6ZY 2520.06	SC 80 HP	25	20	6	40	1	2	3	4	5	6	7	9	■	10	
A29300300306028	P6ZY 3030.06	SC 46 HP	30	30	6	40	1	2	3	4	5	6	7	9	■	10	
A29300300306068	P6ZY 3030.06	SC 150 HP	30	30	6	40	1	2	3	4	5	6	7	9	■	10	
A29300300306078	P6ZY 3030.06	SC 240 HP	30	30	6	40	1	2	3	4	5	6	7	9	■	10	
A69300400306078	P6ZY 4030.06	SC 240 HP	40	30	6	40	1	2	3	4	5	6	7	9	■	10	
A29300400406028	P6ZY 4040.06	SC 46 HP	40	40	6	40	1	2	3	4	5	6	7	9	■	10	
A69300400406048	P6ZY 4040.06	SC 80 HP	40	40	6	40	1	2	3	4	5	6	7	9	■	10	
A69300400406064	P6ZY 4040.06	SC 150 MP	40	40	6	40	1	2	3	4	5	6	7	9	■	10	
A29300400406068	P6ZY 4040.06	SC 150 HP	40	40	6	40	1	2	3	4	5	6	7	9	■	10	
A69300400406091	P6ZY 4040.06	SC 400 MWP	40	40	6	40	1	2	3	4	5	6	7	9	■	10	
A29300500406028	P6ZY 5040.06	SC 46 HP	50	40	6	40	1	2	3	4	5	6	7	9	■	10	
A29300500406068	P6ZY 5040.06	SC 150 HP	50	40	6	40	1	2	3	4	5	6	7	9	■	10	
A29300600406028	P6ZY 6040.06	SC 46 HP	60	40	6	40	1	2	3	4	5	6	7	9	■	10	
A29300600406068	P6ZY 6040.06	SC 150 HP	60	40	6	40	1	2	3	4	5	6	7	9	■	10	

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

Applications: Bores, fillet weldings, moulds tools

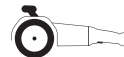
Polishing roll, P6PW



Ordering example: A29401000500041

Further dimensions and grit sizes on request

Machines to suit: page 376

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


PG 4

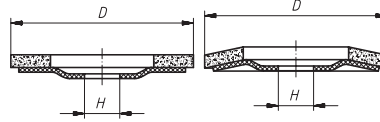
Product number	Description	Quality / Grit	D mm	T mm	H mm	recommended for Information on page 438		
A29401000500041	P6PW 100050	SC 80 MWP	100	50	19	1 2 3 4 5 6 7 9	■	1
A29401001000011	P6PW 100100	SC 24 MWP	100	100	19	1 2 3 4 5 6 7 9	■	1
A29401001000020	P6PW 100100	SC 46 WP	100	100	19	1 2 3 4 5 6 7 9	■	1
A29401001000021	P6PW 100100	SC 46 MWP	100	100	19	1 2 3 4 5 6 7 9	■	1
A29401001000040	P6PW 100100	SC 80 WP	100	100	19	1 2 3 4 5 6 7 9	■	1
A29401001000041	P6PW 100100	SC 80 MWP	100	100	19	1 2 3 4 5 6 7 9	■	1

Polishing roll P6PW for the polishing machine
for perfectly brushed or dull-brushed surfaces

Set Polishing discs P6PT



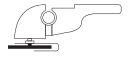
Grinding, Polishing (bonded)



Ordering example: A6700023

v_{max.}: 32 m/s

SIC = Silicon carbide



PG 4

Product number	Description	Quality	D mm	Contents	je 1	recommended for Information on page 438									
A6700023	P6PT 125 (flat) SET	P6PT	125	4-pieces	P150, 240, 400, 800	1	2	3	4	5	6	7		■	1
A6700024	P6PT 125 (dished) SET	P6PT	125	4-pieces	P150, 240, 400, 800	1	2	3	4	5	6	7		■	1

Create extremely smooth surfaces – right up to mirror finish – very quickly on large surfaces.

