

[www.lukas-erzett.com](http://www.lukas-erzett.com)



# Products. Applications. 2014

Always the right tool





# Unique. Multi-talented. LUKAS

## Anytime – Anywhere

High performance tools  
for the world market

## Continuous process development

Changes  
create new  
possibilities

## Surface finish optimisation consultant

Individual.  
Problem solver.  
Innovative.

## We are there for you

## Assortments for distributors

Excellent presentation  
at point of sale

## Quality is not by chance

High performance  
consistency at  
all levels

$$E = iq + M^2$$

Success = innovative quality  
+ focus on people

## A strong brand awareness



## Challenges drive us to a first class performance

See. Learn.  
Apply.

## Product range

- High Performance
- Industry
- Base

## Optimised logistic

**Multi-faceted.  
Ability in abundance.  
A network.**



**Forceful product and technological development**

Identify trends early and immediately formulate the correct solution.

**Family concern**

A stable balance of growth, risk and return

**Always the right tool**

Special tools for special applications

**B2B**

There is no such word as „can't“!

**Consultation on site**



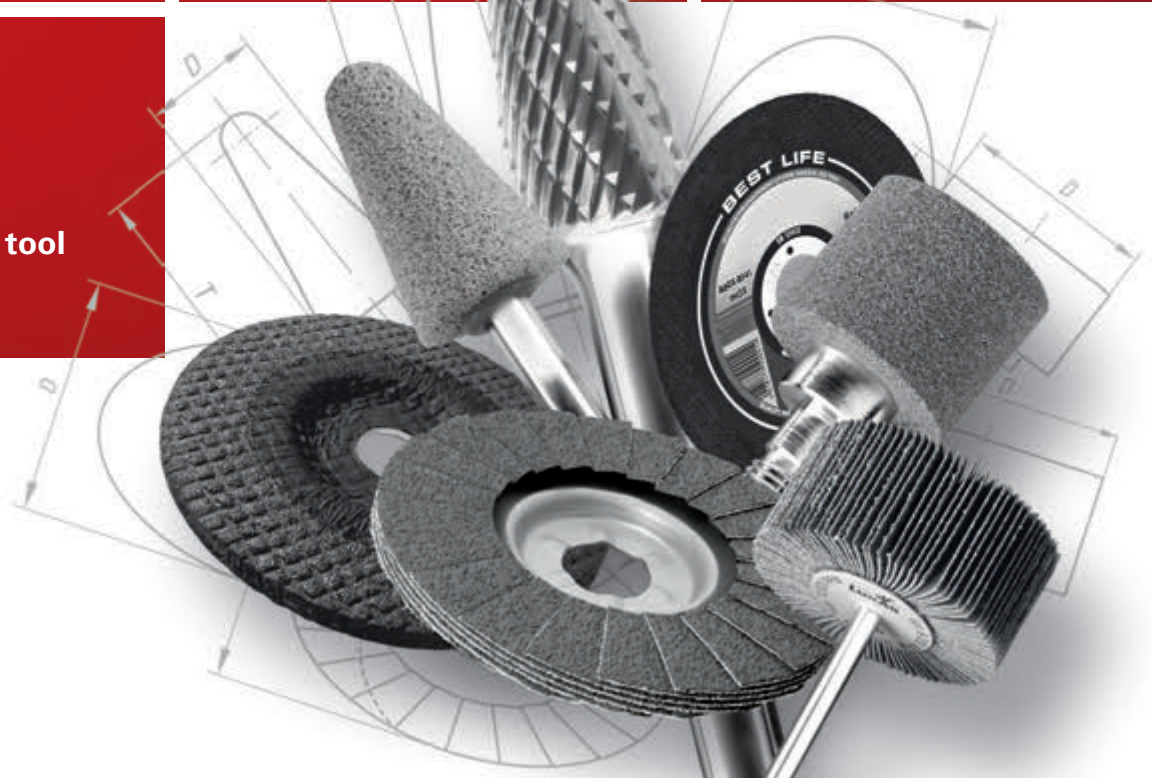
**Catalogue**

Perfect navigation to the correct tool



**Focus on people**

Our employees are the most important tool



# Powerful tool innovations at a glance



**Tungsten Carbide Burrs with TiAlN-coating**  
For an even longer service life.

Page 56



**Rasp burrs and Rotary files**  
For lightweight materials and excellent surfaces.

Page 57



**Burrs with extended shank length**  
For places difficult to reach.

Page 60



**Mounted points  
in CERAMIC quality**  
For the hardest materials.

From page 106



**Mounted points, HOK type**  
With spherical shape aluminium  
oxide for rubber and plastics.

Page 110



**Mounted points, conical,  
RKD 46 O V13**  
For welding seam machining.

Page 118



**Polishing wheels, group P6**

For best surface finishes.

**Page 157**



**Cutting and grinding discs in a new design**

For greater perspective.

**From page 175**



**97 new cutting and grinding discs**

Perfectly engineered for your application.

**From page 184**



**Abrasive disc for cutting and deburring**

For rapid, efficient working.

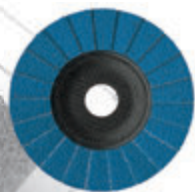
**Page 195**



**Diamond disc LD3 S13**

For top performance in concrete and construction material.

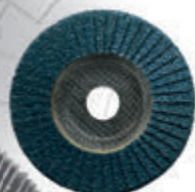
**Page 211**



**Flap disc V2 Power**

Now also available with 230 mm diameter.

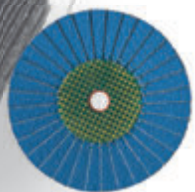
**Page 234**



**Flap disc V4 Master**

For rounding off sharp edges.

**Page 239**



**Flap disc SLTflex – the fillet weld professional**

Now with M14 or 5/8" thread.

**Page 241**



# ...and even more innovations



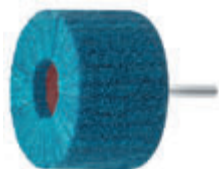
**Flap disc SLTK with plastic backing plate**  
For every application.

Page 248



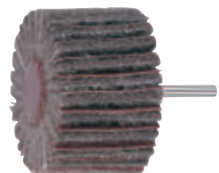
**LSL- the flap wheel for angle grinders**  
Now with M14 or 5/8" thread.

Page 280



**Mounted flap wheel with zirconia fleece**  
For a perfect finish.

Page 269



**Mounted flap wheel with TF fleece**  
With reinforced fleece for uniform wear.

Page 273



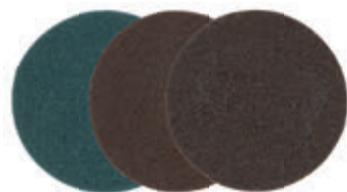
**Conditioning rolls with thread**  
For speed-controlled angle grinders.

From page 289



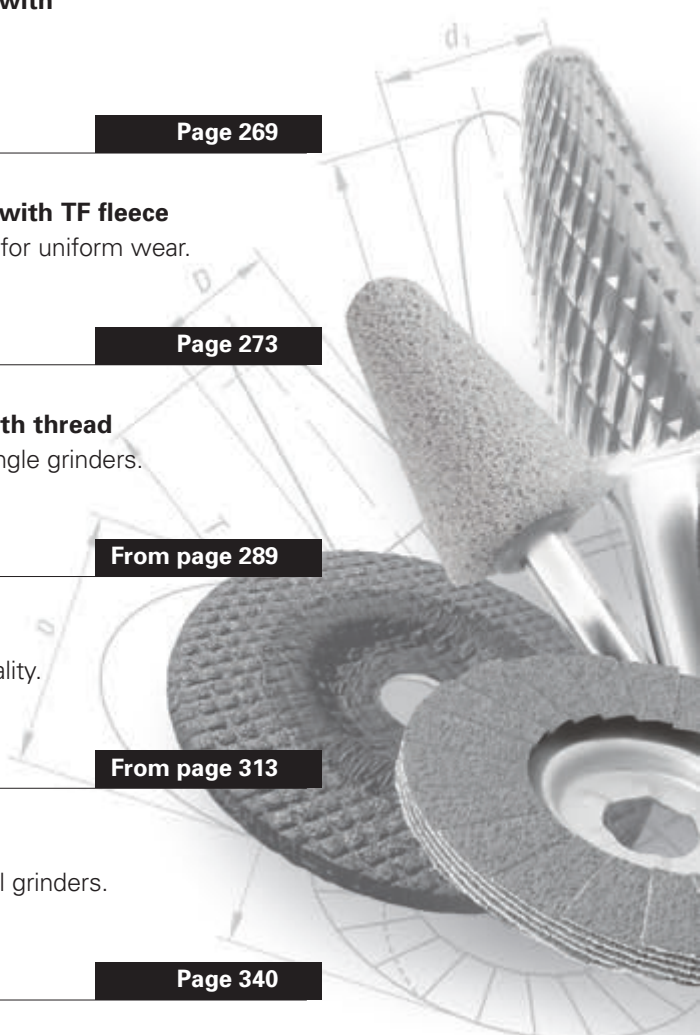
**Abrasive caps NKS**  
Improved industrial quality.

From page 313



**Abrasive fleece discs**  
For eccentric and angel grinders.

Page 340





**Semi-flexible grinding disc SHF**

For paint, adhesive, plastic, etc.

**Page 346**



**Backing pad STF HL with cooling ribs**

For optimum cooling and increased performance.

**Page 347**



**Power tools TGD with turbo drive**

Maximum speed and performance.

**Page 388**



**Conditioning machine ESM**

Creates high-gloss stainless steel surfaces.

**Page 390**



**LUKAS dealer products for point of sale**

A wide range of new packaging for dealers.

**From page 392**



**Arbors ASB**

For optimum mounting.

**Page 402**

**LUKAS tool recommendation – the free test package**

For testing selected tools.

On the internet under [www.lukas-erzett.com](http://www.lukas-erzett.com)

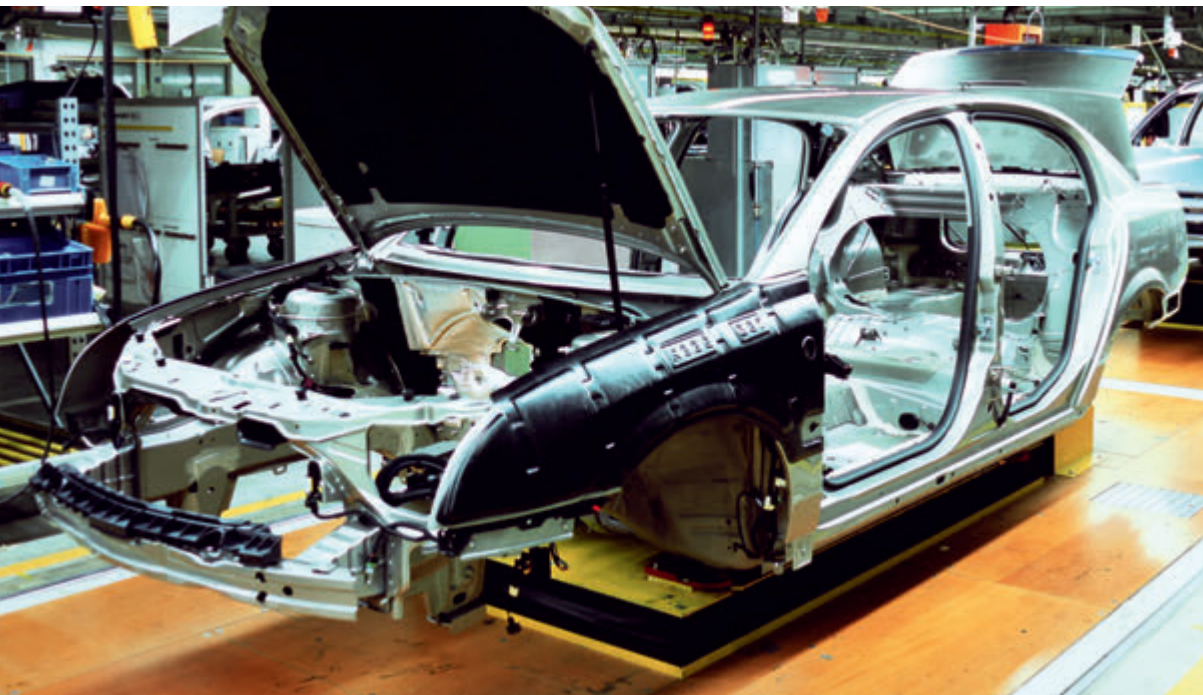




My idea.

Professionally put into practice.

My success.





## Unique. Versatile. LUKAS.

Our motto “Always the right tool at hand” is a promise that we, as an owner-managed international industrial company, have adhered to day after day for your benefit – for more than 75 years!

Excellent quality, high performance and efficiency – these are the advantages you can expect from our brands. Strict quality and safety standards ensure that you can work safely and ergonomically with our tools, despite deadline pressure and a harsh working environment.



## Surface optimisation consultancy

Benefit from our customized tool solutions. We work with you to develop an individual customized solution if you cannot find the right product in our comprehensive catalogue range.

Our application experts and design engineers speak your language and are committed to providing maximum service by gaining a thorough understanding of your processes.

Contact us today! Our surface optimization consultants will assist you during selection of your individual tool.



# LUKAS – high performance tools for the world market



**LUKAS site 1, Engelskirchen**

**Schleifscheibenfabrik Rottluff,  
Chemnitz**

As a leading European specialist for the development and manufacture of high quality tools for deburring, grinding and polishing, we have high expectations: the consistent achievement of customer satisfaction.

Partly through our innovative production solutions, we provide you with a competitive edge which will contribute to your success in the marketplace. We advise and support you via our international organisations.



### LUKAS-sales-team national



Laura-Jane Alberts



Nadine Behnke



Frank Bosbach



Gudrun Böttcher



Eva Jensch



Christian Pallesche



Markus Pollak



Günter Rosner



Lukas Schultz



Ulrike Thomas

### LUKAS-sales-team international



Julia Alef



Adam Angres



Claudia Biesenbach



Andrea Bittner



Pawel Bojar



Marcus W. Held



Christoph Hoffmann



Sandra Holtzem



Dorothea Konopka



Katharina Kroner



Maria Lopez-Lopez



Aline Matenia



Martin Reif



Marion Riettmann



Bernd Schorr



Tobias Tröbs



Nathalie Poulalier-Thiel



Elke Twardowski



Sarah Michelle Villanueva

**We are there for you:**  
Fon +49 2263 84-0 · Fax +49 2263 84-327  
[le@lukas-erzett.de](mailto:le@lukas-erzett.de)





# Special challenges require special tools



With the resources of a privately owned company and production flexibility, we can offer not only individual solutions but also more than 4,500 ex-stock products with their recommended applications.

As a pioneer of such a customer friendly philosophy, we have at our disposal a solid wealth of experience.

**Always the right tool.**



# Quality is no coincidence

Our goal is high performance: Understand the basic conditions and evaluate daily. This concept is strictly used at all levels – at the desk or workbench. In any event, you can rely on the highly esteemed LUKAS – quality.

All processes are centrally controlled by regular audits of the DQS quality management system (DIN EN 9001: 2008 and VDA 6 Part 4)  
We live and breathe quality!

We put great emphasis on all aspects of safety – especially the LUKAS abrasive products (in the catalogue bearing the oSa-logo) which are manufactured and tested to the appropriate stringent oSa safety regulations. In addition, we strongly advise that notice is taken of the FEPA safety recommendations when using our abrasive products; these can be downloaded from [www.lukas-erzett.com](http://www.lukas-erzett.com).



Please note the FEPA safety recommendations for the safe handling of grinding tools. These can be downloaded from [www.lukas-erzett.com](http://www.lukas-erzett.com)



The Symbol of Safety

Organization for the Safety of Abrasives (oSa), website: [www.osa-abrasives.org](http://www.osa-abrasives.org)

**In addition, we are members to the following professional associations:**



Verband Deutscher  
Schleifmittelwerke e. V.  
[www.vds-bonn.de](http://www.vds-bonn.de)



Fachverband  
Werkzeugindustrie e. V.  
[www.werkzeug.org](http://www.werkzeug.org)



## Tool safety

We therefore manufacture and test our tools in according with the specifications of the following standards:

- EN 12413** Safety requirements for bonded abrasive products
- EN 13743** Safety requirements for coated abrasive products
- EN 13236** Safety requirements for diamond and CBN products
- EN 1083-2** Power driven brushes - Part 2: Safety requirements

# For all materials and for any application

## Colour coding system

To easily identify products in the catalogue, we have colour coded our product groups – simply turn to your relevant colour.

### Milling and Engraving Tools



### CBN- and diamond tools for precision machining



### Bonded Grinding and Polishing Tools



### Power Tools



### Cutting and Grinding Discs



### Product selection for retailers, assortments and accessories



### Flexible Grinding and Polishing Tools



## Which product for which material?

The material best suited to our tools is denoted by numerals for the respective application recommendation. The fold-out on the last page identifies which material relates to which number. To search, simply unfold and you will immediately be able to identify which tool is best suited respectively suitable for a particular material classification.



## Material Groups

sixteen different material groups distinguish the area of application for the specific tools. The material-group-no. categorizes the application in conjunction with the material to be processed into best suitable and suitable.

## Product lines, series and brands

Product lines and series are identified as follows in product tables:

- 1 Brand identification
- 2 Product line identification
- 3 Product series identification



# LUKAS product lines and brands

The quality and categories of our different product lines continue to be identified using colours.

## High Performance

Top quality products with an **optimal tool life** to cost ratio



## Industry

Proven product range with **excellent performance** to price ratio



## Base

Tools with **attractive price** to performance ratio



## iQ Series

**Within our product identification iQ-Series, we have incorporated our High Performance Range.** All aspects have been optimised regarding performance and tool life. You benefit from an exceptional stock removal rate, extremely long tool life, more flexibility in areas of application, greater vision of the workpiece etc etc etc.

# Technical teaching centre: See. Learn. Apply.



In our modern equipped test and schooling centre, we impart important knowledge regarding our products; and we give you the opportunity in the adjoining test centre to put theory into practise.

We would be pleased to arrange for you:

- **Practical ad theoretical schooling**
- **Competent technical product advise**
- **Individual tooling trials**

**Call us: +49 2263 84-0  
and make an appointment  
with us.**



# We would appreciate your visit

Do you want to experience LUKAS live? We would be pleased to give you a personal invitation and welcome you to Engelskirchen. We are glad to be of service and would appreciate the opportunity to demonstrate emphatically how you can benefit from applying our tooling solutions; these can be individually tailored to your specific requirements.



LUKAS-ERZETT Vereinigte Schleif- und Fräswerkzeugfabriken GmbH & Co. KG  
Gebrüder-Lukas-Straße 1  
51766 Engelskirchen · Germany  
Fon +49 2263 84-0 · Fax +49 2263 84-300  
le@lukas-erzett.de





# Fast. Safe. Cost-effective.



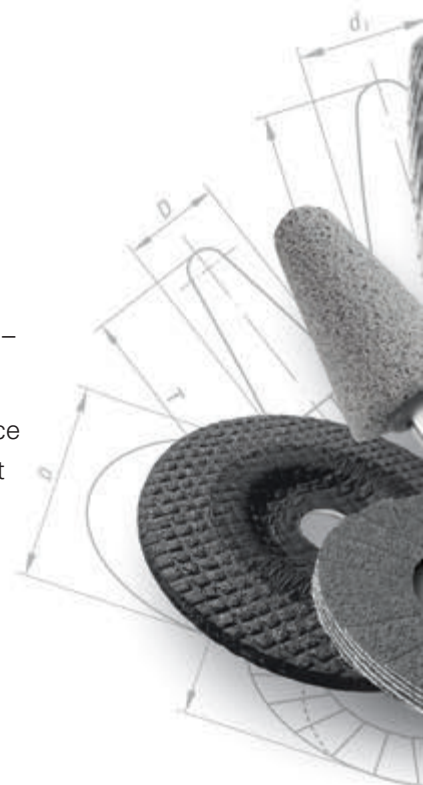
Optimal logistics ensures maximum service.

Since the end of April 2013 tightened safety regulations are valid EU-wide for airfreight shipments. According to the new regulations the airfreight of a company can only be considered as "safe" if it has the status of „officially recognized known sender“.

If this status is missing, the freight has to be considerably checked by a service provider – higher costs and possible delays are the consequences.

We are one of the first companies which has been validated by the Federal Aviation Office as "Known Sender". On April 25th, 2013 – even before the amendment came into effect we were granted the authorization of the Federal Aviation Office.

Due to the status „Known Sender“ we are able to hand over your airfreight – fast, safe and cost-effective – to a certified forwarding company without further examination.



# Top services for you

In addition to developing outstanding and innovative tools, we make focused investments in optimizing our services. A good example for this is our new logistics centre at Engelskirchen.

With this centre, we are able to supply goods across Europe within just 48 hours. We believe that this contributes to smooth workflows for your production and ensures that we are more closely involved in your processes.

Our optimized logistics service includes the use of advanced Navision ERP software with tailored eCommerce solutions. Using this software, we can provide electronic catalogues to BME standard or can handle your orders electronically right up to the delivery note.

We offer data handling in all current formats (ASCII, XML, EDIFACT, VDA, BMECat, Opentrans) as well as transmission via http, https, Telebox, e-mail or Odette. In addition, connection with NEXMART, the dealer portal for hardware, tools and fittings, is available.



**Our IT-staff is always at your disposal for any advice**





# LUKAS Products for Retailers

We have packaged some of our products in special boxes designed specifically for the retail trade. To support you in selling our products with strong and uniform brand positioning, we will also send you practical presentation racks in an eye-catching design.



### Excellent Presentation

By lighting the racks from above, the attention of your customers will be drawn straight to the products.



### Customer Friendly Assortment

The pegs can be placed in the back wall of the rack in many different ways so you can present the LUKAS product line in many different ways.



### Practical Drawer

The drawer in the rack provides you with enough space to maintain an adequate supply.



The LUKAS dealer range comprises:

- iQ series
- Mounted points
- Mounted flap wheels
- Tungsten carbide burrs
- Tool-sets



# LUKAS sales promotion at the POS

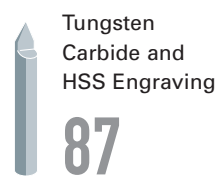
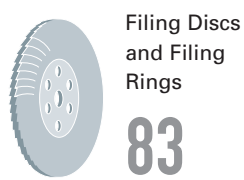
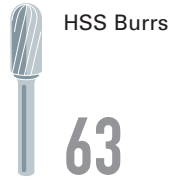
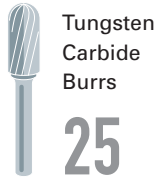
We have greatly enhanced our dealer portfolio so that you can offer a broader LUKAS range, which includes tools for different applications. In addition to the iQ series, we provide mounted points, mounted flap wheels, tungsten carbide burrs und tool-sets in modern, appealing LUKAS sales packaging.

All packs come with the information necessary for your customers to be able to choose the tool they want without the need to ask. The POS presentation format enables customers to pick up the packs themselves, whilst at the same time serves as a point of contact if they wish to ask for more information about products and the product range.

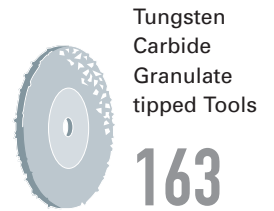
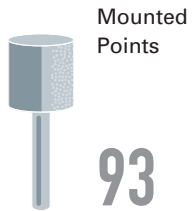
With the versatile LUKAS dealer range, you can attract additional target groups, who regard outstanding quality and the good image of an established brand as being of great importance.



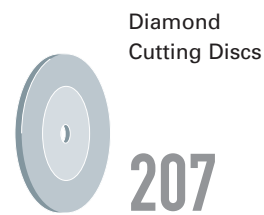
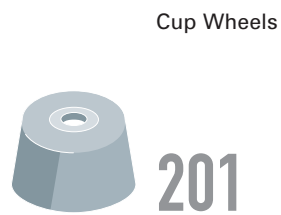
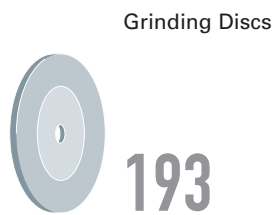
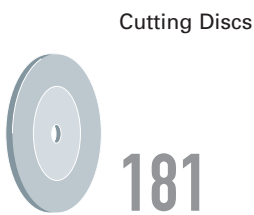
## Milling and Engraving Tools



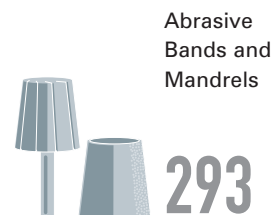
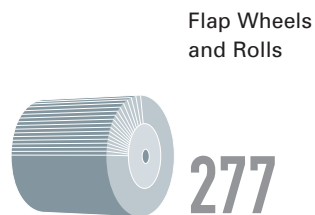
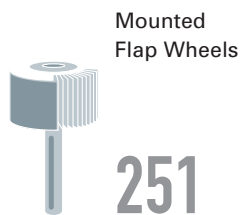
## Bonded Grinding and Polishing Tools



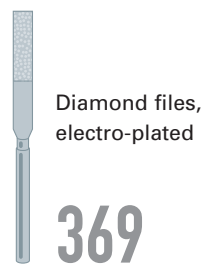
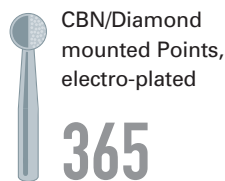
## Cutting and Grinding Discs



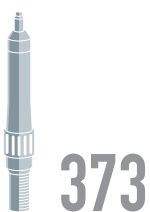
## Flexible Grinding and Polishing Tools



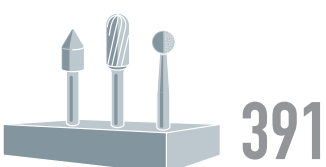
## CBN- and diamond tools for precision machining



## Air Tools



## Product selection for retailers, assortments and accessories



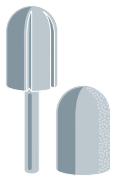
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Technical  
Brushes

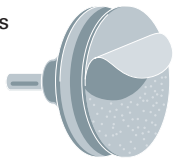


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Abrasive Caps  
and Mandrels,  
Abrasive Sleeves  
and Mandrels

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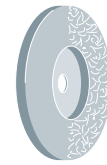
Abrasive Discs  
and Mandrels

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Fibre discs, backing  
plates, economy rolls,  
abrasive sheets  
and fleece rolls

337



AS-cleaning  
fleece

351



“We are constantly looking for innovations to fire our customers' enthusiasm, which is also why we discuss technical developments with them at eye level. Tailor-made tool solutions ensure that our customers enjoy healthy competitive advantages.”

Dr. Peter Bühner



## Tungsten Carbide Burrs

- 26** Technical Information

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- 27** A summary of available shapes

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- 28** Recommendations for use and cuts

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- 30** Choosing the appropriate Burr

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- 31** Coatings

---

- 32** Tungsten Carbide Burrs

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### Product line marking

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



## Technical Information

### Quality

LUKAS carbide burrs are manufactured using high quality types of carbide and modern CNC automatic grinding machines in order to guarantee precision and repeatability of angle, profile and twist. Carbide burrs manufactured to your drawings or details assist in solving your particular stock removal problem.

### Application

The best results are obtained by selecting the recommended cut and speed. Please refer to the cutting speeds in the table on page 28 or according to the table illustrating the various cuts on page 29.

### Power tools

Electric and pneumatic power tools are used; the bearings should be in good condition and the collets running true. Vibration and chatter will cause premature wear and tooth breakage. High pressure will reduce tool life and decreases tool efficiency.

### Shanks

For safety reasons the largest possible shank diameter should always be selected from the table. Other shank diameters and lengths are available on request. A selection of burrs with extra long shanks appears on page 60.

### Robot application

LUKAS tungsten carbide burrs are precision tools, and have produced excellent results when used in conjunction with industrial robots. We can also develop the optimal burr for your particular application.

### Coated

The reasons for producing cutting tools with hard coatings such as TiN, TiCN, TiALN and LTE are as follows:

- to increase tool life
- to reduce machining forces
- to improve chip removal

The increase in tool life is mainly the result of the considerably higher surface hardness of the coating in comparison to the base material of the tool itself. In addition, due to the high chemical stability, it minimizes the reaction between the cutting edge of the tool and the chip to be removed.

The reduction of machining forces and the improvement in chip removal are achieved through a reduction in the friction between the free cutting zone of the tool and workpiece on the one hand, and the cutting edge of the tool and the chip removed on the other. The reduction in friction depends on the coating improving the surface finish and as previously described by largely avoiding any chemical reaction.

Our technicians would be pleased to help you in the selection of the correct coating. Please note the different possibilities on page 31.

### Special tools

Tungsten carbide burrs manufactured to your design or drawing guarantee the LUKAS high quality standard, and can therefore assist in solving your particular machining problem.

### Packaging

We use plastics-packaging; please select the respective packing unit from our product lists.

### Recommendations for use

Select the cut to suit the material to be machined. Please kindly follow the principle: **The harder the material, the finer the cut!** The correct selection of speed is the basis of achieving optimum machining results and long tool-life; please refer to the adjoining table. On the following pages you will find some assistance to choose the right speed for your process. Use the highest possible speed within the indicated area.

Too low a speed results in vibration, chipping and premature wear! Reduce the speed of the burrs only when using in large arc angles or when used on low heat conducting materials. Never let the shank and head become discoloured blue. For safety reasons, extended shanks should also be run at low speed.

The power of your machine should be compatible with the machining process. A reduction in RPM due to lack of power – particularly common with pneumatic tools – should be avoided. Collets must run true. Run-out and vibration will result in chipping and premature wear.

For the same reasons, take care that the machine bearings are in perfect condition.

To avoid vibrations and shank breakage, select the shortest shank overhang as possible.

## A summary of available shapes

Shape	Type	Shape (DIN 8033)	Shape (LUKAS)	Page
	Cylindrical	ZYA	<b>A</b>	32
	Cylindrical round nose	WRC	<b>C</b>	35
	Spherical	KUD	<b>D</b>	37
	Oval	TRE	<b>E</b>	39
	Arch round nose	RBF	<b>F</b>	40
	Arch pointed nose	SPG	<b>G</b>	41
	Flame	–	<b>H</b>	43
	Internal	–	<b>I</b>	43
	Counter sink	KSJ	<b>J</b>	44
	Conical round nose	KEL	<b>L</b>	44
	Conical pointed nose	SKM	<b>M</b>	46
	Inverted cone	WKN	<b>N</b>	47
	Burrs for the machining of plastic	–	<b>P</b>	48
	Engraving Cutters	–	–	49
	Burrs for radius trimming (external)	–	<b>R</b>	50
	Burrs for radius trimming (internal)	–	<b>S</b>	50
	Miniature Burrs	–	–	51
	Small Burrs	–	–	52
	Tool-Set	–	–	54
	Burrs with TiAlN-coating	–	–	56
	Rasp burrs	–	–	57
	Rotary files	–	–	58
	Burrs for machining of non-ferrous metals	–	–	59
	Burrs with extended shank length	–	–	60
	Some examples of our competitive performance	–	–	62
	Power Tools	–	–	373

### Three steps to your optimum burr:

- 1 Select the **material** and **machining mode** (coarse to fine) from the table and
- 2 read off the recommended **cut** and **cutting speed**.
- 3 Determine the appropriate **speed** for your power tool in the second table.

### Recommendations for use of tungsten carbide burrs

1				2	
Material	Lukas material group (see also fold-out tab)	Strength [N/mm <sup>2</sup> ]	Machining	Cut	Recommended cutting speed vc [m/min]
Steel, cast steel	1 STEEL AND CAST STEEL	< 800	coarse	Z3, Z7, ZX	500 – 700
			medium	Z5	300 – 500
			fine	ZF3	500 – 700
	2 ALLOYED/HARDENED & TEMPERED STEELS	800 to 1200	coarse	Z7, ZX	400 – 600
			medium	Z5	300 – 400
			fine	ZF3	400 – 600
	3 TOOL STEELS	> 1200	coarse	Z7, Z4	300 – 500
			medium	Z5	300 – 400
			fine	ZF3	400 – 600
Stainless steel	4 RUST/ACID/HEAT-RESISTANT STEEL AND CAST STEEL	up to 800	coarse	Z2, Z6	400 – 500
			medium	Z3, Z7, Z4, Z5	300 – 500
			fine	ZF3	400 – 600
Cast metal	5 CAST IRON	150 to 300	coarse	Z6	400 – 600
			medium	Z7	300 – 500
	300 to 450	coarse	Z7	300 – 500	
		medium	Z5	300 – 500	
		fine	ZF3	400 – 700	
		Non-ferrous metal 1	6 ALUMINIUM, MAGNESIUM AND COPPER ALLOYS	up to 450	coarse
	medium			Z1	500 – 900
BRASS, BRONZE, TITANIUM	up to 450		coarse	Z9, Z1	400 – 800
	from 450	medium	Z2	400 – 600	
		fine	ZF3	500 – 600	
Non-ferrous metal 2	7 TITANIUM AND NICKEL ALLOYS	up to 900	coarse	Z6	300 – 500
			medium	Z7	300 – 400
	900 to 1500	fine	ZF3	500 – 700	
		coarse	Z4	300 – 400	
		medium	Z5	400 – 500	
		fine	ZF3	400 – 600	
Plastics and wood	8 PLASTIC/WOOD/RUBBER	20 to 400	coarse	Z1, Z9	500 – 1000
			fine	ZP, ZR2	500 – 900
	400 to 1000	coarse	Z1	500 – 800	
		fine	Z2, ZR2	400 – 800	

Tip: Page 27 contains a complete overview of the shapes for your chosen milling tool.

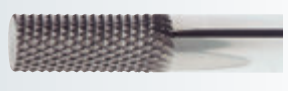
## Machining



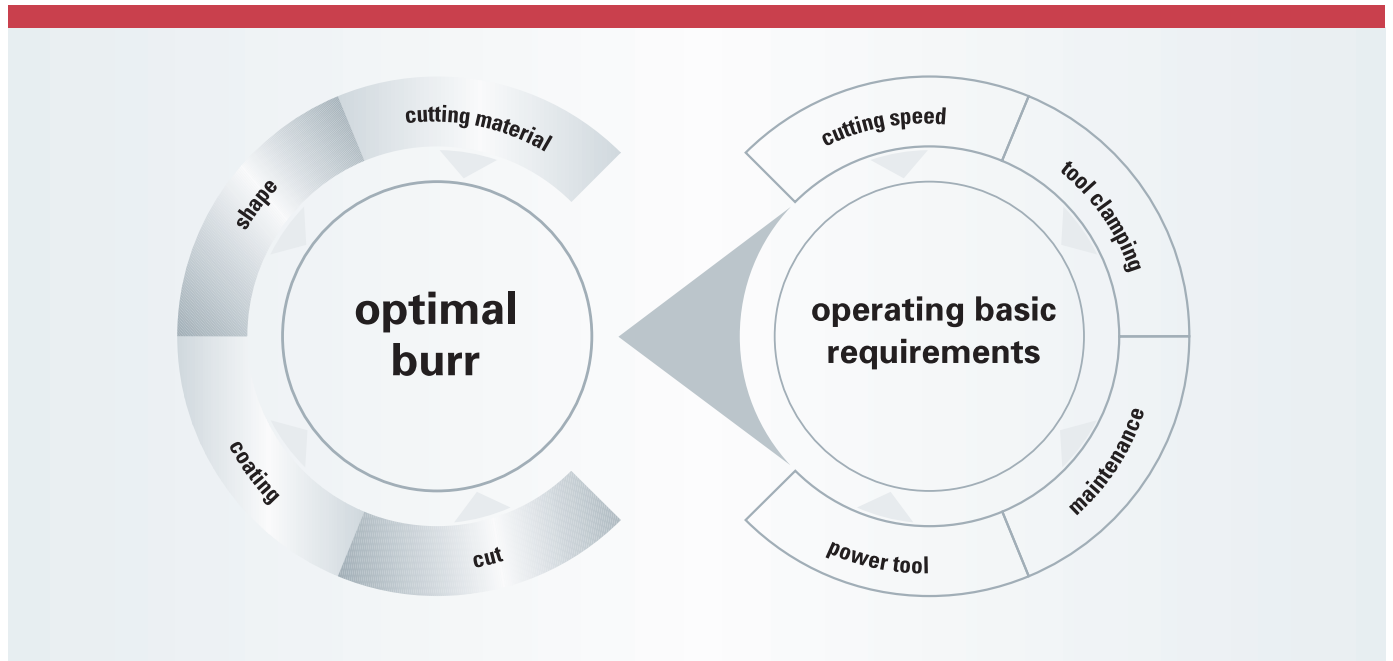
**Rotational speeds for milling tools** based on the tool diameter and cutting speed

3									
Recommended cutting speed $v_c$ [m/min]									
		300	400	500	600	700	800	900	1000
		Rotational speed [min <sup>-1</sup> ]							
Tool diameter [mm]	2	48.000	64.000	80.000	95.000	111.000	127.000	143.000	159.000
	3	32.000	42.000	53.000	64.000	74.000	85.000	95.000	106.000
	4	24.000	32.000	40.000	48.000	56.000	64.000	72.000	80.000
	6	16.000	21.000	27.000	32.000	37.000	42.000	48.000	53.000
	8	12.000	16.000	20.000	24.000	28.000	32.000	36.000	40.000
	10	10.000	13.000	16.000	19.000	22.000	25.000	29.000	32.000
	12	8.000	11.000	13.000	16.000	19.000	21.000	24.000	27.000
	16	6.000	8.000	10.000	12.000	14.000	16.000	18.000	20.000
	20	5.000	6.000	8.000	10.000	11.000	13.000	14.000	16.000



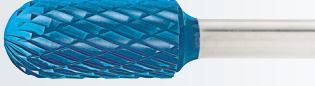

## Cuts

	<b>Z 9</b>	Very coarse single cut with faceting for soft materials		<b>Z 4</b>	Fine cross cut for hard materials
	<b>Z 1</b>	Coarse cut for soft materials		<b>Z 6</b>	Robust cross cut
	<b>Z 2</b>	Robust single cut for high stock removal		<b>Z 7</b>	Medium cross cut
	<b>Z 3</b>	Medium single cut		<b>ZI</b>	Fine cross cut especially to machine the inside of the bore (page 43)
	<b>Z 5</b>	Very fine single cut for high-quality surfaces		<b>ZP</b>	Cross cut for machining plastic (page 48)
	<b>ZF</b>	Very fine cross cut		<b>ZX</b>	Universal cross cut for practically every application
	<b>ZR</b>	Rasp cut for pattern construction			

### Choosing the appropriate Burr



## Coatings

Coatings	Specification (LUKAS)	Properties	Friction on steel (dry)
	<b>TiN</b> (Titanium nitride)	general purpose coating for steel and cast iron, high toughness	0,65–0,70 µm
	<b>TiCN</b> (Titanium carbon nitride)	wear resisting coating for fine deburring process; suited to applications with higher thermal and shock loads	0,10–0,20 µm
	<b>TiAlN</b> (Titanium aluminium nitride) (see page 56)	high performance coating with a high degree of hardness and low heat conductivity; therefore suitable for high thermal and mechanical applications	0,30–0,35 µm
	<b>LTE</b> (hard coating carbon-based)	Special coating with lotus-effect for long chip and smearing non-ferrous metals, particularly aluminium alloys. Excellent sliding friction properties reducing loading on cutting edges.	0,10–0,20 µm

### The reasons for producing cutting tools with hard coatings are as follows:

- to increase tool life
- to reduce machining forces
- to improve chip removal

### Take advantage of our grind service

LUKAS tungsten carbide burrs can be resharpened several times when blunted by normal working conditions. Burrs with severe damage to the cutting edges are priced accordingly. We can offer this service providing the tools are delivered to us carriage paid.

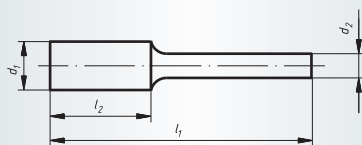


*The symbol denotes burrs which can be reground against enquiry.*



### Shape A, Cylindrical

Ordering example: A10010210305



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs	
								1	2	3	4	5	6	7	8		
HFA 0210.03	Z5	ZYA 0210	2	10	3	40	A10010210305	1	2	3	4			7			■
HFA 0313.03	Z3	ZYA 0313	3	13	3	40	A10010313303	1	2	3	4			7			■
HFA 0313.03	Z4	ZYA 0313	3	13	3	40	A10010313304		2	3	4			7	8		■
HFA 0313.03	Z5	ZYA 0313	3	13	3	40	A10010313305	1	2	3	4			7			■
HFA 0313.03	Z7	ZYA 0313	3	13	3	40	A10010313308	1	2	3		5		7			■
HFA 0413.06	Z3	ZYA 0413	4	13	6	50	A10010413603	1	2	3	4			7			■
HFA 0413.06	Z7	ZYA 0413	4	13	6	50	A10010413608	1	2	3		5		7			■
HFA 0607.03	Z5	ZYA 0607	6	7	3	37	A10010607305	1	2	3	4			7			■ Ⓢ
HFA 0613.03	Z5	ZYA 0613	6	13	3	43	A10010613305	1	2	3	4			7			■ Ⓢ
HFA 0613.03	Z7	ZYA 0613	6	13	3	43	A10010613308	1	2	3		5		7			■ Ⓢ
HFA 0616.06	Z2	ZYA 0616	6	16	6	50	A10010616602	1				5	6		8		■ Ⓢ
HFA 0616.06	Z3	ZYA 0616	6	16	6	50	A10010616603	1	2	3	4			7			■ Ⓢ
HFA 0616.06	Z4	ZYA 0616	6	16	6	50	A10010616604		2	3	4			7	8		■ Ⓢ
HFA 0616.06	Z5	ZYA 0616	6	16	6	50	A10010616605	1	2	3	4			7			■ Ⓢ
HFA 0616.06	Z7	ZYA 0616	6	16	6	50	A10010616608	1	2	3		5		7			■ Ⓢ
HFA 0616.06	Z9	ZYA 0616	6	16	6	50	A10010616609						6		8		■
HFA 0820.06	Z3	ZYA 0820	8	20	6	60	A10010820603	1	2	3	4			7			■ Ⓢ
HFA 0820.06	Z4	ZYA 0820	8	20	6	60	A10010820604		2	3	4			7	8		■ Ⓢ
HFA 0820.06	Z5	ZYA 0820	8	20	6	60	A10010820605	1	2	3	4			7			■ Ⓢ
HFA 0820.06	Z7	ZYA 0820	8	20	6	60	A10010820608	1	2	3		5		7			■ Ⓢ
HFA 1013.06	Z3	ZYA 1013	10	13	6	53	A10011013603	1	2	3	4			7			■ Ⓢ
HFA 1013.06	Z7	ZYA 1013	10	13	6	53	A10011013608	1	2	3		5		7			■ Ⓢ
HFA 1013.08	Z3	ZYA 1013	10	13	8	53	A10011013803	1	2	3	4			7			■ Ⓢ
HFA 1020.06	Z3	ZYA 1020	10	20	6	60	A10011020603	1	2	3	4			7			■ Ⓢ
HFA 1020.06	Z4	ZYA 1020	10	20	6	60	A10011020604		2	3	4			7	8		■ Ⓢ
HFA 1020.06	Z7	ZYA 1020	10	20	6	60	A10011020608	1	2	3		5		7			■ Ⓢ
HFA 1025.06	Z4	ZYA 1025	10	25	6	65	A10011025604		2	3	4			7	8		■ Ⓢ
HFA 1025.06	Z7	ZYA 1025	10	25	6	65	A10011025608	1	2	3		5		7			■ Ⓢ
HFA 1025.08	Z3	ZYA 1025	10	25	8	65	A10011025803	1	2	3	4			7			■ Ⓢ
HFA 1225.06	Z3	ZYA 1225	12	25	6	65	A10011225603	1	2	3	4			7			■ Ⓢ
HFA 1225.06	Z4	ZYA 1225	12	25	6	65	A10011225604		2	3	4			7	8		■ Ⓢ
HFA 1225.06	Z5	ZYA 1225	12	25	6	65	A10011225605	1	2	3	4			7			■ Ⓢ
HFA 1225.06	Z7	ZYA 1225	12	25	6	65	A10011225608	1	2	3		5		7			■ Ⓢ
HFA 1225.06	Z9	ZYA 1225	12	25	6	65	A10011225609						6		8		■
HFA 1225.08	Z4	ZYA 1225	12	25	8	65	A10011225804		2	3	4			7	8		■ Ⓢ
HFA 1225.08	Z9	ZYA 1225	12	25	8	65	A10011225809						6		8		■
HFA 1625.06	Z3	ZYA 1625	16	25	6	65	A10011625603	1	2	3	4			7			■ Ⓢ
HFA 1625.06	Z7	ZYA 1625	16	25	6	65	A10011625608	1	2	3		5		7			■ Ⓢ
HFA 1625.06	Z9	ZYA 1625	16	25	6	65	A10011625609						6		8		■ Ⓢ
HFA 1625.08	Z9	ZYA 1625	16	25	8	65	A10011625809						6		8		■ Ⓢ

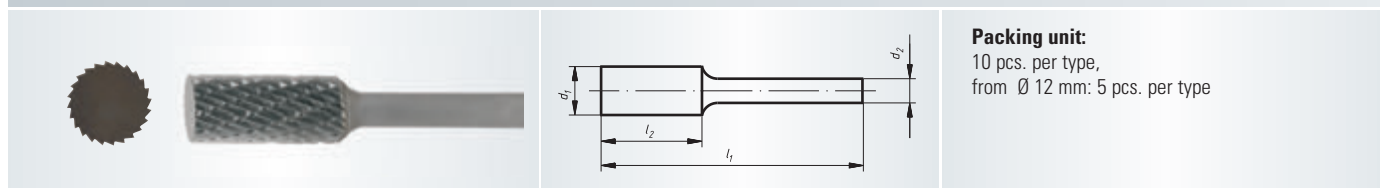




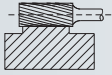
Base

Shape A, Cylindrical BASE-X

Ordering example:A10010313322



**Packing unit:**  
10 pcs. per type,  
from Ø 12 mm: 5 pcs. per type

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs	
HFA 0313.03 BASE-X	ZX	ZYA 0313	3	13	3	40	A10010313322		<input type="checkbox"/>	NEW
HFA 0616.06 BASE-X	ZX	ZYA 0616	6	16	6	50	A10010616622		<input type="checkbox"/>	NEW
HFA 0820.06 BASE-X	ZX	ZYA 0820	8	20	6	60	A10010820622		<input type="checkbox"/>	NEW
HFA 1020.06 BASE-X	ZX	ZYA 1020	10	20	6	60	A10011020622		<input type="checkbox"/>	NEW
HFA 1225.06 BASE-X	ZX	ZYA 1225	12	25	6	65	A10011225622		<input type="checkbox"/>	NEW



## Always the right tool



**Mounted points and polishing points:**  
11,000 specially produced items according to customers' requests reflect the big variety of these products.

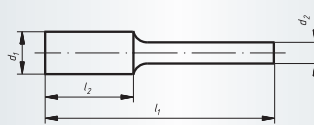
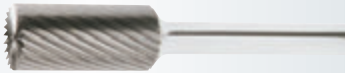
**Martin Reif**  
Sales Department

[www.lukas-erzett.com](http://www.lukas-erzett.com)



### Shape A, Cylindrical, with end-cut

Ordering example: A100102103050001



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

regrind service, please enquire

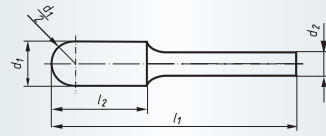
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs	
								1	2	3	4	5	6	7	8		
HFAS 0210.03	Z5	ZYA-S 0210	2	10	3	40	A100102103050001	1	2	3	4			7			■
HFAS 0313.03	Z3	ZYA-S 0313	3	13	3	40	A100103133030001	1	2	3	4			7			■
HFAS 0313.03	Z4	ZYA-S 0313	3	13	3	40	A100103133040001		2	3	4			7	8		■
HFAS 0313.03	Z5	ZYA-S 0313	3	13	3	40	A100103133050001	1	2	3	4			7			■
HFAS 0313.03	Z7	ZYA-S 0313	3	13	3	40	A100103133080001	1	2	3		5		7			■
HFAS 0413.06	Z3	ZYA-S 0413	4	13	6	50	A100104136030001	1	2	3	4			7			■
HFAS 0413.06	Z7	ZYA-S 0413	4	13	6	50	A100104136080001	1	2	3		5		7			■
HFAS 0607.03	Z5	ZYA-S 0607	6	7	3	37	A100106073050001	1	2	3	4			7			■
HFAS 0613.03	Z5	ZYA-S 0613	6	13	3	43	A100106133050001	1	2	3	4			7			■
HFAS 0613.03	Z7	ZYA-S 0613	6	13	3	43	A100106133080001	1	2	3		5		7			■
HFAS 0616.06	Z3	ZYA-S 0616	6	16	6	50	A100106166030001	1	2	3	4			7			■
HFAS 0616.06	Z4	ZYA-S 0616	6	16	6	50	A100106166040001		2	3	4			7	8		■
HFAS 0616.06	Z5	ZYA-S 0616	6	16	6	50	A100106166050001	1	2	3	4			7			■
HFAS 0616.06	Z7	ZYA-S 0616	6	16	6	50	A100106166080001	1	2	3		5		7			■
HFAS 0820.06	Z3	ZYA-S 0820	8	20	6	60	A100108206030001	1	2	3	4			7			■
HFAS 0820.06	Z4	ZYA-S 0820	8	20	6	60	A100108206040001		2	3	4			7	8		■
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HFAS 0820.06	Z7	ZYA-S 0820	8	20	6	60	A100108206080001	1	2	3		5		7			■
HFAS 1013.06	Z3	ZYA-S 1013	10	13	6	53	A100110136030001	1	2	3	4			7			■
HFAS 1013.06	Z7	ZYA-S 1013	10	13	6	53	A100110136080001	1	2	3		5		7			■
HFAS 1020.06	Z3	ZYA-S 1020	10	20	6	60	A100110206030001	1	2	3	4			7			■
HFAS 1020.06	Z4	ZYA-S 1020	10	20	6	60	A100110206040001		2	3	4			7	8		■
HFAS 1020.06	Z7	ZYA-S 1020	10	20	6	60	A100110206080001	1	2	3		5		7			■
HFAS 1025.06	Z4	ZYA-S 1025	10	25	6	65	A100110256040001		2	3	4			7	8		■
HFAS 1025.06	Z7	ZYA-S 1025	10	25	6	65	A100110256080001	1	2	3		5		7			■
HFAS 1225.06	Z3	ZYA-S 1225	12	25	6	65	A100112256030001	1	2	3	4			7			■
HFAS 1225.06	Z4	ZYA-S 1225	12	25	6	65	A100112256040001		2	3	4			7	8		■
HFAS 1225.06	Z5	ZYA-S 1225	12	25	6	65	A100112256050001	1	2	3	4			7			■
HFAS 1225.06	Z7	ZYA-S 1225	12	25	6	65	A100112256080001	1	2	3		5		7			■
HFAS 1225.08	Z4	ZYA-S 1225	12	25	8	65	A100112258040001		2	3	4			7	8		■
HFAS 1225.08	Z7	ZYA-S 1225	12	25	8	65	A100112258080001	1	2	3		5		7			■
HFAS 1625.06	Z3	ZYA-S 1625	16	25	6	65	A100116256030001	1	2	3	4			7			■
HFAS 1625.06	Z7	ZYA-S 1625	16	25	6	65	A100116256080001	1	2	3		5		7			■



Industry

Shape C, Cylindrical Round nose

Ordering example: A10020210305



Packing unit:

1 pc. per type

Further dimensions, cuts and shank lengths on request.

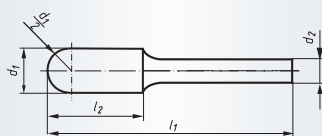
Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs
								1	2	3	4	5	6	7	8	
HFC 0210.03	Z5	WRC 0210	2	10	3	40	A10020210305	1	2	3	4		7			■
HFC 0210.03	Z7	WRC 0210	2	10	3	40	A10020210308	1	2	3		5		7		■
HFC 0313.03	Z2	WRC 0313	3	13	3	40	A10020313302	1				5	6		8	■
HFC 0313.03	Z3	WRC 0313	3	13	3	40	A10020313303	1	2	3	4			7		■
HFC 0313.03	Z4	WRC 0313	3	13	3	40	A10020313304		2	3	4			7	8	■
HFC 0313.03	Z5	WRC 0313	3	13	3	40	A10020313305	1	2	3	4			7		■
HFC 0313.03	Z7	WRC 0313	3	13	3	40	A10020313308	1	2	3		5		7		■
HFC 0413.06	Z3	WRC 0413	4	13	6	50	A10020413603	1	2	3	4			7		■
HFC 0413.06	Z4	WRC 0413	4	13	6	50	A10020413604		2	3	4			7	8	■
HFC 0413.06	Z7	WRC 0413	4	13	6	50	A10020413608	1	2	3		5		7		■ Ⓢ
HFC 0613.03	Z5	WRC 0613	6	13	3	43	A10020613305	1	2	3	4			7		■ Ⓢ
HFC 0613.03	Z7	WRC 0613	6	13	3	43	A10020613308	1	2	3		5		7		■ Ⓢ
HFC 0616.06	Z1	WRC 0616	6	16	6	50	A10020616601						6		8	■
HFC 0616.06	Z2	WRC 0616	6	16	6	50	A10020616602	1				5	6		8	■ Ⓢ
HFC 0616.06	Z3	WRC 0616	6	16	6	50	A10020616603	1	2	3	4			7		■ Ⓢ
HFC 0616.06	Z4	WRC 0616	6	16	6	50	A10020616604		2	3	4			7	8	■ Ⓢ
HFC 0616.06	Z5	WRC 0616	6	16	6	50	A10020616605	1	2	3	4			7		■ Ⓢ
HFC 0616.06	Z7	WRC 0616	6	16	6	50	A10020616608	1	2	3		5		7		■ Ⓢ
HFC 0616.06	Z9	WRC 0616	6	16	6	50	A10020616609						6		8	■
HFC 0820.06	Z3	WRC 0820	8	20	6	60	A10020820603	1	2	3	4			7		■ Ⓢ
HFC 0820.06	Z4	WRC 0820	8	20	6	60	A10020820604		2	3	4			7	8	■ Ⓢ
HFC 0820.06	Z5	WRC 0820	8	20	6	60	A10020820605	1	2	3	4			7		■ Ⓢ
HFC 0820.06	Z6	WRC 0820	8	20	6	60	A10020820606		2	3	4			7	8	■ Ⓢ
HFC 0820.06	Z7	WRC 0820	8	20	6	60	A10020820608	1	2	3		5		7		■ Ⓢ
HFC 0820.06	Z9	WRC 0820	8	20	6	60	A10020820609						6		8	■
HFC 1020.06	Z3	WRC 1020	10	20	6	60	A10021020603	1	2	3	4			7		■ Ⓢ
HFC 1020.06	Z4	WRC 1020	10	20	6	60	A10021020604		2	3	4			7	8	■ Ⓢ
HFC 1020.06	Z5	WRC 1020	10	20	6	60	A10021020605	1	2	3	4			7		■ Ⓢ
HFC 1020.06	Z6	WRC 1020	10	20	6	60	A10021020606		2	3	4			7	8	■ Ⓢ
HFC 1020.06	Z7	WRC 1020	10	20	6	60	A10021020608	1	2	3		5		7		■ Ⓢ
HFC 1020.08	Z4	WRC 1020	10	20	8	60	A10021020804		2	3	4			7	8	■ Ⓢ
HFC 1020.08	Z7	WRC 1020	10	20	8	60	A10021020808	1	2	3		5		7		■ Ⓢ
HFC 1025.06	Z7	WRC 1025	10	25	6	65	A10021025608	1	2	3		5		7		■ Ⓢ
HFC 1225.06	Z1	WRC 1225	12	25	6	65	A10021225601						6		8	■ Ⓢ
HFC 1225.06	Z2	WRC 1225	12	25	6	65	A10021225602	1				5	6		8	■ Ⓢ
HFC 1225.06	Z3	WRC 1225	12	25	6	65	A10021225603	1	2	3	4			7		■ Ⓢ
HFC 1225.06	Z4	WRC 1225	12	25	6	65	A10021225604		2	3	4			7	8	■ Ⓢ
HFC 1225.06	Z5	WRC 1225	12	25	6	65	A10021225605	1	2	3	4			7		■ Ⓢ
HFC 1225.06	Z6	WRC 1225	12	25	6	65	A10021225606		2	3	4			7	8	■ Ⓢ
HFC 1225.06	Z7	WRC 1225	12	25	6	65	A10021225608	1	2	3		5		7		■ Ⓢ



### Shape C, Cylindrical Round nose

Ordering example: A10021225609



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

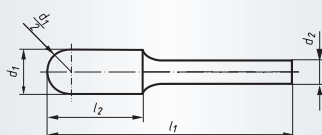
Ⓢ *regrind service, please enquire*

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs	
								1	2	3	4	5	6	7	8		
HFC 1225.06	Z9	WRC 1225	12	25	6	65	A10021225609						6		8		■
HFC 1225.08	Z3	WRC 1225	12	25	8	65	A10021225803	1	2	3	4				7		■ Ⓢ
HFC 1225.08	Z4	WRC 1225	12	25	8	65	A10021225804		2	3	4				7	8	■ Ⓢ
HFC 1225.08	Z7	WRC 1225	12	25	8	65	A10021225808	1	2	3			5		7		■ Ⓢ
HFC 1225.08	Z9	WRC 1225	12	25	8	65	A10021225809							6		8	■
HFC 1625.06	Z3	WRC 1625	16	25	6	65	A10021625603	1	2	3	4				7		■ Ⓢ
HFC 1625.06	Z7	WRC 1625	16	25	6	65	A10021625608	1	2	3			5		7		■ Ⓢ
HFC 1625.06	Z9	WRC 1625	16	25	6	65	A10021625609							6		8	■ Ⓢ
HFC 1625.08	Z3	WRC 1625	16	25	8	65	A10021625803	1	2	3	4				7		■ Ⓢ
HFC 1625.08	Z9	WRC 1625	16	25	8	65	A10021625809							6		8	■ Ⓢ



### Shape C, Cylindrical Round nose BASE-X

Ordering example: A10020313322



**Packing unit:**

10 pcs. per type,

from Ø 12 mm: 5 pcs. per type

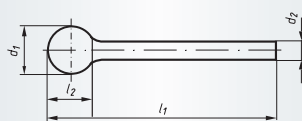
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs	
								1	2	3	4	5	6	7	8		
<b>NEW</b> HFC 0313.03 BASE-X	ZX	WRC 0313	3	13	3	40	A10020313322	1	2	3	4	5			7		■
<b>NEW</b> HFC 0613.03 BASE-X	ZX	WRC 0613	6	13	3	43	A10020613322	1	2	3	4	5			7		■
<b>NEW</b> HFC 0616.06 BASE-X	ZX	WRC 0616	6	16	6	50	A10020616622	1	2	3	4	5			7		■
<b>NEW</b> HFC 0820.06 BASE-X	ZX	WRC 0820	8	20	6	60	A10020820622	1	2	3	4	5			7		■
<b>NEW</b> HFC 1020.06 BASE-X	ZX	WRC 1020	10	20	6	60	A10021020622	1	2	3	4	5			7		■
<b>NEW</b> HFC 1225.06 BASE-X	ZX	WRC 1225	12	25	6	65	A10021225622	1	2	3	4	5			7		■



Industry

Shape D, Spherical

Ordering example: A10030303302



Packing unit:

1 pc. per type

Further dimensions, cuts and shank lengths on request.

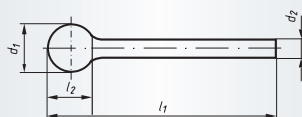
Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for								New burrs	
								1	2	3	4	5	6	7	8		
HFD 0302.03	Z2	KUD 0302	3	2	3	40	A10030303302	1				5	6		8	■	
HFD 0302.03	Z3	KUD 0302	3	2	3	40	A10030303303	1	2	3	4				7	■	
HFD 0302.03	Z4	KUD 0302	3	2	3	40	A10030303304		2	3	4				7	8	■
HFD 0302.03	Z5	KUD 0302	3	2	3	40	A10030303305	1	2	3	4				7	■	
HFD 0302.03	Z7	KUD 0302	3	2	3	40	A10030303308	1	2	3		5			7	■	
HFD 0403.03	Z5	KUD 0403	4	3	3	34	A100304043050001	1	2	3	4				7	■	
HFD 0403.03	Z7	KUD 0403	4	3	3	34	A100304043080001	1	2	3		5			7	■	
HFD 0403.06	Z3	KUD 0403	4	3	6	50	A10030404603	1	2	3	4				7	■	
HFD 0403.06	Z4	KUD 0403	4	3	6	50	A10030404604		2	3	4				7	8	■
HFD 0403.06	Z7	KUD 0403	4	3	6	50	A10030404608	1	2	3		5			7	■	
HFD 0605.03	Z5	KUD 0605	6	5	3	35	A10030606305	1	2	3	4				7	■	
HFD 0605.03	Z7	KUD 0605	6	5	3	35	A10030606308	1	2	3		5			7	■	
HFD 0605.06	Z3	KUD 0605	6	5	6	50	A10030606603	1	2	3	4				7	■	
HFD 0605.06	Z4	KUD 0605	6	5	6	50	A10030606604		2	3	4				7	8	■
HFD 0605.06	Z5	KUD 0605	6	5	6	50	A10030606605	1	2	3	4				7	■	
HFD 0605.06	Z7	KUD 0605	6	5	6	50	A10030606608	1	2	3		5			7	■	
HFD 0807.06	Z3	KUD 0807	8	7	6	47	A10030808603	1	2	3	4				7	■	
HFD 0807.06	Z4	KUD 0807	8	7	6	47	A10030808604		2	3	4				7	8	■
HFD 0807.06	Z5	KUD 0807	8	7	6	47	A10030808605	1	2	3	4				7	■	
HFD 0807.06	Z7	KUD 0807	8	7	6	47	A10030808608	1	2	3		5			7	■	
HFD 1009.06	Z3	KUD 1009	10	9	6	49	A10031010603	1	2	3	4				7	■	
HFD 1009.06	Z4	KUD 1009	10	9	6	49	A10031010604		2	3	4				7	8	■
HFD 1009.06	Z5	KUD 1009	10	9	6	49	A10031010605	1	2	3	4				7	■	
HFD 1009.06	Z7	KUD 1009	10	9	6	49	A10031010608	1	2	3		5			7	■	
HFD 1210.06	Z3	KUD 1210	12	10	6	51	A10031212603	1	2	3	4				7	■	
HFD 1210.06	Z4	KUD 1210	12	10	6	51	A10031212604		2	3	4				7	8	■
HFD 1210.06	Z5	KUD 1210	12	10	6	51	A10031212605	1	2	3	4				7	■	
HFD 1210.06	Z7	KUD 1210	12	10	6	51	A10031212608	1	2	3		5			7	■	
HFD 1210.06	Z9	KUD 1210	12	10	6	50	A10031212609						6		8	■	
HFD 1210.08	Z4	KUD 1210	12	10	8	51	A10031212804		2	3	4				7	8	■
HFD 1210.08	Z7	KUD 1210	12	10	8	51	A10031210808	1	2	3		5			7	■	
HFD 1210.08	Z9	KUD 1210	12	10	8	50	A10031212809						6		8	■	
HFD 1614.06	Z3	KUD 1614	16	14	6	54	A10031616603	1	2	3	4				7	■	
HFD 1614.06	Z4	KUD 1614	16	14	6	54	A10031616604		2	3	4				7	8	■
HFD 1614.06	Z7	KUD 1614	16	14	6	54	A10031616608	1	2	3		5			7	■	
HFD 1614.06	Z9	KUD 1614	16	14	6	54	A10031616609						6		8	■	
HFD 1614.08	Z3	KUD 1614	16	14	8	54	A10031616803	1	2	3	4				7	■	
HFD 1614.08	Z9	KUD 1614	16	14	8	54	A10031616809						6		8	■	



### Shape D, Spherical

Ordering example: A10032020603



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

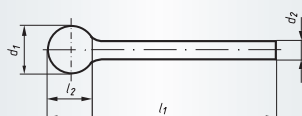
reground service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFD 2018.06	Z3	KUD 2018	20	18	6	58	A10032020603		■
HFD 2018.06	Z7	KUD 2018	20	18	6	58	A10032020608		■
HFD 2018.08	Z3	KUD 2018	20	18	8	58	A10032020803		■



### Shape D, Spherical BASE-X

Ordering example: A10030403322



**Packing unit:**

10 pcs. per type,

from Ø 12 mm: 5 pcs. per type

Further dimensions, cuts and shank lengths on request.

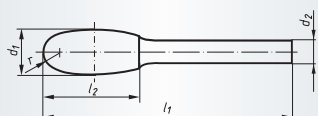
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
<b>NEW</b> HFD 0403.03 BASE-X	ZX	KUD 0403	4	3	3	34	A10030403322		■
<b>NEW</b> HFD 0605.03 BASE-X	ZX	KUD 0605	6	5	3	35	A10030605322		■
<b>NEW</b> HFD 0807.06 BASE-X	ZX	KUD 0807	8	7	6	47	A10030807622		■
<b>NEW</b> HFD 1009.06 BASE-X	ZX	KUD 1009	10	9	6	49	A10031009622		■
<b>NEW</b> HFD 1210.06 BASE-X	ZX	KUD 1210	12	10	6	51	A10031210622		■



Industry

Shape E, Oval

Ordering example: A10060307303



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

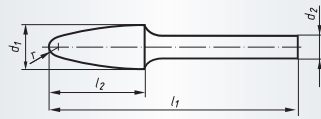
Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r≈ mm	Product-Number	recommended for								New burrs	
									1	2	3	4	5	6	7	8		
HFE 0307.03	Z3	TRE 0307	3	7	3	40	1,2	A10060307303	1	2	3	4			7			■
HFE 0307.03	Z5	TRE 0307	3	7	3	40	1,2	A10060307305	1	2	3	4			7			■
HFE 0307.03	Z7	TRE 0307	3	7	3	40	1,2	A10060307308	1	2	3		5		7			■
HFE 0610.03	Z5	TRE 0610	6	10	3	40	2,8	A10060610305	1	2	3	4			7			■ Ⓢ
HFE 0610.03	Z7	TRE 0610	6	10	3	40	2,8	A10060610308	1	2	3		5		7			■ Ⓢ
HFE 0610.06	Z3	TRE 0610	6	10	6	50	2,8	A10060610603	1	2	3	4			7			■ Ⓢ
HFE 0610.06	Z4	TRE 0610	6	10	6	50	2,8	A10060610604		2	3	4			7	8		■ Ⓢ
HFE 0610.06	Z7	TRE 0610	6	10	6	50	2,8	A10060610608	1	2	3		5		7			■ Ⓢ
HFE 0813.06	Z3	TRE 0813	8	13	6	53	3,7	A10060813603	1	2	3	4			7			■ Ⓢ
HFE 0813.06	Z4	TRE 0813	8	13	6	53	3,7	A10060813604		2	3	4			7	8		■ Ⓢ
HFE 0813.06	Z7	TRE 0813	8	13	6	53	3,7	A10060813608	1	2	3		5		7			■ Ⓢ
HFE 1220.06	Z3	TRE 1220	12	20	6	60	5,0	A10061220603	1	2	3	4			7			■ Ⓢ
HFE 1220.06	Z4	TRE 1220	12	20	6	60	5,0	A10061220604		2	3	4			7	8		■ Ⓢ
HFE 1220.06	Z5	TRE 1220	12	20	6	60	5,0	A10061220605	1	2	3	4			7			■ Ⓢ
HFE 1220.06	Z7	TRE 1220	12	20	6	60	5,0	A10061220608	1	2	3		5		7			■ Ⓢ
HFE 1225.08	Z3	TRE 1225	12	25	8	65	5,0	A10061225803	1	2	3	4			7			■ Ⓢ
HFE 1225.08	Z9	TRE 1225	12	25	8	65	5,0	A10061225809						6		8		■
HFE 1625.06	Z7	TRE 1625	16	25	6	65	7,1	A10061625608	1	2	3		5		7			■ Ⓢ
HFE 1625.08	Z3	TRE 1625	16	25	8	65	7,1	A10061625803	1	2	3	4			7			■ Ⓢ
HFE 1625.08	Z9	TRE 1625	16	25	8	65	7,1	A10061625809						6		8		■
HFE 2035.08	Z3	TRE 2035	20	35	8	75	8,0	A10062035803	1	2	3	4			7			■ Ⓢ



### Shape F, Arch round nose

Ordering example: A10100307303



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r≈ mm	Product-Number	recommended for								New burrs	
									1	2	3	4	5	6	7	8		
HFF 0307.03	Z3	RBF 0307	3	7	3	40	0,75	A10100307303	1	2	3	4			7			■
HFF 0307.03	Z4	RBF 0307	3	7	3	40	0,75	A10100307304		2	3	4			7	8		■
HFF 0307.03	Z5	RBF 0307	3	7	3	40	0,75	A10100307305	1	2	3	4			7			■
HFF 0313.03	Z5	RBF 0313	3	13	3	40	0,75	A10100313305	1	2	3	4			7			■
HFF 0313.03	Z7	RBF 0313	3	13	3	40	0,75	A10100313308	1	2	3		5		7			■
HFF 0613.03	Z5	RBF 0613	6	13	3	43	1,4	A10100613305	1	2	3	4			7			■
HFF 0613.03	Z7	RBF 0613	6	13	3	43	1,4	A10100613308	1	2	3		5		7			■
HFF 0618.06	Z3	RBF 0618	6	18	6	50	1,5	A10100618603	1	2	3	4			7			■
HFF 0618.06	Z4	RBF 0618	6	18	6	50	1,5	A10100618604		2	3	4			7	8		■
HFF 0618.06	Z5	RBF 0618	6	18	6	50	1,5	A10100618605	1	2	3	4			7			■
HFF 0618.06	Z7	RBF 0618	6	18	6	50	1,5	A10100618608	1	2	3		5		7			■
HFF 0820.06	Z3	---	8	20	6	60	1,8	A10100820603	1	2	3	4			7			■
HFF 0820.06	Z7	---	8	20	6	60	1,8	A10100820608	1	2	3		5		7			■
HFF 1020.06	Z3	RBF 1020	10	20	6	60	2,5	A10101020603	1	2	3	4			7			■
HFF 1020.06	Z4	RBF 1020	10	20	6	60	2,5	A10101020604		2	3	4			7	8		■
HFF 1020.06	Z6	RBF 1020	10	20	6	60	2,5	A10101020606		2	3	4			7	8		■
HFF 1020.06	Z7	RBF 1020	10	20	6	60	2,5	A10101020608	1	2	3		5		7			■
HFF 1225.06	Z1	RBF 1225	12	25	6	65	2,5	A10101225601						6		8		■
HFF 1225.06	Z3	RBF 1225	12	25	6	65	2,5	A10101225603	1	2	3	4			7			■
HFF 1225.06	Z4	RBF 1225	12	25	6	65	2,5	A10101225604		2	3	4			7	8		■
HFF 1225.06	Z7	RBF 1225	12	25	6	65	2,5	A10101225608	1	2	3		5		7			■
HFF 1225.06	Z9	RBF 1225	12	25	6	65	2,5	A10101225609						6		8		■
HFF 1225.08	Z3	RBF 1225	12	25	8	65	2,5	A10101225803	1	2	3	4			7			■
HFF 1225.08	Z7	RBF 1225	12	25	8	65	2,5	A10101225808	1	2	3		5		7			■
HFF 1225.08	Z9	RBF 1225	12	25	8	65	2,5	A10101225809						6		8		■
HFF 1230.06	Z3	RBF 1230	12	30	6	70	2,7	A10101230603	1	2	3	4			7			■
HFF 1230.06	Z7	RBF 1230	12	30	6	70	2,7	A10101230608	1	2	3		5		7			■
HFF 1230.08	Z3	RBF 1230	12	30	8	70	2,7	A10101230803	1	2	3	4			7			■
HFF 1630.06	Z7	RBF 1630	16	30	6	70	3,6	A10101630608	1	2	3		5		7			■
HFF 1630.06	Z9	RBF 1630	16	30	6	70	3,6	A10101630609						6		8		■
HFF 1630.08	Z3	RBF 1630	16	30	8	70	3,6	A10101630803	1	2	3	4			7			■
HFF 1630.08	Z9	RBF 1630	16	30	8	70	3,6	A10101630809						6		8		■

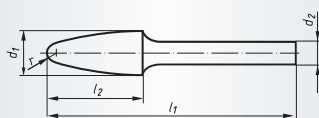




**Base**

**Shape F, Arch round nose BASE-X**

Ordering example: A10100313322



**Packing unit:**  
10 pcs. per type,  
from Ø 12 mm: 5 pcs. per type

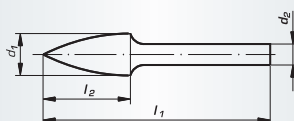
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r≈ mm	Product-Number	recommended for	New burrs
HFF 0313.03 BASE-X	ZX	RBF 0313	3	13	3	40	0,75	A10100313322	1 2 3 4 5 7	NEW
HFF 0618.06 BASE-X	ZX	RBF 0618	6	18	6	50	1,5	A10100618622	1 2 3 4 5 7	NEW
HFF 0820.06 BASE-X	ZX	---	8	20	6	60	1,8	A10100820622	1 2 3 4 5 7	NEW
HFF 1020.06 BASE-X	ZX	RBF 1020	10	20	6	60	2,5	A10101020622	1 2 3 4 5 7	NEW
HFF 1225.06 BASE-X	ZX	RBF 1225	12	25	6	65	2,5	A10101225622	1 2 3 4 5 7	NEW



**Industry**

**Shape G, Arch pointed nose**

Ordering example: A10040307305



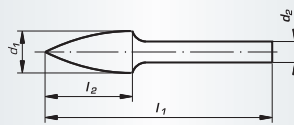
**Packing unit:**  
1 pc. per type  
Further dimensions, cuts and shank lengths on request.  
Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFG 0307.03	Z5	SPG 0307	3	7	3	40	A10040307305	1 2 3 4 7	■
HFG 0307.03	Z7	SPG 0307	3	7	3	40	A10040307308	1 2 3 5 7	■
HFG 0313.03	Z3	SPG 0313	3	13	3	40	A10040313303	1 2 3 4 7	■
HFG 0313.03	Z4	SPG 0313	3	13	3	40	A10040313304	2 3 4 7 8	■
HFG 0313.03	Z5	SPG 0313	3	13	3	40	A10040313305	1 2 3 4 7	■
HFG 0313.03	Z7	SPG 0313	3	13	3	40	A10040313308	1 2 3 5 7	■
HFG 0613.03	Z5	SPG 0613	6	13	3	43	A10040613305	1 2 3 4 7	■ Ⓢ
HFG 0613.03	Z7	SPG 0613	6	13	3	43	A10040613308	1 2 3 5 7	■ Ⓢ
HFG 0618.06	Z1	SPG 0618	6	18	6	50	A10040618601	6 8	■
HFG 0618.06	Z2	SPG 0618	6	18	6	50	A10040618602	1 5 6 8	■ Ⓢ
HFG 0618.06	Z3	SPG 0618	6	18	6	50	A10040618603	1 2 3 4 7	■ Ⓢ
HFG 0618.06	Z4	SPG 0618	6	18	6	50	A10040618604	2 3 4 7 8	■ Ⓢ
HFG 0618.06	Z5	SPG 0618	6	18	6	50	A10040618605	1 2 3 4 7	■ Ⓢ
HFG 0618.06	Z7	SPG 0618	6	18	6	50	A10040618608	1 2 3 5 7	■ Ⓢ
HFG 0820.06	Z3	---	8	20	6	60	A10040820603	1 2 3 4 7	■ Ⓢ
HFG 0820.06	Z7	---	8	20	6	60	A10040820608	1 2 3 5 7	■ Ⓢ
HFG 1020.06	Z3	SPG 1020	10	20	6	60	A10041020603	1 2 3 4 7	■ Ⓢ
HFG 1020.06	Z4	SPG 1020	10	20	6	60	A10041020604	2 3 4 7 8	■ Ⓢ
HFG 1020.06	Z5	SPG 1020	10	20	6	60	A10041020605	1 2 3 4 7	■ Ⓢ
HFG 1020.06	Z7	SPG 1020	10	20	6	60	A10041020608	1 2 3 5 7	■ Ⓢ



### Shape G, Arch pointed nose

Ordering example: A10041220603



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

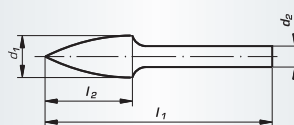
Ⓢ *regrind service, please enquire*

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFG 1220.06	Z3	SPG 1220	12	20	6	60	A10041220603	1 2 3 4 7	■ Ⓢ
HFG 1220.06	Z7	SPG 1220	12	20	6	60	A10041220608	1 2 3 5 7	■ Ⓢ
HFG 1225.06	Z2	SPG 1225	12	25	6	65	A10041225602	1 5 6 8	■ Ⓢ
HFG 1225.06	Z3	SPG 1225	12	25	6	65	A10041225603	1 2 3 4 7	■ Ⓢ
HFG 1225.06	Z4	SPG 1225	12	25	6	65	A10041225604	2 3 4 7 8	■ Ⓢ
HFG 1225.06	Z7	SPG 1225	12	25	6	65	A10041225608	1 2 3 5 7	■ Ⓢ
HFG 1225.08	Z3	SPG 1225	12	25	8	65	A10041225803	1 2 3 4 7	■ Ⓢ
HFG 1230.06	Z2	SPG 1230	12	30	6	70	A10041230602	1 5 6 8	■ Ⓢ
HFG 1230.06	Z3	SPG 1230	12	30	6	70	A10041230603	1 2 3 4 7	■ Ⓢ
HFG 1230.06	Z4	SPG 1230	12	30	6	70	A10041230604	2 3 4 7 8	■ Ⓢ
HFG 1230.06	Z5	SPG 1230	12	30	6	70	A10041230605	1 2 3 4 7	■ Ⓢ
HFG 1230.06	Z7	SPG 1230	12	30	6	70	A10041230608	1 2 3 5 7	■ Ⓢ
HFG 1230.08	Z3	SPG 1230	12	30	8	70	A10041230803	1 2 3 4 7	■ Ⓢ
HFG 1630.06	Z3	SPG 1630	16	30	6	70	A10041630603	1 2 3 4 7	■ Ⓢ
HFG 1630.06	Z4	SPG 1630	16	30	6	70	A10041630604	2 3 4 7 8	■ Ⓢ
HFG 1630.06	Z7	SPG 1630	16	30	6	70	A10041630608	1 2 3 5 7	■ Ⓢ
HFG 1630.08	Z3	SPG 1630	16	30	8	70	A10041630803	1 2 3 4 7	■ Ⓢ



### Shape G, Arch pointed nose BASE-X

Ordering example: A10040313322



**Packing unit:**

10 pcs. per type,

from Ø 12 mm: 5 pcs. per type

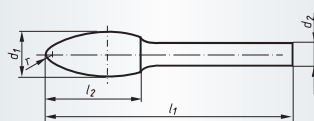
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
<b>NEW</b> HFG 0313.03 BASE-X	ZX	SPG 0313	3	13	3	40	A10040313322	1 2 3 4 5 7	■
<b>NEW</b> HFG 0613.03 BASE-X	ZX	SPG 0613	6	13	3	43	A10040613322	1 2 3 4 5 7	■
<b>NEW</b> HFG 0820.06 BASE-X	ZX	SPG 0820	8	20	6	60	A10040820622	1 2 3 4 5 7	■
<b>NEW</b> HFG 1020.06 BASE-X	ZX	SPG 1020	10	20	6	60	A10041020622	1 2 3 4 5 7	■
<b>NEW</b> HFG 1225.06 BASE-X	ZX	SPG 1225	12	25	6	65	A10041225622	1 2 3 4 5 7	■
<b>NEW</b> HFG 1230.06 BASE-X	ZX	SPG 1230	12	30	6	65	A10041230622	1 2 3 4 5 7	■



Industry

**Shape H, Flame**

Ordering example: A10090307305



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Ⓢ regrind service, please enquire

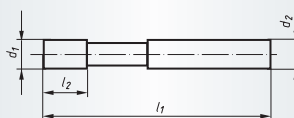
Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	Product-Number	recommended for	New burrs
HFH 0307.03	Z5	3	7	3	40	0,8	A10090307305	① ② ③ ④ ⑦	■
HFH 0613.03	Z1	6	13	3	43	1,0	A10090613301	⑥ ⑧	■
HFH 0613.03	Z2	6	13	3	43	1,0	A10090613302	① ⑤ ⑥ ⑧	■
HFH 0613.03	Z3	6	13	3	43	1,0	A10090613303	① ② ③ ④ ⑦	■ Ⓢ
HFH 0613.03	Z4	6	13	3	43	1,0	A10090613304	② ③ ④ ⑦ ⑧	■ Ⓢ
HFH 0613.03	Z5	6	13	3	43	1,0	A10090613305	① ② ③ ④ ⑦	■ Ⓢ
HFH 0613.03	Z7	6	13	3	43	1,0	A10090613308	① ② ③ ⑤ ⑦	■ Ⓢ
HFH 0820.06	Z2	8	20	6	60	1,6	A10090820602	① ⑤ ⑥ ⑧	■ Ⓢ <b>NEW</b>
HFH 0820.06	Z3	8	20	6	60	1,6	A10090820603	① ② ③ ④ ⑦	■ Ⓢ
HFH 0820.06	Z4	8	20	6	60	1,6	A10090820604	② ③ ④ ⑦ ⑧	■ Ⓢ
HFH 0820.06	Z7	8	20	6	60	1,6	A10090820608	① ② ③ ⑤ ⑦	■ Ⓢ
HFH 1230.06	Z3	12	30	6	70	2,0	A10091230603	① ② ③ ④ ⑦	■ Ⓢ
HFH 1230.06	Z4	12	30	6	70	2,0	A10091230604	② ③ ④ ⑦ ⑧	■ Ⓢ
HFH 1230.06	Z7	12	30	6	70	2,0	A10091230608	① ② ③ ⑤ ⑦	■ Ⓢ
HFH 1230.08	Z3	12	30	8	70	2,0	A10091230803	① ② ③ ④ ⑦	■ Ⓢ
HFH 1635.06	Z7	16	35	6	75	2,5	A10091635608	① ② ③ ⑤ ⑦	■ Ⓢ
HFH 1635.08	Z3	16	35	8	75	2,5	A10091635803	① ② ③ ④ ⑦	■ Ⓢ



Industry

**Shape I, Internal burr with multi purpose cut**

Ordering example: A10010204300



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

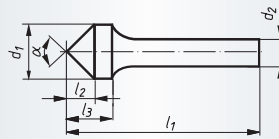
Ⓢ regrind service, please enquire

Description	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFI 0204.03	2,5	4	3	40	A10010204300	③ ④ ⑦	■
HFI 0408.03	4	8	3	50	A10010408300	③ ④ ⑦	■ Ⓢ
HFI 0610.06	6	10	6	65	A10010610600	③ ④ ⑦	■ Ⓢ
HFI 0810.06	8	10	6	65	A10010810600	③ ④ ⑦	■ Ⓢ



### Shape J, Pointed nose

Ordering example: A10080660603



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

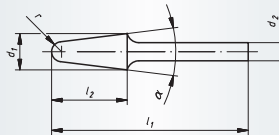
regrind service, please enquire

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	Product-Number	recommended for	New burrs
HFJ 0605.06	Z3	KSJ 0605	6	5	-	6	50	60°	A10080660603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1010.06	Z3	KSK 1005	10	5	10	6	50	90°	A10081090603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1013.06	Z3	KSJ 1008	10	9	13	6	53	60°	A10081060603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1613.06	Z3	KSK 1608	16	8	13	6	53	90°	A10081690603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1613.08	Z3	KSK 1608	16	8	13	8	53	90°	A10081690803	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1616.06	Z3	KSJ 1613	16	14	16	6	56	60°	A10081660603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFJ 1616.08	Z3	KSJ 1613	16	14	16	8	56	60°	A10081660803	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>



### Shape L, Conical Round nose

Ordering example: A10070820603



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

regrind service, please enquire

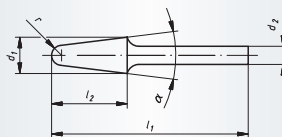
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	α	Product-Number	recommended for	New burrs
HFL 0820.06	Z3	---	8	20	6	60	1,5	14°	A10070820603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 0820.06	Z7	---	8	20	6	60	1,5	14°	A10070820608	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 0820.06	Z9	---	8	20	6	60	1,5	14°	A10070820609	<input type="checkbox"/> 6 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1015.06	Z3	---	10	15	6	55	3,6	14°	A10071015603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1020.06	Z3	KEL 1020	10	20	6	60	2,9	14°	A10071020603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1020.06	Z7	KEL 1020	10	20	6	60	2,9	14°	A10071020608	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1020.06	Z9	KEL 1020	10	20	6	60	2,9	14°	A10071020609	<input type="checkbox"/> 6 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1225.06	Z3	KEL 1225	12	25	6	65	3,3	14°	A10071225603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1225.06	Z4	KEL 1225	12	25	6	65	3,3	14°	A10071225604	<input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1225.06	Z7	KEL 1225	12	25	6	65	3,3	14°	A10071225608	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1225.06	Z9	KEL 1225	12	25	6	65	3,3	14°	A10071225609	<input type="checkbox"/> 6 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1225.08	Z3	KEL 1225	12	25	8	65	3,3	14°	A10071225803	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1225.08	Z7	KEL 1225	12	25	8	65	3,3	14°	A10071225808	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1230.06	Z1	KEL 1230	12	30	6	70	2,6	14°	A10071230601	<input type="checkbox"/> 6 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1230.06	Z3	KEL 1230	12	30	6	70	2,6	14°	A10071230603	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1230.06	Z4	KEL 1230	12	30	6	70	2,6	14°	A10071230604	<input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7 <input type="checkbox"/> 8	<input checked="" type="checkbox"/>
HFL 1230.06	Z5	KEL 1230	12	30	6	70	2,6	14°	A10071230605	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 4 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>
HFL 1230.06	Z7	KEL 1230	12	30	6	70	2,6	14°	A10071230608	<input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 3 <input type="checkbox"/> 5 <input type="checkbox"/> 7	<input checked="" type="checkbox"/>



**Industry**

**Shape L, Conical Round nose**

Ordering example: A10071230609



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Ⓢ regrind service, please enquire

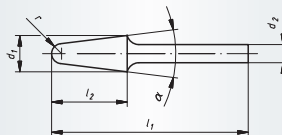
Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	α	Product-Number	recommended for	New burrs
HFL 1230.06	Z9	KEL 1230	12	30	6	70	2,6	14 °	A10071230609	6 8	■
HFL 1230.08	Z4	KEL 1230	12	30	8	70	2,6	14 °	A10071230804	2 3 4 7 8	■ Ⓢ
HFL 1230.08	Z9	KEL 1230	12	30	8	70	2,6	14 °	A10071230809	6 8	■ Ⓢ
HFL 1630.06	Z3	KEL 1630	16	30	6	70	4,8	14 °	A10071630603	1 2 3 4 7	■ Ⓢ
HFL 1630.06	Z7	KEL 1630	16	30	6	70	4,8	14 °	A10071630608	1 2 3 5 7	■ Ⓢ
HFL 1630.08	Z3	KEL 1630	16	30	8	70	4,8	14 °	A10071630803	1 2 3 4 7	■ Ⓢ
HFL 1630.08	Z9	KEL 1630	16	30	8	70	4,8	14 °	A10071630809	6 8	■ Ⓢ
HFL 2040.08	Z9	KEL 2040	20	40	8	80	5,5	14 °	A10072040809	6 8	■ Ⓢ



**Base**

**Shape L, Conical Round nose BASE-X**

Ordering example: A10071230622



**Packing unit:**

10 pcs. per type,

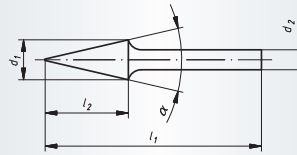
from Ø 12 mm: 5 pcs. per type

Description	Cut	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	α	Product-Number	recommended for	New burrs
HFL 1230.06 BASE-X	ZX	KEL 1230	12	30	6	70	2,6	14 °	A10071230622	1 2 3 4 5 7	■ <b>NEW</b>



### Shape M, Conical Pointed nose

Ordering example: A10050307303



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

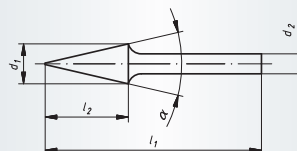
Ⓢ regrind service, please enquire

Description	Cut	similar DIN 8033	d1 mm	l2 mm	d2 mm	l1 mm	α	Product-Number	recommended for								New burrs	
HFM 0307.03	Z3	SKM 0307	3	7	3	40	22°	A10050307303	1	2	3	4			7			■
HFM 0307.03	Z5	SKM 0307	3	7	3	40	22°	A10050307305	1	2	3	4			7			■
HFM 0307.03	Z7	SKM 0307	3	7	3	40	22°	A10050307308	1	2	3		5		7			■
HFM 0311.03	Z5	SKM 0311	3	11	3	40	14°	A10050311305	1	2	3	4			7			■
HFM 0311.03	Z7	SKM 0311	3	11	3	40	14°	A10050311308	1	2	3		5		7			■
HFM 0613.03	Z5	SKM 0613	6	13	3	43	25°	A10050613305	1	2	3	4			7			■ Ⓢ
HFM 0613.03	Z7	SKM 0613	6	13	3	43	25°	A10050613308	1	2	3		5		7			■ Ⓢ
HFM 0618.06	Z3	SKM 0618	6	18	6	50	16°	A10050618603	1	2	3	4			7			■ Ⓢ
HFM 0618.06	Z4	SKM 0618	6	18	6	50	16°	A10050618604		2	3	4			7	8		■ Ⓢ
HFM 0618.06	Z5	SKM 0618	6	18	6	50	16°	A10050618605	1	2	3	4			7			■ Ⓢ
HFM 0618.06	Z7	SKM 0618	6	18	6	50	16°	A10050618608	1	2	3		5		7			■ Ⓢ
HFM 0820.06	Z3	---	8	20	6	60	21°	A10050820603	1	2	3	4			7			■ Ⓢ
HFM 0820.06	Z7	---	8	20	6	60	21°	A10050820608	1	2	3		5		7			■ Ⓢ
HFM 1020.06	Z3	SKM 1020	10	20	6	60	27°	A10051020603	1	2	3	4			7			■ Ⓢ
HFM 1020.06	Z4	SKM 1020	10	20	6	60	27°	A10051020604		2	3	4			7	8		■ Ⓢ
HFM 1020.06	Z7	SKM 1020	10	20	6	60	27°	A10051020608	1	2	3		5		7			■ Ⓢ
HFM 1020.08	Z3	---	10	20	8	60	27°	A10051020803	1	2	3	4			7			■ Ⓢ
<b>NEW</b> HFM 1225.06	Z1	SKM 1225	12	25	6	65	26°	A10051225601							6		8	■ Ⓢ
HFM 1225.06	Z3	SKM 1225	12	25	6	65	26°	A10051225603	1	2	3	4			7			■ Ⓢ
HFM 1225.06	Z4	SKM 1225	12	25	6	65	26°	A10051225604		2	3	4			7	8		■ Ⓢ
HFM 1225.06	Z7	SKM 1225	12	25	6	65	26°	A10051225608	1	2	3		5		7			■ Ⓢ
HFM 1225.08	Z3	SKM 1225	12	25	8	65	26°	A10051225803	1	2	3	4			7			■ Ⓢ



### Shape M, Conical Pointed nose BASE-X

Ordering example: A10050311322



**Packing unit:**

10 pcs. per type,

from Ø 12 mm: 5 pcs. per type


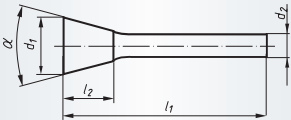
Description	Cut	similar DIN 8033	d1 mm	l2 mm	d2 mm	l1 mm	α	Product-Number	recommended for								New burrs		
<b>NEW</b> HFM 0311.03 BASE-X	ZX	SKM 0311	3	11	3	40	14°	A10050311322	1	2	3	4	5			7			■
<b>NEW</b> HFM 0618.06 BASE-X	ZX	SKM 0618	6	18	6	50	16°	A10050618622	1	2	3	4	5			7			■
<b>NEW</b> HFM 1020.06 BASE-X	ZX	SKM 1020	10	20	6	60	27°	A10051020622	1	2	3	4	5			7			■
<b>NEW</b> HFM 1225.06 BASE-X	ZX	SKM 1225	12	25	6	65	26°	A10051225622	1	2	3	4	5			7			■



Industry


Shape N, Inverted cone











Ordering example: A10120307305

**Packing unit:**  
1 pc. per type

Further dimensions, cuts and shank lengths on request.

 regrind service, please enquire


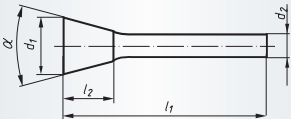
Description	Cut	similar DIN 8033	d1 mm	l2 mm	d2 mm	l1 mm	α	Product-Number	recommended for								New burrs		
									1	2	3	4	5	6	7	8		9	10
HFN 0307.03	Z5	WKN 0307	3	7	3	40	10°	A10120307305	1	2	3	4			7				■
HFN 0307.03	Z7	WKN 0307	3	7	3	40	10°	A10120307308	1	2	3		5		7				■
HFN 0607.03	Z5	WKN 0607	6	7	3	37	10°	A10120607305	1	2	3	4			7				■ 
HFN 0607.06	Z3	WKN 0607	6	7	6	50	10°	A10120607603	1	2	3	4			7				■ 
HFN 0607.06	Z4	WKN 0607	6	7	6	50	10°	A10120607604		2	3	4			7	8			■ 
HFN 0607.06	Z5	WKN 0607	6	7	6	50	10°	A10120607605	1	2	3	4			7				■ 
HFN 1013.06	Z3	WKN 1013	10	13	6	53	10°	A10121013603	1	2	3	4			7				■ 
HFN 1013.06	Z4	WKN 1013	10	13	6	53	10°	A10121013604		2	3	4			7	8			■ 
HFN 1213.06	Z3	WKN 1213	12	13	6	53	20°	A10121213603	1	2	3	4			7				■ 
HFN 1213.06	Z4	WKN 1213	12	13	6	53	20°	A10121213604		2	3	4			7	8			■ 
HFN 1613.08	Z3	WKN 1613	16	13	8	53	20°	A10121613803	1	2	3	4			7				■ 
HFN 2013.06	Z4	---	20	13	6	53	30°	A10122013604		2	3	4			7	8			■ 



Industry


Shape N, Inverted cone with end-cut








Ordering example: A101203073050001

**Packing unit:**  
1 pc. per type

Further dimensions, cuts and shank lengths on request.