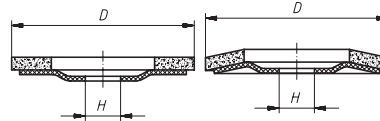
Range of application:

- polishing of different surfaces
- cleaning and derusting
- removing paint and coatings
- replaces cloth discs, felt discs and polishing pastes

Benefits:

- for standard controlled angle grinders
- clean working conditions, as no abrasive paste is required
- rapid work progress

Polishing disc P6PT



Ordering example: A671612515014

v_{max.}: 32 m/s

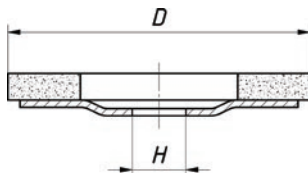
SIC = Silicon carbide



PG 4

Product number	Description	Quality	D mm	reinforced hardness	recommended for Information on page 438									
A671612515014	P6PT 125 (flat)	SC 150 MP	125	medium	1	2	3	4	5	6	7		■	5
A671612515014001	P6PT 125 (flat)	SC 150 MWP	125	medium	1	2	3	4	5	6	7		■	5
A671612524014	P6PT 125 (flat)	SC 240 MWP	125	fine	1	2	3	4	5	6	7		■	5
A671612540014	P6PT 125 (flat)	SC 400 WP	125	very fine	1	2	3	4	5	6	7		■	5
A671612580014	P6PT 125 (flat)	SC 800 WP	125	ultra fine	1	2	3	4	5	6	7		■	5
A671712515014	P6PT 125 (dished)	SC 150 MP	125	medium	1	2	3	4	5	6	7		■	5
A671712524014	P6PT 125 (dished)	SC 240 MWP	125	fine	1	2	3	4	5	6	7		■	5
A671712540014	P6PT 125 (dished)	SC 400 WP	125	very fine	1	2	3	4	5	6	7		■	5
A671712580014	P6PT 125 (dished)	SC 800 WP	125	ultra fine	1	2	3	4	5	6	7		■	5
A6717125120014	P6PT 125 (dished)	SC 1200 WP	125	ultra fine	1	2	3	4	5	6	7		■	5

Polishing disc P6PT quality CG



Ordering example: A671611506014

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

EKW = Aluminum oxide white

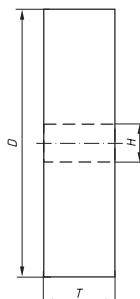
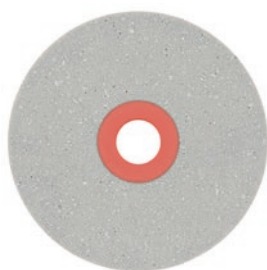


PG 4

Product number	Description	Quality	D mm	B mm	n max. (1/min)	recommended for												Information on page 438	Image
						1	2	3	4	5	6	7	8	9	10	11	12		
A671611506014	P6PT 115 (flat)	EKW 60 SHP CG	115	22,23	12.200	1	2	3	4	5	6							■	5
A671611512014	P6PT 115 (flat)	EKW 120 SHP CG	115	22,23	12.200	1	2	3	4	5	6							■	5
A671612506014	P6PT 125 (flat)	EKW 60 SHP CG	125	22,23	12.200	1	2	3	4	5	6							■	5
A671612512014	P6PT 125 (flat)	EKW 120 SHP CG	125	22,23	12.200	1	2	3	4	5	6							■	5

Grinding, Polishing (bonded)