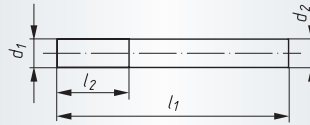
 regrind service, please enquire

Description	Cut	similar DIN 8033	d1 mm	l2 mm	d2 mm	l1 mm	α	Product-Number	recommended for								New burrs		
									1	2	3	4	5	6	7	8		9	10
HFNS 0307.03	Z5	WKN-S 0307	3	7	3	40	10°	A101203073050001	1	2	3	4			7				■
HFNS 0307.03	Z7	WKN-S 0307	3	7	3	40	10°	A101203073080001	1	2	3		5		7				■
HFNS 0607.03	Z5	WKN-S 0607	6	7	3	37	10°	A101206073050001	1	2	3	4			7				■ 
HFNS 1013.06	Z3	WKN-S 1013	10	13	6	53	10°	A101210136030001	1	2	3	4			7				■ 
HFNS 1013.06	Z4	WKN-S 1013	10	13	6	53	10°	A101210136040001		2	3	4			7	8			■ 
HFNS 1213.06	Z3	WKN-S 1213	12	13	6	53	20°	A101212136030001	1	2	3	4			7				■ 
HFNS 1213.06	Z4	WKN-S 1213	12	13	6	53	20°	A101212136040001		2	3	4			7	8			■ 
HFNS 1613.06	Z4	WKN-S 1613	16	13	6	53	20°	A101216136040001		2	3	4			7	8			■ 
HFNS 1613.08	Z3	WKN-S 1613	16	13	8	53	20°	A101216138030001	1	2	3	4			7				■ 



## Special milling cutters for machining of fibre reinforced materials and plastics

Ordering example: A101603133001



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	end cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFP 0313.03	01	3	13	3	40	A101603133001		■
HFP 0313.03	02	3	13	3	40	A101603133002		■
HFP 0313.03	03	3	13	3	40	A101603133003		■
HFP 0313.03	04	3	13	3	40	A101603133004		■
HFP 0416.04	02	4	16	4	50	A101604164002		■
HFP 0620.06	01	6	20	6	50	A101606206001		■
HFP 0620.06	02	6	20	6	50	A101606206002		■
HFP 0620.06	04	6	20	6	50	A101606206004		■
HFP 0825.08	01	8	25	8	80	A101608258001		■
HFP 0825.08	02	8	25	8	80	A101608258002		■
HFP 0825.08	04	8	25	8	80	A101608258004		■
HFP 1025.10	02	10	25	10	80	A101610251002		■
HFP 1025.10	04	10	25	10	80	A101610251004		■
HFP 1230.12	02	12	30	12	80	A101612301202		■

**Type of end cut:**



01 = no end cut



03 = double-flute



02 = multi-flute



04 = drill type, 120° tip angle

## Allgemeine Informationen

<b>Workpiece material properties:</b>	GRP (glass fibre reinforced plastics) and CRP (carbon reinforced plastics) generally require machining where a high degree of specific strength and rigidity are required. Such particularly light materials should only be machined with special milling cutters which reduce the cutting pressure and prevent damage to the fibres in the material.
<b>Market potential:</b>	<ul style="list-style-type: none"> <li>Aerospace</li> <li>Automotive</li> <li>Ship and yacht building</li> <li>Construction of wind turbines</li> <li>Model building</li> <li>Motor sport</li> </ul>
<b>Examples of application:</b>	<ul style="list-style-type: none"> <li>Aircraft components</li> <li>Car components</li> <li>Pipes</li> <li>Sport equipment</li> <li>Components for wind turbines</li> <li>Applied off-hand or on stationary machines</li> </ul>
<b>LUKAS-milling cutters:</b>	The special milling tool in cut P has been developed solely for the use on CRP and GRP. The special flute geometry allows for precise machining – the choice of different face tooth geometry facilitates drilling (plunge) into the material or simply allows for an optimal facing application.

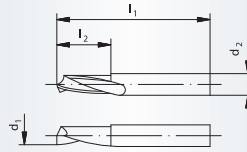




Industry

**Engraving cutters of solid carbide single flute type**

Ordering example: A13150030337102

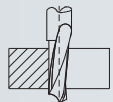


**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Unless otherwise specified, the tolerances are as DIN 7468

Description	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HGE 0207.03	2	7	3	40	A13150030337102		■
HGE 0307.03	3	7	3	40	A13150030337103		■

**Application:** Very well suited for the machining of light metals, non-ferrous metals, plastics and for high-speed-machining of aluminium parts.

Cutters with mirror finished flute to allow ideal chip removal and to avoid clogging.

**Recommended cutting speeds**

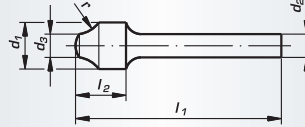
Main group of materials	Sub-group	Hardness (HB)	Strength (N/mm <sup>2</sup> )	Optimal cutting speed (m/min)
Aluminium, Magnesium	Al, Mg non alloyed	≤ 100	≤ 350	≤ 400
	Al alloyed Si < 0,5%	≤ 150	≤ 500	≤ 400
	Al alloyed Si ≥ 0,5 < 10%	≤ 120	≤ 400	≤ 100
	Al alloyed Si ≥ 10%, Mg-all., Al-Whisker	≤ 120	≤ 400	≤ 70
	Thermoplastics	–	–	≤ 150
Plastics	Thermo-setting plastics	–	–	–



Industry

## Shape R, Trimming burr (external)

Ordering example: A10140812603



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

regrind service, please enquire

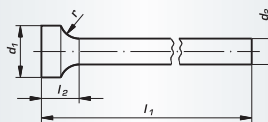
Description	Cut	d <sub>1</sub> mm	d <sub>3</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	Product-Number	recommended for	New burrs
HFR 0812.06	Z3	8	3	12	6	52	2,5	A10140812603		■
HFR 1015.06	Z3	10	2	15	6	55	8	A10141015603		■
HFR 1215.06	Z3	12	6	15	6	55	8	A10141215603		■
HFR 1215.08	Z3	12	6	15	8	55	8	A10141215803		■
HFR 1315.06	Z3	13	3	15	6	55	10	A10141315603		■
HFR 1315.06	Z5	13	3	15	6	55	10	A10141315605		■
HFR 1315.08	Z3	13	3	15	8	55	10	A10141315803		■



Industry

## Shape S, Trimming burr (internal)

Ordering example: A10131618803



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

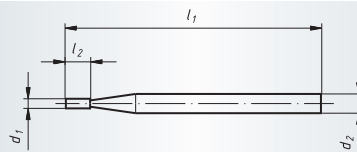
regrind service, please enquire

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r ≈ mm	Product-Number	recommended for	New burrs
HFS 1618.08	Z3	16	18	8	120	6	A10131618803		■
HFS 1818.08	Z3	18	18	8	120	8	A10131818803		■
HFS 2218.08	Z3	22	18	8	120	10	A10132218803		■



Miniature burrs with multi-purpose cut

Ordering example: A10010104312



Packing unit:

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	Shape	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for							New burrs	
							2	3	4	7	8	9	10		
HFA 01004.03		1	4	3	40	A10010104312	2	3	4	7					■
HFA 01504.03		1,5	4	3	40	A100101043120001	2	3	4	7					■
HFA 02004.03		2	4	3	40	A10010204312	2	3	4	7					■
HFC 01004.03		1	4	3	40	A10020104312	2	3	4	7					■
HFC 01504.03		1,5	4	3	40	A100201043120001	2	3	4	7					■
HFC 02004.03		2	4	3	40	A10020204312	2	3	4	7					■
HFD 01001.03		1	0,9	3	40	A10030101312	2	3	4	7					■
HFD 01501.03		1,5	1,35	3	40	A100301013120001	2	3	4	7					■
HFD 02002.03		2	1,8	3	40	A10030202312	2	3	4	7					■
HFE 01504.03		1,5	4	3	40	A10060104312	2	3	4	7					■
HFF 01504.03		1,5	4	3	40	A10100104312	2	3	4	7					■
HFG 01504.03		1,5	4	3	40	A10040104312	2	3	4	7					■
HFM 01504.03		1,5	4	3	40	A10050104312	2	3	4	7					■

Application:

- tool manufacture
- precision engineering
- jewellery industry
- turbine manufacture

Power Tool:

- We recommend our pneumatic grinder AMIN 72-013 GD, page 387

Materials to be processed:

- stainless steel
- CrNi alloys
- non-ferrous metals
- zinc diecasting
- soft ceramics
- titanium alloys

Useful hints:

- choose shortest overhang
- concentric running of the collett chuck is very important
- recommended speed: 70.000 rpm

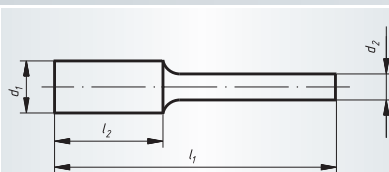
Advantages:

- high dimensional accuracy
- minimal runout
- multi-purpose cut
- micro grain carbide
- precision ground cutting edges



### Miniature burrs in cut 5, shank 3 mm

Ordering example: A10010210305



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

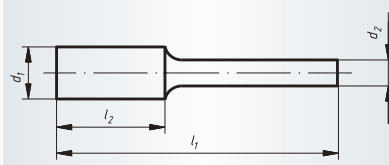
Ⓢ regrind service, please enquire

Description	Cut	Shape	similar DIN 8033	Shank H = solid carbide S = Steel	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	New burrs
HFA 0210.03	Z5		ZYA 0210	H	2	10	40	A10010210305	1 2 3 4 7	■
HFA 0313.03	Z5		ZYA 0313	H	3	13	40	A10010313305	1 2 3 4 7	■
HFA 0607.03	Z5		ZYA 0607	S	6	7	37	A10010607305	1 2 3 4 7	■ Ⓢ
HFA 0613.03	Z5		ZYA 0613	S	6	13	43	A10010613305	1 2 3 4 7	■ Ⓢ
HFAS 0210.03	Z5		ZYA-S 0210	H	2	10	40	A100102103050001	1 2 3 4 7	■
HFAS 0313.03	Z5		ZYA-S 0313	H	3	13	40	A100103133050001	1 2 3 4 7	■
HFAS 0607.03	Z5		ZYA-S 0607	S	6	7	37	A100106073050001	1 2 3 4 7	■ Ⓢ
HFAS 0613.03	Z5		ZYA-S 0613	S	6	13	43	A100106133050001	1 2 3 4 7	■ Ⓢ
HFC 0210.03	Z5		WRC 0210	H	2	10	40	A10020210305	1 2 3 4 7	■
HFC 0313.03	Z5		WRC 0313	H	3	13	40	A10020313305	1 2 3 4 7	■
HFC 0613.03	Z5		WRC 0613	S	6	13	43	A10020613305	1 2 3 4 7	■ Ⓢ
HFD 0302.03	Z5		KUD 0302	H	3	2	40	A10030303305	1 2 3 4 7	■
HFD 0403.03	Z5		KUD 0403	H	4	3	34	A100304043050001	1 2 3 4 7	■ Ⓢ
HFD 0605.03	Z5		KUD 0605	S	6	5	35	A10030606305	1 2 3 4 7	■ Ⓢ
HFE 0307.03	Z5		TRE 0307	H	3	7	40	A10060307305	1 2 3 4 7	■
HFE 0610.03	Z5		TRE 0610	S	6	10	40	A10060610305	1 2 3 4 7	■ Ⓢ
HFF 0307.03	Z5		RBF 0307	H	3	7	40	A10100307305	1 2 3 4 7	■
HFF 0313.03	Z5		RBF 0313	H	3	13	40	A10100313305	1 2 3 4 7	■
HFF 0613.03	Z5		RBF 0613	S	6	13	43	A10100613305	1 2 3 4 7	■ Ⓢ
HFG 0307.03	Z5		SPG 0307	H	3	7	40	A10040307305	1 2 3 4 7	■
HFG 0313.03	Z5		SPG 0313	H	3	13	40	A10040313305	1 2 3 4 7	■
HFG 0613.03	Z5		SPG 0613	S	6	13	43	A10040613305	1 2 3 4 7	■ Ⓢ
HFH 0307.03	Z5		---	H	3	7	40	A10090307305	1 2 3 4 7	■



Miniature burrs in cut 5, shank 3 mm

Ordering example: A10090613305



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

\* available only with fine cross-cut

Ⓢ regrind service, please enquire

Description	Cut	Shape	similar DIN 8033	Shank H = solid carbide S = Steel	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for							New burrs		
									1	2	3	4	5	6	7			
HFH 0613.03	Z5		---	S	6	13	43	A10090613305	1	2	3	4			7			■ Ⓢ
HFI 0204.03	*		---	H	2,5	4	40	A10010204300	1	2	3	4			7			■
HFI 0408.03	*		---	H	4	8	50	A10010408300	1	2	3	4			7			■ Ⓢ
HFM 0307.03	Z5		SKM 0307	H	3	7	40	A10050307305	1	2	3	4			7			■
HFM 0311.03	Z5		SKM 0311	H	3	11	40	A10050311305	1	2	3	4			7			■
HFM 0613.03	Z5		SKM 0613	S	6	13	43	A10050613305	1	2	3	4			7			■ Ⓢ
HFN 0307.03	Z5		WKN 0307	H	3	7	40	A10120307305	1	2	3	4			7			■
HFN 0607.03	Z5		WKN 0607	S	6	7	37	A10120607305	1	2	3	4			7			■ Ⓢ
HFNS 0307.03	Z5		WKN-S 0307	H	3	7	40	A101203073050001	1	2	3	4			7			■
HFNS 0607.03	Z5		WKN-S 0607	S	6	7	37	A101206073050001	1	2	3	4			7			■ Ⓢ

# 54 Tungsten Carbide Burrs



Industry

## Tool-sets, cut 7, shank 3 mm

Ordering example: A10390010



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 pc. each	Product-Number	recommended for	
F10 S3	3	Z7	10-pieces	HFA 0313, HFA 0613, HFC 0313, HFC 0613, HFD 0302, HFD 0605, HFG 0313, HFG 0613, HFM 0613, HFF 0313	A10390010	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 7 <input type="checkbox"/> 8 <input type="checkbox"/> 9 <input type="checkbox"/> 10	■



Industry

## Tool-sets, cut 7, shank 6 mm

Ordering example: A1039001006



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 pc. each	Product-Number	recommended for	
F10 S6	6	Z7	10-pieces	HFAS 0616, HFAS 1225, HFC 0616, HFC 1225, HFD 0605, HFD 1210, HFG 0618, HFG 1225, HFF 0820, HFF 1225	A1039001006	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input checked="" type="checkbox"/> 7 <input type="checkbox"/> 8 <input type="checkbox"/> 9 <input type="checkbox"/> 10	■



Base

**Tool-set, BASE-X, F5 S3**

Ordering example: A10390053



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 pc. each	Product-Number	recommended for	
F5 S3 BASE-X	3	ZX	5-pieces	HFA 0313, HFC 0313, HFD 0605, HFF 0313, HFG 0313	A10390053	<span style="border: 1px solid red; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">7</span>	■

**NEW**



Base

**Tool-set, BASE-X, F5 S6**

Ordering example: A10390056



**Packing unit:**  
1 pc. per type

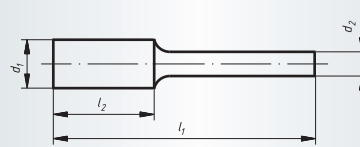
Description	Shank Ø mm	Cut	Contents	1 pc. each	Product-Number	recommended for	
F5 S6 BASE-X	6	ZX	5-pieces	HFA 1225, HFC 1225, HFD 1210, HFF 1225, HFG 1225	A10390056	<span style="border: 1px solid red; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">7</span>	■

**NEW**



### Tungsten Carbide Burrs with TiAlN-coating\*

Ordering example: A10010616608TIALN



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for							New burrs
HFA 0616.06 Z7 TIALN		Z7	6	16	6	50	A10010616608TIALN	1	2	3	5	7			■
HFA 0820.06 Z7 TIALN		Z7	8	20	6	60	A10010820608TIALN	1	2	3	5	7			■
<b>NEW</b> HFA 1020.06 Z7 TIALN		Z7	10	20	6	60	A10011020608TIALN	1	2	3	5	7			■
HFAS 0616.06 Z7 TIALN		Z7	6	16	6	50	A10010616608TIAL1	1	2	3	5	7			■
HFAS 0820.06 Z7 TIALN		Z7	8	20	6	60	A10010820608TIAL1	1	2	3	5	7			■
<b>NEW</b> HFAS 1020.06 Z7 TIALN		Z7	10	20	6	60	A10011020608TIAL1	1	2	3	5	7			■
<b>NEW</b> HFAS 1225.06 Z7 TIALN		Z7	12	25	6	65	A10011225608TIAL1	1	2	3	5	7			■
HFC 0616.06 Z7 TIALN		Z7	6	16	6	50	A10020616608TIALN	1	2	3	5	7			■
HFC 0820.06 Z7 TIALN		Z7	8	20	6	60	A10020820608TIALN	1	2	3	5	7			■
HFC 1020.06 Z7 TIALN		Z7	10	20	6	60	A10021020608TIALN	1	2	3	5	7			■
HFC 1225.06 Z7 TIALN		Z7	12	25	6	65	A10021225608TIALN	1	2	3	5	7			■
HFD 0605.06 Z7 TIALN		Z7	6	5	6	50	A10030606608TIALN	1	2	3	5	7			■
HFD 0807.06 Z7 TIALN		Z7	8	7	6	47	A10030808608TIALN	1	2	3	5	7			■
HFD 1009.06 Z7 TIALN		Z7	10	9	6	49	A10031010608TIALN	1	2	3	5	7			■
<b>NEW</b> HFD 1210.06 Z7 TIALN		Z7	12	10	6	50	A10031210608TIALN	1	2	3	5	7			■
<b>NEW</b> HFD 1614.06 Z7 TIALN		Z7	16	14	6	54	A10031614608TIALN	1	2	3	5	7			■
<b>NEW</b> HFF 0618.06 Z7 TIALN		Z7	6	18	6	50	A10100618608TIALN	1	2	3	5	7			■
HFF 1225.06 Z7 TIALN		Z7	12	25	6	65	A10101225608TIALN	1	2	3	5	7			■
<b>NEW</b> HFF 1630.06 Z7 TIALN		Z7	16	30	6	70	A10101630608TIALN	1	2	3	5	7			■
HFG 0618.06 Z7 TIALN			Z7	6	18	6	50	A10040618608TIALN	1	2	3	5	7		
HFG 1020.06 Z7 TIALN	Z7		10	20	6	60	A10041020608TIALN	1	2	3	5	7			■
HFG 1225.06 Z7 TIALN	Z7		12	25	6	65	A10041225608TIALN	1	2	3	5	7			■
<b>NEW</b> HFG 1630.06 Z7 TIALN	Z7		16	30	6	70	A10041630608TIALN	1	2	3	5	7			■
HFH 0820.06 Z7 TIALN		Z7	8	20	6	60	A10090820608TIALN	1	2	3	5	7			■
HFH 1230.06 Z7 TIALN		Z7	12	30	6	70	A10091230608TIALN	1	2	3	5	7			■
HFL 1020.06 Z7 TIALN		Z7	10	20	6	60	A10071020608TIALN	1	2	3	5	7			■
<b>NEW</b> HFL 1230.06 Z7 TIALN		Z7	12	30	6	70	A10071230608TIALN	1	2	3	5	7			■
<b>NEW</b> HFM 1020.06 Z7 TIALN		Z7	10	20	6	60	A10051020608TIALN	1	2	3	5	7			■

\*High performance coating with a high degree of hardness and flow heat conductivity; therefore suitable for high thermal and mechanical applications; very low friction value

**The reasons for producing Tungsten Carbide Burrs with TiAlN-coating are as follows:**

- to increase tool life
- to reduce machining forces
- to improve chip removal

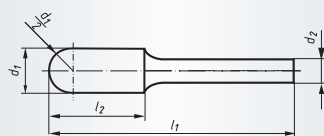




**High Performance**

**Tungsten Carbide Rasp burrs**

Ordering example: A10021225618



**Packing unit:**

1 pc. per type

Ⓢ reground service, please enquire

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for
HFC 1225.06	ZR2	12	25	6	65	A10021225618	Ⓢ ■ Ⓢ <b>NEW</b>

Rasp burrs are manufactured from fine grit tungsten carbide and achieve a service life far exceeding that of comparable HSS or stippled burrs. A positive cutting geometry means that, even where only light force is applied, the burrs are very efficient during

cutting, achieving a high level of stock removal. In particular, when working with wood and other pattern construction materials, the desired contours can be achieved rapidly and accurately. Burrs and material remain cool and do not overheat.

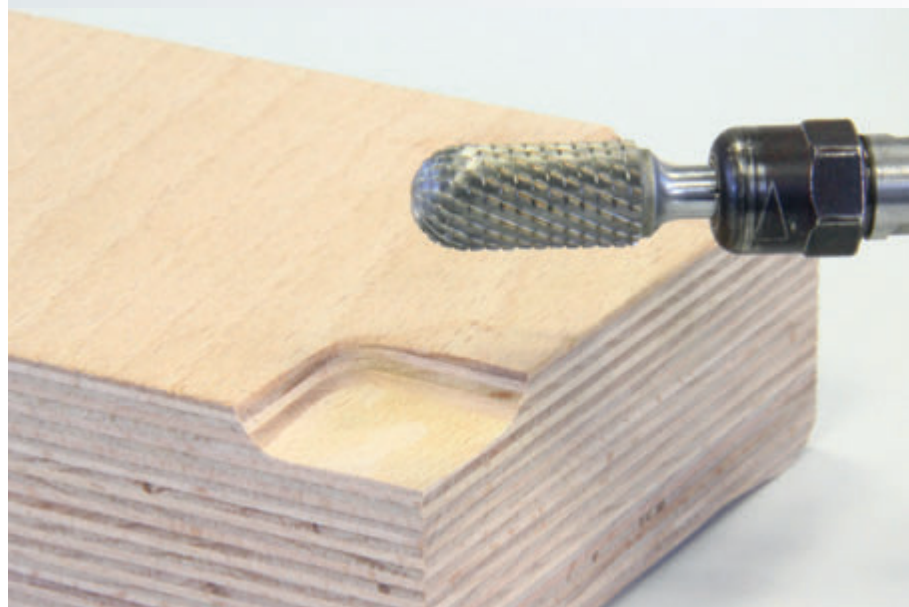
**Characteristics:**

- Extremely aggressive, owing to a positive rake angle
- Long service life, owing to tungsten carbide
- Smooth running without vibration

**Particularly suitable for:**

- Pattern construction and wood
- Mould & die and cores
- Soft materials
- Composite materials

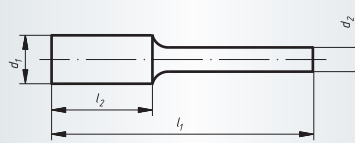
Example using Rasp burr with ZR2 cut





### Tungsten Carbide Rotary files

Ordering example: A100106166150001



**Packing unit:**

1 pc. per type

Ⓢ) regrind service, please enquire

Description	Cut	Shape	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	
<b>NEW</b> HFAS 0616.06	ZF2		6	16	6	50	A100106166150001	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFAS 0616.06	ZF3		6	16	6	50	A100106166140001	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFAS 1225.06	ZF1		12	25	6	65	A100112256160001	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFAS 1225.06	ZF2		12	25	6	65	A100112256150001	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFC 0616.06	ZF3		6	16	6	50	A10020616614	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFC 1225.06	ZF1		12	25	6	65	A10021225616	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFC 1225.06	ZF2		12	25	6	65	A10021225615	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFD 1009.06	ZF2		10	9	6	49	A10031009615	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFG 0618.06	ZF2		6	18	6	50	A10040618615	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFG 0618.06	ZF3		6	18	6	50	A10040618614	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFG 1230.06	ZF1		12	30	6	70	A10041230616	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFG 1230.06	ZF2		12	30	6	70	A10041230615	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFG 1230.06	ZF3		12	30	6	70	A10041230614	1 2 3 4 5 7	■ Ⓢ
<b>NEW</b> HFM 1225.06	ZF2		12	25	6	65	A10051225615	1 2 3 4 5 7	■ Ⓢ

The micro-serration of the new tungsten carbide rotary files is based on the cutting geometry of a file and thus prevents clogging, even when removing soft materials. The precision cut is achieved on CNC grinding machines, thus ensuring perfect concentricity and chatter-free working. The burrs remain sharp for a long time as a result, achieving a clean surface finish free of chatter marks.

Rotary files are available in numerous sizes and shapes and three different cuts ranging from ZF1 (coarse) to ZF3 (fine). This means that the conditions of use can be optimised for each application with the result of the best surface finish.

**Characteristics:**

- Optimum surface finishes, owing to fine serration
- Long service life, owing to tungsten carbide
- No clogging

**Particularly suitable for:**

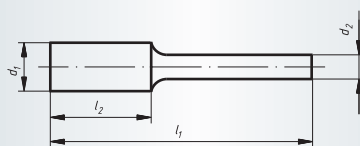
- Perfect surface finishes
- Composite materials
- Soft materials
- Bores



Industry

**Burrs for machining non-ferrous metals, cut 9**

Ordering example: A10010616609



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

regrind service, please enquire

Description	Cut	Shape	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for				New burrs		
HFA 0616.06	Z9		6	16	6	50	A10010616609					6	8	■
HFA 1225.06	Z9		12	25	6	65	A10011225609					6	8	■
HFA 1225.08	Z9		12	25	8	65	A10011225809					6	8	■
HFA 1625.06	Z9		16	25	6	65	A10011625609					6	8	■
HFA 1625.08	Z9		16	25	8	65	A10011625809					6	8	■
HFC 0616.06	Z9		6	16	6	50	A10020616609					6	8	■
HFC 0820.06	Z9		8	20	6	60	A10020820609					6	8	■
HFC 1225.06	Z9		12	25	6	65	A10021225609					6	8	■
HFC 1225.08	Z9		12	25	8	65	A10021225809					6	8	■
HFC 1625.06	Z9		16	25	6	65	A10021625609					6	8	■
HFC 1625.08	Z9		16	25	8	65	A10021625809					6	8	■
HFD 1210.06	Z9		12	10	6	50	A10031212609					6	8	■
HFD 1210.08	Z9		12	10	8	50	A10031212809					6	8	■
HFD 1614.06	Z9		16	14	6	54	A10031616609					6	8	■
HFD 1614.08	Z9		16	14	8	54	A10031616809					6	8	■
HFE 1225.08	Z9		12	25	8	65	A10061225809					6	8	■
HFE 1625.08	Z9		16	25	8	65	A10061625809					6	8	■
HFF 1225.06	Z9		12	25	6	65	A10101225609					6	8	■
HFF 1225.08	Z9		12	25	8	65	A10101225809					6	8	■
HFF 1630.06	Z9		16	30	6	70	A10101630609					6	8	■
HFF 1630.08	Z9		16	30	8	70	A10101630809					6	8	■
HFL 0820.06	Z9		8	20	6	60	A10070820609					6	8	■
HFL 1020.06	Z9		10	20	6	60	A10071020609					6	8	■
HFL 1225.06	Z9		12	25	6	65	A10071225609					6	8	■
HFL 1230.06	Z9		12	30	6	70	A10071230609					6	8	■
HFL 1230.08	Z9		12	30	8	70	A10071230809					6	8	■
HFL 1630.08	Z9		16	30	8	70	A10071630809					6	8	■
HFL 2040.08	Z9	20	40	8	80	A10072040809					6	8	■	

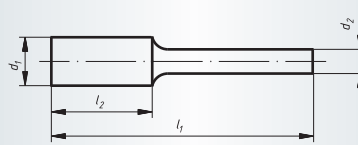
Example using burr with Z9 cut





## Burrs with extended shank length (shank length 200 mm)

Ordering example: A10011225603200



**Packing unit:**

1 pc. per type

Further dimensions, cuts and shank lengths on request.

NEW

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for							New burrs	
HFA 1225.06 L		Z3	12	25	6	225	A10011225603200	1	2	3	4		7			■
HFA 1225.06 L		Z7	12	25	6	225	A10011225608200	1	2	3		5	7			■
HFC 0616.06 L		Z3	6	16	6	216	A10020616603200	1	2	3	4		7			■
HFC 0616.06 L		Z7	6	16	6	216	A10020616608200	1	2	3		5	7			■
HFC 0820.06 L		Z3	8	20	6	220	A10020820603200	1	2	3	4		7			■
HFC 0820.06 L		Z7	8	20	6	220	A10020820608200	1	2	3		5	7			■
HFC 1020.06 L		Z7	10	20	6	220	A10021020608200	1	2	3		5	7			■
HFC 1225.06 L		Z7	12	25	6	225	A10021225608200	1	2	3		5	7			■
HFD 0605.06 L		Z3	6	5	6	205	A10030605603200	1	2	3	4		7			■
HFD 0605.06 L		Z7	6	5	6	205	A10030605608200	1	2	3		5	7			■
HFD 0807.06 L		Z3	8	7	6	207	A10030807603200	1	2	3	4		7			■
HFD 0807.06 L		Z7	8	7	6	207	A10030807608200	1	2	3		5	7			■
HFD 1009.06 L		Z3	10	9	6	209	A10031009603200	1	2	3	4		7			■
HFD 1009.06 L		Z7	10	9	6	209	A10031009608200	1	2	3		5	7			■
HFD 1210.06 L		Z3	12	10	6	210	A10031210603200	1	2	3	4		7			■
HFD 1210.06 L		Z7	12	10	6	210	A10031210608200	1	2	3		5	7			■
HFD 1210.08 L		Z3	12	10	8	210	A10031210803200	1	2	3	4		7			■
HFD 1210.08 L		Z7	12	10	8	210	A10031210808200	1	2	3		5	7			■
HFE 1220.06 L		Z3	12	20	6	220	A10061220603200	1	2	3	4		7			■
HFE 1220.06 L		Z7	12	20	6	220	A10061220608200	1	2	3		5	7			■
HFE 1220.08 L		Z7	12	20	8	220	A10061220808200	1	2	3		5	7			■
HFF 0618.06 L		Z3	6	18	6	218	A10100618603200	1	2	3	4		7			■
HFF 0618.06 L		Z7	6	18	6	218	A10100618608200	1	2	3		5	7			■
HFF 1230.08 L		Z3	12	30	8	230	A10101230803200	1	2	3	4		7			■
HFF 1230.08 L		Z7	12	30	8	230	A10101230808200	1	2	3		5	7			■
HFG 0618.06 L		Z3	6	18	6	218	A10040618603200	1	2	3	4		7			■
HFG 0618.06 L		Z7	6	18	6	218	A10040618608200	1	2	3		5	7			■
HFG 1230.08 L		Z7	12	30	8	230	A10041230808200	1	2	3		5	7			■
HFH 1020.06 L		Z3	10	20	6	220	A10091020603200	1	2	3	4		7			■
HFH 1020.06 L		Z7	10	20	6	220	A10091020608200	1	2	3		5	7			■
HFH 1230.08 L		Z7	12	30	8	230	A10091230808200	1	2	3		5	7			■

**Safety instructions: Recommended operating speed for major exposed shank lengths**

In order to avoid the risk of accidents, it is necessary to ensure contact between the tool and workpiece prior to starting the power tool, or to insert the tool into bores or channels. Contact with the workpiece must be ensured until the machine is deactivated. If permanent contact with the workpiece cannot be ensured, the machine should run at idling speed.

**Reduced speeds for tungsten carbide burrs with extra long shank (200 mm)**

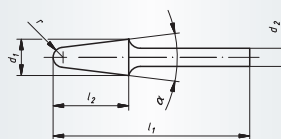
Tool diameter d1 mm	6	8	10	12	12
Shank diameter d2 mm	6	6	6	6	8
Maximum idling speed without workpiece contact (1/min)	4.000	3.200	2.800	2.200	3.600
Recommended reduced operating speed with workpiece contact (1/min)	13.000	10.000	8.000	7.000	7.000



Base

**Tungsten Carbide Burrs with Imperial-Sized Shanks, BASE-X**

Ordering example: A5001082062214



**Packing unit:**  
10 pcs. per type,  
from Ø 12 mm: 5 pcs. per type

Description	Cut	Shape	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	r ≈ mm	Product-Number	recommended for	New burrs
HFA 0820.06 BASE-X	ZX		ZYA 8020	8	20	1/4"	60			A5001082062214	1 2 3 4 5 7	NEW
HFA 1020.06 BASE-X	ZX		ZYA 1020	10	20	1/4"	60			A5001102062214	1 2 3 4 5 7	NEW
HFA 1225.06 BASE-X	ZX		ZYA 1225	12	25	1/4"	65			A5001122562214	1 2 3 4 5 7	NEW
HFC 0616.06 BASE-X	ZX		WRC 0616	6	16	1/4"	50			A5002061662214	1 2 3 4 5 7	NEW
HFC 0820.06 BASE-X	ZX		WRC 0820	8	20	1/4"	60			A5002082062214	1 2 3 4 5 7	NEW
HFC 1020.06 BASE-X	ZX		WRC 1020	10	20	1/4"	60			A5002102062214	1 2 3 4 5 7	NEW
HFC 1225.06 BASE-X	ZX	WRC 1225	12	25	1/4"	65			A5002122562214	1 2 3 4 5 7	NEW	
HFD 1009.06 BASE-X	ZX		KUD 1009	10	9	1/4"	49			A5003100962214	1 2 3 4 5 7	NEW
HFD 1210.06 BASE-X	ZX		KUD 1210	12	10	1/4"	51			A5003121062214	1 2 3 4 5 7	NEW
HFF 0820.06 BASE-X	ZX		---	8	20	1/4"	60		1,8	A5010082062214	1 2 3 4 5 7	NEW
HFF 1020.06 BASE-X	ZX		RBF 1020	10	20	1/4"	60		2,5	A5010102062214	1 2 3 4 5 7	NEW
HFF 1225.06 BASE-X	ZX		RBF 1225	12	25	1/4"	65		2,5	A5010122562214	1 2 3 4 5 7	NEW
HFG 0820.06 BASE-X	ZX		SPG 8020	8	20	1/4"	60			A5004082062214	1 2 3 4 5 7	NEW
HFG 1020.06 BASE-X	ZX		SPG 1020	10	20	1/4"	60			A5004102062214	1 2 3 4 5 7	NEW
HFG 1225.06 BASE-X	ZX		SPG 1225	12	25	1/4"	65			A5004122562214	1 2 3 4 5 7	NEW
HFG 1230.06 BASE-X	ZX		SPG 1230	12	30	1/4"	70			A5004123062214	1 2 3 4 5 7	NEW
HFL 1230.06 BASE-X	ZX		KEL 1230	12	30	1/4"	70	14°	2,6	A5007123062214	1 2 3 4 5 7	NEW
HFM 0618.06 BASE-X	ZX		SKM 0618	6	18	1/4"	50	16°		A5005061862214	1 2 3 4 5 7	NEW
HFM 1020.06 BASE-X	ZX		SKM 1020	10	20	1/4"	60	27°		A5005102062214	1 2 3 4 5 7	NEW
HFM 1225.06 BASE-X	ZX		SKM 1225	12	25	1/4"	65	26°		A5005122562214	1 2 3 4 5 7	NEW



Tools for stationary use

	<p><b>Range of application:</b></p> <ul style="list-style-type: none"> <li>• Tool construction</li> <li>• Turbine construction</li> <li>• Aircraft and space industry</li> <li>• general machine tool construction</li> </ul>	<p>In addition to rotary burrs, we also produce tungsten carbide milling tools in special shapes and sizes for stationary application.</p> <p>We supply these milling cutters with a diameter of <b>12 mm</b> maximum diameter and with a maximum length of <b>250 mm</b>; they differ from our extensive standard range by the shape, tool material and geometry (rake, relief and helix angles).</p>
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<p>Differential drill, radius mill, shank-end mill, die mill, profile mill</p>	<p>delivery on request</p>
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Tools for hand-held and floor-stand application

	<p><b>Range of application:</b></p> <ul style="list-style-type: none"> <li>• general machine tool construction</li> <li>• shipbuilding</li> </ul>	
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<p>Trimming burr</p>	<p>delivery on request</p>
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# Burrs of HSS

- 64 Technical Information

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- 65 A summary of available shapes

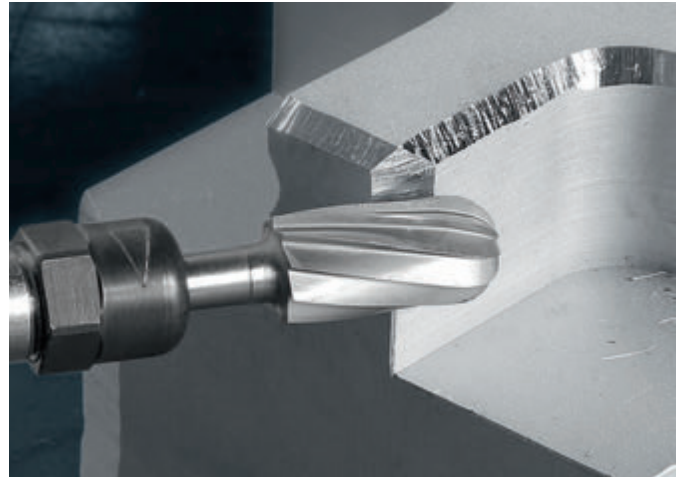
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- 67 Types of cut and their application

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- 68 Burrs of HSS

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## Product line marking

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



## Technical Information

### Quality

LUKAS HSS burrs are manufactured from high quality and well-proven HSS. Our automatic flute grinding machines and our own heat treatment plant guarantee a top quality product.

### Application

Providing the correct type and speed are used, LUKAS HSS burrs will economically machine a wide variety of materials. Regarding cutting speeds, please refer to the table on page **66** or according to the table illustrating the various cuts on page **67**. A rule of thumb: Coarse cuts for soft materials – fine cuts for hard materials. The file cuts H1, H2 and H3 are „rotary files“ and run more smoothly than toothed burrs. For higher stock removal rates, toothed burrs should be used.

### Power tools

LUKAS HSS burrs can be used on any air or electric powered machines. To achieve the optimal performance, the machines must be run at the correct speed, the collets must run true, and the bearings to be in good condition.

### Shanks

Standard shank length is 40 mm. To reach inaccessible working areas, extra long shanks are available on request.

### Packaging













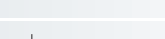
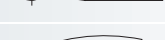
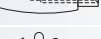

Depending on burr dimension and quantity ordered, we choose the most appropriate packing method from our environmentally-friendly unit packs (5 or 10 pieces).

### Special tools

We can manufacture HSS burrs to your design and drawing and guarantee the usual high quality LUKAS standard.



## A summary of available shapes

Shape	Type	Shape (LUKAS)	Page
	Cylindrical	<b>A</b>	68
	Cylindrical round nose	<b>C</b>	70
	Spherical	<b>D</b>	70
	Oval	<b>E</b>	71
	Arch pointed nose	<b>G</b>	72
	Flame	<b>H</b>	73
	Club	<b>K</b>	73
	Conical round nose	<b>L</b>	74
	Conical pointed nose	<b>M</b>	74
	Inverted cone	<b>N</b>	75
	Edge trimming burr	<b>W</b>	75
	Miniature Burrs, Shank 3 mm		76
	Miniature Burrs, Shank 6 mm		78
	Burrs with internal thread		79
	Tools sets		81
	Power Tools		373

### Three steps to your optimum burr:

- 1 Select the **material** and **machining mode** (coarse to fine) from the table and
- 2 read off the recommended **cut** and **cutting speed**.
- 3 Determine the appropriate **speed** for your power tool in the second table.

### Recommendations for use burrs of HSS

1				2		
Material	Lukas material group (see also fold-out tab)	Strength [N/mm <sup>2</sup> ]	Machining	Cut	Recommended cutting speed vc [m/min]	
Steel, cast steel	1 STEEL AND CAST STEEL	< 800	coarse	Z2	50 – 100	
			medium	Z3	100 – 200	
			fine	Z5	50 – 200	
	2 ALLOYED/HARDENED & TEMPERED STEELS	800 to 1200	coarse	Z2	50 – 100	
			medium	Z3	100 – 200	
			fine	Z5	50 – 200	
Non-ferrous metal 1	6 ALUMINIUM, MAGNESIUM AND COPPER ALLOYS	up to 450	coarse	Z1	200 – 300	
			medium	Z2	150 – 300	
Plastics and wood	8 PLASTIC/WOOD/RUBBER	20 to 400	coarse	Z1	200 – 300	
			fine	Z2	150 – 300	

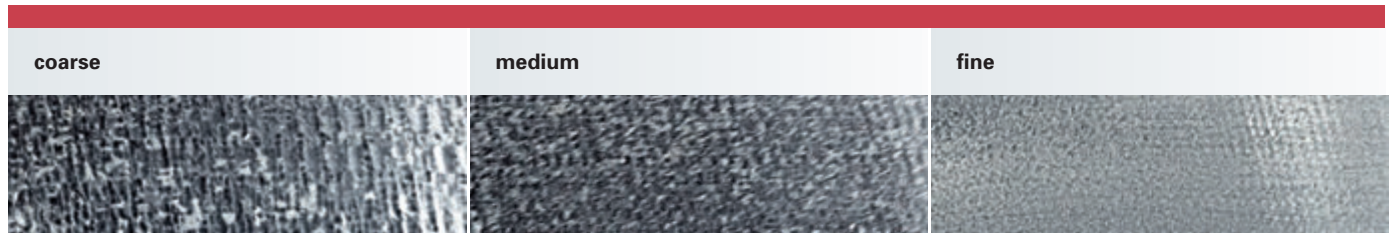
### Rotational speeds for milling tools based on the tool diameter and cutting speed

3							
Recommended cutting speed vc [m/min]							
		50	100	150	200	250	300
		Rotational speed [min <sup>-1</sup> ]					
Tool diameter [mm]	2	8.000	16.000	24.000	32.000	40.000	48.000
	3	5.000	11.000	16.000	21.000	27.000	32.000
	4	4.000	8.000	12.000	16.000	20.000	24.000
	6	3.000	5.000	8.000	11.000	13.000	16.000
	8	2.000	4.000	6.000	8.000	10.000	12.000
	10	2.000	3.000	5.000	6.000	8.000	10.000
	12	1.000	3.000	4.000	5.000	7.000	8.000
	16	1.000	2.000	3.000	4.000	5.000	6.000
	20	1.000	2.000	2.000	3.000	4.000	5.000
	22	1.000	1.000	2.000	3.000	4.000	4.000
	25	1.000	1.000	2.000	3.000	3.000	4.000
	30	1.000	1.000	2.000	2.000	3.000	3.000
	35	–	1.000	1.000	2.000	2.000	3.000

Please see page 373 to 388 for appropriate power tools.

**Tip: Page 65 contains a complete overview of the shapes for your chosen milling tool.**

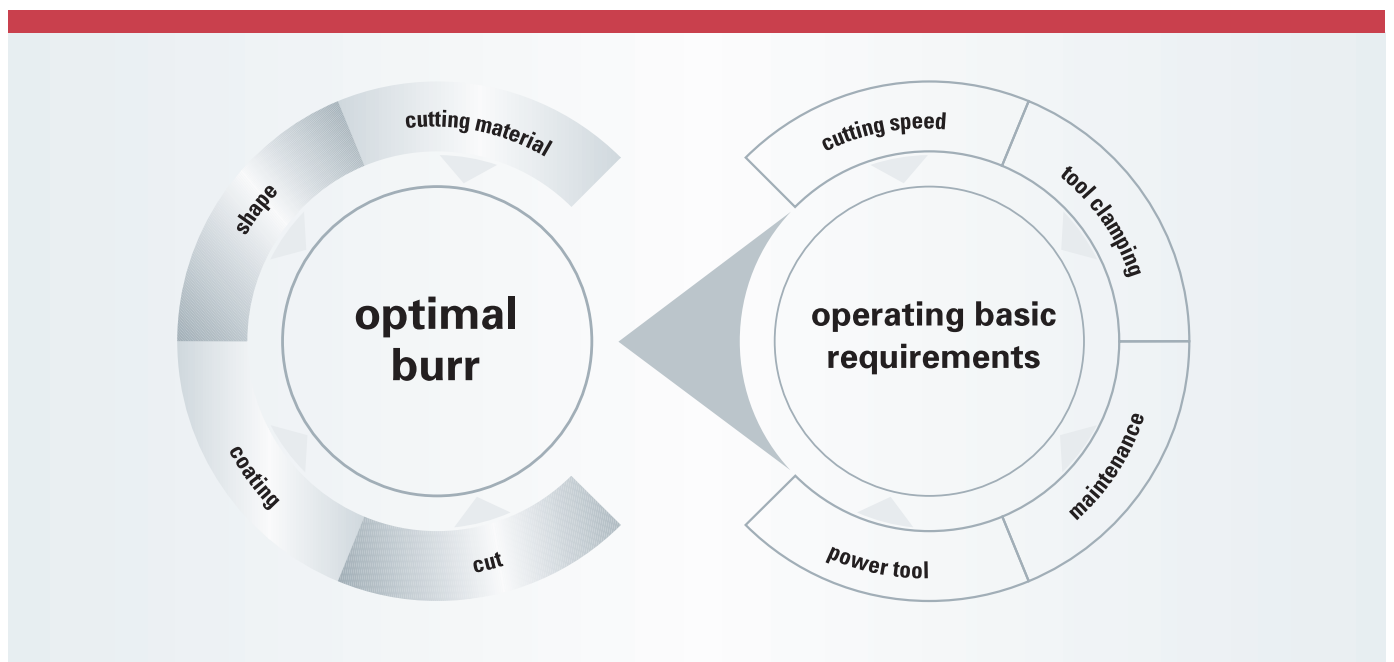
## Machining



## Cuts



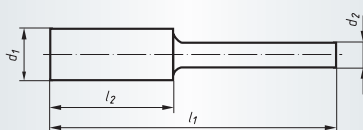
## Choosing the appropriate Burr





### Shape A, Cylindrical

Ordering example: A12000304605



**Packing unit:**

up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.


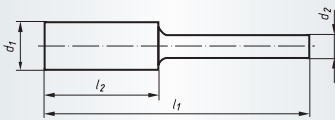
Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> mm	Product-Number	recommended for										New burrs					
MFA 0304.06	Z5	3	4,5	60	6	A12000304605	1	2					6									■
MFA 0607.06	Z5	6	7	60	6	A12000607605	1	2					6									■
MFA 0616.06	Z1	6	16	56	6	A12000616601							6							8		■
MFA 0616.06	Z2	6	16	56	6	A12000616602							6							8		■
MFA 0616.06	Z3	6	16	56	6	A12000616603	1	2														■
MFA 0616.06	Z5	6	16	56	6	A12000616605	1	2					6									■
MFA 0820.06	Z3	8	20	60	6	A12000820603	1	2														■
MFA 1013.06	Z2	10	13	53	6	A12001013602							6							8		■
MFA 1013.06	Z3	10	13	53	6	A12001013603	1	2														■
MFA 1020.06	Z3	10	20	60	6	A12001020603	1	2														■
MFA 1225.06	Z1	12	25	65	6	A12001225601							6							8		■
MFA 1225.06	Z2	12	25	65	6	A12001225602							6							8		■
MFA 1225.06	Z3	12	25	65	6	A12001225603	1	2														■
MFA 1225.06	Z5	12	25	65	6	A12001225605	1	2					6									■
MFA 1625.06	Z1	16	25	65	6	A12001625601							6							8		■
MFA 1625.06	Z2	16	25	65	6	A12001625602							6							8		■
MFA 1625.06	Z3	16	25	65	6	A12001625603	1	2														■



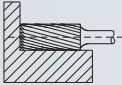
Industry

Shape A, Cylinder with end-cut

Ordering example: A120006166010001

**Packing unit:**  
 up to d<sub>1</sub> 10 mm = 10 pc. per type  
 from d<sub>1</sub> 12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

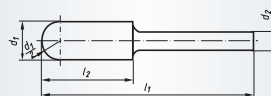
Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> mm	Product-Number	recommended for										New burrs					
																						
MFAS 0616.06	Z1	6	16	56	6	A120006166010001											6	8			■	
MFAS 0616.06	Z2	6	16	56	6	A120006166020001											6	8			■	
MFAS 0616.06	Z3	6	16	56	6	A120006166030001	1	2														■
MFAS 0616.06	Z5	6	16	56	6	A120006166050001	1	2									6					■
MFAS 0820.06	Z3	8	20	60	6	A120008206030001	1	2														■
MFAS 1013.06	Z2	10	13	53	6	A120010136020001											6	8			■	
MFAS 1013.06	Z3	10	13	53	6	A120010136030001	1	2														■
MFAS 1225.06	Z1	12	25	65	6	A120012256010001											6	8			■	
MFAS 1225.06	Z2	12	25	65	6	A120012256020001											6	8			■	
MFAS 1225.06	Z3	12	25	65	6	A120012256030001	1	2														■
MFAS 1625.06	Z1	16	25	65	6	A120016256010001											6	8			■	
MFAS 1625.06	Z2	16	25	65	6	A120016256020001											6	8			■	
MFAS 1625.06	Z3	16	25	65	6	A120016256030001	1	2														■



Industry

## Shape C, Round nose

Ordering example: A12010304605



**Packing unit:**

up to d<sub>1</sub> 10 mm = 10 pc. per type  
from d<sub>1</sub> 12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

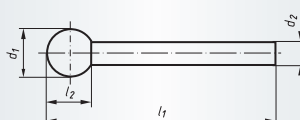
Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> mm	Product-Number	recommended for										New burrs				
MFC 0304.06	Z5	3	4,5	60	6	A12010304605	1	2					6								■
MFC 0620.06	Z1	6	20	60	6	A12010620601							6		8						■
MFC 0620.06	Z2	6	20	60	6	A12010620602							6		8						■
MFC 0620.06	Z3	6	20	60	6	A12010620603	1	2													■
MFC 0620.06	Z5	6	20	60	6	A12010620605	1	2					6								■
MFC 0820.06	Z3	8	20	60	6	A12010820603	1	2													■
MFC 0850.06	Z1	8	50	90	6	A12010850601							6		8						■
MFC 0850.06	Z2	8	50	90	6	A12010850602							6		8						■
MFC 1020.06	Z3	10	20	60	6	A12011020603	1	2													■
MFC 1225.06	Z1	12	25	65	6	A12011225601							6		8						■
MFC 1225.06	Z2	12	25	65	6	A12011225602							6		8						■
MFC 1225.06	Z3	12	25	65	6	A12011225603	1	2													■
MFC 1225.06	Z5	12	25	65	6	A12011225605	1	2					6								■



Industry

## Shape D, Spherical

Ordering example: A12050303603



**Packing unit:**

up to d<sub>1</sub> 10 mm = 10 pc. per type  
from d<sub>1</sub> 12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

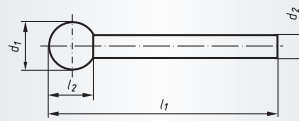
Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for										New burrs				
MFD 0302.06	Z3	3	2	6	60	A12050303603	1	2													■
MFD 0303.06	Z3	3,5	3	6	60	A120503036030001	1	2													■
MFD 0403.06	Z3	4	3	6	60	A12050404603	1	2													■
MFD 0404.06	Z2	4,5	4	6	60	A120504046020001							6		8						■
MFD 0404.06	Z3	4,5	4	6	60	A120504046030001	1	2													■
MFD 0504.06	Z3	5	4	6	60	A12050505603	1	2													■
MFD 0605.06	Z2	6	5	6	60	A12050606602							6		8						■
MFD 0605.06	Z3	6	5	6	60	A12050606603	1	2													■
MFD 0807.06	Z1	8	7	6	60	A12050808601							6		8						■
MFD 0807.06	Z2	8	7	6	60	A12050808602							6		8						■
MFD 0807.06	Z3	8	7	6	60	A12050808603	1	2													■
MFD 0807.06	Z5	8	7	6	60	A12050808605	1	2					6								■



Industry

Shape D, Spherical

Ordering example: A12051010602



Packing unit:

up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

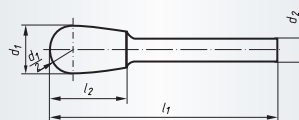
Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	Product-Number	recommended for								New burrs		
							1	2	3	4	5	6	7	8			
MFD 1009.06	Z2	10	9	6	60	A12051010602							6		8		■
MFD 1009.06	Z3	10	9	6	60	A12051010603	1	2									■
MFD 1009.06	Z5	10	9	6	60	A12051010605	1	2					6				■
MFD 1210.06	Z1	12	10	6	60	A12051212601							6		8		■
MFD 1210.06	Z2	12	10	6	60	A12051212602							6		8		■
MFD 1210.06	Z3	12	10	6	60	A12051212603	1	2									■
MFD 1614.06	Z1	16	14	6	60	A12051614601							6		8		■
MFD 1614.06	Z2	16	14	6	60	A12051614602							6		8		■
MFD 1614.06	Z3	16	14	6	60	A12051614603	1	2									■



Industry

Shape E, Oval

Ordering example: A12080607605



Packing unit:

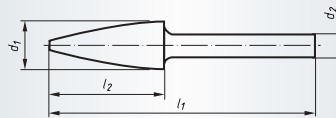
up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	Product-Number	recommended for								New burrs		
							1	2	3	4	5	6	7	8			
MFE 0607.06	Z5	6	7	6	60	A12080607605	1	2					6				■
MFE 1220.06	Z1	12	20	6	60	A12081220601							6		8		■
MFE 1220.06	Z3	12	20	6	60	A12081220603	1	2									■
MFE 1625.06	Z1	16	25	6	60	A12081625601							6		8		■
MFE 1625.06	Z2	16	25	6	60	A12081625602							6		8		■
MFE 1625.06	Z3	16	25	6	60	A12081625603	1	2									■



### Shape G, Arch pointed nose

Ordering example: A12060618601



**Packing unit:**

up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for										New burrs		
MFG 0618.06	Z1	6	18	6	58	A12060618601											6	8	■
MFG 0618.06	Z2	6	18	6	58	A12060618602											6	8	■
MFG 0618.06	Z3	6	18	6	58	A12060618603	1	2											■
MFG 1220.06	Z1	12	20	6	60	A12061220601											6	8	■
MFG 1220.06	Z2	12	20	6	60	A12061220602											6	8	■
MFG 1220.06	Z3	12	20	6	60	A12061220603	1	2											■
MFG 1225.06	Z3	12	25	6	65	A12061225603	1	2											■
MFG 1230.06	Z1	12	30	6	70	A12061230601											6	8	■
MFG 1230.06	Z2	12	30	6	70	A12061230602											6	8	■
MFG 1230.06	Z3	12	30	6	70	A12061230603	1	2											■
MFG 1230.06	Z5	12	30	6	70	A12061230605	1	2									6		■
MFG 1630.06	Z1	16	30	6	70	A12061630601											6	8	■
MFG 1630.06	Z2	16	30	6	70	A12061630602											6	8	■
MFG 1630.06	Z3	16	30	6	70	A12061630603	1	2											■
MFG 1630.06	Z5	16	30	6	70	A12061630605	1	2									6		■

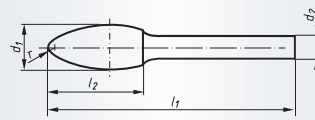




Industry

Shape H, Flame

Ordering example: A12070305605



Packing unit:

up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

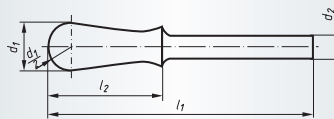
Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	$r \approx$ mm	Product-Number	recommended for	New burrs
MFH 0305.06	Z5	3	5	6	60	---	A12070305605		■
MFH 0820.06	Z3	8	20	6	60	1,3	A12070820603		■
MFH 1230.06	Z3	12	30	6	70	1,9	A12071230603		■
MFH 1635.06	Z3	16	35	6	75	2,4	A12071635603		■
MFH 1750.08	Z1	17	50	8	80	---	A12071750801		■



Industry

Shape K, Club

Ordering example: A12090620602



Packing unit:

up to  $d_1$  10 mm = 10 pc. per type  
 from  $d_1$  12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

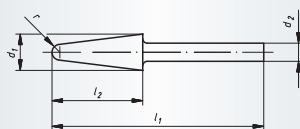
Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	Product-Number	recommended for	New burrs
MFK 0620.06	Z2	6	20	6	60	A12090620602		■
MFK 0620.06	Z3	6	20	6	60	A12090620603		■
MFK 1230.06	Z2	12	30	6	70	A12091230602		■
MFK 1230.06	Z3	12	30	6	70	A12091230603		■



Industry

## Shape L, Conical round nose

Ordering example: A12031020602



**Packing unit:**

up to  $d_1$  10 mm = 10 pc. per type  
from  $d_1$  12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

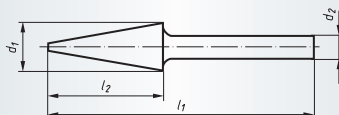
Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	$r \approx$ mm	Product-Number	recommended for								New burrs			
MFL 1020.06	Z2	10	20	6	60	2,9	A12031020602							6		8			■
MFL 1020.06	Z3	10	20	6	60	2,9	A12031020603	1	2										■
MFL 1230.06	Z3	12	30	6	70	2,6	A12031230603	1	2										■
MFL 1630.06	Z1	16	30	6	70	4,8	A12031630601							6		8			■
MFL 1630.06	Z2	16	30	6	70	4,8	A12031630602							6		8			■
MFL 1630.06	Z3	16	30	6	70	4,8	A12031630603	1	2										■
MFL 1630.06	Z5	16	30	6	70	4,8	A12031630605	1	2					6					■



Industry

## Shape M, Conical pointed nose

Ordering example: A12020304605



**Packing unit:**

up to  $d_1$  10 mm = 10 pc. per type  
from  $d_1$  12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	Cut	$d_1$ mm	$l_2$ mm	$d_2$ mm	$l_1$ mm	Product-Number	recommended for								New burrs				
MFM 0304.06	Z5	3	4,5	6	60	A12020304605	1	2					6						■
MFM 0607.06	Z5	6	7	6	60	A12020607605	1	2					6						■
MFM 0618.06	Z1	6	18	6	58	A12020618601							6		8				■
MFM 0618.06	Z2	6	18	6	58	A12020618602							6		8				■
MFM 0618.06	Z3	6	18	6	58	A12020618603	1	2											■
MFM 0820.06	Z3	8	20	6	60	A12020820603	1	2											■
MFM 1020.06	Z2	10	20	6	60	A12021020602							6		8				■
MFM 1020.06	Z3	10	20	6	60	A12021020603	1	2											■
MFM 1225.06	Z1	12	25	6	65	A12021225601							6		8				■
MFM 1225.06	Z3	12	25	6	65	A12021225603	1	2											■
MFM 1230.06	Z1	12	30	6	70	A12021230601							6		8				■
MFM 1230.06	Z2	12	30	6	70	A12021230602							6		8				■
MFM 1230.06	Z3	12	30	6	70	A12021230603	1	2											■
MFM 1230.06	Z5	12	30	6	70	A12021230605	1	2					6						■



Industry

Shape N, Inverted cone

Ordering example: A12040303605

**Packing unit:**  
 up to d<sub>1</sub> 10 mm = 10 pc. per type  
 from d<sub>1</sub> 12 mm = 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	Product-Number	recommended for	New burrs
MFN 0303.06	Z5	3	3	6	60	20°	A12040303605	① ② ⑥	■
MFN 0606.06	Z5	6	6	6	60	20°	A12040606605	① ② ⑥	■
MFN 1213.06	Z1	12	13	6	53	17°	A12041213601	⑥ ⑧	■
MFN 1213.06	Z3	12	13	6	53	17°	A12041213603	① ②	■
MFN 1230.06	Z3	12	30	6	70	8°	A12041230603	① ②	■



Industry

Shape N, Inverted cone with end-cut

Ordering example: A120412136010001

**Packing unit:**  
 5 pc. per type  
 Further dimensions, cuts and shank lengths on request.

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	Product-Number	recommended for	New burrs
MFNS 1213.06	Z1	12	13	6	53	17°	A120412136010001	⑥ ⑧	■
MFNS 1213.06	Z3	12	13	6	53	17°	A120412136030001	① ②	■
MFNS 1230.06	Z3	12	30	6	70	8°	A120412306030001	① ②	■



Industry

Shape W, Cylindrical multiple concave burrs

Ordering example: A12430340

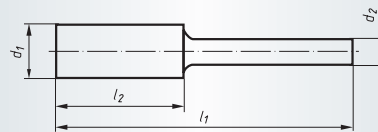
**Packing unit:**  
 10 pc. per type  
 Further dimensions, cuts and shank lengths on request.

Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	Product-Number	recommended for	New burrs
MFW 0620.06	16	6	20	6	60	3	A12430340	① ② ⑥	■
MFW 0830.06	18	8	30	6	70	5	A12433401	① ② ⑥	■



### Miniature Burrs, shank 3 mm

Ordering example: A1236082705



**Packing unit:**

up to d<sub>1</sub> 10 mm = 10 pc. per type  
 from d<sub>1</sub> 12 mm = 5 pc. per type

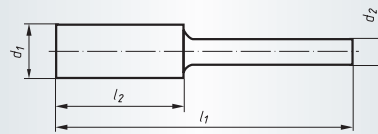
Further dimensions, cuts and shank lengths on request.

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for												New burrs								
							1	2	3	4	5	6	7	8	9	10	11	12									
MF 827		Z5	4	2,8	40	A1236082705	1	2							6											■	
MF 829		Z5	6	4,2	41	A1236082905	1	2							6												■
MF 831		Z5	8	5,5	43	A1236083105	1	2							6												■
MF 837		Z5	6	6	43	A1236083705	1	2							6												■
MF 839		Z5	8	8	45	A1236083905	1	2							6												■
MF 840		Z5	1,6	2,8	40	A1237084005	1	2							6												■
MF 841		Z5	2,3	4	41	A1237084105	1	2							6												■
MF 842		Z5	3,2	5,6	43	A1237084205	1	2							6												■
MF 843		Z5	4	7	44	A1237084305	1	2							6												■
MF 844		Z5	5	8,7	46	A1237084405	1	2							6												■
MF 845		Z5	6	10,5	46	A1237084505	1	2							6												■
MF 846		Z5	7	12,5	46	A1237084605	1	2							6												■
MF 847		Z5	8	14	46	A1237084705	1	2							6												■
MF 848		Z5	1,6	1,5	38	A1238084805	1	2							6												■
MF 849		Z5	2,3	2,1	39	A1238084905	1	2							6												■
MF 850		Z5	3,2	3	40	A1238085005	1	2							6												■
MF 851		Z5	4	3,8	41	A1238085105	1	2							6												■
MF 852		Z5	5	4,8	42	A1238085205	1	2							6												■
MF 853		Z5	6	5,6	43	A1238085305	1	2							6												■



Miniature Burrs, shank 3 mm

Ordering example: A1238085405

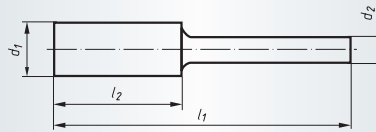


Packing unit:

up to  $d_1$  10 mm = 10 pc. per type  
from  $d_1$  12 mm = 5 pc. per type

Further dimensions, cuts and shank lengths on request.

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for										New burrs				
							1	2	3	4	5	6	7	8	9	10					
MF 854		Z5	7	6,7	44	A1238085405	1	2					6								■
MF 855		Z5	8	7,7	45	A1238085505	1	2					6								■
MF 806		Z5	7	7,5	40	A1235080605	1	2					6								■
MF 807		Z5	7	10	42	A1235080705	1	2					6								■
MF 808		Z5	8	11	43	A1235080805	1	2					6								■
MF 813		Z5	7	10	42	A1235081305	1	2					6								■
MF 814		Z5	6	10	42	A1235081405	1	2					6								■
MF 815		Z5	7	12	44	A1235081505	1	2					6								■
MF 864		Z5	8	2	39	A1239086405	1	2					6								■
MF 865		Z5	10	2,5	40	A1239086505	1	2					6								■
MF 866		Z5	12	3	40	A1239086605	1	2					6								■
MF 867		Z5	14	3,5	41	A1239086705	1	2					6								■
MF 868		Z5	8	2	39	A1240086805	1	2					6								■
MF 869		Z5	10	2,3	39	A1240086905	1	2					6								■
MF 870		Z5	12	2,6	40	A1240087005	1	2					6								■
MF 871		Z5	14	3	40	A1240087105	1	2					6								■
MF 872		Z5	6	1	38	A1241087205	1	2					6								■
MF 873		Z5	8	1	38	A1241087305	1	2					6								■
MF 874		Z5	10	1	38	A1241087405	1	2					6								■


**Miniature Burrs, shank 6 mm**
*Ordering example: A12000304605*


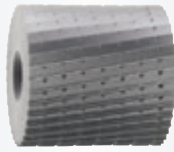
**Packing unit:**  
10 pc. per type  
Further dimensions, cuts and shank  
lengths on request.

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for										New burrs					
MFA 0304.06		Z5	3	4,5	60	A12000304605	①	②						⑥								■
MFA 0607.06		Z5	6	7	60	A12000607605	①	②						⑥								■
MFC 0304.06		Z5	3	4,5	60	A12010304605	①	②						⑥								■
MFD 0302.06		Z3	3	2	60	A12050303603	①	②														■
MFD 0303.06		Z3	3,5	3	60	A120503036030001	①	②														■
MFE 0607.06		Z5	6	7	60	A12080607605	①	②						⑥								■
MFH 0305.06		Z5	3	5	60	A12070305605	①	②						⑥								■
MFM 0304.06		Z5	3	4,5	60	A12020304605	①	②						⑥								■
MFM 0607.06		Z5	6	7	60	A12020607605	①	②						⑥								■
MFN 0303.06		Z5	3	3	60 (20°)	A12040303605	①	②						⑥								■
MFN 0606.06		Z5	6	6	60 (20°)	A12040606605	①	②						⑥								■



Burrs with internal thread

Ordering example: A122022150803



**Packing unit:**

2 pc. per type

MFAS = with end-cut

Other dimensions and cuts available on request.

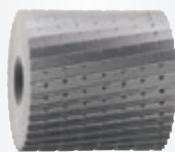
Suitable mounting arbors pages 402

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	B mm	Product-Number	recommended for	New burrs
MFA 2215.08		Z3	22	15	M 8	A122022150803	① ② ③ ④ ⑦	■
MFA 3030.10		Z2	30	30	M 10	A122030301002	① ⑤ ⑥ ⑧	■
MFAS 2215.08		Z3	22	15	M 8	A1220221508030001	① ② ③ ④ ⑦	■
MFAS 3030.10		Z2	30	30	M 10	A1220303010020001	① ⑤ ⑥ ⑧	■
MFD 2018.08		Z3	20	18	M 8	A122520180803	① ② ③ ④ ⑦	■
MFD 2522.10		Z1	25	22	M 10	A122525221001	⑥ ⑧	■
MFD 2522.10		Z2	25	22	M 10	A122525221002	① ⑤ ⑥ ⑧	■
MFD 3027.12		Z3	30	27	M 12	A122530271203	① ② ③ ④ ⑦	■
MFE 2535.12		Z3	25	35	M 12	A122825351203	① ② ③ ④ ⑦	■
MFG 3555.12		Z1	35	55	M 12	A122635551201	⑥ ⑧	■
MFH 2055.10		Z1	20	55/65	M 10	A122720551001	⑥ ⑧	■
MFH 2055.10		Z2	20	55/65	M 10	A122720551002	① ⑤ ⑥ ⑧	■



Burrs with internal thread

Ordering example: A122320551001



**Packing unit:**  
2 pc. per type  
Further dimensions and cuts on request.  
Suitable mounting arbors pages 402

Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	B mm	Product-Number	recommended for	New burrs
MFL 2055.10		Z1	20	55	M 10	A122320551001	6 8	■
MFM 2540.10		Z3	25	40	M 10	A122225401003	1 2 3 4 7	■

What is your experience when using this tool?

**V3 Control:** Fast removal whilst maintaining your workpiece in view – this allows you to grind exactly where you want to (I tested this myself).

**Eva Jensch**  
Sales Department



[www.lukas-erzett.com](http://www.lukas-erzett.com)





Industry

Tool-sets, cut 5, shank 3 mm

Ordering example: A1239000110



Packing unit:  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for	
F1	3	Z5	10-pieces	MF 807, MF 813, MF 841, MF 845, MF 850, MF 853, MF 864, MF 866, MF 872, MF 874	A1239000110	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩	■



Industry

Tool-sets, cut 5, shank 6 mm

Ordering example: A123900003



Packing unit:  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for	
F3	6	Z3	10-pieces	MFA 0616, MFA 1225, MFC 1225, MFD 0403, MFD 1210, MFE 1220, MFG 1230, MFH 1230, MFK 0620, MFM 0618	A123900003	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩	■



**Tool-sets, cut 3 and cut 5, shank 6 mm**

Ordering example: A12390004



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for																	
						1	2	3	4	5	6	7	8	9	10	11	12						
F4	6	Z3/Z5	20-pieces	Z3 MFA 0616, MFA 1013, MFA 1225, MFC 1225, MFD 0807, MFD 1210, MFE 1220, MFE 1625, MFG 1220 MFG 1230, MFK 1230, MFL 1630, MFM 0618, MFM 1230, MFN 1213, MFN 1230 Z5 MFA 0304, MFA 0607, MFN 0303, MFN 0606	A12390004	1	2					6											■

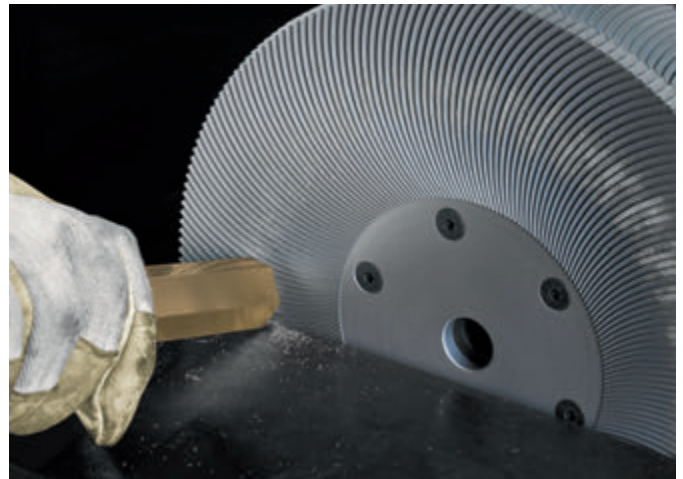
## Filing Discs and Rings Tailor-made solution

84 Technical Information

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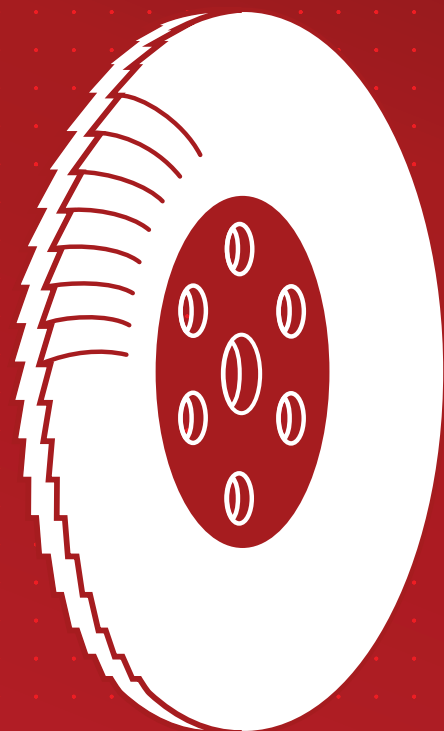
85 Filing Discs and Rings Special production

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### Product line marking

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

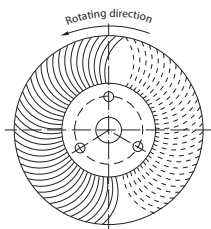


## Types of cut and their application

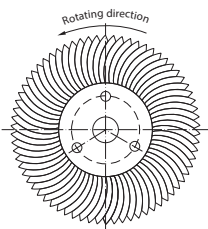
	Z1	Z2	Z3
	Aluminium alloys, plastics v = 38–150 m/min Wood v = 150–300 m/min	Aluminium alloys, plastics v = 38–150 m/min Bronze, brass v = 150–300 m/min	Steel up to 450 N/mm <sup>2</sup> v = 38–75 m/min  Cast and malleable iron v = 38–150 m/min

## Number of teeth

Disc-Ø Ring-Ø	Z1 cut coarse		Z2 cut medium		Z3 cut fine	
	Disc	Ring	Disc	Ring	Disc	Ring
160	120	160	160	200	200	240
210	160	200	200	240	240	280
260	200	240	240	280	280	320
310	240	280	280	320	320	360



**Cut design 1**  
Right-hand cutting,  
usable both sides



**Cut design 4**  
One-sided cutting with  
teeth on periphery

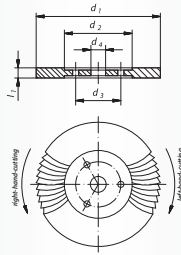
### Recommended speeds

Material	speeds approx. RPM
Cast iron	75/150
Steel up to 450 N/mm <sup>2</sup>	75
Aluminium alloys	75/150
Bronze, brass	300
Plastics	75/150
Wood	300



Filing discs

Ordering example: F 16-R-1 Z3



**Packing unit:**

1 pc. per type

If left-hand-cutting is desired for cut design 1 and cut design 4 please replace R by L in the Lukas-No.

Further dimensions on request.

Description	Cut	d <sub>1</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>4</sub> mm	l <sub>1</sub> mm	Number of bores	recommended for					
F 16-R-1	Z1	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 16-R-1	Z2	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 16-R-1	Z3	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 16-R-4	Z1	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 16-R-4	Z2	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 16-R-4	Z3	160	80	60	15	7	3	①		⑤	⑥	⑧	▲
F 21-R-1	Z1	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 21-R-1	Z2	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 21-R-1	Z3	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 21-R-4	Z1	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 21-R-4	Z2	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 21-R-4	Z3	210	80	60	15	8	3	①		⑤	⑥	⑧	▲
F 26-R-1	Z1	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 26-R-1	Z2	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 26-R-1	Z3	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 26-R-4	Z1	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 26-R-4	Z2	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 26-R-4	Z3	260	110	90	20	9	6	①		⑤	⑥	⑧	▲
F 31-R-1	Z1	310	125	90	20	10	6	①		⑤	⑥	⑧	▲
F 31-R-1	Z2	310	125	90	20	10	6	①		⑤	⑥	⑧	▲
F 31-R-1	Z3	310	125	90	20	10	6	①		⑤	⑥	⑧	▲
F 31-R-4	Z1	310	125	90	20	10	6	①		⑤	⑥	⑧	▲
F 31-R-4	Z2	310	125	90	20	10	6	①		⑤	⑥	⑧	▲
F 31-R-4	Z3	310	125	90	20	10	6	①		⑤	⑥	⑧	▲

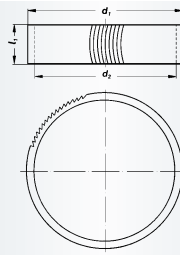
Made of alloyed tool steel (WS) for all machinable materials with tensile strength up to approx. 450 N/mm<sup>2</sup>. Particularly suitable for the machining of aluminium and non-ferrous metals. Filing discs in cut design 1 can be used on

both sides. For the severest conditions, filing discs in HSS are also available on request.



### Filing rings

Ordering example: FR 16 Z3



**Packing unit:**

1 pc. per type

Further dimensions on request.

Description	Cut	d <sub>1</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> mm	recommended for									
FR 16	Z1	160	40	145	①				⑤	⑥		⑧		▲
FR 16	Z2	160	40	145	①				⑤	⑥		⑧		▲
FR 16	Z3	160	40	145	①				⑤	⑥		⑧		▲
FR 21	Z1	210	40	195	①				⑤	⑥		⑧		▲
FR 21	Z2	210	40	195	①				⑤	⑥		⑧		▲
FR 21	Z3	210	40	195	①				⑤	⑥		⑧		▲
FR 26	Z1	260	40	245	①				⑤	⑥		⑧		▲
FR 26	Z2	260	40	245	①				⑤	⑥		⑧		▲
FR 26	Z3	260	40	245	①				⑤	⑥		⑧		▲
FR 31	Z1	310	40	295	①				⑤	⑥		⑧		▲
FR 31	Z2	310	40	295	①				⑤	⑥		⑧		▲
FR 31	Z3	310	40	295	①				⑤	⑥		⑧		▲

Filing rings of WS are seamless forged. If correctly used, they will not crack even under the most severe conditions. **Application – similar to filing discs.**

Not available in high speed steel.

# Engraving cutters of solid carbide and HSS

- 88 General Information

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- 89 Technical Information

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- 90 Engraving cutters of solid carbide and HSS

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## Product line marking

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

**Engraving cutters are available in the following tungsten carbide grade:**

**Engraving cutters of High Speed Steel (HSS) are available in the following special HSS-qualities**

<p><b>K 10 F</b> Micro grain carbide for machining all materials, for machining steel, cast steel, non-ferrous metals and plastics. Extra long life!</p>	<p><b>HSS-50</b> for machining high-tensile and high-grade carbide materials and heat resistant qualities.</p> <p><b>HSS-60</b> applications similar to HSS-50, but with extended life. Performance is improved when used in conjunction with a high quality cutting oil.</p> <p>We supply our engraving cutters semi-finished with rough-ground profile (+0,1 mm) or finish ground to your specification.</p>
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Example	Description	Page
	Tungsten carbide engraving cutters	90
	HSS engraving cutters	91
	Tungsten carbide cutters, spiral flute type	92

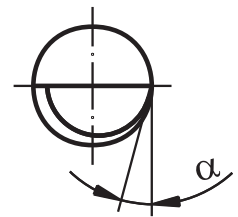
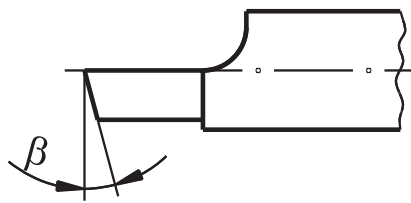
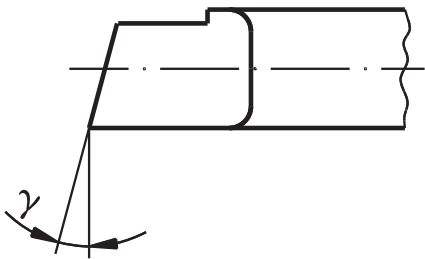
**Engraving Cutters – Recommendation for various applications**

For optimal results the cutting and lead angles have to suit the material to be machined.  
The values in the tables are recommendations.



## Recommended cutting and lead angles

Material to be machined	Engraving cutters of Tungsten Carbide			Engraving cutters of HSS		
	$\sphericalangle \alpha$	$\sphericalangle \beta$	$\sphericalangle \gamma$	$\sphericalangle \alpha$	$\sphericalangle \beta$	$\sphericalangle \gamma$
Cast iron, cast steel	25°	15°	5°	25°	15°	5°
Brass, aluminium	30°	15°	5°	30°	15°	5°
Plastics, reinforced and non-reinforced	35°	15°	5°	35°	15°	5°
Light metals, copper, gold, silver	30°	15°	5°	30°	15°	5°



## Recommended cutting speeds in m/min

Material to be machined	Engraving cutters of Tungsten Carbide	Engraving cutters of HSS	Engraving cutters of HSS
	K 10 F	HSS-50	HSS-60
Cast iron, cast steel	60–100	50–70	50–70
Steel up to 900 N/mm <sup>2</sup>	120–160	40–70	40–70
Steel above 900 N/mm <sup>2</sup>	50–70	–	25–40
Brass, aluminium	200–400	200–250	200–250
Plastics, reinforced and non-reinforced	200–600	200–300	200–300

## Recommended feed rates $f_z$ in mm

Material to be machined	
Cast iron, cast steel	0,04–0,1
Steel up to 900 N/mm <sup>2</sup>	0,05–0,08
Steel above 900 N/mm <sup>2</sup>	0,04–0,08
Brass, aluminium	0,08–0,15
Plastics, reinforced and non-reinforced	0,05–0,20



## Engraving cutters

Ordering example: A1300403042

A

B  
100°

C

D  
60°

F

**Packing unit:**  
1 pc. per type

Further profiles and dimensions on request

d<sub>1</sub>/2 as per your request

l<sub>2</sub> does not apply to profile F

Tolerance of semi-finished cutting edge + 0,1, finish ground on request

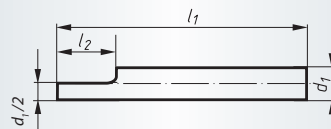
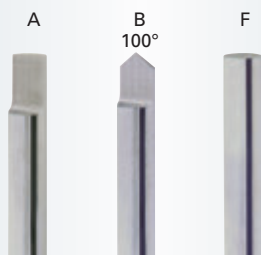
Description	Profile	Quality	d <sub>1</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	Product-Number	recommended for					
HGA 03.040	D	K10F	3	40	6	A1300403042	1		5	6	8	■
HGA 04.040	A	K10F	4	40	6	A1300404012	1		5	6	8	■
HGA 04.040	D	K10F	4	40	6	A1300404042	1		5	6	8	■
HGA 04.040	F	K10F	4	40	6	A1300404062	1		5	6	8	■
HGA 04.060	A	K10F	4	60	6	A1300405012	1		5	6	8	■
HGA 04.060	D	K10F	4	60	6	A1300405042	1		5	6	8	■
HGA 06.070	A	K10F	6	70	8	A1300407012	1		5	6	8	■
HGA 06.070	D	K10F	6	70	8	A1300407042	1		5	6	8	■
HGA 06.100	D	K10F	6	100	8	A1300407142	1		5	6	8	■
HGA 08.080	A	K10F	8	80	12	A1300408012	1		5	6	8	■
HGA 08.100	A	K10F	8	100	12	A1300408112	1		5	6	8	■
HGA 10.080	A	K10F	10	80	14	A1300409012	1		5	6	8	■
HGA 10.100	A	K10F	10	100	14	A1300409112	1		5	6	8	■
HGA 12.080	A	K10F	12	80	16	A1300410012	1		5	6	8	■
HGA 12.100	A	K10F	12	100	16	A1300410112	1		5	6	8	■



Industry

Engraving cutters of HSS-50

Ordering example: A135046106



**Packing unit:**

5 pc. per type

Further profiles and dimensions on request

$d_1/2$  as per your request

$l_2$  does not apply to profile F

Tolerance of semi-finished cutting edge + 0,1, finish ground on request

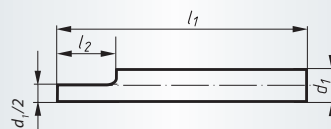
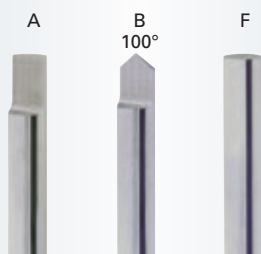
Description	Profile	Quality	$d_1$ mm	$l_1$ mm	$l_2$ mm	Product-Number	recommended for		
SGA 04.060	F	HSS-50	4	60	10	A135046106	①	⑤ ⑥ ⑧	■
SGA 06.080	A	HSS-50	6	80	14	A135046201	①	⑤ ⑥ ⑧	■
SGA 06.080	F	HSS-50	6	80	14	A135046206	①	⑤ ⑥ ⑧	■
SGA 06.160	F	HSS-50	6	160	14	A135046256	①	⑤ ⑥ ⑧	■
SGA 08.125	F	HSS-50	8	125	16	A135046406	①	⑤ ⑥ ⑧	■



Industry

Engraving cutters of HSS-60

Ordering example: A136046101



**Packing unit:**

5 pc. per type

Further profiles and dimensions on request

$d_1/2$  as per your request

$l_2$  does not apply to profile F

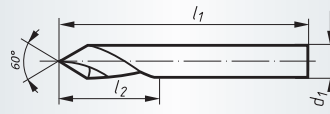
Tolerance of semi-finished cutting edge + 0,1, finish ground on request

Description	Profile	Quality	$d_1$ mm	$l_1$ mm	$l_2$ mm	Product-Number	recommended for		
SGA 04.060	A	HSS-60	4	60	10	A136046101	①	⑤ ⑥ ⑧	■
SGA 06.080	A	HSS-60	6	80	14	A136046201	①	⑤ ⑥ ⑧	■
SGA 06.080	F	HSS-60	6	80	14	A136046206	①	⑤ ⑥ ⑧	■



## Engraving cutters of solid carbide, spiral fluted

Ordering example: A1300484071



**Packing unit:**

1 pc. per type  
 Further dimensions on request.  
 Relief-grinding 25°  
 Quality K 10 F = micro grain tungsten carbide

Description	d <sub>1</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	Product-Number	recommended for	
HGS 03.040	3	40	15	A1300484071		■
HGS 04.040	4	40	20	A1300485071		■
HGS 06.050	6	50	22	A1300486071		■

**Application:**

Engraving of non-ferrous metals and plastics with minimum generation of burr.