Polishing wheels, Shape SE1 CG

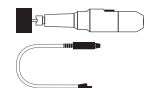


Ordering example: A29100800060B39

Further dimensions and grit sizes in request

$v_{max.}$: 63 m/s

EKW = Aluminum oxide white



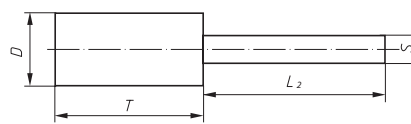
PG 4

Product number	Description	Quality/Grit	D mm	T mm	H mm	recommended for												Information on page 438	Image
						1	2	3	4	5	6	7	8	9	10	11	12		
A29100800060B39	P6SE1 08006 B.06	EKW 60 SHP CG	80	6	6	1	2	3	4	5	6							■	20
A29100800060B59	P6SE1 08006 B.06	EKW 120 SHP CG	80	6	6	1	2	3	4	5	6							■	20
A29101500100B39	P6SE1 15010 B.25	EKW 60 SHP CG	150	10	25	1	2	3	4	5	6							■	10
A29101500100B59	P6SE1 15010 B.25	EKW 120 SHP CG	150	10	25	1	2	3	4	5	6							■	10
A29102000200B39	P6SE1 20020 B.25	EKW 60 SHP CG	200	20	25	1	2	3	4	5	6							■	10
A29102000200B59	P6SE1 20020 B.25	EKW 120 SHP CG	200	20	25	1	2	3	4	5	6							■	10

Polishing points, Cylindrical, Group P6 CG



Grinding, Polishing
(bonded)

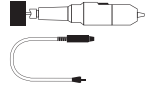


Ordering example: A29300130203B39

Further dimensions and grit sizes on request.

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

EKW = Aluminum oxide white



PG 4

Product number	Description	Quality/Grit	D mm	T mm	H mm	recommended for Information on page 438										
A29300130203B39	P6ZY 1320.03	EKW 60 SHP CG	13	20	3	1	2	3	4	5	6	7			■	10
A29300130203B59	P6ZY 1320.03	EKW 120 SHP CG	13	20	3	1	2	3	4	5	6	7			■	10
A29300160206B39	P6ZY 1620.06	EKW 60 SHP CG	16	20	6	1	2	3	4	5	6	7			■	10
A69300160206B59	P6ZY 1620.06	EKW 120 SHP CG	16	20	6	1	2	3	4	5	6	7			■	10
A69300200206B39	P6ZY 2020.06	EKW 60 SHP CG	20	20	6	1	2	3	4	5	6	7			■	10
A29300200206B59	P6ZY 2020.06	EKW 120 SHP CG	20	20	6	1	2	3	4	5	6	7			■	10
A29300300306B39	P6ZY 3030.06	EKW 60 SHP CG	30	30	6	1	2	3	4	5	6	7			■	10
A69300300306B59	P6ZY 3030.06	EKW 120 SHP CG	30	30	6	1	2	3	4	5	6	7			■	10

Specification and application P7

LUKAS polishing points, discs and lenses have been especially developed for intricate mechanical and laboratory use. The small

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

Polishing discs and polishing lenses in a soft elastomer bonding

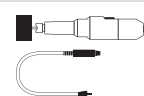


Ordering example: A2950000101007

Further dimensions and grit sizes on request

v_{max} : 16 m/s

Suitable mounting arbors on request



Product number	Description	Quality	Shape	D mm	T mm	H mm	recommended for Information on page 438	PG 4	
								1	2
A2950000101007	P7- R22	SICGR 240		22	3,5	1,8	1 2 3 4 5 6 7 9	■	100
A2950000105007	P7- L22	SICGR 240		22	3,4	1,8	1 2 3 4 5 6 7 9	■	100

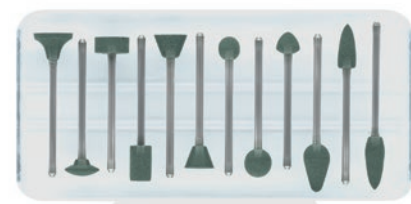
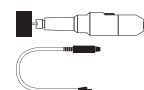
Assortment of small polishing points with soft elastomer bond mounted on shank



Ordering example: A29551301582077

Individual tools available on request.

v_{max} : 16 m/s



Product number	Description	Quality	Contents	shank mm	recommended for Information on page 438	PG 4		
						1	2	3
A29551301582077	P7Sort. 130-15	SICGR 240	12-pieces	2,35	1 2 3 4 5 6 7 9	■	1	
A29551301582071	P7Sort. 130-15	SICGR 400	12-pieces	2,35	1 2 3 4 5 6 7 9	■	1	