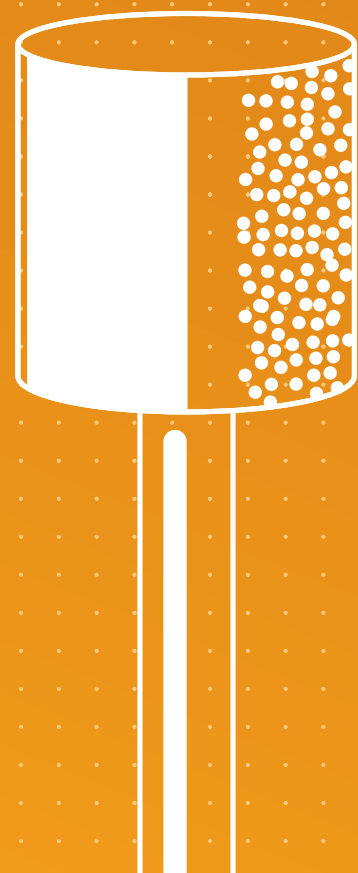
# Mounted points

<b>94</b>	Technical Information
<b>96</b>	Qualities and areas of application
<b>97</b>	Choice of the optimal grinding tool
<b>98</b>	Safety instructions
<b>99</b>	A summary of available shapes
<b>106</b>	Mounted points
<b>130</b>	Mounted points, tailor-made solution



## Product line marking

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



## Technical Information

### Grit sizes, ISO 525

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

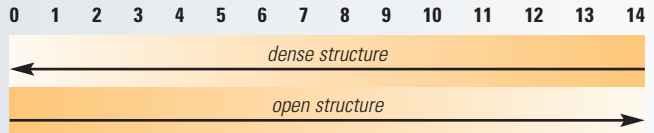
### Hardness grade, ISO 525

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

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

### Structure

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



### Bond

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

#### Vitrified bond

**V** = vitrified bond

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

#### Organic bonds

**Ba** = resin bond

**BF** = resin bond, reinforced

**R** = rubber bond or other elastomers

**RF** = rubber bond, reinforced

#### Impregnation

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

**Su** = with sulphur

**Lu** = with resin

**W** = with wax

**F** = with grinding oil

## Description of Mounted points

Shape	Diameter	Length	Shank	Abrasive	Grit size	Hardness	Bond
ZY	1632	06	EKR		46	N	V4

## Technical Information

### Quality

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

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

## Abrasives

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

## Qualities and areas of application

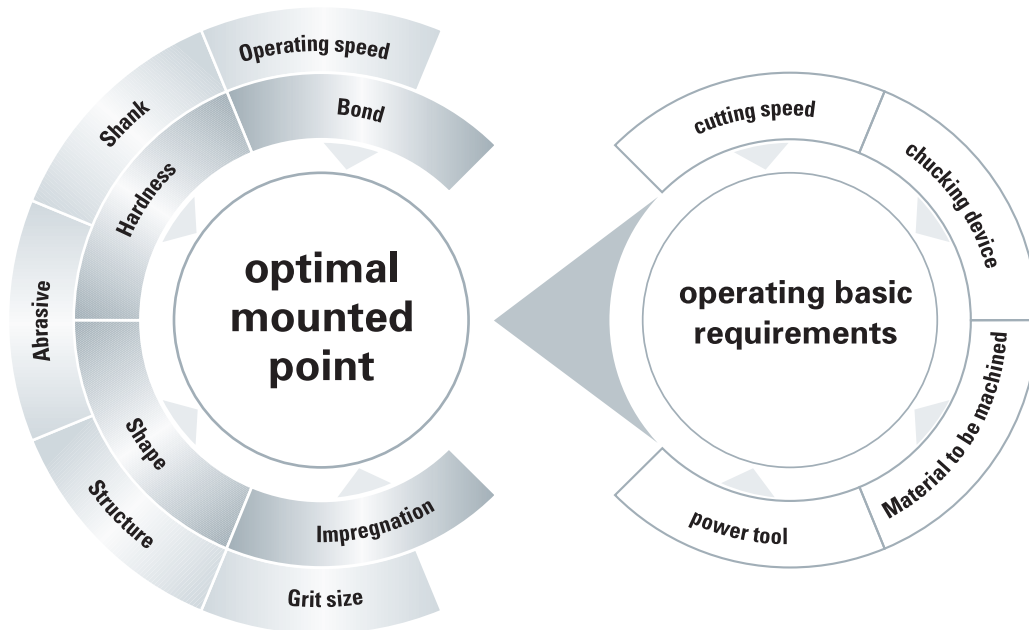
From the large variety of specifications we have selected various dimensions and shapes in well-proven standard qualities for you. These mounted points are available ex-stock.

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

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




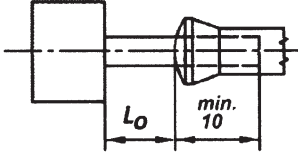


## Choice of the optimal grinding tool



## Speeds for grinding tools

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

## Safety instructions

Schleifkörper keramisch Brousicí tělíska keramická Mounted points - vitrified Muelas cerámicas Meule vitrifiée													
A200002032602 ZY 2032.06 EKR 36 N V4													
Stück pcs.	20	FA1334200											
  EN 12413			<table border="1"> <thead> <tr> <th>L<sub>0</sub>(mm)</th> <th>max. rpm</th> </tr> </thead> <tbody> <tr> <td>10</td> <td>40.600</td> </tr> <tr> <td>15</td> <td>34.500</td> </tr> <tr> <td>20</td> <td>29.700</td> </tr> </tbody> </table>			L <sub>0</sub> (mm)	max. rpm	10	40.600	15	34.500	20	29.700
L <sub>0</sub> (mm)	max. rpm												
10	40.600												
15	34.500												
20	29.700												

### Peripheral speeds, safety

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

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

These maximum operating speeds are limited by the following criteria:

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

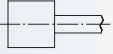

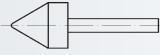
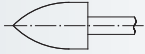

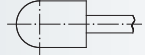

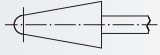






The safety aspect of a grinding wheel is of paramount importance.

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

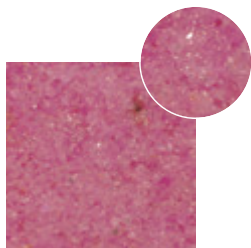
We enclose a safety ticket with all our deliveries, as illustrated above. The maximum speeds shown on these safety tickets refer to the overhang length (open shank length  $L_0$ ) of the shank i.e. 10, 15 and 20 mm respectively.

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

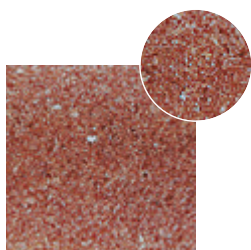
## A summary of available shapes

Shape	Type	Shape (Lukas)	Page
	Cylindrical, Typ 1	<b>ZY</b>	106
	Cylindrical, Typ 2	<b>ZY2</b>	112
	Cylindrical pointed nose	<b>WKS</b>	113
	Arch pointed nose	<b>SP</b>	113
	Spherical	<b>KU</b>	115
	Cylindrical round nose	<b>WR</b>	115
	Cup	<b>TO</b>	117
	Conical round nose	<b>KE</b>	117
	American shapes	<b>A</b>	118
	American shapes	<b>B</b>	120
	Miniature-Mounted points	<b>D</b>	120
	Handstones	–	124
	Mounted points, assortments	–	125
	Power Tools	–	373

**Qualities:**



**EKR**  
aluminium oxide pink



**EKWbr**  
aluminium oxide white,  
type brown

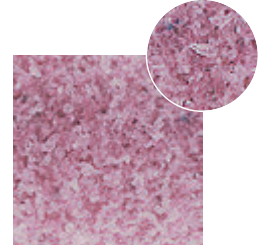


**General Information**

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

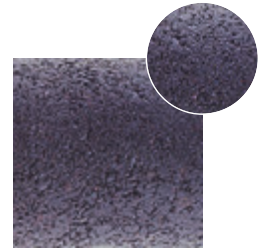


**Qualities:**



**RKD**

mixture aluminium oxide  
deep red / aluminium  
oxide pink



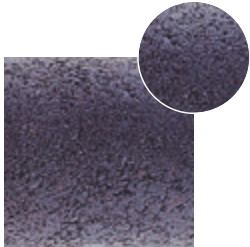
**NK-BA-soft**

aluminium oxide resin  
bonded iron and  
sulphur free

**General Information**

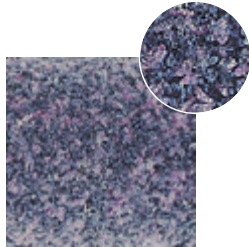
<p><b>Properties of workpiece material:</b></p>	<p>Alloyed steels i.e., non-rusting steels are included in the materials which are difficult to machine. They tend to “smear” due to the nickel content, and as a result of poor heat dissipation causes overheating of the material within the grinding contact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

**Qualities:**



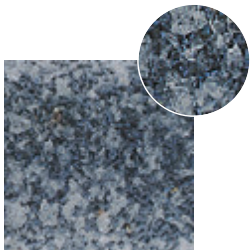
**NK Ba-hard**

aluminium oxide  
resin bonded



**MK**

mixture aluminium oxide  
pink / aluminium oxide



**HK**

mixture aluminium oxide  
white / aluminium oxide

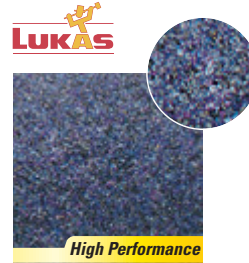


**General Information**

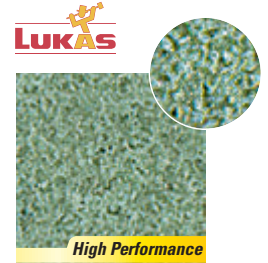
<p><b>Properties of workpiece material:</b></p>	<p>The characteristics of the various types of cast materials are normally determined by their carbon content, and the way in which the carbon is removed from the material structure.</p> <p>Cast components are generally “rough” machined. The skin contains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



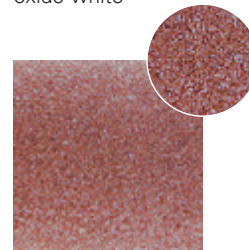
**Qualities:**



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



**CERAMIC**  
Mixture of ceramic grain and monocrystal aluminium oxide



**EKbr**  
aluminium oxide pink, type brown

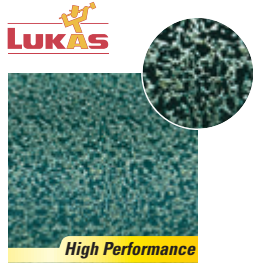


**EKW**  
aluminium oxide white

**General Information**

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

**Quality:**



**SIC-ALU**

silicon carbide green



**General Information**

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





**Quality:**



**HOK**  
mixture aluminium  
oxide hollow ball

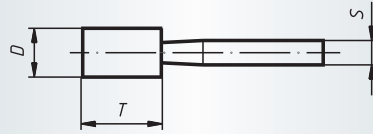
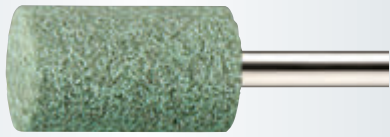
**General Information**

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



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

Ordering example: A200000408377



**Packing unit:**

20 pcs. per type

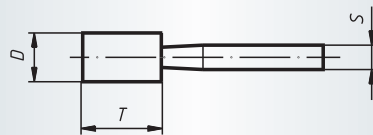
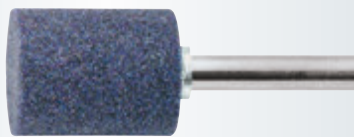
Further dimensions, qualities and shank lengths on request.

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



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

Ordering example: A200000306353



**Packing unit:**

20 pcs. per type

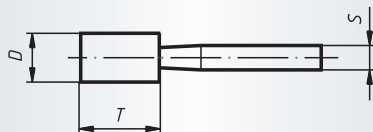
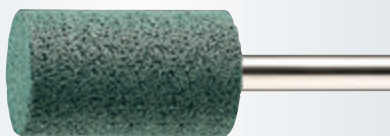
Further dimensions, qualities and shank lengths on request.

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



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

Ordering example: A200000408318A



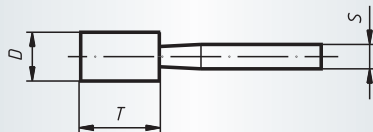
**Packing unit:**  
20 pcs. per type  
Further dimensions, qualities and shank lengths on request.

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



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

Ordering example: A200000104302



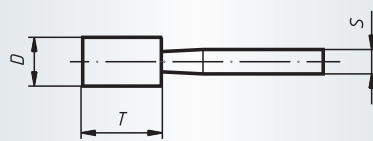
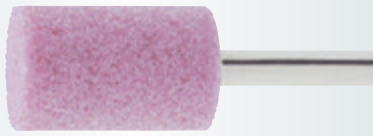
**Packing unit:**  
20 pcs. per type  
Further dimensions, qualities and shank lengths on request.

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



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

Ordering example: A200000306602



**Packing unit:**

20 pcs. per type

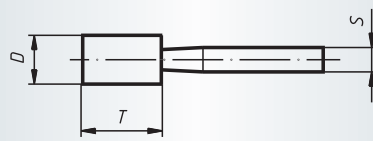
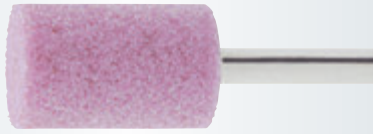
Further dimensions, qualities and shank lengths on request.

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



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

Ordering example: A200001013602



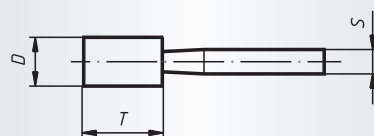
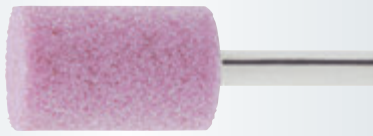
**Packing unit:**  
20 pcs. per type  
Further dimensions, qualities and shank lengths on request.

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ZY 1013.06	EKR 60 N V4	10	13	6 x 40	A200001013602	1	2	3								■
ZY 1020.06	EKR 60 N V4	10	20	6 x 40	A200001020602	1	2	3								■
ZY 1020.06	EKR 46 QU V4	10	20	6 x 40	A2000010206020001	1	2	3								■
ZY 1020.06	EKWBR 60 O/P V7	10	20	6 x 40	A200001020612	1	2									■
ZY 1020.06	NK 46 QU BA hard	10	20	6 x 40	A200001020627		2	3		5						■
ZY 1020.06	MK 46 N V10	10	20	6 x 40	A200001020616		2		4	5						■
ZY 1032.06	EKR 60 N V4	10	32	6 x 40	A200001032602	1	2	3								■
ZY 1032.06	EKR 46 QU V4	10	32	6 x 40	A2000010326020001	1	2	3								■
ZY 1032.06	EKWBR 60 O/P V7	10	32	6 x 40	A200001032612	1	2									■
ZY 1032.06	NK 46 QU BA hard	10	32	6 x 40	A200001032627		2	3		5						■
ZY 1040.06	EKR 60 N V4	10	40	6 x 40	A200001040602	1	2	3								■
ZY 1040.06	NK 46 QU BA hard	10	40	6 x 40	A200001040627		2	3		5						■
ZY 1313.03	EKR 46 N V4	13	13	3 x 30	A200001313302	1	2	3								■
ZY 1313.03	EKWBR 60 O/P V7	13	13	3 x 30	A200001313312	1	2									■
ZY 1313.03	RKD 60 P (6) V21	13	13	3 x 30	A200001313347		2	3	4							■
ZY 1313.06	EKR 46 N V4	13	13	6 x 40	A200001313602	1	2	3								■
ZY 1313.06	RKD 60 P (6) V21	13	13	6 x 40	A200001313647		2	3	4							■
ZY 1320.06	EKR 46 N V4	13	20	6 x 40	A200001320602	1	2	3								■
ZY 1320.06	EKR 46 QU V4	13	20	6 x 40	A2000013206020001	1	2	3								■
ZY 1320.06	EKWBR 60 O/P V7	13	20	6 x 40	A200001320612	1	2									■
ZY 1320.06	NK 46 QU BA hard	13	20	6 x 40	A200001320627		2	3		5						■
ZY 1320.06	MK 46 N V10	13	20	6 x 40	A200001320616		2		4	5						■
ZY 1325.06	EKR 46 N V4	13	25	6 x 40	A200001325602	1	2	3								■
ZY 1325.06	RKD 60 QU V21	13	25	6 x 40	A200001325647		2	3	4							■
ZY 1332.06	EKR 46 N V4	13	32	6 x 40	A200001332602	1	2	3								■
ZY 1332.06	NK 24 N BA soft	13	32	6 x 40	A200001332627W		2	3	4	6						■
ZY 1332.06	NK 46 QU BA hard	13	32	6 x 40	A200001332627		2	3		5						■
ZY 1616.06	EKR 46 N V4	16	16	6 x 40	A200001616602	1	2	3								■
ZY 1616.06	RKD 36 O (6) V21	16	16	6 x 40	A200001616647		2	3	4							■
ZY 1620.06	EKR 46 N V4	16	20	6 x 40	A200001620602	1	2	3								■
ZY 1620.06	EKWBR 46 O/P V7	16	20	6 x 40	A200001620612	1	2									■
ZY 1620.06	NK 24 QU BA hard	16	20	6 x 40	A200001620627		2	3		5						■
ZY 1632.06	EKR 46 N V4	16	32	6 x 40	A200001632602	1	2	3								■
ZY 1632.06	EKWBR 46 O/P V7	16	32	6 x 40	A200001632612	1	2									■
ZY 1632.06	RKD 36 O (6) V21	16	32	6 x 40	A200001632647		2	3	4							■
ZY 1632.06	NK 24 N BA soft	16	32	6 x 40	A200001632627W		2	3	4	6						■
ZY 1632.06	NK 24 QU BA hard	16	32	6 x 40	A200001632627		2	3		5						■
ZY 1632.06	HK 30 N V13	16	32	6 x 40	A200001632633				4	5						■
ZY 1632.06	MK 36 N V10	16	32	6 x 40	A200001632616		2		4	5						■
ZY 1640.06	EKR 46 N V4	16	40	6 x 40	A200001640602	1	2	3								■
ZY 1640.06	NK 24 QU BA hard	16	40	6 x 40	A200001640627		2	3		5						■
ZY 1640.06	MK 36 N V 10	16	40	6 x 40	A200001640616		2		4	5						■



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

Ordering example: A200002013602



**Packing unit:**

20 pcs. per type

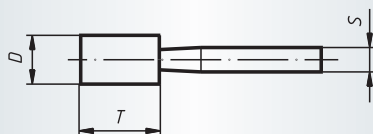
Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for												
ZY 2013.06	EKR 36 N V4	20	13	6 x 40	A200002013602	1	2	3										■
ZY 2020.06	EKR 36 N V4	20	20	6 x 40	A200002020602	1	2	3										■
ZY 2020.06	RKD 36 O (6) V21	20	20	6 x 40	A200002020647		2	3	4									■
ZY 2020.06	NK 24 QU BA hard	20	20	6 x 40	A200002020627		2	3		5								■
ZY 2020.06	MK 36 N V10	20	20	6 x 40	A200002020616		2		4	5								■
ZY 2020.06	EKW 60 L V1	20	20	6 x 40	A200002020608			3					7		9			■
ZY 2025.06	EKR 36 N V4	20	25	6 x 40	A200002025602	1	2	3										■
ZY 2025.06	RKD 36 O (6) V21	20	25	6 x 40	A200002025647		2	3	4									■
ZY 2025.06	HOK 0-3 V9	20	25	6 x 40	A202202025626										8			■
ZY 2032.06	EKR 36 N V4	20	32	6 x 40	A200002032602	1	2	3										■
ZY 2032.06	EKR 30/36 QU (7) V21	20	32	6 x 40	A2000020326020001	1	2	3										■
ZY 2032.06	RKD 36 O (6) V21	20	32	6 x 40	A200002032647		2	3	4									■
ZY 2032.06	NK 24 QU BA hard	20	32	6 x 40	A200002032627		2	3		5								■
ZY 2032.06	HK 30 N V13	20	32	6 x 40	A200002032633				4	5								■
ZY 2032.06	MK 36 N V10	20	32	6 x 40	A200002032616		2		4	5								■
ZY 2040.06	EKR 36 N V4	20	40	6 x 40	A200002040602	1	2	3										■
ZY 2040.06	EKWBR 46 O/P V7	20	40	6 x 40	A200002040612	1	2											■
ZY 2040.06	RKD 36 O (6) V21	20	40	6 x 40	A200002040647		2	3	4									■
ZY 2040.06	NK 24 N BA soft	20	40	6 x 40	A200002040627W		2	3	4		6							■
ZY 2040.06	NK 24 QU BA hard	20	40	6 x 40	A200002040627		2	3		5								■
ZY 2040.06	HK 30 N V13	20	40	6 x 40	A200002040633				4	5								■
ZY 2040.06	MK 36 N V10	20	40	6 x 40	A200002040616		2		4	5								■
ZY 2040.08	NK 24 N BA soft	20	40	8 x 40	A200002040827W		2	3	4		6							■
ZY 2040.08	NK 24 QU BA hard	20	40	8 x 40	A200002040827		2	3		5								■
ZY 2040.08	HK 30 N V13	20	40	8 x 40	A200002040833				4	5								■
ZY 2520.06	EKR 36 N V4	25	20	6 x 40	A200002520602	1	2	3										■
ZY 2525.06	EKR 36 N V4	25	25	6 x 40	A200002525602	1	2	3										■
ZY 2525.06	RKD 30 O (6) V21	25	25	6 x 40	A200002525647		2	3	4									■
ZY 2525.06	NK 24 QU BA hard	25	25	6 x 40	A200002525627		2	3		5								■
ZY 2532.06	EKR 36 N V4	25	32	6 x 40	A200002532602	1	2	3										■
ZY 2532.06	RKD 30 O (6) V21	25	32	6 x 40	A200002532647		2	3	4									■
ZY 2532.06	NK 24 N BA soft	25	32	6 x 40	A200002532627W		2	3	4		6							■
ZY 2532.06	NK 24 QU BA hard	25	32	6 x 40	A200002532627		2	3		5								■
ZY 2532.06	HK 30 N V13	25	32	6 x 40	A200002532633				4	5								■
ZY 2532.06	MK 36 N V10	25	32	6 x 40	A200002532616		2		4	5								■
ZY 3220.06	EKR 30 N V4	32	20	6 x 40	A200003220602	1	2	3										■
ZY 3220.06	NK 24 QU BA hard	32	20	6 x 40	A200003220627		2	3		5								■
ZY 3220.06	MK 36 N V10	32	20	6 x 40	A200003220616		2		4	5								■
ZY 3232.06	EKR 30 N V4	32	32	6 x 40	A200003232602	1	2	3										■
ZY 3232.06	EKR 30/36 QU (7) V21	32	32	6 x 40	A2000032326020001	1	2	3										■
ZY 3232.06	EKWBR 46 O/P V7	32	32	6 x 40	A200003232612	1	2											■
ZY 3232.06	RKD 30 O (6) V21	32	32	6 x 40	A200003232647		2	3	4									■



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

Ordering example: A200003232627W



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
ZY 3232.06	NK 24 N BA soft	32	32	6 x 40	A200003232627W	2	3	4	6											
ZY 3232.06	NK 24 QU BA hard	32	32	6 x 40	A200003232627	2	3		5											
ZY 3232.06	MK 36 N V10	32	32	6 x 40	A200003232616	2		4	5											
ZY 3240.06	EKR 30 N V4	32	40	6 x 40	A200003240602	1	2	3												
ZY 3240.06	RKD 30 O (6) V21	32	40	6 x 40	A200003240647		2	3	4											
ZY 3240.06	MK 36 N V10	32	40	6 x 40	A200003240616		2		4	5										
ZY 4020.06	EKR 30 N V4	40	20	6 x 40	A200004020602	1	2	3												
ZY 4020.06	RKD 24 O (6) V21	40	20	6 x 40	A200004020647		2	3	4											
ZY 4020.06	NK 24 N BA soft	40	20	6 x 40	A200004020627W		2	3	4	6										
ZY 4020.06	NK 24 QU BA hard	40	20	6 x 40	A200004020627		2	3		5										
ZY 4020.06	HK 30 N V13	40	20	6 x 40	A200004020633				4	5										
ZY 4020.06	MK 36 N V10	40	20	6 x 40	A200004020616		2		4	5										
ZY 4020.06	HOK 0-3 V9	40	20	6 x 40	A202204020626														8	
ZY 4020.08	RKD 24 O (6) V21	40	20	8 x 40	A200004020847		2	3	4											
ZY 4020.08	NK 24 N BA soft	40	20	8 x 40	A200004020827W		2	3	4	6										
ZY 4020.08	NK 24 QU BA hard	40	20	8 x 40	A200004020827		2	3		5										
ZY 4020.08	HK 30 N V13	40	20	8 x 40	A200004020833				4	5										
ZY 4040.06	EKR 30 N V4	40	40	6 x 40	A200004040602	1	2	3												
ZY 4040.06	RKD 24 O (6) V21	40	40	6 x 40	A200004040647		2	3	4											
ZY 4040.08	RKD 24 O (6) V21	40	40	8 x 40	A200004040847		2	3	4											
ZY 4040.08	NK 24 QU BA hard	40	40	8 x 40	A200004040827		2	3		5										
ZY 4040.08	MK 36 N V10	40	40	8 x 40	A200004040816		2		4	5										
ZY 5013.08	NK 24 QU BA hard	50	13	8 x 40	A200005013827		2	3		5										
ZY 5020.06	EKR 30 N V4	50	20	6 x 40	A200005020602	1	2	3												
ZY 5020.06	RKD 24 O (6) V21	50	20	6 x 40	A200005020647		2	3	4											
ZY 5020.06	NK 24 N BA soft	50	20	6 x 40	A200005020627W		2	3	4	6										
ZY 5020.06	NK 24 QU BA hard	50	20	6 x 40	A200005020627		2	3		5										
ZY 5020.08	NK 24 N BA soft	50	20	8 x 40	A200005020827W		2	3	4	6										
ZY 5020.08	NK 24 QU BA hard	50	20	8 x 40	A200005020827		2	3		5										
ZY 5025.06	MK 30 M V10	50	25	8 x 40	A200005025616		2		4	5										
ZY 5025.08	NK 24 QU BA hard	50	25	8 x 40	A200005025827		2	3		5										

NEU

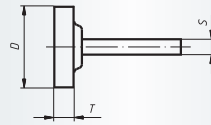
# 112 Mounted points



High Performance

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

Ordering example: A201301303377



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

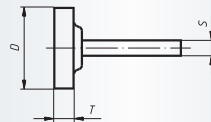
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for
<b>NEW</b> ZY2 1303.03	CERAMIC 80 L V118	13	3	3 x 30	A201301303377	② ③ ④ ⑦



Industry

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

Ordering example: A201301303302



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

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

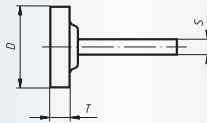
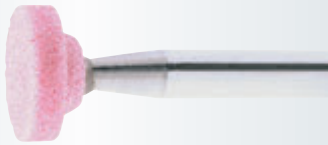




**Industry**

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

Ordering example: A201305006627



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

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

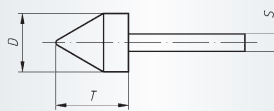
**NEW**



**Industry**

**Shape WKS, Cylindrical pointed nose**

Ordering example: A200402025602



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

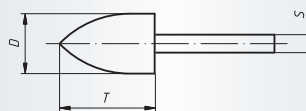
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for															
WKS 2025.06	EKR 60 N V4	20	25	6 x 40	A200402025602	1	2	3													■



**High Performance**

**Shape SP, Pointed nose (according to DIN 69170)**

Ordering example: A200200510377



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

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

**NEW**

**NEW**

**NEW**

# 114 Mounted points



**High Performance**

## Shape SP, Pointed nose (according to DIN 69170)

Ordering example: A2002005103530001

Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
						1	2	3	4	5	6	7	8	9	10		11	12		
SP 0510.03	NDW 100 QU V115	5	10	3 x 30	A2002005103530001	②	③													■
SP 0510.03	NDW 100 QU V115	5	10	3 x 50	A200200510353	②	③													■
SP 0810.03	NDW 100 QU V115	8	10	3 x 30	A2002008103530001	②	③													■
SP 0810.03	NDW 100 QU V115	8	10	3 x 50	A200200810353	②	③													■



**Industry**

## Shape SP, Pointed nose (according to DIN 69170)

Ordering example: A200200306302

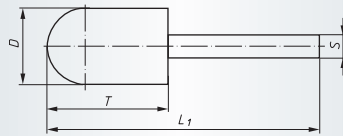
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for														
						1	2	3	4	5	6	7	8	9	10		11	12		
SP 0306.03	EKR 100 N V4	3	6	3 x 30	A200200306302	①	②	③												■
SP 0306.03	RKD 120 QU V21	3	6	3 x 30	A200200306347		②	③	④											■
SP 0510.03	EKR 80 N V4	5	10	3 x 30	A200200510302	①	②	③												■
SP 0510.03	RKD 100 QU V21	5	10	3 x 30	A200200510347		②	③	④											■
SP 0510.06	EKR 80 N V4	5	10	6 x 40	A200200510602	①	②	③												■
SP 0816.03	EKR 60 N V4	8	16	3 x 30	A200200816302	①	②	③												■
SP 0816.03	RKD 80 QU V21	8	16	3 x 30	A200200816347		②	③	④											■
SP 0816.06	EKR 60 N V4	8	16	6 x 40	A200200816602	①	②	③												■
SP 1020.06	EKR 60 N V4	10	20	6 x 40	A200201020602	①	②	③												■
SP 1320.06	EKR 46 N V4	13	20	6 x 40	A200201320602	①	②	③												■
SP 2032.06	EKR 36 N V4	20	32	6 x 40	A200202032602	①	②	③												■



**High Performance**

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

Ordering example: A2014010133530001



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

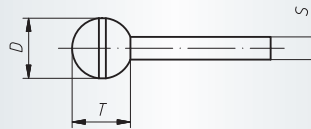
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for	
WR 1013.03	NDW 100 QU V115	10	13	3 x 30	A2014010133530001	② ③	■
WR 1013.03	NDW 100 QU V115	10	13	3 x 50	A201401013353	② ③	■



**High Performance**

**Shape KU, Spherical (according to DIN 69170)**

Ordering example: A201100606377



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

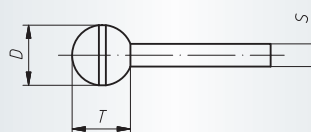
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for		
KU 0606.03	CERAMIC 80 L V118	6	6	3 x 30	A201100606377	② ③ ④ ⑦	■	NEW
KU 1010.06	CERAMIC 46 L V118	10	10	6 x 40	A201101010677	② ③ ④ ⑦	■	NEW
KU 1313.06	CERAMIC 46 L V118	13	13	6 x 40	A201101313677	② ③ ④ ⑦	■	NEW



**High Performance**

**Shape KU, Spherical (according to DIN 69170)**

Ordering example: A2011004043530001



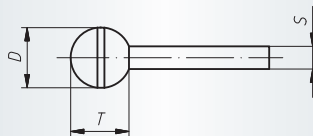
**Packing unit:**  
20 pcs. per type  
Further dimensions, qualities and shank lengths on request.

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



### Shape KU, Spherical (according to DIN 69170)

Ordering example: A201100606302



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

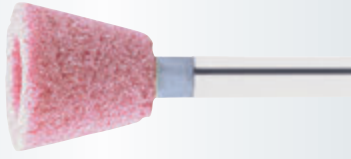
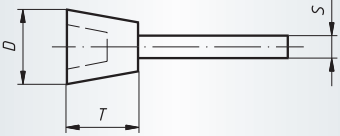
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for												
KU 0606.03	EKR 60 N V4	6	6	3 x 30	A201100606302	1	2	3										
KU 0606.03	EKR 80/100 QU V4	6	6	3 x 30	A2011006063020001	1	2	3										
KU 0606.03	EKWBR. 60 O/P V7	6	6	3 x 30	A201100606312	1	2											
KU 0606.06	EKR 60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



**Industry**

**Shape TO, Cup (according to DIN 69170)**

Ordering example: A202002019602


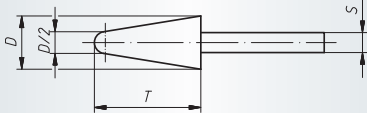
					<b>Packing unit:</b> 20 pcs. per type Further dimensions, qualities and shank lengths on request.							
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for						
TO 2020.06	EKR 60 N V4	20	20	6 x 40	A202002019602	①	②	③				■
TO 2524.06	EKR 60 N V4	25	24	6 x 40	A202002524602	①	②	③				■
TO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



**High Performance**

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

Ordering example: A201501025677

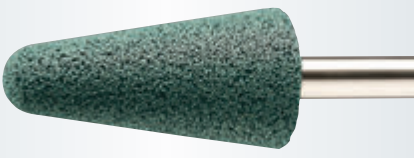
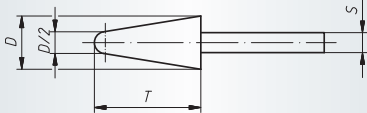
					<b>Packing unit:</b> 20 pcs. per type								
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for							
KE 1025.06	CERAMIC 46 L V118	10	25	6 x 40	A201501025677	②	③	④		⑦		■	NEW
KE 1632.06	CERAMIC 46 L V118	16	32	6 x 40	A201501632677	②	③	④		⑦		■	NEW



**High Performance**

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

Ordering example: A201501632618A

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

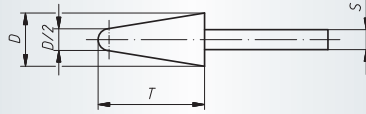
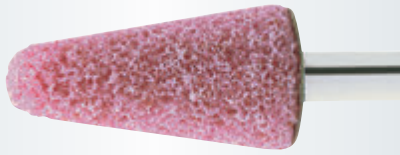
# 118 Mounted points



Industry

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

Ordering example: A201501025647



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

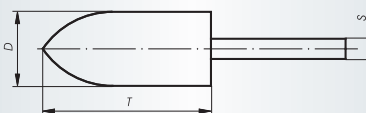
Description	Quality	D mm	T mm	S mm	Product-Number	recommended for																
KE 1025.06	RKD 60 P (6) V21	10	25	6 x 40	A201501025647		②	③	④													■
KE 1025.06	EKRBR.46/60 P V7	10	25	6 x 40	A201601025606	①																■
KE 1632.06	EKR 46 N V4	16	32	6 x 40	A201501632602	①	②	③													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



Industry

## Shape A, american shapes

Ordering example: A2062022636020001

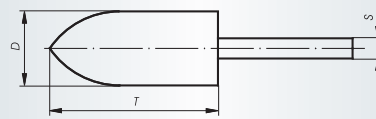


**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

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


**Shape A, american shapes**
*Ordering example: A206200620602*

**Packing unit:**

20 pcs. per type

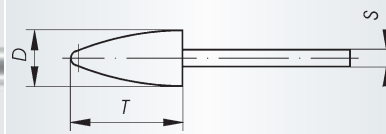
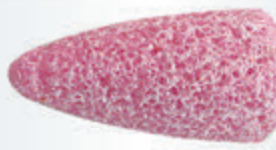
Further dimensions, qualities and shank lengths on request.

Description	Quality	Shape	D inch	T inch	D mm	T mm	S mm	Product-Number	recommended for												
A4 3232.06	EKR 30/36 QU (7) V21		1 1/4	1 1/4	32	32	6 x 40	A206203232602	1	2	3										■
A10 2270.06	EKR 36 N V4		7/8	2 3/4	22	70	6 x 40	A206202270602	1	2	3										■
A11 2250.06	EKR 36 QU V4		7/8	2	22	50	6 x 40	A206202250602	1	2	3										■
A11 2250.06	EKR 36 N V4		7/8	2	22	50	6 x 40	A2062022506020001	1	2	3										■
A11 2250.06	HK 36/46 M V13		7/8	2	22	50	6 x 40	A206202250633				4	5								■
A11 2250.06	HOK 0-3 V9		7/8	2	22	50	6 x 40	A206202250626											8		■
A11 2250.08	HK 36/46 M V13		7/8	2	22	50	8 x 40	A206402250833				4	5								■
A12 1832.06	EKR 30/36 QU (7) V21		1 1/16	1 1/4	18	32	6 x 40	A206201832602	1	2	3										■
A15 0625.06	EKR 80/100 QU V4		1/4	1	6	25	6 x 40	A206200625602	1	2	3										■
A15 0625.06	HK 46/60 N V13		1/4	1	6	25	6 x 40	A206200625633				4	5								■
A24 0620.06	EKR 60/80 QU V4		1/4	3/4	6	20	6 x 40	A206200620602	1	2	3										■
A36 4010.06	EKR 60/80 QU V4		1 5/8	3/8	40	10	6 x 40	A206204010602	1	2	3										■
A37 3206.06	EKR 46 QU V4		1 1/4	1/4	32	6	6 x 40	A206203206602	1	2	3										■



### Shape B, american shapes

Ordering example: A206601616302



**Packing unit:**

20 pcs. per type

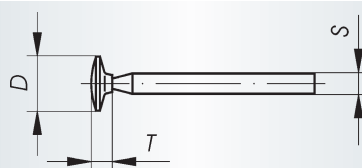
Further dimensions, qualities and shank lengths on request.

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



### Miniature-Mounted points

Ordering example: A202900001302



**Packing unit:**

20 pcs. per type

Further dimensions, qualities and shank lengths on request.

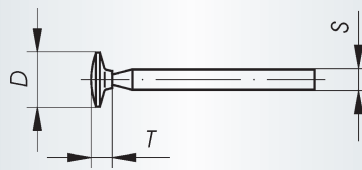
Description	Quality	Shape	D mm	T mm	S mm	Product-Number	recommended for	
D1	EKR 100 N V4		9	2	3 x 30	A202900001302	① ② ③	■
D1	EKBR 100 M V1/6		9	2	3 x 30	A202900001311	② ③	■
D2	EKR 80 N V4		9	3	3 x 30	A202900002302	① ② ③	■
D2	EKBR 80 M V1/6		9	3	3 x 30	A202900002311	② ③	■
D3	EKR 100 N V4		8	2	3 x 30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





Miniature-Mounted points

Ordering example: A202900007302

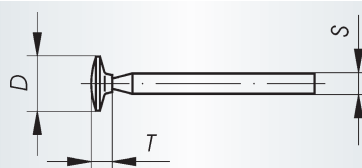


**Packing unit:**  
20 pcs. per type  
Further dimensions, qualities and  
shank lengths on request.

Description	Quality	Shape	D mm	T mm	S mm	Product-Number	recommended for															
D7	EKR 100 N V4		2,5/5	2,5	3 x 30	A202900007302	①	②	③													■
D7	EKBR 100 M V1/6		2,5/5	2,5	3 x 30	A202900007311		②	③													■
D8	EKR 100 N V4		2,5/6	3	3 x 30	A202900008302	①	②	③													■
D8	EKBR 100 M V1/6		2,5/6	3	3 x 30	A202900008311		②	③													■
D9	EKR 80 N V4		3,5/8	4	3 x 30	A202900009302	①	②	③													■
D9	EKBR 80 M V1/6		3,5/8	4	3 x 30	A202900009311		②	③													■
D10	EKR 100 N V4		2/3,2	4	3 x 30	A202900010302	①	②	③													■
D10	EKBR 100 M V1/6		2/3,2	4	3 x 30	A202900010311		②	③													■
D11	EKR 80 N V4		5	5	3 x 30	A202900011302	①	②	③													■
D12	EKR 80 N V4		4/7	6	3 x 30	A202900012302	①	②	③													■
D12	EKBR 80 M V1/6		4/7	6	3 x 30	A202900012311		②	③													■
D13	EKR 100 N V4		3	3	3 x 30	A202900013302	①	②	③													■
D13	EKBR. 100 M V1/6		3	3	3 x 30	A202900013311		②	③													■
D14	EKR 80 N V4		4	4	3 x 30	A202900014302	①	②	③													■
D14	EKBR 80 M V1/6		4	4	3 x 30	A202900014311		②	③													■
D15	EKR 80 N V4		5	5	3 x 30	A202900015302	①	②	③													■
D15	EKBR 80 M V1/6		5	5	3 x 30	A202900015311		②	③													■
D16	EKR 100 N V4		3	4	3 x 30	A202900016302	①	②	③													■
D16	EKBR 100 M V1/6		3	4	3 x 30	A202900016311		②	③													■
D17	EKR 80 N V4		4	5	3 x 30	A202900017302	①	②	③													■
D17	EKBR 80 M V1/6		4	5	3 x 30	A202900017311		②	③													■



## Miniature-Mounted points

*Ordering example: A202900018302*


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

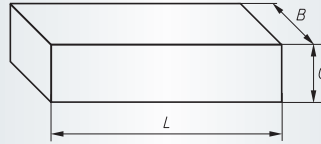
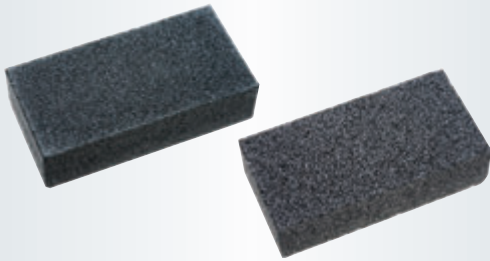
Description	Quality	Shape	D mm	T mm	S mm	Product-Number	recommended for															
D18	EKR 80 N V4		7	8	3 x 30	A202900018302	1	2	3													■
D18	EKBR 80 M V1/6		7	8	3 x 30	A202900018311		2	3													■
D20	EKR 100 N V4		7	5	3 x 30	A202900020302	1	2	3													■
D21	EKR 100 N V4		8	1,6	3 x 30	A202900021302	1	2	3													■
D21	EKBR 100 M V1/6		8	1,6	3 x 30	A202900021311		2	3													■
D22	EKR 100 N V4		2,5	6	3 x 30	A202900022302	1	2	3													■
D22	EKBR 100 M V1/6		2,5	6	3 x 30	A202900022311		2	3													■
D23	EKR 80 N V4		5	6	3 x 30	A202900023302	1	2	3													■
D23	EKBR 80 M V1/6		5	6	3 x 30	A202900023311		2	3													■
D24	EKR 60 N V4		6	6	3 x 30	A202900024302	1	2	3													■
D24	EKBR 60 M 1/6		6	6	3 x 30	A202900024311		2	3													■
D25	EKR 100 N V4		5	1,5	3 x 30	A202900025302	1	2	3													■
D26	EKR 100 N V4		6	2,5	3 x 30	A202900026302	1	2	3													■
D26	EKBR 100 M V1/6		6	2,5	3 x 30	A202900026311		2	3													■
D27	EKR 100 N V4		2/3,5	10	3 x 30	A202900027302	1	2	3													■
D28	EKR 80 N V4		3,5/5,5	11	3 x 30	A202900028302	1	2	3													■
D29	EKR 100 N V4		3	6,4	3 x 30	A202900029302	1	2	3													■
D29	EKBR 100 M V1/6		3	6,4	3 x 30	A202900029311		2	3													■
D30	EKR 100 N V4		4,4	10	3 x 30	A202900030302	1	2	3													■
D30	EKBR 100 M V1/6		4,4	10	3 x 30	A202900030311		2	3													■





### Handstones

Ordering example: A204300000118



**Packing unit:**

5 pcs. per type

Further dimensions (see table below) and qualities on request.

Description	Quality	L mm	B mm	C mm	Product-Number	recommended for																	
RU 1	SICGR 60 O V23/green=fine	50	25	15	A204300000118																9	■	
RU 1	SICDKL 24 O V23/dark=coarse	50	25	15	A204300000122																	9	■
RU 2	SICGR 60 O V23/green=fine	100	30	15	A204300000218																	9	■
RU 2	SICDKL 24 O V23/dark=coarse	100	30	15	A204300000222																	9	■
RU 3	SICGR 60 O V23/green=fine	100	50	25	A204300000318																	9	■
RU 3	SICDKL 24 O V23/dark=coarse	100	50	25	A204300000322																	9	■
RU 4	SICGR 60 O V23/green=fine	150	50	25	A204300000418																	9	■
RU 4	SICDKL 24 O V23/dark=coarse	150	50	25	A204300000422																	9	■
RU 5	EKW 100 E (9) V40	150	25	16,5	A2043150251608																	3	■
RU 6	EKW 100 E (9) V40	200	50	25	A2043200502508																	3	■

RU 1-4 is particularly suitable for

- profiling
  - opening of pores
  - sharpening
  - dressing
- of bonded grinding and polishing tools.

### Available dimensions for handstones

Shape	length mm	width mm	height mm
	25	15	5 to 30
	44	35	18 to 30
	48	19	5 to 30
	50	25	10 to 35
	90	70	20 to 35
	100	30	10 to 35
	100	50	10 to 35
	120	10	5 to 35
	150	25	10 to 35
	150	50	10 to 35
	200	50	10 to 35
	216	78	20 to 35
	150	13	5 to 35



**High Performance**

**Mounted points-Assortments**

Ordering example: A201000000353



**Packing unit:**  
1 pc. per type

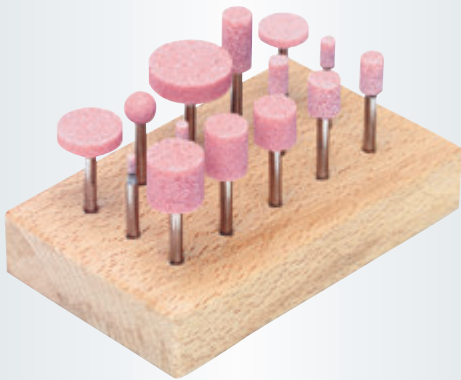
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 10	3 x 50	NDW	10-pieces	ZY 0408, ZY 0610, ZY 0810, ZY 1013, SP 0510, SP 0810, KU 0404, KU 0606, KU 0808, WR 1013	A201000000353	② ③	■



**Industry**

**Mounted points-Assortments**

Ordering example: A204700001402



**Packing unit:**  
1 pc. per type

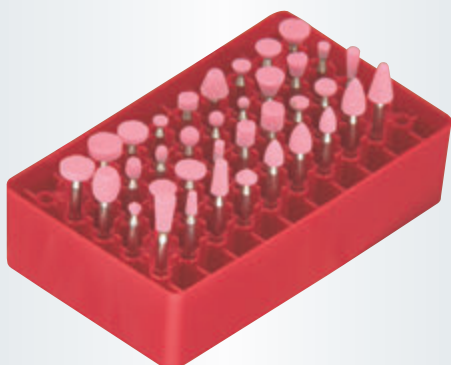
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 14	3 x 30	EKR	14-pieces	ZY 0205, ZY 0306, ZY 0408, ZY 0510, ZY 0610, ZY 0810, ZY 0816, ZY 1010, ZY 1013, ZY 1313, KU 0808, ZY2 1303, ZY2 1604, ZY2 2006	A204700001402	① ② ③	■



Industry

## Mounted points-Assortments

Ordering example: A204800003602



**Packing unit:**  
1 pc. per type

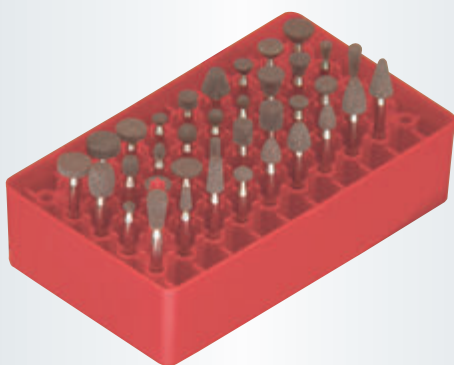
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 36	3 x 30	EKR	36-pieces	D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11, D12, D13, D14, D15, D16, D17, D18, D19, D20, D21, D22, D23, D24, D25, D26, D27, D28, D29, D30, D31, D32, D33, D34, D35, D36	A204800003602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



Industry

## Mounted points-Assortments

Ordering example: A204800003611



**Packing unit:**  
1 pc. per type

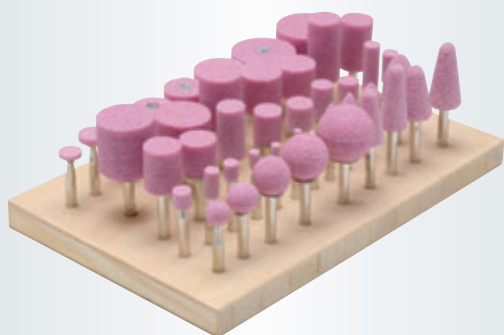
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 36	3 x 30	EKBR	36-pieces	D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11, D12, D13, D14, D15, D16, D17, D18, D19, D20, D21, D22, D23, D24, D25, D26, D27, D28, D29, D30, D31, D32, D33, D34, D35, D36	A204800003611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



**Industry**

## Mounted points-Assortments

Ordering example: A204600000202



**Packing unit:**  
1 pc. per type

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

# 128 Mounted points-Assortments



Industry

## Mounted point assortment – STEEL

Ordering example: A20480005602



**Packing unit:**  
1 pc. per type

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



Industry

## Mounted point assortment – INOX

Ordering example: A20480004627W



**Packing unit:**  
1 pc. per type

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



# Always the right tool

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

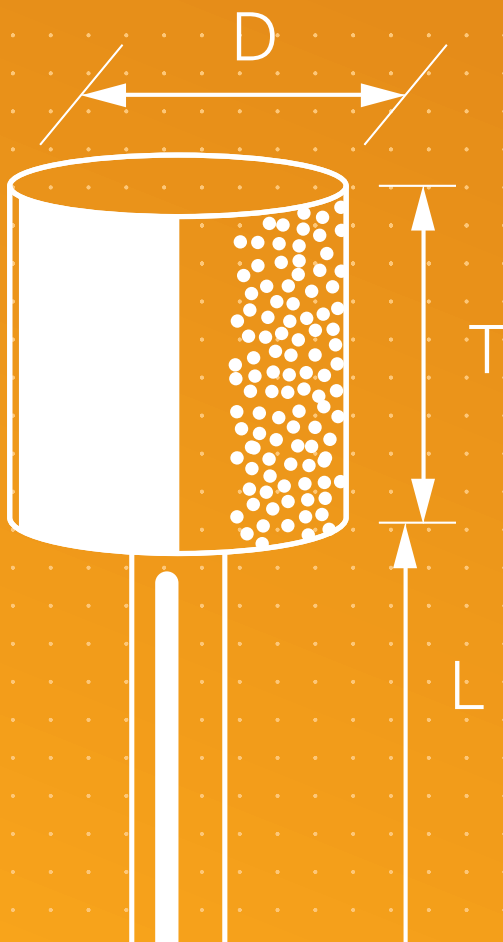
**Holger Roland**  
Production



# Grinding wheels – special for your particular application

131 Examples of our efficiency

131 Enquiry parameters



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

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

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

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

Always the right tool

# For Highest Performance and Best Ergonomics!



# Polishing tools

**134** General Information

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**137** Polishing points, group P1

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**140** Polishing points, group P2

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**144** Felt polishing points, group P3

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**148** Grinding- and diamond pastes,  
sprays and thinners

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**151** Flexible polishing sticks, group P4

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**153** Polishing points, group P5

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**155** Polishing points and wheels,  
marbling points, group P6

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**161** Small polishing points, group P7

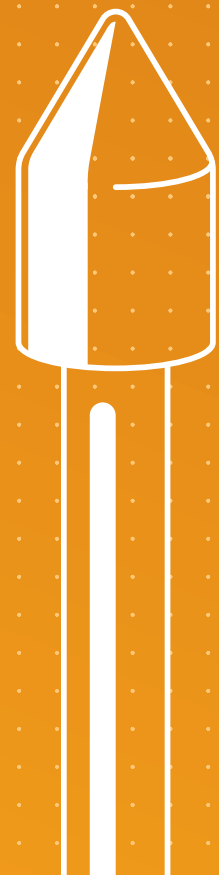
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**373** Power tools

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## Product line marking

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



## General Information

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

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

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

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

## Safety instructions

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

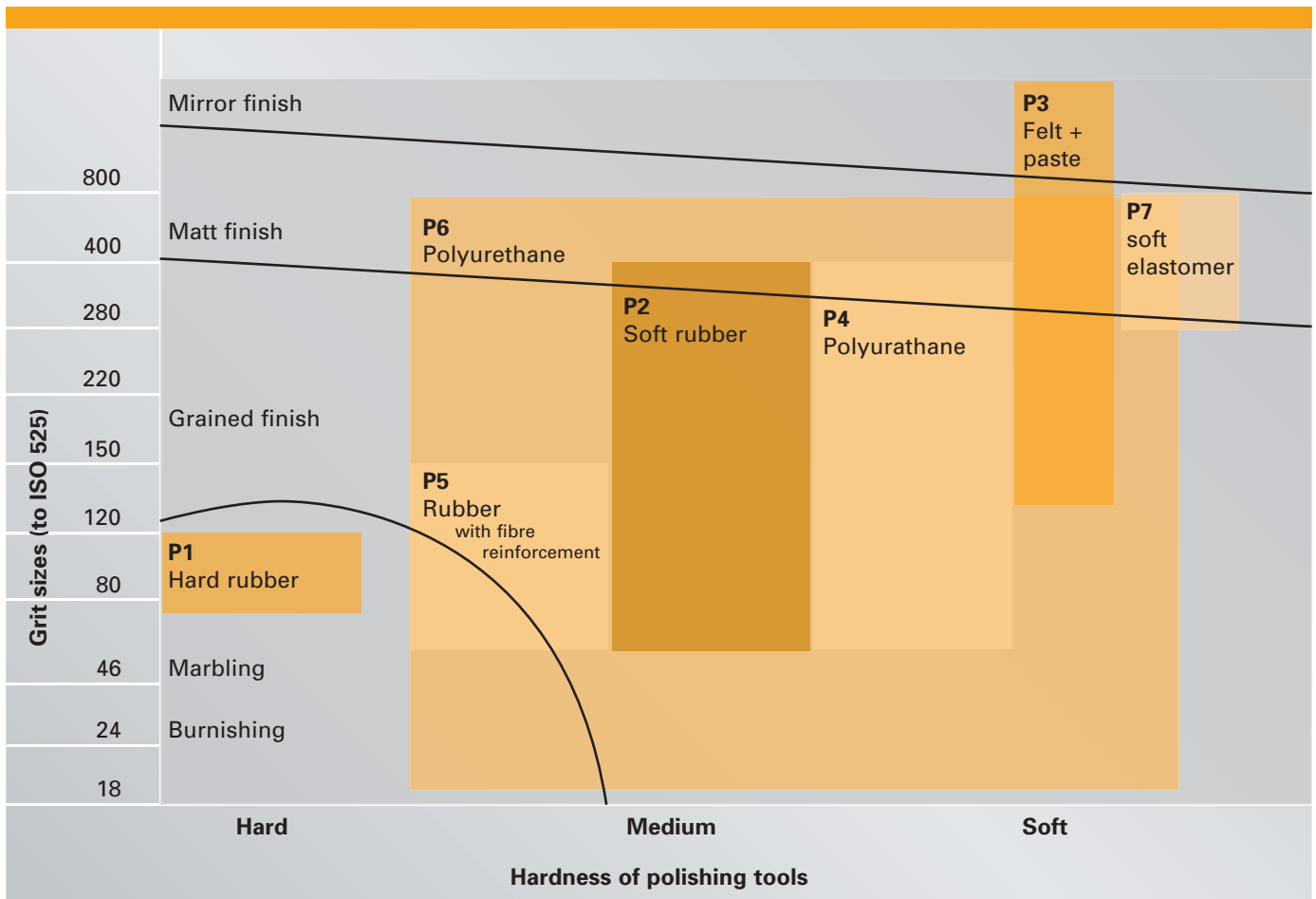
For the safe use of polishing points and wheels, please take note of the following operating instructions:

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

### Application example of P2



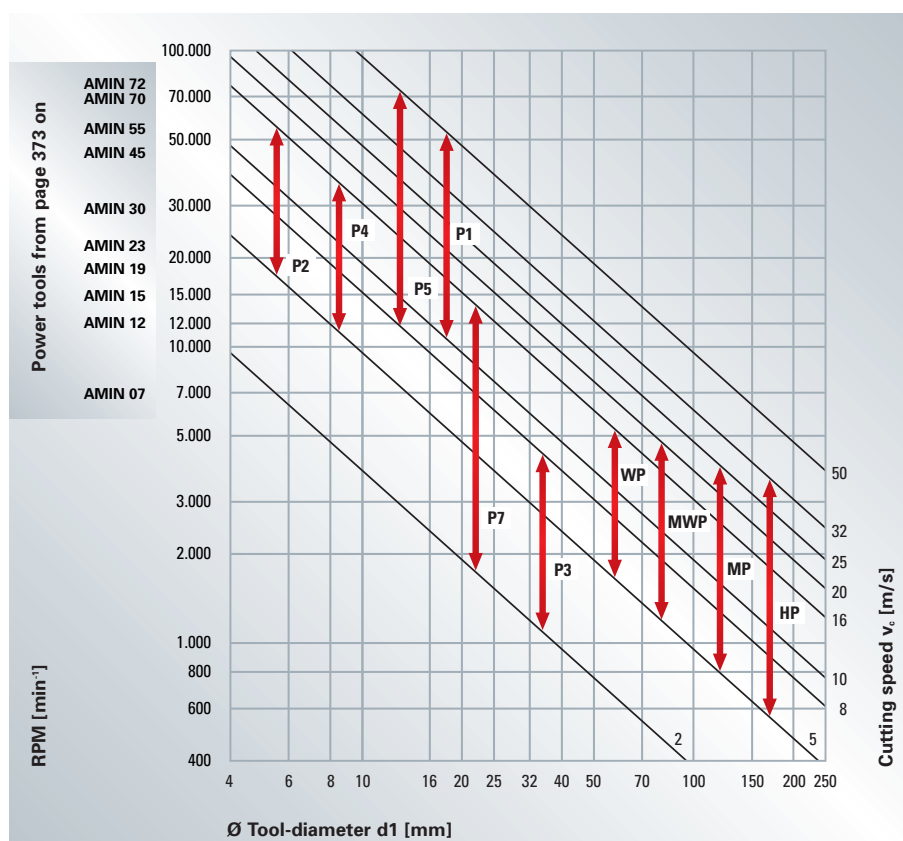
## Areas of application



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

### A summary of available shapes

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





## Quality and application P1

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


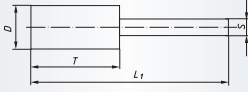

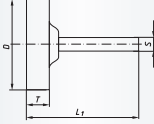
no loading with these points. If applied with low pressure, they have a long and economical tool life.



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2600004083

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

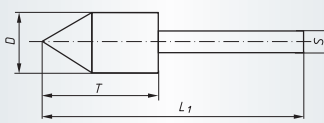
Description	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for									
P1ZY 0408.03	1	4	8	3	38	A2600004083	1	2	3	4	5	7				■
P1ZY 0510.03	1	5	10	3	40	A2600005103	1	2	3	4	5	7				■
P1ZY 0610.03	1	6	10	3	40	A2600006103	1	2	3	4	5	7				■
P1ZY 0710.03	1	7	10	3	40	A2600007103	1	2	3	4	5	7	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



Industry

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

Ordering example: A2602016326



**Packing unit:**

10 pcs. per type

Further dimensions on request

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

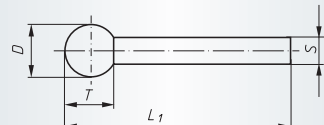
Description	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P1KS 1632.06	16	32	6	72	A2602016326	1 2 3 4 5 7



Industry

## Shape KU, Spherical (according to DIN 69170)

Ordering example: A2605008083



**Packing unit:**

Shank 3 mm = 20 pcs. per type,

Shank 6 mm = 10 pcs. per type

Further dimensions on request

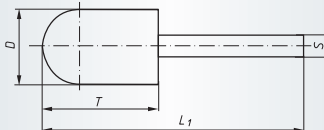
$v_{max.}$ : 50 m/s

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



Industry

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



**Packing unit:**

10 pcs. per type

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

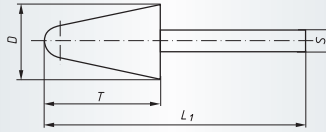
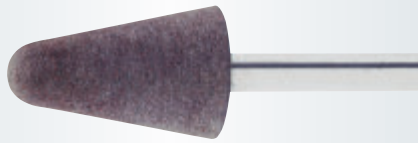
						available on request
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Industry

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

Ordering example: A2609020326



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

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



Industry

**Assortment, Polishing points, 114**

Ordering example: A2600114



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

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

## Specification and application P2

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

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


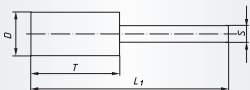

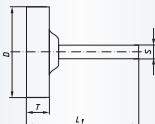
					
<b>Color</b>	black	pale grey	red	brown	green
<b>Grit size</b>	46	80	120	220	280



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610004083080

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

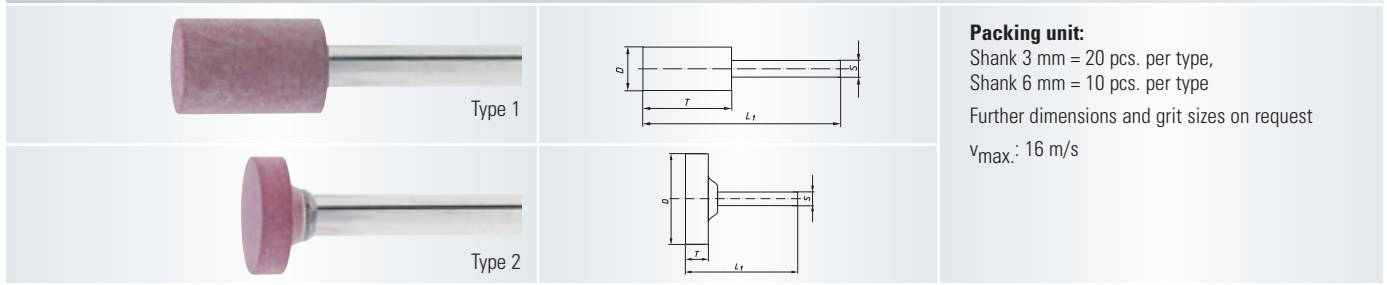
Description	Grit	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P2ZY 0408.03	80	1	4	8	3	38	A2610004083080	1 2 3 4 5 6 7 8
P2ZY 0408.03	120	1	4	8	3	38	A2610004083120	1 2 3 4 5 6 7 8
P2ZY 0408.03	220	1	4	8	3	38	A2610004083220	1 2 3 4 5 6 7 8
P2ZY 0408.03	280	1	4	8	3	38	A2610004083280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



Industry

**Shape ZY, Cylindrical (according to DIN 69170)**

Ordering example: A2610008103080



**Packing unit:**

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

Further dimensions and grit sizes on request

v<sub>max.</sub>: 16 m/s

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

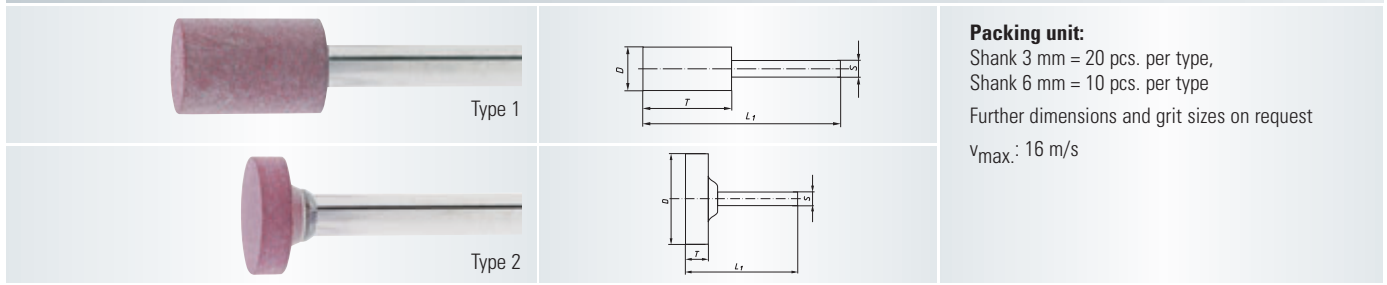
# 142 Polishing points, group P2



Industry

## Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610020206280



**Packing unit:**

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

Further dimensions and grit sizes on request

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

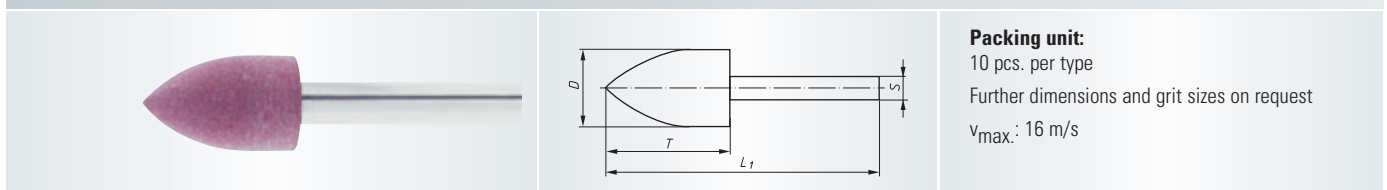
Description	Grit	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2ZY 2020.06	280	1	20	20	6	60	A2610020206280	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	80	1	20	32	6	72	A2610020326080	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	120	1	20	32	6	72	A2610020326120	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	220	1	20	32	6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



Industry

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

Ordering example: A2611013206120



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

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

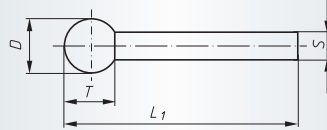
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2SP 1320.06	120	13	20	6	60	A2611013206120	1 2 3 4 5 6 7 8	■
P2SP 2032.06	220	20	32	6	72	A2611020326220	1 2 3 4 5 6 7 8	■



Industry

**Shape KU, Spherical (according to DIN 69170)**

Ordering example: A2615008083120



**Packing unit:**

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

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

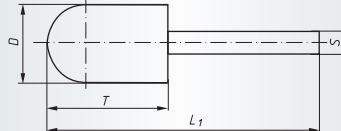
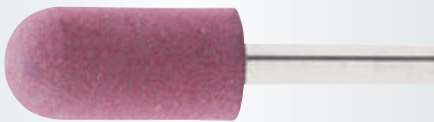
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2KU 0808.03	120	8	8	3	38	A2615008083120	1 2 3 4 5 6 7 8	■
P2KU 1010.03	120	10	10	3	40	A2615010103120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	120	16	16	6	56	A2615016166120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	220	16	16	6	56	A2615016166220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



Industry

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

Ordering example: A2618016326120



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

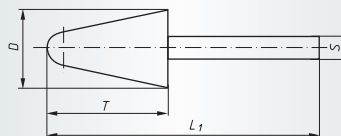
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2WR 1632.06	120	16	32	6	72	A2618016326120	1 2 3 4 5 6 7 8	■



Industry

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

Ordering example: A2619010206080



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

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

## Specification and application P3

**LUKAS felt polishing points are available in two specifications:**

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

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

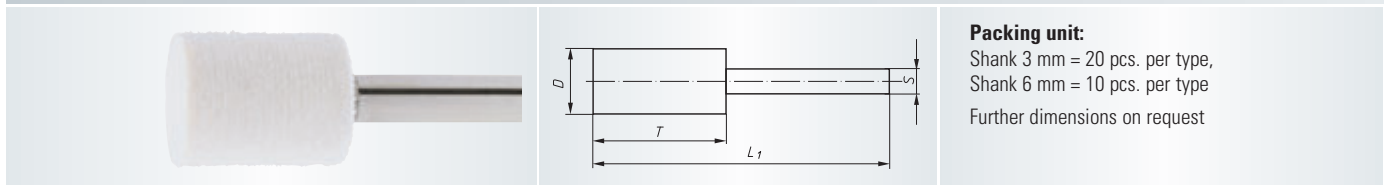
The LUKAS assortment of felt polishing tools reflects years of experience in this field and encompasses the most common shapes and sizes. Due to the extreme flexibility, felt polishing points together with LUKAS diamond paste are ideally suited for polishing exceptionally complex shapes e.g. pressure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



**Industry**

### Shape ZY, Cylindrical

Ordering example: A3700006103



**Packing unit:**

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

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

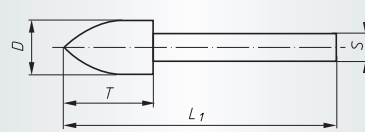




Industry

**Shape SP, Arch pointed nose**

Ordering example: A3701006103



**Packing unit:**

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

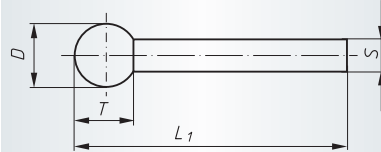
Description	Quality	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P3SP 0610.03	H3	6	10	3	50	A3701006103	1 2 3 4 5 6 7 9	■
P3SP 0810.03	H3	8	10	3	50	A3701008103	1 2 3 4 5 6 7 9	■
P3SP 1012.03	H3	10	12	3	52	A3701010123	1 2 3 4 5 6 7 9	■
P3SP 1015.06	H3	10	15	6	55	A3701010156	1 2 3 4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



Industry

**Shape KU, Spherical**

Ordering example: A3703006063



**Packing unit:**

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

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

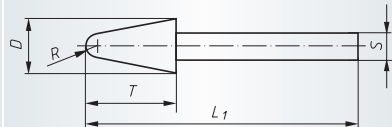
# 146 Felt polishing points, group P3



Industry

## Shape KE, Conical round nose

Ordering example: A3705010123



**Packing unit:**

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

Further dimensions on request

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

### Application example P3

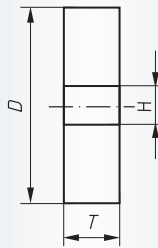




Industry

**Shape S1, Wheels**

Ordering example: A3750040106



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

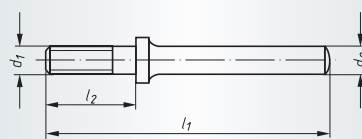
Description	Quality	D mm	T mm	H mm	Product-Number	recommended for	
P3S1 4010.06	H3	40	10	6	A3750040106	1 2 3 4 5 6 7 9	■
P3S1 5010.06	H3	50	10	6	A3750050106	1 2 3 4 5 6 7 9	■
P3S1 5020.06	H3	50	20	6	A3750050206	1 2 3 4 5 6 7 9	■
P3S1 6010.06	H3	60	10	6	A3750060106	1 2 3 4 5 6 7 9	■
P3S1 6020.06	H3	60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



Industry

**Arbors for felt polishing wheels**

Ordering example: A1630780



**Packing unit:**  
5 pcs. per type  
2 washers and a nut are supplied per arbor.

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

### Specification and application of diamond paste

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

### List of grit sizes

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

Examples of diamond pastes and diamond sprays





Industry

Grinding compound

Ordering example: A3760120



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

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

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

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



Industry

Diamond pastes

Ordering example: A34105062



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

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

# 150 Diamond sprays and thinner



Industry

## Diamond sprays

Ordering example: A34104070



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

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



Industry

## Thinner

Ordering example: A341063003



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

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

## Specification and application P4

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

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

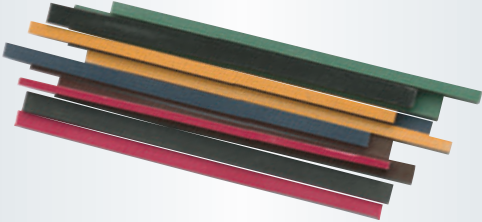
Color	Qualities	Color	Qualities	Color	Qualities
pale grey	SiC 80 soft	pale green	SiC 240 soft	pale red	EKW 150 soft
grey	SiC 80 hard	green	SiC 240 hard	red	EKW 150 hard
pale blue	SiC 150 soft	beige	EKW 80 soft	pale brown	EKW 240 soft
blue	SiC 150 hard	dark beige	EKW 80 hard	brown	EKW 240 hard



Industry

### Polishing sticks, flat

Ordering example: P4SF 0612.070 SiC 80 soft



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

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

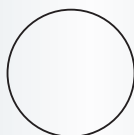
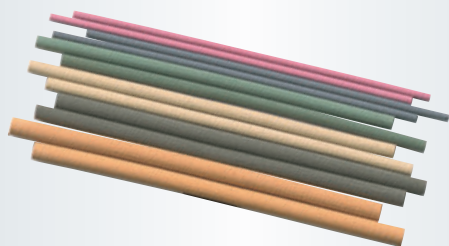
# 152 Polishing sticks, group P4



Industry

## Polishing sticks, round

Ordering example: P4SR 0006.070 EKW 80 hard



**Packing unit:**

10 pcs. per type

Further dimensions on request

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

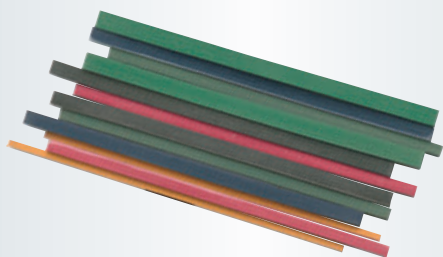
Description	Ø mm	L mm			recommended for	
P4SR 0006.070	6	70			1 2 3 4 5 6 7	▲
P4SR 0006.140	6	140			1 2 3 4 5 6 7	▲
P4SR 0010.070	10	70			1 2 3 4 5 6 7	▲
P4SR 0010.140	10	140			1 2 3 4 5 6 7	▲
P4SR 0010.210	10	210			1 2 3 4 5 6 7	▲
P4SR 0012.070	12	70			1 2 3 4 5 6 7	▲
P4SR 0012.140	12	140			1 2 3 4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



Industry

## Polishing sticks, square

Ordering example: P4SV 0606.070 SIC 80 hard



**Packing unit:**

10 pcs. per type

Further dimensions on request

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

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



## Specification and application P5

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

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

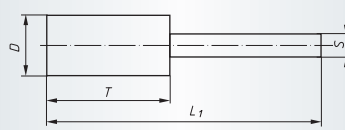
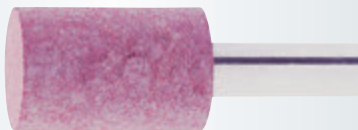
			
<b>Color</b>	black	pale grey	red
<b>Grit</b>	46	80	120



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620004083080



**Packing unit:**

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

Further dimensions and grit sizes on request

$v_{max}$ : 50 m/s

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

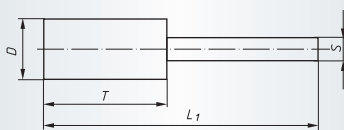
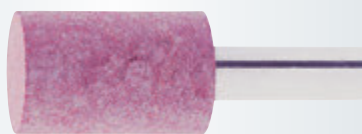
# 154 Polishing points, group P5



Industry

## Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620013206080



**Packing unit:**

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

Further dimensions and grit sizes on request

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

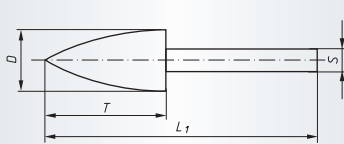
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5ZY 1320.06	120	13	20	6	60	A2620013206120	1 2 3 4 5 6 7	■
P5ZY 1620.06	80	16	20	6	60	A2620016206080	1 2 3 4 5 6 7	■
P5ZY 1620.06	120	16	20	6	60	A2620016206120	1 2 3 4 5 6 7	■
P5ZY 1632.06	46	16	32	6	72	A2620016326046	1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



Industry

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

Ordering example: A2621020326080



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

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

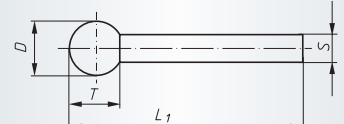
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5SP 2032.06	80	20	32	6	72	A2621020326080	1 2 3 4 5 6 7	■



Industry

## Shape KU, Spherical (according to DIN 69170)

Ordering example: A2625008083080



**Packing unit:**

20 pcs. per type

Further dimensions and grit sizes on request

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

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

## Specification and application P6

Products in group 6 are manufactured with a polyurethane bond (PU) in different hardnesses.

These tools

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

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

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

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

The following grades are available:

**WP** = soft, very flexible

**MWP** = medium to soft

**MP** = medium for general application

**HP** = hard, resilient for flat surfaces

**SHP** = super hard, for stationary applications

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

### Application examples marbling points P6



Application recommendations polishing tools P6

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

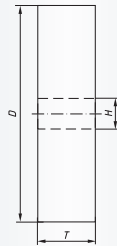
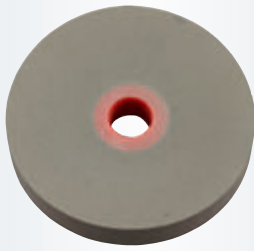
Grit sizes



Industry

**Polierscheiben, Form SE1**

Ordering example: A29100600060041



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

$v_{max}$ : MWP = 20 m/s

WP = 16 m/s

SHP = 32 m/s

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

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

**Safety instructions:**

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

# 158 Mounting system for polishing wheels



Industry

## Mounting system for polishing wheels

Ordering example: A6981008000




**Packing unit:**  
1 pc. per type


Description	Product-Number		
Mounting system MCA + K25	A6981008000		■

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

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



## Always the right tool



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

**Andrea Bittner**  
Sales Department

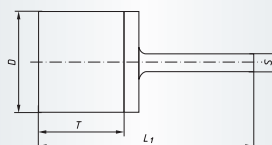
[www.lukas-erzett.com](http://www.lukas-erzett.com)



Industry

## Marbling points, Shape ZY, Cylinder

Ordering example: A29200200306021



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

v<sub>max</sub>: 10 m/s

Description	Quality/ Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P6MA ZY 2030.06	SC 46 MWP	20	30	6	80	A29200200306021	1 2 3 4 5 6 7 9	■
P6MA ZY 3030.06	SC 46 MWP	30	30	6	80	A29200300306021	1 2 3 4 5 6 7 9	■
P6MA ZY 4030.06	SC 46 MWP	30	30	6	80	A29200400306046	1 2 3 4 5 6 7 9	■
P6MA ZY 5030.06	SC 46 MWP	30	30	6	80	A29200500306046	1 2 3 4 5 6 7 9	■
P6MA ZY 6030.06	SC 46 MWP	30	30	6	80	A29200600306046	1 2 3 4 5 6 7 9	■

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

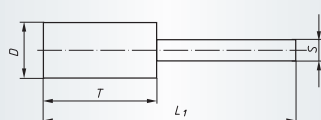
The marbling points do not load with abrasive dust and their quality lasts up to the plastic cap.



Industry

## Polishing points, Shape ZY, Cylindrical

Ordering example: A29300160203028



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

v<sub>max</sub>: 20 m/s

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

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

**Applications:**

Bores, Hollow weldings, Moulding tools

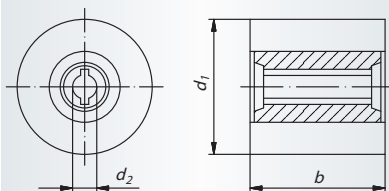
# 160 Polishing roll, group P6



Industry

## Polishing roll, P6PW

Ordering example: A29401000500041



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

Machine to suit: ESM 1310

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

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



Industry

## Conditioning machine ESM 1310

Ordering example: A3995ESM1310



**Packing unit:**

1 pc. per type

**Weight:** approx. 2,9 kg

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



## Specification and application P7

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

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



**Industry**

### Polishing discs and polishing lenses in a soft elastomer bonding

Ordering example: A2950000101007

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



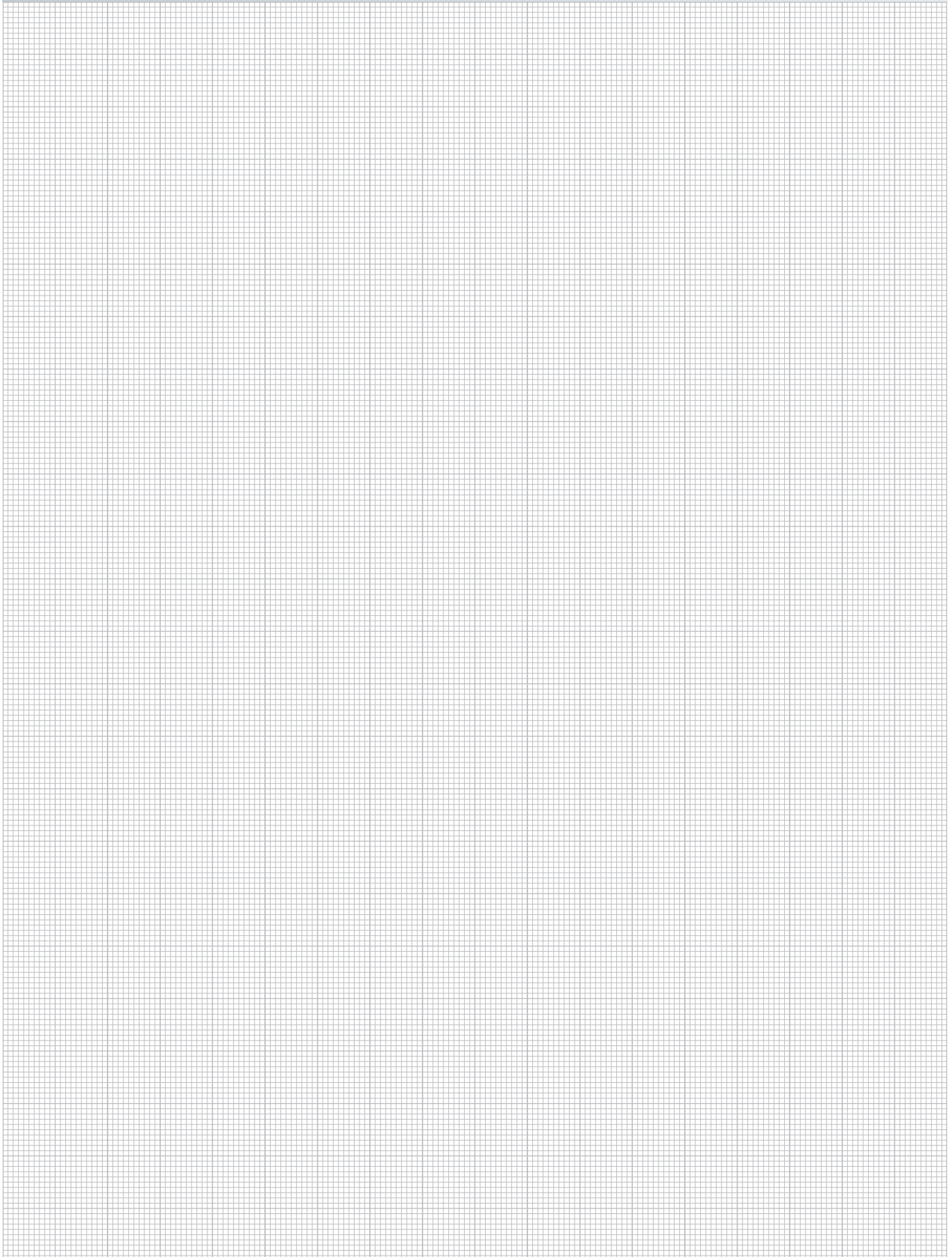
**Industry**

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

Ordering example: A29551301582077

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

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid consists of small, uniform squares.

# Tungsten Carbide Granulate-tipped Tools

164 General Information

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165 HGW-discs

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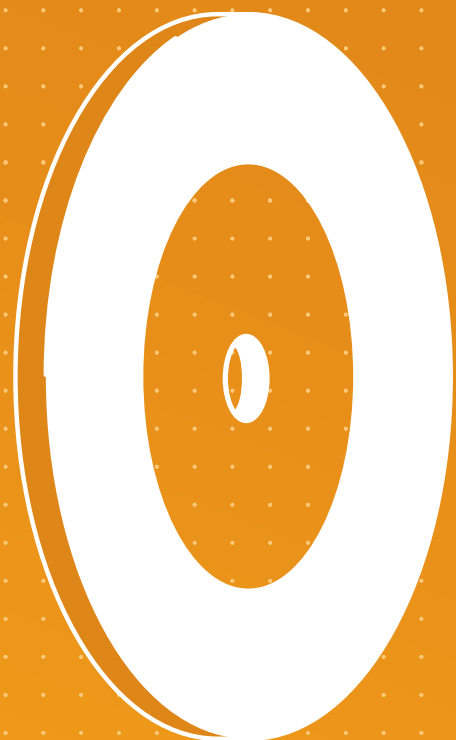
165 HGW-core drills

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## Product line marking

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



## Technical Information

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



## Application examples

Coarse grit is used to grind soft materials; the harder the material, the finer the grit.

A special manufacturing process is used to bond the grit to the core.

Special coatings are available, but are dependent upon a wide variety of technical parameters. Please send your enquiry.

## Safety regulations

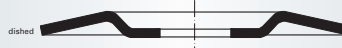
We strongly recommend that use is made of machines with variable speeds in order to optimize cutting speeds; this will lie between 10-50 m/sec. depending on the material to be ground.



Industry

**Tungsten Carbide Granulate-tipped disc, HGWT**

Ordering example: A18031151E



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

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



Industry

**Core Drill-Set**

Ordering example: A18300012E



**Packing unit:**  
1 pc. per type

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



"We invest continually in our company's future, with solid and independent funding from our own resources."

Stefan Lukas

## Technical Brushes

**168** General Information

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**169** Cylindrical brush, shaft mounted

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**169** Cylindrical brush of abrasive nylon

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**170** Conical brush

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**170** End brush, shaft mounted

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**171** Pipe brush

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**171** Pipe brush of abrasive nylon

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**172** Twist knotted wheel brush

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**172** Cylindrical wheel brush

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**173** Cup wheel brush, thread mounted

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**173** Hand brush

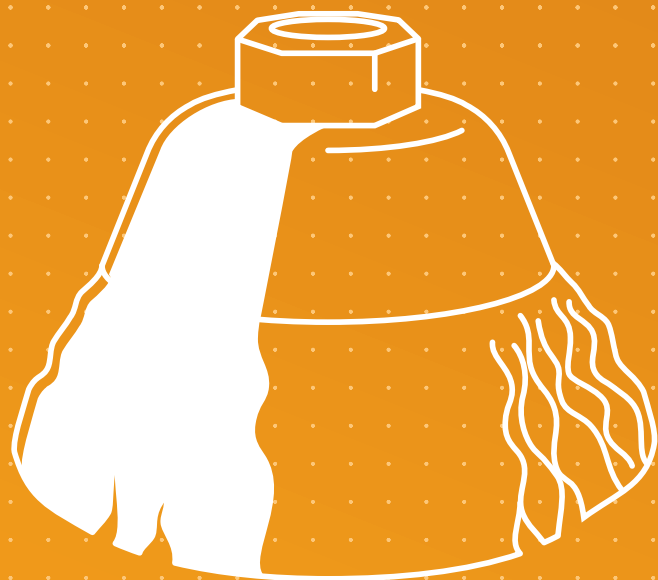
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**373** Power tools

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### Product line marking

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



## General Information

### Filament Quality and Style

#### Quality steel wire

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

#### Stainless steel wire

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

#### Nylon filaments, abrasive impregnated

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

#### Style

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

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

#### Application

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

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

#### Working mode and machines

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

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

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

#### Operating speeds

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

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

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

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

#### Safety instructions

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





Industry

**BS, Cylindrical brush, Shank 6 mm**

Ordering example: A350104010111

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



Industry

**BSN, Cylindrical brush of abrasive nylon, Shank 6 mm**



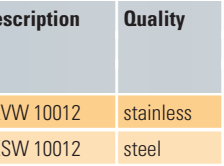
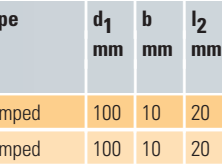
Ordering example: A350105010048

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



### BK, Conical brushes



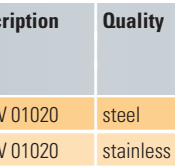

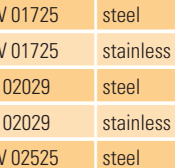
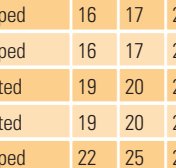

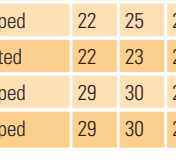



Ordering example: A350610012213

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



### BP, End brush, Shank 6 mm

Ordering example: A350101006

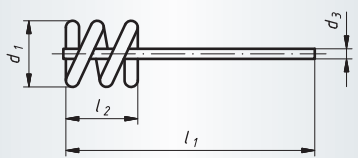
Description		Quality	Type	d <sub>1</sub> mm	b mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Wire ø	n max. (1/min)	Product-Number	Packing unit: 10 pcs. per type								recommended for
		steel	crimped	10	10	20	60	0,3	20.000	A350101006	1				5		8	■	
		stainless	crimped	10	10	20	60	0,3	20.000	A351101006		2	3	4	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



Industry

**RBSD, pipe brush, crimped wire**

Ordering example: A359901025



**Packing unit:**  
10 pcs. per type

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

**Ideal for**

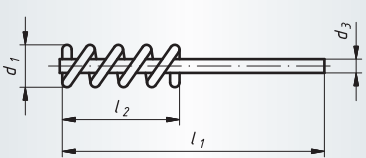
- |                  |                           |
|------------------|---------------------------|
| deburring of     | polishing and cleaning of |
| • bores          | • injectors/nozzles       |
| • cross-holes    | • small bores             |
| • O-ring grooves | • threaded bores          |



Industry

**RBSN, pipe brush of abrasive nylon, silicon carbide**

Ordering example: A359901065120



**Packing unit:**  
10 pcs. per type

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

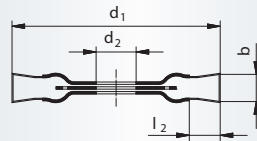
**Ideal for**

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



### BR, Wheel brush, twist knotted

Ordering example: A350211512135



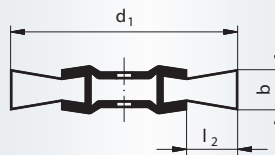
**Packing unit:**  
1 pc. per type

Description	Quality	Type	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	l <sub>2</sub> mm	Wire ø	n max. (1/min)	Product-Number	recommended for												
BRSZ 11512	steel	knotted	115	14	22,23	20	0,5	12.500	A350211512135	1				5								■
BRVZ 11512	stainless	knotted	115	14	22,23	20	0,35	12.500	A350211512234		2	3	4					7				■
BRSZ 12514	steel	knotted	125	14	22,23	20	0,5	12.500	A350312514135	1					5							■
BRVZ 12514	stainless	knotted	125	14	22,23	20	0,5	12.500	A350312514235		2	3	4					7				■
BRSZ 17814	steel	knotted	178	14	22,23	32	0,5	9.000	A350317814135	1					5							■



### BR, Wheel brush, crimped wire

Ordering example: A350315022114



**Packing unit:**  
1 pc. per type

Description	Quality	Type	d <sub>1</sub> mm	b mm	R mm	l <sub>2</sub> mm	Wire ø	n max. (1/min)	Product-Number	recommended for												
BRSW 15022	steel	crimped	150	22	40	33	0,35	6.000	A350315022114	1					5							■
BRVW 15023	stainless	crimped	150	23	50	33	0,3	6.000	A350315023213		2	3	4					7				■
BRSW 20024	steel	crimped	200	24	50	48	0,35	6.000	A350320024114	1					5							■



All brushes are supplied with adapters sets for easy mounting on all popular grinding machines. The adapters have the following dimensions:

tube "R" 40 mm: 40 / 32 / 1" / 22,23 / 20 / 16 1/2"

tube "R" 50 mm: 50 / 32 / 1" / 22,23 / 20 / 16 1/2"

Please take note of the technical advices for the correct and safe assembly.

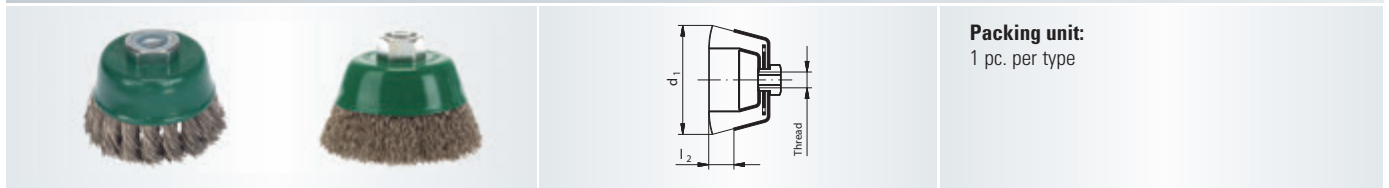
The corresponding information leaflet is included in our packing.



**Industry**

**BTG, Cup brush with thread**

Ordering example: A350406021213



**Packing unit:**  
1 pc. per type

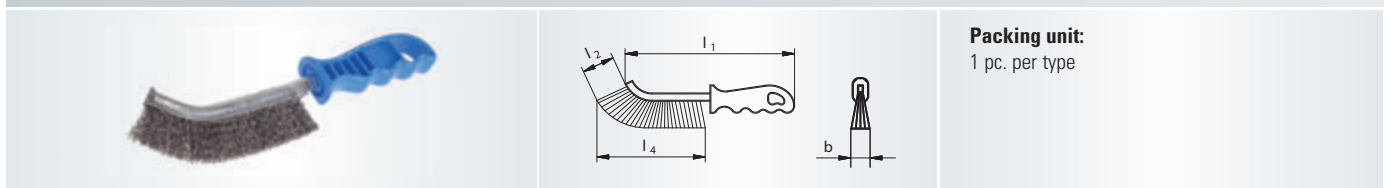
Description	Quality	Type	d <sub>1</sub> mm	l <sub>2</sub> mm	Thread	Wire ø	n max. (1/min)	Product-Number	recommended for	
BTWV 06021 G	stainless	crimped	60	20	M 14	0,3	12.000	A350406021213	2 3 4 7	■
BTSW 06020 G	steel	crimped	60	20	M 14	0,35	12.000	A350406020114	1 5	■
BTSZ 06520 G	steel	knotted	65	20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



**Industry**

**BHU, Hand brush for universal application**

Ordering example: A350726525113



**Packing unit:**  
1 pc. per type

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



"We develop and manufacture tools that meet the highest quality and safety requirements, and our modern test facility delivers reliable evidence of these standards."

Paul Lehnard

## Cutting and Grinding Discs

**176** Structure and Components

**177** Technical Information

**178** Safety

**179** Labelling

**181** Cutting discs

**193** Grinding discs

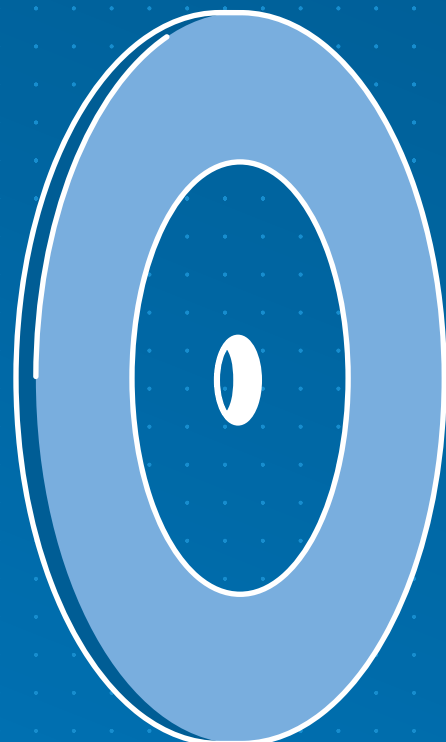
**201** Grinding cup wheels

**205** Diamondtools

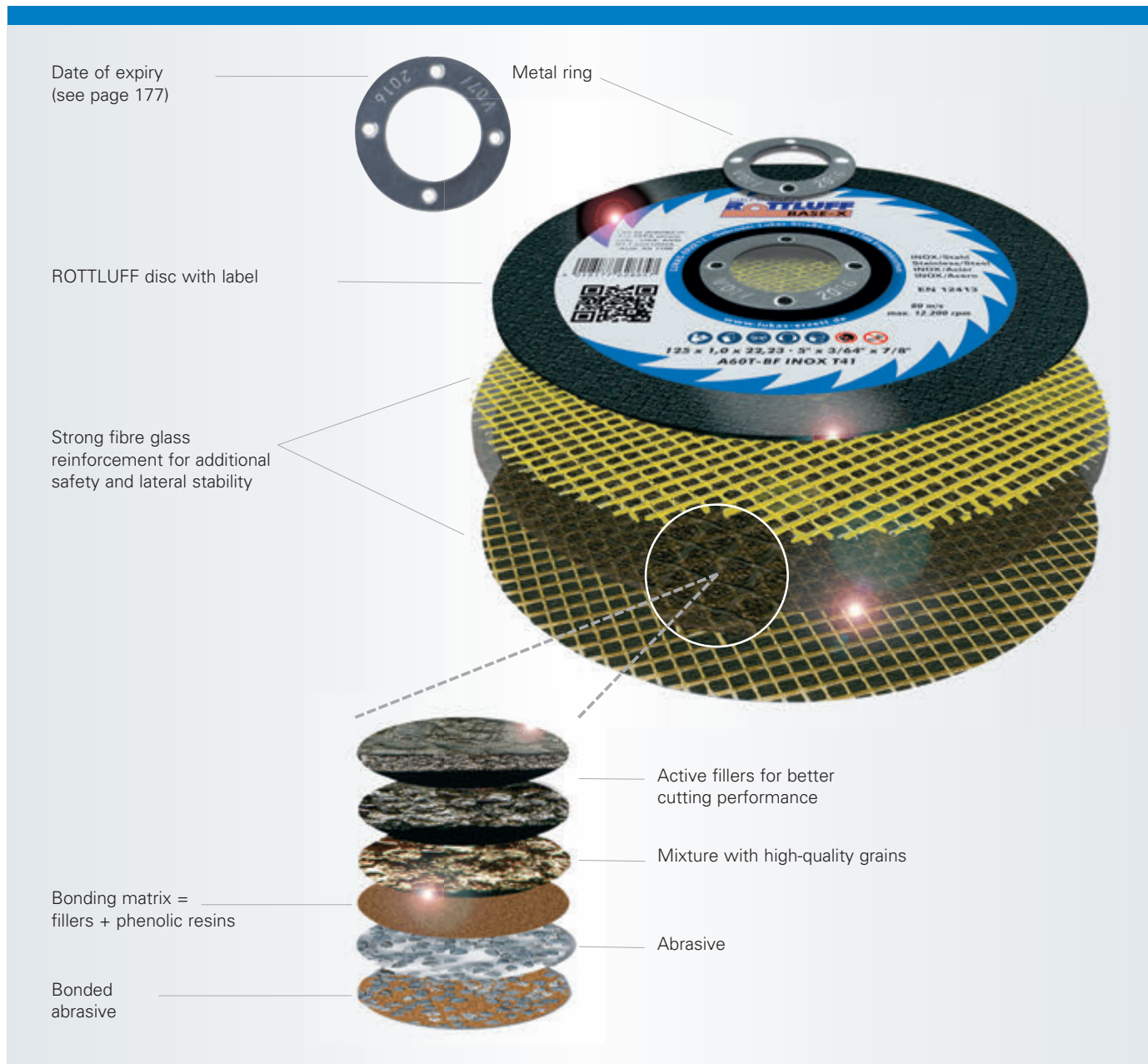


### Product line marking

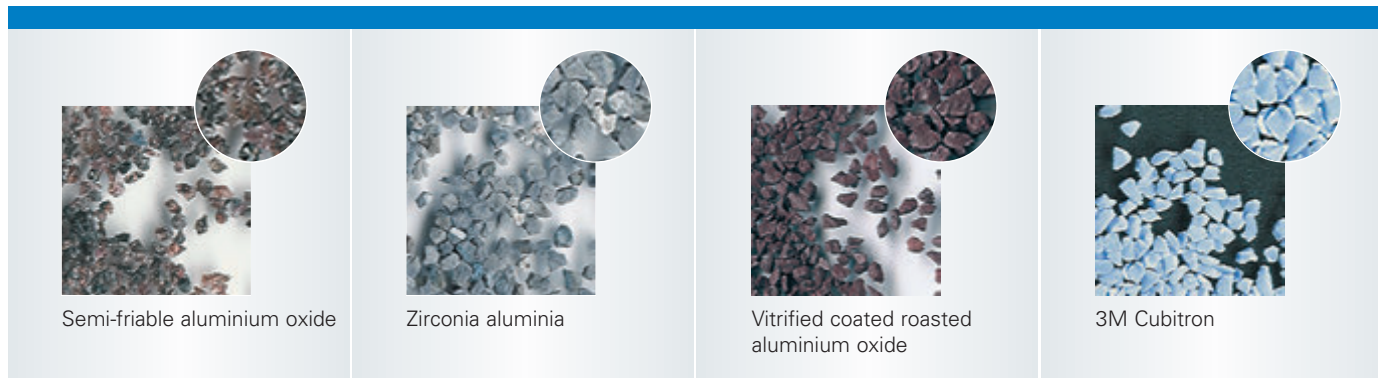
Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



## Structure and Components



## Abrasives





## Technical Information

### Durability

Resin bonded grinding and cutting wheels for freehand applications must be depleted within three years of manufacture.

Please see metal ring for the expiry date which is specified by month and year; for instance V07/2016.



### 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	up to	Q	S	V	BF – resin bond, fibre-reinforced
Z - zirconia alumina	24	54	120	P	T	X	

### Operating speeds

LUKAS- grinding wheels and discs of the brand ROTTLUFF are developed and tested for particular working speeds and grinding processes.

Prior to the mounted of 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 <sup>-1</sup> ]									
	100	115	125	150	180	230	300	350	400	
80 m/s	15.300	13.300	12.200	10.200	8.500	6.600	5.100	4.400	3.850	
100 m/s	19.100	16.650	16.600	12.700	10.600	8.300	6.400	5.500	4.800	

## 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: EN 13236

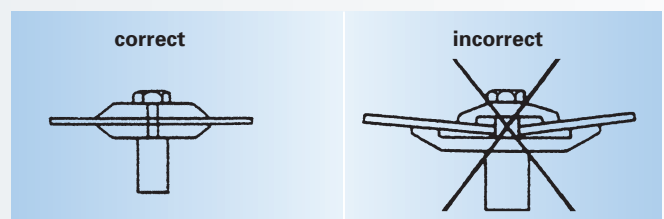


### Safety recommendations

- 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).



## Rottluff-Labeling

**Safety standard** →

**EAN Code** → 4 018177 628657

**QR Code** →

**Safety and operation Instructions** →

**Application** → INOX/Stahl, Stainless/Steel, INOX/Acier, INOX/Acero

**EN 12413** → Manufactured according to EN 12413

**max. operating speed** → 80 m/s, max. 12.200 rpm

**max. rpm** → max. 12.200 rpm

**Grit size** → 60 = Grit size (16/very coarse, 36/medium, 60/fine)

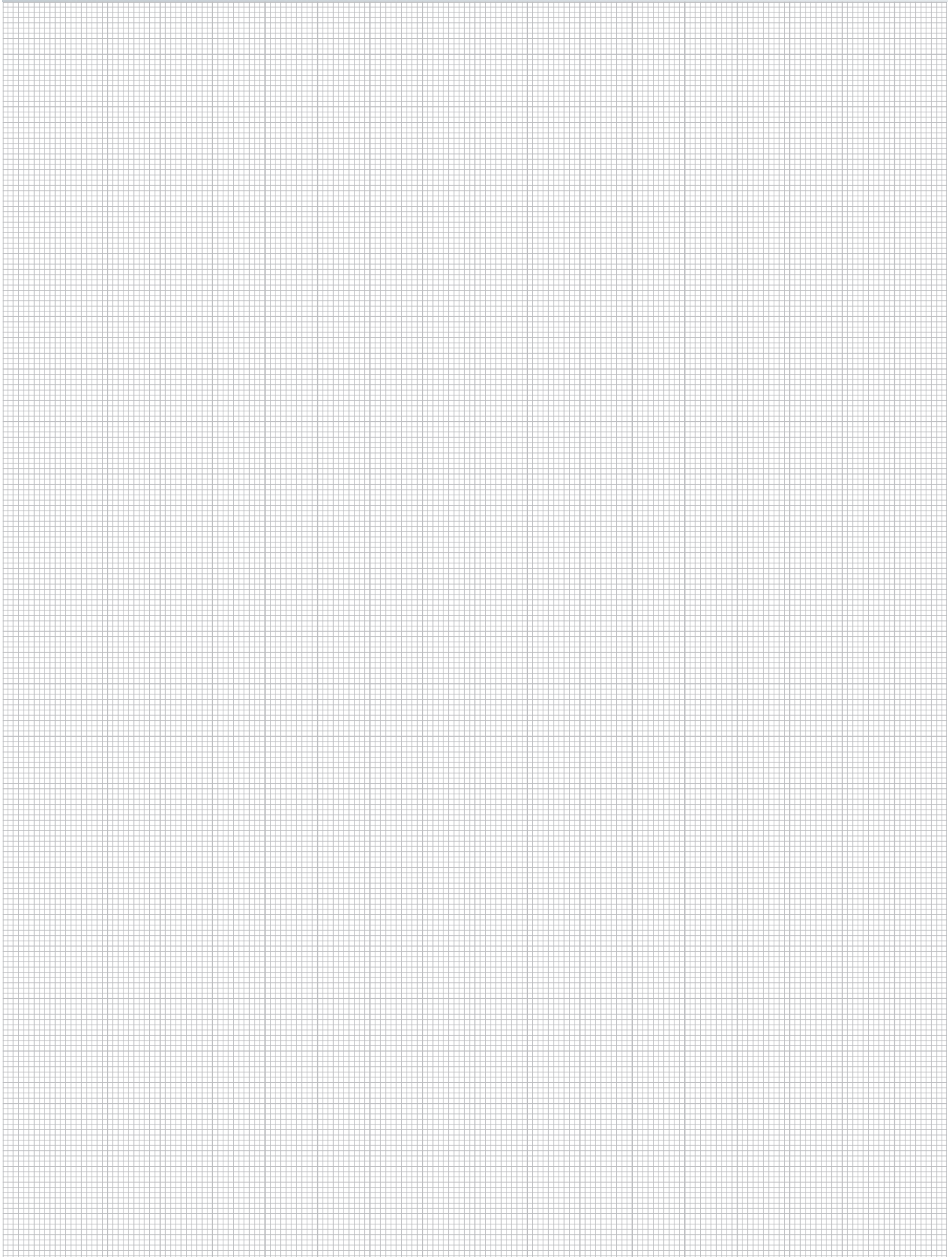
**Resin bond** → BF = resin bond, fibre-reinforced

**Dimensions** → 125 x 1,0 x 22,23 = D x U x H  
 5 x 3/64" x 7/8" = D x U x H  
 Diameter x thickness x bore size

## Types of resin-bonded grinding wheels

<p>                     Cutting discs                      U = (0,8 mm–4,5 mm)                      (USA: Typ 1)                 </p> <p> <b>T 41</b>  <b>Straight cutting discs.</b> <ul style="list-style-type: none"> <li>Available in diameters from 50 (2") to 230 mm (9") for freehand applications,</li> <li>from 300 mm (12") to 500 mm (20") for use in stationary machines</li> </ul> </p>	<p>                     Cutting discs                      U = (0,8 mm–4,5 mm)                      (USA: Typ 27)                 </p> <p> <b>T 42</b>  <b>Depressed centre cutting discs.</b> <ul style="list-style-type: none"> <li>Available in diameters from 50 (2") to 230 mm (9"), allowed for freehand use.</li> </ul> </p>	<p>                     Grinding wheels                      U = (4 mm–10 mm)                      (USA: Typ 27)                 </p> <p> <b>T 27</b>  <b>Depressed centre grinding wheels.</b> <ul style="list-style-type: none"> <li>Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use.</li> </ul> </p>	<p>                     Grinding wheels                      U = (6 mm–8 mm)                      (USA: Typ 28)                 </p> <p> <b>T 28</b>  <b>Depressed centre grinding wheels.</b> <ul style="list-style-type: none"> <li>Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use.</li> </ul> </p>
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Notes

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

## Cutting discs

- 182** Qualities and areas of application

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

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

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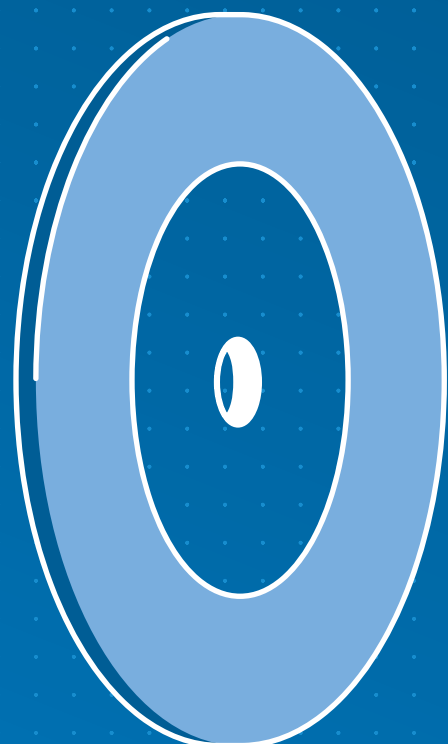
- 192** Small cutting disc (less than 100 mm)

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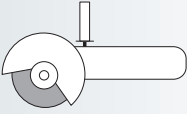











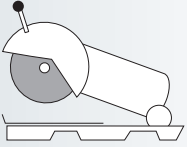





### Product line marking

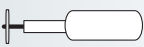

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



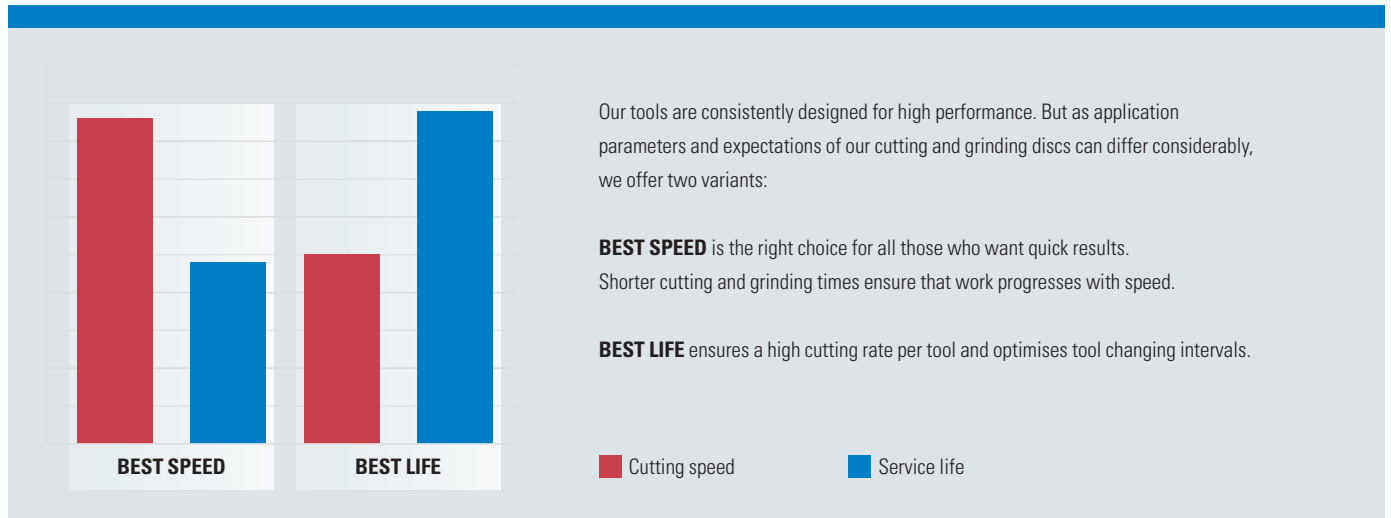
## Cutting discs

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Free-hand cutting disc for angle grinders (100 mm–230 mm) 	<b>High Performance</b>				
	High Performance	Page 184 	Page 186 	Page 188 	Page 189 
	<b>Industry</b>				
	Industry	Page 185 	Page 187 		Page 189 
<b>Base</b>					
	Base	Page 185 	Page 188 		

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Large cutting disc (greater than 230 mm) 	<b>High Performance</b>				
	High Performance				Page 192 
	<b>Industry</b>				
Industry	Page 190 	Page 190 		Page 191 	

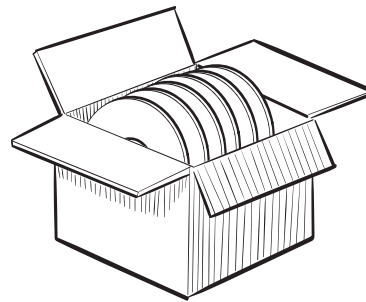
Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Small cutting disc (less than 100 mm) 	<b>Industry</b>				
	Industry	Page 192 			

## BEST SPEED and BEST LIFE – it's your choice!



## Packing units

Diameter (mm)	Disc width (mm)	Packing units
50–76	all	100 pieces
100–125	< 2	50 pieces (BASE-X 100 pieces)
	≥ 2	25 pieces
150–300	all	25 pieces
300–350	all	10 pieces
400	all	5 pieces




**LUKAS**

### Always the right tool

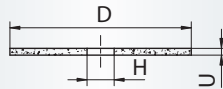
**Cutting and grinding discs „Premiumflex“:**  
Please convince yourself of our premium tools with an excellent price-performance ratio!

**www.lukas-erzett.com**

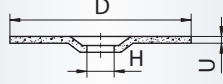
**Tobias Tröbs**  
Sales Department

## Cutting discs for stainless steel – PROMAX

Ordering example: AT003000



T41



T42

**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

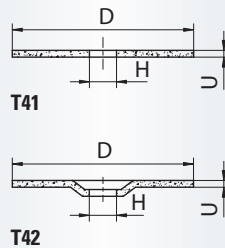
v<sub>max.</sub>: 80 m/s

	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T41 PROMAX	A60X-BF INOX	BEST LIFE	100	1,0	16,00	15.300	AT003000	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A60T-BF INOX	BEST SPEED	100	1,0	16,00	15.300	AT001634	1 2 3 4 5 6 7	■
<b>NEW</b>	T42 PROMAX	A60X-BF INOX	BEST LIFE	115	0,8	22,23	13.300	AT005301	1 2 3 4 5 6 7	■
	T42 PROMAX	A60T-BF INOX	BEST SPEED	115	0,8	22,23	13.300	AT004266	1 2 3 4 5 6 7	■
	T41 PROMAX	A60X-BF INOX	BEST LIFE	115	1,0	22,23	13.300	AT005841	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A60T-BF INOX	BEST SPEED	115	1,0	22,23	13.300	AT001655	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A46X-BF INOX	BEST LIFE	115	1,6	22,23	13.300	AT003346	1 2 3 4 5 6 7	■
	T42 PROMAX	A60X-BF INOX	BEST LIFE	125	0,8	22,23	12.200	AT005302	1 2 3 4 5 6 7	■
<b>NEW</b>	T42 PROMAX	A60T-BF INOX	BEST SPEED	125	0,8	22,23	12.200	AT005287	1 2 3 4 5 6 7	■
	T41 PROMAX	A60X-BF INOX	BEST LIFE	125	1,0	22,23	12.200	AT005842	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A60T-BF INOX	BEST SPEED	125	1,0	22,23	12.200	AT001685	1 2 3 4 5 6 7	■
	T41 PROMAX	A46X-BF INOX	BEST LIFE	125	1,6	22,23	12.200	AT003348	1 2 3 4 5 6 7	■
	T41 PROMAX	A36U-BF INOX	BEST LIFE	125	2,0	22,23	12.200	AT001687	1 2 3 4 5 6 7	■
	T42 PROMAX	A30U-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT001696	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A46X-BF INOX	BEST LIFE	150	1,6	22,23	10.200	AT003327	1 2 3 4 5 6 7	■
<b>NEW</b>	T42 PROMAX	A46X-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT005571	1 2 3 4 5 6 7	■
	T41 PROMAX	A36U-BF INOX	BEST LIFE	180	2,0	22,23	8.500	AT001743	1 2 3 4 5 6 7	■
	T41 PROMAX	A46X-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT005864	1 2 3 4 5 6 7	■
<b>NEW</b>	T42 PROMAX	A46X-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT005877	1 2 3 4 5 6 7	■
	T41 PROMAX	A36U-BF INOX	BEST LIFE	230	2,0	22,23	6.600	AT001782	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PROMAX	A30U-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT001786	1 2 3 4 5 6 7	■
<b>NEW</b>	T42 PROMAX	A30U-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT001791	1 2 3 4 5 6 7	■



Cutting discs for stainless steel – PREMIUMFLEX

Ordering example: AT003108



Packing unit:

see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

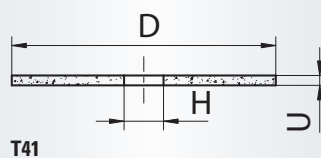
v<sub>max.</sub>: 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	100	1,0	16,00	15.300	AT003108	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	100	1,6	16,00	15.300	AT000630	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	115	1,0	22,23	13.300	AT004643	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	115	1,2	22,23	13.300	AT000643	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	115	1,6	22,23	13.300	AT000647	1 2 3 4 5 6 7	■
T42 PREMIUMFLEX	A46P-BF INOX	BEST SPEED	115	1,6	22,23	13.300	AT003461	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	125	1,0	22,23	12.200	AT002672	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	125	1,2	22,23	12.200	AT000670	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	125	1,6	22,23	12.200	AT000674	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT004154	1 2 3 4 5 6 7	■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	3,0	22,23	12.200	AT010154	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	150	1,6	22,23	10.200	AT000700	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT000716	1 2 3 4 5 6 7	■
T42 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT000718	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	2,5	22,23	8.500	AT003723	1 2 3 4 5 6 7	■ NEW
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	2,5	22,23	8.500	AT005450	1 2 3 4 5 6 7	■ NEW
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	3,0	22,23	8.500	AT003163	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT000742	1 2 3 4 5 6 7	■ NEW
T42 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT000744	1 2 3 4 5 6 7	■ NEW
T42 PREMIUMFLEX	A46P-BF INOX	BEST SPEED	230	1,9	22,23	6.600	AT003475	1 2 3 4 5 6 7	■ NEW
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT003568	1 2 3 4 5 6 7	■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	3,0	22,23	6.600	AT004168	1 2 3 4 5 6 7	■



Cutting discs for stainless steel – BASE-X

Ordering example: A3890101150122002



Packing unit:

see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

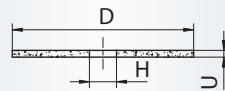
v<sub>max.</sub>: 80 m/s

Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 BASE-X	A60T-BF INOX	115	1,0	22,23	13.300	A3890101150122002	1 2 3 4 5 6 7	■ NEW
T41 BASE-X	A60T-BF INOX	125	1,0	22,23	12.200	A3890101250122002	1 2 3 4 5 6 7	■ NEW
T41 BASE-X	A46T-BF INOX	230	1,8	22,23	6.600	A3890102300122002	1 2 3 4 5 6 7	■ NEW

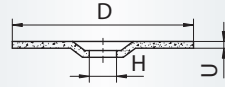


**Cutting discs for metal – PREMIUMFLEX**

Ordering example: AT000636



T1



T2

**Packing unit:**

see page 183

T1 = flat

T2 = depressed centre

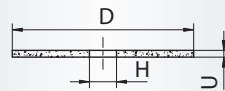
Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

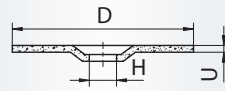
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for									
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	100	3,0	16,00	15.300	AT000636	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	100	3,0	16,00	15.300	AT000638	1	2	3	5					■	
T41 PREMIUMFLEX	A60S-BF	BEST LIFE	115	1,0	22,23	13.300	AT006440	1	2	3	5					■	
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	115	1,2	22,23	13.300	AT000644	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	115	1,6	22,23	13.300	AT000648	1	2	3	5					■	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	115	2,5	22,23	13.300	AT000656	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	115	3,0	22,23	13.300	AT000660	1	2	3	5					■	
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	115	3,0	22,23	13.300	AT000662	1	2	3	5					■	
T41 PREMIUMFLEX	A24P-BF	BEST SPEED	115	3,0	22,23	13.300	AT005161	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	115	3,0	22,23	13.300	AT005162	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A60S-BF	BEST LIFE	125	1,0	22,23	12.200	AT006710	1	2	3	5					■	
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	125	1,2	22,23	12.200	AT000671	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	125	1,6	22,23	12.200	AT000675	1	2	3	5					■	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	125	2,5	22,23	12.200	AT000679	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	125	3,0	22,23	12.200	AT000686	1	2	3	5					■	
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	125	3,0	22,23	12.200	AT005164	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	125	3,0	22,23	12.200	AT000688	1	2	3	5					■	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	150	3,0	22,23	10.200	AT000707	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	180	1,6	22,23	8.500	AT000717	1	2	3	5					■	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	180	3,0	22,23	8.500	AT000728	1	2	3	5					■	
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	180	3,0	22,23	8.500	AT001239	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	180	3,0	22,23	8.500	AT000732	1	2	3	5					■	
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	230	1,9	22,23	6.600	AT000743	1	2	3	5					■	
T42 PREMIUMFLEX	A46T-BF	BEST LIFE	230	1,9	22,23	6.600	AT000745	1	2	3	5					■	
T41 PREMIUMFLEX	A36T-BF	BEST LIFE	230	2,0	22,23	6.600	AT000967	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	230	2,5	22,23	6.600	AT000861	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	230	2,5	22,23	6.600	AT004063	1	2	3	5					■	NEW
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	230	3,0	22,23	6.600	AT000750	1	2	3	5					■	
T41 PREMIUMFLEX	A24P-BF	BEST SPEED	230	3,0	22,23	6.600	AT005165	1	2	3	5					■	NEW
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	230	3,0	22,23	6.600	AT000754	1	2	3	5					■	
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	230	3,0	22,23	6.600	AT005166	1	2	3	5					■	NEW

## Cutting discs for metal – BASE-X

Ordering example: A3890101150122001



T41



T42

**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

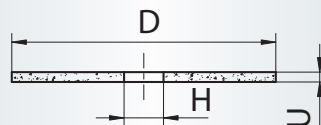
Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

	Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T41 BASE-X	A60T-BF	115	1,0	22,23	13.300	A3890101150122001	① ② ③ ⑤	■
<b>NEW</b>	T41 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322002	① ② ③ ⑤	■
<b>NEW</b>	T42 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322001	① ② ③ ⑤	■
<b>NEW</b>	T41 BASE-X	A60T-BF	125	1,0	22,23	12.200	A3890101250122001	① ② ③ ⑤	■
<b>NEW</b>	T41 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322002	① ② ③ ⑤	■
<b>NEW</b>	T42 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322001	① ② ③ ⑤	■
<b>NEW</b>	T41 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322002	① ② ③ ⑤	■
<b>NEW</b>	T42 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322001	① ② ③ ⑤	■
<b>NEW</b>	T41 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322002	① ② ③ ⑤	■
<b>NEW</b>	T42 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322001	① ② ③ ⑤	■

## Cutting discs for non-ferrous metals – PROMAX

Ordering example: AT000920



T41

**Packing unit:**

see page 183

T41 = flat

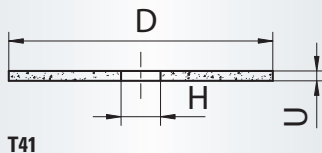
T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
	T41 PROMAX	A60N-BF ALU	BEST LIFE	115	1,0	22,23	13.300	AT000920	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A46N-BF ALU	BEST LIFE	115	1,6	22,23	13.300	AT004776	① ② ③ ④ ⑤ ⑥ ⑦	■
<b>NEW</b>	T41 PROMAX	A36N-BF ALU	BEST LIFE	115	2,5	22,23	13.300	AT001664	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A60N-BF ALU	BEST LIFE	125	1,0	22,23	12.200	AT000950	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A46N-BF ALU	BEST LIFE	125	1,6	22,23	12.200	AT004788	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A36N-BF ALU	BEST LIFE	125	2,5	22,23	12.200	AT001694	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A46N-BF ALU	BEST LIFE	150	1,6	22,23	10.200	AT001000	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A46N-BF ALU	BEST LIFE	180	1,6	22,23	8.500	AT000985	① ② ③ ④ ⑤ ⑥ ⑦	■
<b>NEW</b>	T41 PROMAX	A46N-BF ALU	BEST LIFE	230	1,9	22,23	6.600	AT002613	① ② ③ ④ ⑤ ⑥ ⑦	■
<b>NEW</b>	T41 PROMAX	A36N-BF ALU	BEST LIFE	230	2,5	22,23	6.600	AT001789	① ② ③ ④ ⑤ ⑥ ⑦	■
	T41 PROMAX	A36N-BF ALU	BEST LIFE	230	3,0	22,23	6.600	AT003459	① ② ③ ④ ⑤ ⑥ ⑦	■



**Stationary cutting discs for stainless steel – PREMIUMFLEX**
*Ordering example: AT010003*

**Packing unit:**

see page 183

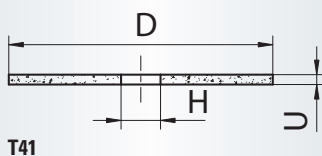
T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine &lt; 0,1%

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

	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	300	3,5	32,00	5.100	AT010003	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PREMIUMFLEX	A36S-BF INOX	BEST LIFE	350	2,6	25,40	4.400	AT020208	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	350	3,5	32,00	4.400	AT010011	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	25,40	3.800	AT010014	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	32,00	3.800	AT010015	1 2 3 4 5 6 7	■
<b>NEW</b>	T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	40,00	3.800	AT010016	1 2 3 4 5 6 7	■

**Cutting discs for metal – PREMIUMFLEX**
*Ordering example: AT010052*

**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

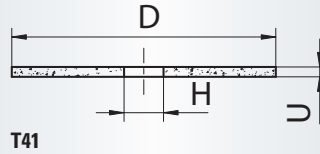
Iron, sulphur and chlorine &lt; 0,1%

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

	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T41 PREMIUMFLEX	A24R-BF	BEST LIFE	300	4,0	20,00	6.400	AT010052	1 2 3 5	■
<b>NEW</b>	T41 PREMIUMFLEX	A24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT010055	1 2 3 5	■
<b>NEW</b>	T41 PREMIUMFLEX	A24R-BF	BEST LIFE	350	4,0	25,40	5.400	AT010057	1 2 3 5	■
<b>NEW</b>	T41 PREMIUMFLEX	A24R-BF	BEST LIFE	400	4,5	22,23	4.700	AT002844	1 2 3 5	■

Stationary cutting discs for metal – PREMIUMFLEX

Ordering example: AT010028



Packing unit:

see page 183

T41 = flat

T42 = depressed centre

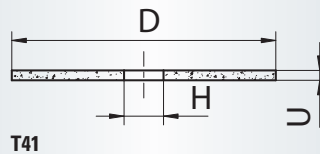
Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for			
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	300	2,6	25,40	5.100	AT010028	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	22,23	6.400	AT001774	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	25,40	6.400	AT001776	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	32,00	6.400	AT010020	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	350	2,6	25,40	4.400	AT010029	1 2 3 5		■	
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	350	3,5	25,40	5.400	AT010022	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	350	3,5	32,00	5.400	AT010023	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	400	3,2	25,40	3.800	AT010030	1 2 3 5		■	NEW
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	400	4,0	32,00	4.700	AT010026	1 2 3 5		■	NEW

Cutting discs for stone, concrete and cast iron – PREMIUMFLEX

Ordering example: AT010060



Packing unit:

see page 183

T41 = flat

T42 = depressed centre

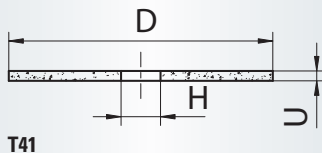
Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for			
T41 PREMIUMFLEX	C24R-BF	BEST LIFE	300	4,0	25,40	6.400	AT010060	5 10 11 12		■	NEW
T41 PREMIUMFLEX	AC24R-BF	BEST LIFE	300	4,0	20,00	6.400	AT000788	5 10 11 12		■	NEW
T41 PREMIUMFLEX	C24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT010061	5 10 11 12		■	NEW
T41 PREMIUMFLEX	AC24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT000816	5 10 11 12		■	NEW

## Stationary cutting discs for stone, concrete and cast iron – PROMAX

Ordering example: AT005828



T41

**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

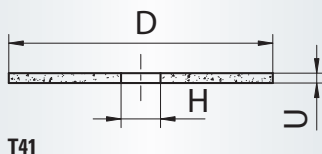
Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 100 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for
T41 PROMAX	ZA300-BF	BEST LIFE	350	4,0	22,23	5.400	AT005828	1 2 5 10 11 12

## Small cutting discs for stainless steel – PREMIUMFLEX

Ordering example: AT501006



T41

**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 100 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for
<b>NEW</b> T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	1,0	6,00	30.500	AT501006	1 2 3 4 5 6 7
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	1,0	10,00	30.500	AT501010	1 2 3 4 5 6 7
<b>NEW</b> T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	2,0	6,00	30.500	AT502006	1 2 3 4 5 6 7
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	1,0	10,00	20.100	AT761010	1 2 3 4 5 6 7
<b>NEW</b> T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	2,0	6,00	20.100	AT762006	1 2 3 4 5 6 7
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	2,0	10,00	20.100	AT762010	1 2 3 4 5 6 7
<b>NEW</b> T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	3,0	10,00	20.100	AT763010	1 2 3 4 5 6 7



## Grinding discs

- 194** Qualities and areas of application

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- 195** Free-hand grinding discs for angle grinders

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- 200** Small grinding discs

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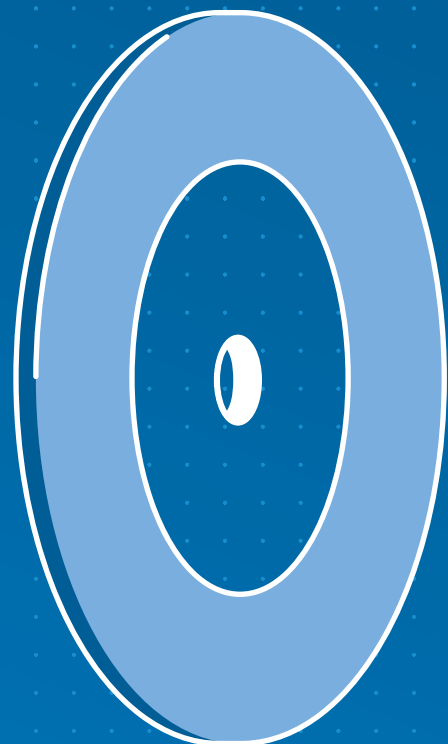
- 201** Cup Wheels

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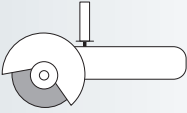













### Product line marking

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

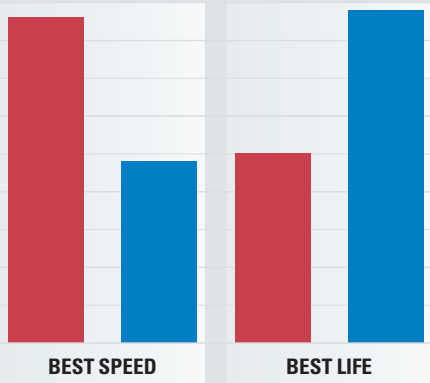


## Grinding discs

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Free-hand grinding discs for angle grinders 	<b>High Performance</b>				
	High Performance	Page 195 	Page 197 	Page 199 	Page 199 
	<b>Industry</b>				
	Industry	Page 197 	Page 198 		Page 200 
	<b>Base</b>				
	Base		Page 198 		

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Small grinding discs 	<b>Industry</b>				
	Industry	Page 200 			

## BEST SPEED and BEST LIFE – it's your choice!



The chart shows two groups of bars. The first group, labeled 'BEST SPEED', has a tall red bar (Cutting speed) and a shorter blue bar (Service life). The second group, labeled 'BEST LIFE', has a shorter red bar (Cutting speed) and a tall blue bar (Service life). A legend at the bottom indicates that red represents 'Cutting speed' and blue represents 'Service life'.

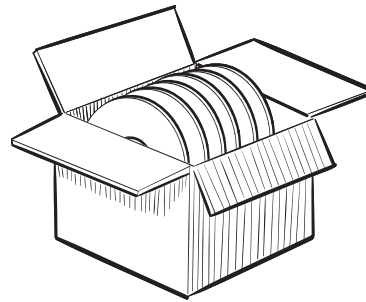
Our tools are consistently designed for high performance. But as application parameters and expectations of our cutting and grinding discs can differ considerably, we offer you variants:

**BEST SPEED** is the right choice for all those who want quick results. Shorter grinding times ensure that work progresses with speed.

**BEST LIFE** ensures a long service life per tool and optimizes tool changing intervals.

### Packing units

Diameter (mm)	Disc width (mm)	Packing units
76	all	50 pieces
100–230	3	25 pieces
	4	20 pieces
	≥ 6	10 pieces




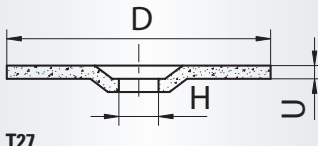
**ROTLUFF**

**High Performance**

### Grinding and cutting disc to machine stainless steel – PROMAX COOL JOBBER

Ordering example: AS005675





**T27**

**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A36V-BF INOX COOL JOBBER	BEST LIFE	115	3,0	22,23	13.300	AS005675	1 2 3 4 6	■
T27 PROMAX	A36V-BF INOX COOL JOBBER	BEST LIFE	125	3,0	22,23	12.200	AS005676	1 2 3 4 6	■
T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	125	3,0	22,23	12.200	AS005705	1 2 3 4 6	■


- For universal applications involving cutting and rough grinding
- Excellent grinding performance, thanks to the pimples in its structure

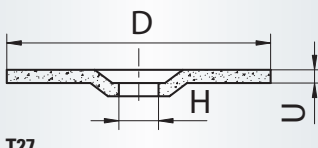
**ROTLUFF**

**High Performance**

### Grinding and cutting disc to machine stainless steel – PROMAX

Ordering example: AS001674





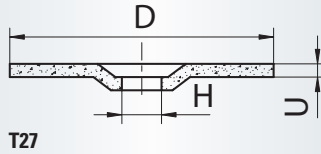
**T27**

**Packing unit:**  
see page 195  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A24V-BF INOX	BEST SPEED	115	4,0	22,23	13.300	AS001674	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	125	4,0	22,23	12.200	AS001705	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	150	4,0	22,23	10.200	AS001521	1 2 3 4 6	■ <b>NEW</b>
T27 PROMAX	A24V-BF INOX	BEST SPEED	180	4,0	22,23	8.500	AS001766	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	230	4,0	22,23	6.600	AS001805	1 2 3 4 6	■ <b>NEW</b>

## Grinding discs for stainless steel – PROMAX

Ordering example: AS003491



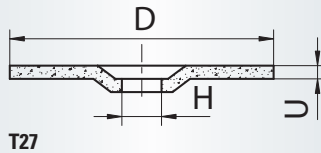
**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A24U-BF INOX	BEST LIFE	115	7,0	22,23	13.300	AS003491	1 2 3 4 6	■
T27 PROMAX	A24U-BF INOX	BEST LIFE	125	7,0	22,23	12.200	AS003492	1 2 3 4 6	■
<b>NEW</b> T27 PROMAX	A24U-BF INOX	BEST LIFE	180	7,0	22,23	8.500	AS003494	1 2 3 4 6	■

- Very aggressive grinding performance, thanks to its structured surface
- Harder bond for high stock removal and the same service life

## Grinding discs for stainless steel – PROMAX

Ordering example: AS003100

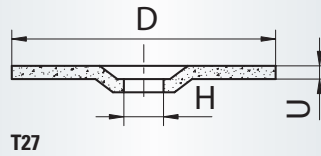


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> T27 PROMAX	A24X-BF INOX BEST LIFE	BEST LIFE	115	7,0	22,23	13.300	AS003100	1 2 3 4 6	■
T27 PROMAX	A24X-BF INOX BEST LIFE	BEST LIFE	125	7,0	22,23	12.200	AS003101	1 2 3 4 6	■
<b>NEW</b> T27 PROMAX	A24V-BF INOX	BEST SPEED	125	7,0	22,23	12.200	AS001709	1 2 3 4 6	■
T27 PROMAX	A24S-BF INOX	BEST SPEED	125	7,0	22,23	12.200	AS003393	1 2 3 4 6	■
T27 PROMAX	A24X-BF INOX BEST LIFE	BEST LIFE	180	7,0	22,23	8.500	AS003103	1 2 3 4 6	■
<b>NEW</b> T27 PROMAX	A24X-BF INOX BEST LIFE	BEST LIFE	230	7,0	22,23	6.600	AS003104	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	230	7,0	22,23	6.600	AS001810	1 2 3 4 6	■

Grinding discs for stainless steel – PREMIUMFLEX

Ordering example: AS002037

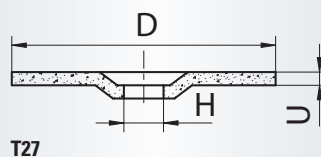


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	100	6,0	16,00	15.300	AS002037	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	115	6,4	22,23	13.300	AS000105	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	4,0	22,23	12.200	AS003106	1 2 3 4	■
T27 PREMIUMFLEX	A24P-BF INOX	BEST SPEED	125	6,0	22,23	12.200	AS000694	1 2 3 4	■ NEW
T27 PREMIUMFLEX	A24/30Q-BF INOX	BEST SPEED	125	6,0	22,23	12.200	AS001603	1 2 3 4	■ NEW
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	6,4	22,23	12.200	AS000106	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	150	6,4	22,23	10.200	AS000107	1 2 3 4	■ NEW
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	6,4	22,23	8.500	AS000108	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	8,0	22,23	8.500	AS002108	1 2 3 4	■
T27 PREMIUMFLEX	A24/30Q-BF INOX	BEST SPEED	180	8,0	22,23	8.500	AS001606	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	6,4	22,23	6.600	AS000109	1 2 3 4	■
T27 PREMIUMFLEX	A24P-BF INOX	BEST SPEED	230	6,5	22,23	6.600	AS000763	1 2 3 4	■ NEW

Grinding discs for metal – PROMAX

Ordering example: AS002451

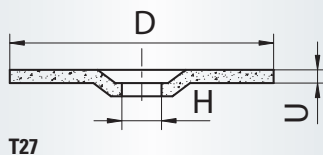


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A24X-BF BEST LIFE	BEST LIFE	115	7,0	22,23	13.300	AS002451	1 2 3	■
T27 PROMAX	A24/30T-BF	BEST SPEED	115	7,0	22,23	13.300	AS001679	1 2 3 5	■ NEW
T27 PROMAX	A24T-BF	BEST LIFE	125	4,0	22,23	12.200	AS001706	1 2 3 5	■
T27 PROMAX	A24X-BF BEST LIFE	BEST LIFE	125	7,0	22,23	12.200	AS002453	1 2 3	■
T27 PROMAX	A24/30T-BF	BEST SPEED	125	7,0	22,23	12.200	AS001710	1 2 3 5	■
T27 PROMAX	A24X-BF BEST LIFE	BEST LIFE	180	7,0	22,23	8.500	AS002466	1 2 3	■
T27 PROMAX	A24/30T-BF	BEST SPEED	180	7,0	22,23	8.500	AS001772	1 2 3 5	■ NEW
T27 PROMAX	A24X-BF BEST LIFE	BEST LIFE	230	7,0	22,23	6.600	AS002468	1 2 3	■ NEW
T27 PROMAX	A24/30T-BF	BEST SPEED	230	7,0	22,23	6.600	AS001811	1 2 3 5	■ NEW
T27 PROMAX	A24X-BF BEST LIFE	BEST LIFE	230	8,0	22,23	6.600	AS002469	1 2 3	■ NEW

## Grinding discs for metal – PREMIUMFLEX

Ordering example: AS000642



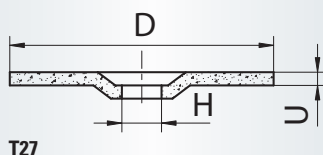
**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	100	6,0	16,00	15.300	AS000642	1 2 3	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	115	6,0	22,23	13.300	AS000667	1 2 3	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	115	6,0	22,23	13.300	AS000992	1 2 3 5	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	4,0	22,23	12.200	AS000690	1 2 3	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	6,0	22,23	12.200	AS000692	1 2 3	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	125	6,0	22,23	12.200	AS000999	1 2 3 5	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	8,0	22,23	12.200	AS000696	1 2 3	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	150	4,0	22,23	10.200	AS002920	1 2 3	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	150	6,0	22,23	10.200	AS003712	1 2 3 5	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	150	6,0	22,23	10.200	AS000712	1 2 3	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	180	6,5	22,23	8.500	AS001009	1 2 3 5	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	180	6,5	22,23	8.500	AS000737	1 2 3	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	180	8,0	22,23	8.500	AS000740	1 2 3	■
	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	230	6,5	22,23	6.500	AS000762	1 2 3	■
	T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	230	6,5	22,23	6.500	AS001017	1 2 3 5	■
<b>NEW</b>	T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	230	8,0	22,23	6.500	AS000767	1 2 3	■



## Grinding discs for metal – BASE

Ordering example: A3891101150622001

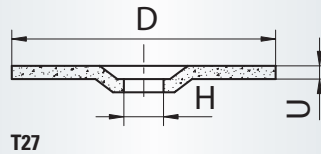


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

	Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	T27 BASE-X	A24R-BF	115	6,0	22,23	13.300	A3891101150622001	1 2 3	■
<b>NEW</b>	T27 BASE-X	A24R-BF	125	6,0	22,23	12.200	A3891101250622001	1 2 3	■
<b>NEW</b>	T27 BASE-X	A24R-BF	180	6,0	22,23	8.500	A3891101800622001	1 2 3	■
<b>NEW</b>	T27 BASE-X	A24R-BF	230	6,0	22,23	6.500	A3891102300622001	1 2 3	■

Grinding discs for non-ferrous metals – PROMAX

Ordering example: AS001677

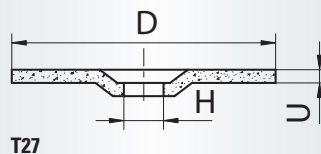


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for		
T27 PROMAX	A36N-BF ALU	BEST LIFE	115	7,0	22,23	13.300	AS001677	① ② ③ ④ ⑤ ⑥	■	NEW
T27 PROMAX	A36N-BF ALU	BEST LIFE	125	7,0	22,23	12.200	AS001708	① ② ③ ④ ⑤ ⑥	■	
T27 PROMAX	A36N-BF ALU	BEST LIFE	180	7,0	22,23	8.500	AS001770	① ② ③ ④ ⑤ ⑥	■	
T27 PROMAX	A36N-BF ALU	BEST LIFE	230	7,0	22,23	6.500	AS001809	① ② ③ ④ ⑤ ⑥	■	NEW

Grinding discs for cast iron – PROMAX

Ordering example: AS001773

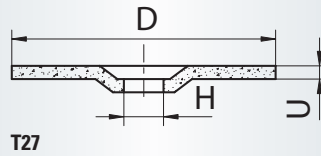


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	ZA24R-BF	BEST LIFE	180	7,0	22,23	8.500	AS001773	⑤	■
T27 PROMAX	ZA24R-BF	BEST LIFE	230	7,0	22,23	6.500	AS001812	⑤	■

## Grinding discs for stone and cast iron – PREMIUMFLEX

Ordering example: AS001617

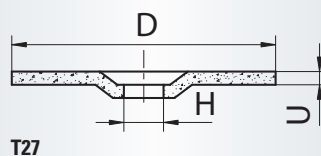


**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> T27 PREMIUMFLEX	C24N-BF	BEST LIFE	115	6,0	22,23	13.300	AS001617	5 10 11 12	■
<b>NEW</b> T27 PREMIUMFLEX	C24N-BF	BEST LIFE	125	6,0	22,23	12.200	AS001618	5 10 11 12	■
<b>NEW</b> T27 PREMIUMFLEX	AC24S-BF	BEST LIFE	180	8,0	22,23	8.500	AS001598	5 10 11 12	■
<b>NEW</b> T27 PREMIUMFLEX	AC24S-BF	BEST LIFE	230	6,8	22,23	6.500	AS001599	5 10 11 12	■
<b>NEW</b> T27 PREMIUMFLEX	C24N-BF	BEST LIFE	230	6,8	22,23	6.500	AS001625	5 10 11 12	■
T27 PREMIUMFLEX	AC24S-BF	BEST LIFE	230	8,0	22,23	6.500	AS001600	5 10 11 12	■

## Small grinding discs for metal – PREMIUMFLEX

Ordering example: AS000676



**Packing unit:**  
see page 195  
T27 = depressed centre  
Iron, sulphur and chlorine < 0,1%  
 $v_{max}$ : 80 m/s

Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	76	6,0	10,00	20.100	AS000676	1 2 3	■

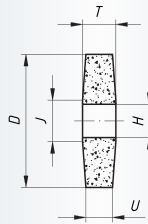
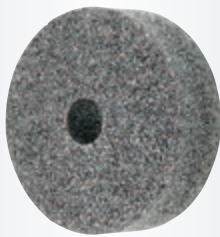




Industry

**Taper sided, grinding wheel, Shape SE4 (nach ISO 603-12)**

Ordering example: A2039080200320001



**Packing unit:**  
10 pcs. per type  
max. operating speed  
50 m/s = 11.900 1/min

Description	Quality	D mm	T mm	U mm	H mm	J mm	Product-Number	recommended for	
SE4 08020.16	HK 24 M BA. soft	80	20	16	16	25	A2039080200320001	④ ⑤	■
SE4 08020.16	HK 16 P BA. hard	80	20	16	16	25	A2039080200320002	④ ⑤	■
SE4 08020.20	HK 24 M BA. soft	80	20	16	20	25	A2039080200320003	④ ⑤	■
SE4 08020.20	HK 16 P BA. hard	80	20	16	20	25	A2039080200320004	④ ⑤	■

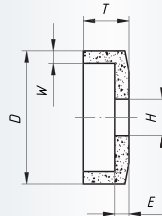
These tools must be used with a flange which complies with the regulations of DIN 69864.



Industry

**Cup wheels for angle grinders, shape SE 6 (to ISO 603-7)**

Ordering example: A204108027027



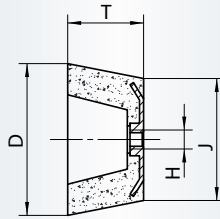
**Packing unit:**  
5 pcs.  
max. operating speed  
50 m/s = 11.900 1/min

Description	Quality	D mm	T mm	H mm	W mm	E mm	Product-Number	recommended for	
SE6 08027.22	A 24 P BA	80	27	22,2	8	8	A204108027027	② ③ ⑤	■
SE6 08027.22	A 36 P BA	80	27	22,2	8	8	A2041080270270001	② ③ ⑤	■
SE6 08027.22	C 30 N BA	80	27	22,2	8	8	A204108027039	② ③ ④ ⑤ ⑥	■



### Cup wheels for angle grinders, shape SE11 with screw thread

Ordering example: A2094110551111



**Packing unit:**

10 pcs., up to Ø 130 mm 5 pcs.

v<sub>max</sub>: 50 m/s

Description	Quality	D mm	J mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
SE11 110055.M14	A 16 Q BA	110	90	55	M14	8.600	A2094110551111	1 3 4 5	■
SE11 110055.M14	A 24 Q BA	110	90	55	M14	8.600	A2094110551211	1 3 4 5	■
SE11 110055.M14	A 36 Q BA	110	90	55	M14	8.600	A2094110551311	1 3 4 5	■
SE11 110055.M14	C 16 N BA	110	90	55	M14	8.600	A2094110551121	5 10 11 12 13	■
SE11 110055.M14	C 24 N BA	110	90	55	M14	8.600	A2094110551221	5 10 11 12 13	■
SE11 110055.M14	C 36 N BA	110	90	55	M14	8.600	A2094110551321	5 10 11 12 13	■
SE11 110055.M14	C 60 N BA	110	90	55	M14	8.600	A2094110551521	5 10 11 12 13	■
SE11 110055.M14	C 80 N BA	110	90	55	M14	8.600	A2094110551621	5 10 11 12 13	■
SE11 110055.M14	C 120 N BA	110	90	55	M14	8.600	A2094110551721	5 10 11 12 13	■
SE11 130055.M14	A 16 Q BA	130	90	55	M14	7.300	A2094130551111	1 3 4 5	■
SE11 130055.M14	A 24 Q BA	130	90	55	M14	7.300	A2094130551211	1 3 4 5	■
SE11 130055.M14	C 16 N BA	130	90	55	M14	7.300	A2094130551121	5 10 11 12 13	■
SE11 130055.M14	C 24 N BA	130	90	55	M14	7.300	A2094130551221	5 10 11 12 13	■
SE11 130055.M14	C 36 N BA	130	90	55	M14	7.300	A2094130551321	5 10 11 12 13	■
SE11 130055.M14	C 60 N BA	130	90	55	M14	7.300	A2094130551521	5 10 11 12 13	■

**This product excels in**

- High stock removal
- Long life
- Less vibration
- Low noise
- Aggressive cut

**Applications for the A quality, brown aluminium oxide**

- Welding seams
- Grinding in corners and edges
- Steel sheets
- Railway tracks
- Descaling
- Trimming of castings
- Thin profiles

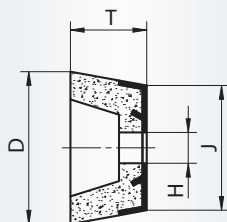
**Applications for the C quality, silicon carbide**

- Ductile cast iron pipes
- Spherical castings
- Malleable cast iron
- Reinforced concrete
- Roof tiles
- Lime sand brick, artificial stone and dressed stone
- General stone
- Ceramic
- Grey iron castings
- Steel castings
- Marble
- Bottom plates
- Curbstones
- Fair faced brick
- Floating screed



Cup wheels for angle grinders, shape SE11 with steel cover and bore

Ordering example: A209411055511



**Packing unit:**  
10 pcs., up to Ø 130 mm 5 pcs.  
 $v_{max}$ : 50 m/s

Description	Quality	D mm	J mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
SE11 110055.22	A 16 Q BA	110	90	55	22,23	8.600	A2094110555111	1 3 4 5	■
SE11 110055.22	A 24 Q BA	110	90	55	22,23	8.600	A2094110555211	1 3 4 5	■
SE11 110055.22	A 36 Q BA	110	90	55	22,23	8.600	A2094110555311	1 3 4 5	■
SE11 110055.22	A 60 Q BA	110	90	55	22,23	8.600	A2094110555511	1 3 4 5	■
SE11 110055.22	C 16 N BA	110	90	55	22,23	8.600	A2094110555121	5 10 11 12 13	■
SE11 110055.22	C 24 N BA	110	90	55	22,23	8.600	A2094110555221	5 10 11 12 13	■
SE11 110055.22	C 60 Q BA	110	90	55	22,23	8.600	A2094110555521	5 10 11 12 13	■
SE11 110055.22	C 80 N BA	110	90	55	22,23	8.600	A2094110555621	5 10 11 12 13	■
SE11 110055.22	C 120 Q BA	110	90	55	22,23	8.600	A2094110555721	5 10 11 12 13	■
SE11 130055.22	A 16 Q BA	130	90	55	22,23	7.300	A2094130555111	1 3 4 5	■
SE11 130055.22	A 24 Q BA	130	90	55	22,23	7.300	A2094130555211	1 3 4 5	■
SE11 130055.22	C 16 Q BA	130	90	55	22,23	7.300	A2094130555121	5 10 11 12 13	■
SE11 130055.22	C 24 N BA	130	90	55	22,23	7.300	A2094130555221	5 10 11 12 13	■

**This product excels in**

- High stock removal
- Long life
- Less vibration
- Low noise
- Aggressive cut

**Applications for the A quality, brown aluminium oxide**

- Welding seams
- Grinding in corners and edges
- Steel sheets
- Railway tracks
- Descaling
- Trimming of castings
- Thin profiles

**Applications for the C quality, silicon carbide**

- Ductile cast iron pipes
- Spherical castings
- Malleable cast iron
- Reinforced concrete
- Roof tiles
- Lime sand brick, artificial stone and dressed stone
- General stone
- Ceramic
- Grey iron castings
- Steel castings
- Marble
- Bottom plates
- Curbstones
- Fair faced brick
- Floating screed

Always the right tool

# For Highest Standards in Surface Finishing!



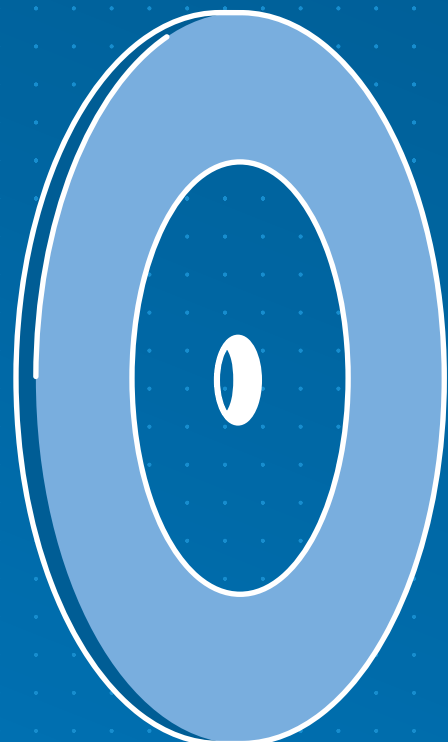
## Diamondtools

<b>206</b>	Technical Information
<b>207</b>	Qualities and application
<b>208</b>	Vacuum-Brazed Diamond cutting discs
<b>209</b>	Diamond cutting discs
<b>217</b>	Diamond cup wheels



### Product line marking

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



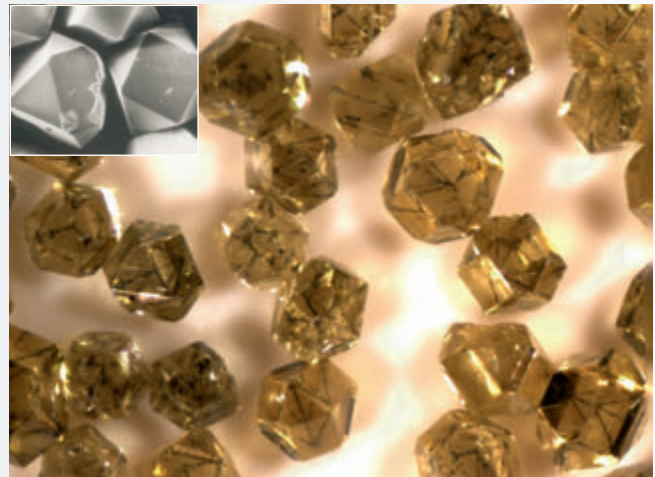
## Technical Information

### The Diamond

Diamonds are the hardest known material. They are selected depending on the field of application. For diamond blade manufacture synthetic diamonds are solely used. Compared to natural diamonds, their properties are reproducible and controllable. The following quality characteristics are significant for selecting diamonds:

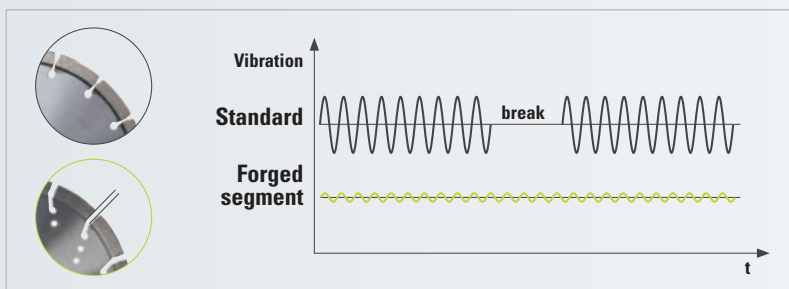
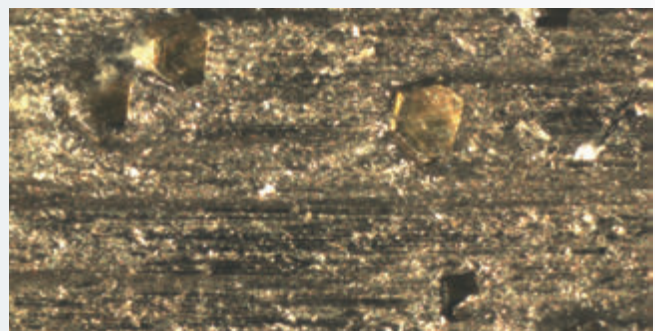
- degree of purity
- defined breaking strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grain sizes.

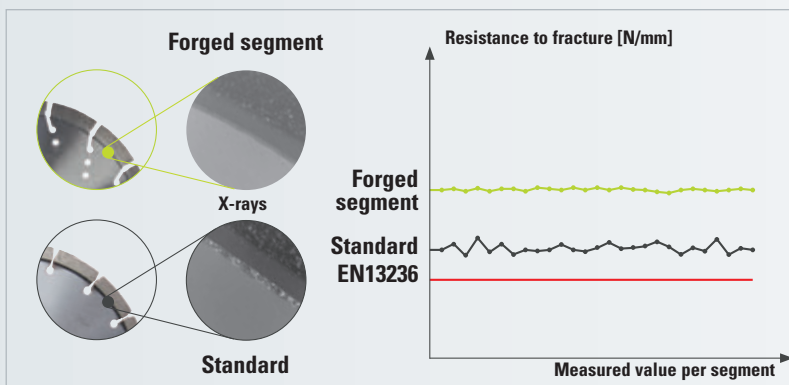


### The Segment

The segments consist of diamond embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists, for example, of bronze, cobalt, iron, metal carbides, tungsten carbide. The various properties of metal powder provide for sharpness and wear and tear of the segment. Segment coating is carried out by sintering. Therefore, abrasive materials require a hard bond against what hard materials call for soft bond.



Comparison of cutting properties low vibration cutting discs with narrow gaps



Welding properties of forged segment: with highest safety against fracture

Due to the patented forged segment geometry even high segments can be arranged with small gaps in between. This produces considerably lower vibration for the user. Another essential advantage is safety. The dense segments have been forged without any pores. This ensures welding properties which provide much more safety against fracture compared to the usual sintered segments.

- Universal and fast – owing to new types of alloys in the segments
- Less vibration – owing to a trapezoid segment geometry
- More safety – owing to segment feet which are free of pores and provide for the utmost safety
- Against a fracture of the segment
- Longer life – owing to higher segments and retarded diamond shedding

## User instructions

Type	Catalogue page	Tiles			Granite, hard materials			Concrete			Construction material			Asphalt, abrasive materials			Grey iron		Segment height
		Tiles	Fine stoneware	Granite tiles	Granite	Porphyry	Clinker bricks	Reinforced concrete	Exposed aggregate concrete	Concrete products	Bricks, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Screed	Asphalt	Fresh concrete	
<b>Diamond cutting discs</b>																			
VDCM	208																		
VDC	209																		
LD MULTI S13	210																		13
LD 3 S13	211																		13
TURBO HP S12	211																		12
ABRASIV S13	217																		13
LD7 S13	217																		13
LD7 S10	218																		10
LD3 S10	212																		10
TURBO S10	212																		10
BLUE CUT plus S10	213																		10
BLUE CUT S10	215																		10
BC7	213																		7
BG-Laser	214																		7
TC7	214																		7
<b>Tile cutting discs</b>																			
FAST CUT S7	215																		7
FLIESE S7	216																		7
FC7	216																		7
<b>Diamond cup wheels</b>																			
DST HP S5	218																		5
DST S6	219																		6
DST S5	219																		5

**High Performance**
**High Performance**

- extremely quick cut, even through difficult materials
- Very good service life and designed for universal applications, for professional use

**Industry**
**Industry**

- quick cut and reliable
- long service life

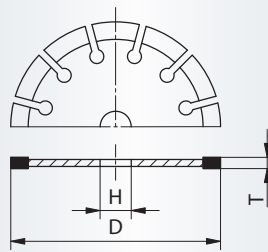
**Base**
**Base**

- price-conscious and good



### VDCM Multi, the exceptional cutting disc for nearly any workpiece

Ordering example: A34911152022



Packing unit:  
1 pc.  
 $v_{max}$ : 80 m/s

**VDC MULTI**  
Series

Description	D mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDCM 115020	115	2,0	22,23	13.300	A34911152022	① 5 8 10 11 12	■
VDCM 125020	125	2,0	22,23	12.200	A34911252022	① 5 8 10 11 12	■
VDCM 180026	180	2,6	22,23	8.500	A34911802622	① 5 8 10 11 12	■
VDCM 230030	230	3,0	22,23	6.600	A34912303022	① 5 8 10 11 12	■

The segment coating made of carbide granulates prevents the disc from getting stuck in soft workpieces. The result is a clean cut.

#### Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter

#### Ideal for cutting of

- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GRP)
- Normal and red brass
- Steel
- Bricks
- Reinforced concrete
- Stone, tiles, wood

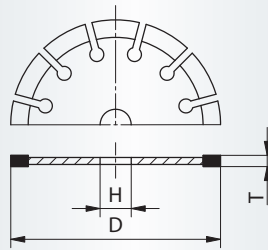




High Performance

## VDC, a revolution in the cutting of grey cast iron

Ordering example: A34901152222



Packing unit:  
1 pc.  
 $v_{max}$ : 80 m/s

**VDC**  
iSeries

Description	D mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDC 115022	115	2,2	22,23	13.300	A34901152222	5	■
VDC 125022	125	2,2	22,23	12.200	A34901252222	5	■
VDC 180026	180	2,6	22,23	8.500	A34901802622	5	■
VDC 230030	230	3,0	22,23	6.600	A34902303022	5	■
VDC 350036	350	3,6	32,00	5.500	A34903503632	5	■

NEW

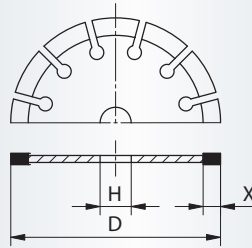
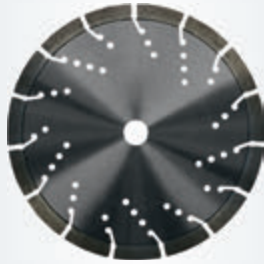
### Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter

### Ideal for cutting of

- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GFK)
- Normal and red brass

**LD Multi S13, the professional disc for granite, concrete and construction material** *Ordering example: A344031151213083*



**Packing unit:**

1 pc.

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

Ø 300, 350, 400 mm: 100m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	LD Multi S13	115	13	22,23	13.300	A344031151213083	10 11 14	■
PROMAX	LD Multi S13	125	13	22,23	12.200	A344031251213093	10 11 14	■
PROMAX	LD Multi S13	150	13	22,23	10.200	A344031501213113	10 11 14	■
PROMAX	LD Multi S13	180	13	22,23	8.500	A344031801213133	10 11 14	■
PROMAX	LD Multi S13	230	13	22,23	6.600	A344032301213153	10 11 14	■
PROMAX	LD Multi S13	300	13	25,4	6.400	A344033002213183	10 11 14	■
PROMAX	LD Multi S13	350	13	25,4	5.500	A344033502213213	10 11 14	■
PROMAX	LD Multi S13	400	13	25,4	4.800	A344034002213243	10 11 14	■

**This diamond cutting disc excels in:**

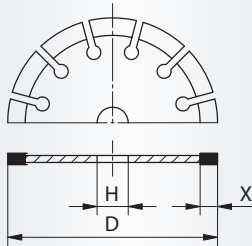
- Most universal properties along with optimum cutting speed
- Long life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 30 mm bore. Please refer to the chart on page 207 for detailed information on applications.

**Turbo HP S12, with turbo segments, also suitable for reinforced concrete**

Ordering example: A344031151212093



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	TURBO HP S12	115	12	22,23	13.300	A344031151212093	10 11 14	■
PROMAX	TURBO HP S12	125	12	22,23	12.200	A344031251212103	10 11 14	■
PROMAX	TURBO HP S12	150	12	22,23	10.200	A344031501212123	10 11 14	■
PROMAX	TURBO HP S12	180	12	22,23	8.500	A344031801212143	10 11 14	■
PROMAX	TURBO HP S12	230	12	22,23	6.600	A344032301212153	10 11 14	■

**This diamond cutting disc excels in:**

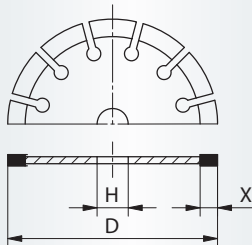
- A wide field of applications
- Long life
- Good cutting speed

**Bonding method:** laser welded

Please refer to the chart on page 207 for detailed information on applications.

**LD3 S13, for top performance in concrete and construction material**

Ordering example: A3440311517113038

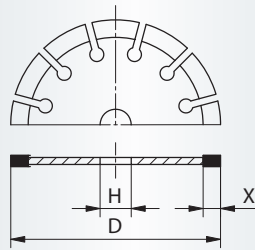


**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
PROMAX	LD3 S13	115	13	22,23	13.300	A344031151713083	10 11 14	■	NEW
PROMAX	LD3 S13	125	13	22,23	12.200	A344031251713093	10 11 14	■	NEW
PROMAX	LD3 S13	150	13	22,23	10.200	A344031501713113	10 11 14	■	NEW
PROMAX	LD3 S13	180	13	22,23	8.500	A344031801713133	10 11 14	■	NEW
PROMAX	LD3 S13	230	13	22,23	6.600	A344032301713153	10 11 14	■	NEW
PROMAX	LD3 S13	300	13	25,4	6.400	A344033002713183	10 11 14	■	NEW
PROMAX	LD3 S13	350	13	25,4	5.500	A344033502713213	10 11 14	■	NEW
PROMAX	LD3 S13	400	13	25,4	4.800	A344034002713243	10 11 14	■	NEW

## LD3 S10, for a high cutting rate in concrete and construction material

Ordering example: A344131151210083



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	LD3 S10	115	10	22,23	13.300	A344131151210083	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	125	10	22,23	12.200	A344131251210093	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	150	10	22,23	10.200	A344131501210113	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	180	10	22,23	8.500	A344131801210143	⑩ ⑪	■
PREMIUMFLEX	LD3 S10	230	10	22,23	6.600	A344132301210163	⑩ ⑪	■

**This diamond cutting disc excels in:**

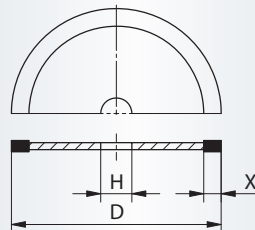
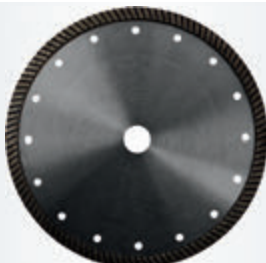
- Universal use in concrete/building material
- Excellent price-performance ratio

**Bonding method:** laser welded

Please refer to the chart on page 207 for detailed information on applications.

## Turbo S 10, the disc for the clear cut in building material or concrete

Ordering example: A344141151110013



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	TURBO S10	115	10	22,23	13.300	A344141151110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	125	10	22,23	12.200	A344141251110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	150	10	22,23	10.200	A344141501110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	180	10	22,23	8.500	A344141801110013	⑩ ⑪	■
PREMIUMFLEX	TURBO S10	230	10	22,23	6.600	A344142301110013	⑩ ⑪	■

**This diamond cutting disc excels in:**

- Various applications
- Clear cuts

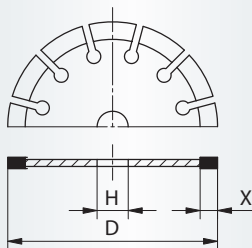
Please refer to the chart on page 207 for detailed information on applications.



Industry

**BLUE CUT plus S10, the universal disc for construction sites**

Ordering example: A344141151110093



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	BLUE CUT plus S10	115	10	22,23	13.300	A344141151110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	125	10	22,23	12.200	A344141251110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	180	10	22,23	8.500	A344141801110093	⑩ ⑪	■
PREMIUMFLEX	BLUE CUT plus S10	230	10	22,23	6.600	A344142301110093	⑩ ⑪	■

**This diamond cutting disc excels in:**

- An optimum price-performance ratio

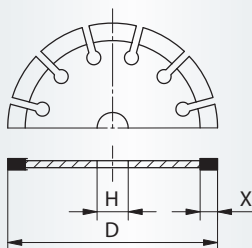
Please refer to the chart on page 207 for detailed information on applications.



Base

**BC7, the cost-effective disc for building and handicraft**

Ordering example: A345241151107085



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
BASE-X	BC7	115	7	22,23	13.300	A345241151107085	⑩	■	NEW
BASE-X	BC7	125	7	22,23	12.200	A345241251107095	⑩	■	NEW
BASE-X	BC7	230	7	22,23	6.600	A345242301107165	⑩	■	NEW

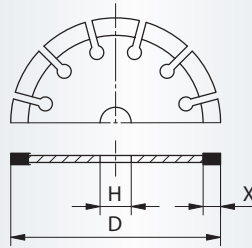
# 214 Diamond cutting discs

**ROTLUFF**

**Base**

## TC7, the cost-effective turbo disc for a clean cut

Ordering example: A345241151107775



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

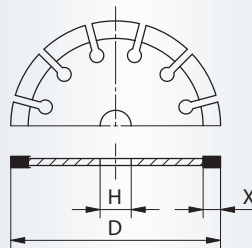
	Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	BASE-X	TC7	115	7	22,23	13.300	A345241151107775	10	■
<b>NEW</b>	BASE-X	TC7	125	7	22,23	12.200	A345241251107775	10	■
<b>NEW</b>	BASE-X	TC7	230	7	22,23	6.600	A345242301107775	10	■

**ROTLUFF**

**Base**

## BG-Laser, the price-conscious disc for granite and concrete

Ordering example: A345231251207105



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

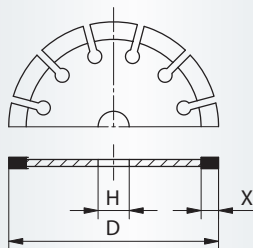
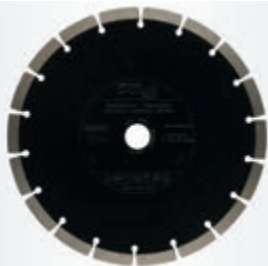
	Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b>	BASE-X	BG-L	125	7	22,23	12.200	A345231251207105	11 14	■
<b>NEW</b>	BASE-X	BG-L	230	7	22,23	6.600	A345232301207165	11 14	■

**ROTLUFF**

**Base**

**Blue Cut S10, the popular disc for construction sites**

Ordering example: A345231251207105



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

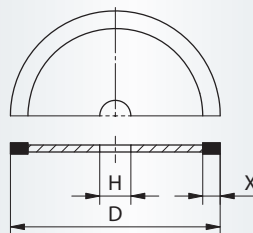
Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for				
BASE-X	Blue Cut S10	100	10	16,00	15.300	A345241001110075	⑩ ⑪			■	NEW
BASE-X	Blue Cut S10	115	10	22,23	13.300	A345241151110085	⑩ ⑪			■	NEW
BASE-X	Blue Cut S10	125	10	22,23	12.200	A345241251110095	⑩ ⑪			■	NEW
BASE-X	Blue Cut S10	150	10	22,23	10.200	A345241501110125	⑩ ⑪			■	NEW
BASE-X	Blue Cut S10	180	10	22,23	8.500	A345241801110145	⑩ ⑪			■	NEW
BASE-X	Blue Cut S10	230	10	22,23	6.600	A345242301110165	⑩ ⑪			■	NEW

**ROTLUFF**

**High Performance**

**FAST CUT S7, the extra thin turbo cutting disc for ceramics and stoneware**

Ordering example: A344091151107013



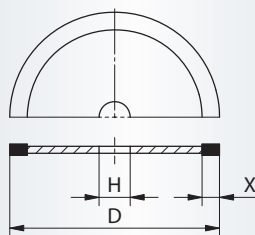
**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for			
PROMAX	FAST CUT S7	115	7	22,23	13.300	A344091151107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	125	7	22,23	12.200	A344091251107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	150	7	22,23	10.200	A344091501107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	180	7	22,23	8.500	A344091801107013	⑩ ⑫ ⑭			■
PROMAX	FAST CUT S7	230	7	22,23	6.600	A344092301107013	⑩ ⑫ ⑭			■



## FLIESE S7, the popular cutting disc for tiles and ceramics

Ordering example: A34411151107013



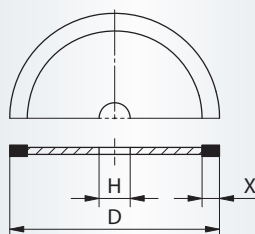
**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	FLIESE S7	115	7	22,23	13.300	A34411151107013	12	■
PREMIUMFLEX	FLIESE S7	125	7	22,23	12.200	A344111251107013	12	■
PREMIUMFLEX	FLIESE S7	150	7	22,23	10.200	A344111501107013	12	■
PREMIUMFLEX	FLIESE S7	180	7	22,23	8.500	A344111801107013	12	■
PREMIUMFLEX	FLIESE S7	230	7	22,23	6.600	A344112301107013	12	■



## FC7, the cost-effective tile cutting disc

Ordering example: A345211151107015



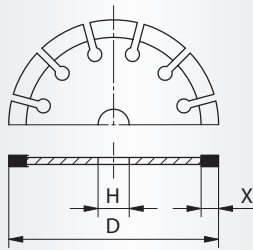
**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> BASE-X	FC7	115	7	22,23	13.300	A345211151107015	12	■
<b>NEW</b> BASE-X	FC7	125	7	22,23	12.200	A345211251107015	12	■
<b>NEW</b> BASE-X	FC7	230	7	22,23	6.600	A345212301107015	12	■



**ABRASIV S13, the professional disc for fresh concrete and much more**

Ordering example: A344053002213203



**Packing unit:**

1 pc.

$v_{max}$ : 80 m/s

Ø 300, 350, 400 mm: 100m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	ABRASIV S13	115	13	22,23	13.300	A344051151213083	10 11 15 16	■
PROMAX	ABRASIV S13	125	13	22,23	12.200	A344051251213093	10 11 15 16	■
PROMAX	ABRASIV S13	180	13	22,23	8.500	A344051801213133	10 11 15 16	■
PROMAX	ABRASIV S13	230	13	22,23	6.600	A344052301213163	10 11 15 16	■
PROMAX	ABRASIV S13	300	13	25,4	6.400	A344053002213203	10 11 15 16	■
PROMAX	ABRASIV S13	350	13	25,4	5.500	A344053502213243	10 11 15 16	■
PROMAX	ABRASIV S13	400	13	25,4	4.800	A344054002213283	10 11 15 16	■
PROMAX	ABRASIV S13	450	13	25,4	3.400	A344054502213253	10 11 15 16	■
PROMAX	ABRASIV S13	500	13	25,4	3.100	A344055002213303	10 11 15 16	■

**This diamond cutting disc excels in:**

- Very universal properties along with optimum life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

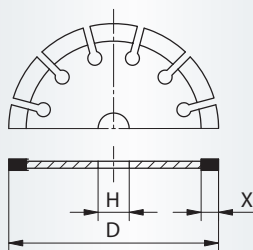
**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

Please refer to the chart on page 207 for detailed information on applications.

**LD7 S13, for top performance in asphalt**

Ordering example: A344073002213183



**Packing unit:**

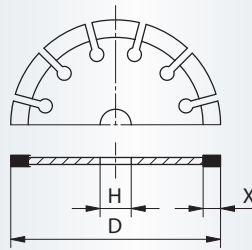
1 pc.

$v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
PROMAX	LD7 S13	300	10	22,23	5.100	A344073002213183	16	■	NEW
PROMAX	LD7 S13	350	10	22,23	4.400	A344073502213213	16	■	NEW
PROMAX	LD7 S13	400	10	22,23	3.800	A344074002213243	16	■	NEW
PROMAX	LD7 S13	450	10	22,23	3.900	A344074502213253	16	■	NEW
PROMAX	LD7 S13	500	10	22,23	3.100	A344075002213303	16	■	NEW

## LD7 S10 for a perfect cutting of asphalt

Ordering example: A344173002210183



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	LD7 S10	300	10	25,4	5.100	A344173002210183	15 16	■
PREMIUMFLEX	LD7 S10	350	10	25,4	4.400	A344173502210213	15 16	■
PREMIUMFLEX	LD7 S10	400	10	25,4	3.800	A344174002210243	15 16	■
PREMIUMFLEX	LD7 S10	450	10	25,4	3.400	A344174502210283	15 16	■
PREMIUMFLEX	LD7 S10	500	10	25,4	3.100	A344175002210303	15 16	■

**This diamond cutting disc excels in:**

- Especially shaped segments providing extreme running smoothness and core protection

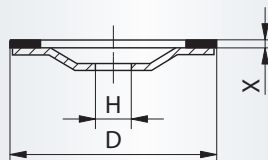
**Bonding method:** laser welded

**Note:** Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

Please refer to the chart on page 207 for detailed information on applications.

## DST HP S5 to meet the highest expectations for stock removal and smooth running

Ordering example: A344331001505083



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PROMAX	DST HP S5	100	5	22,23	15.300	A344331001505083	10 11 14 15	■
PROMAX	DST HP S5	125	5	22,23	12.200	A344331251505083	10 11 14 15	■
PROMAX	DST HP S5	180	5	22,23	8.500	A344331801505123	10 11 14 15	■

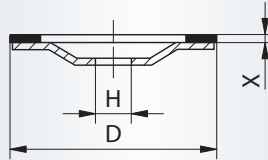
**This diamond cup wheel excels in:**

- High performance segments for maximum stock removal
- Universal segment alloy for concrete/granite
- Low vibration during working due to inductive welded segments (no imbalance in tool)
- Optimum suction at segment

Please refer to the chart on page 207 for detailed information on applications.

**DST S6, the cup wheel for universal application**

Ordering example: A344431251606183



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
PREMIUMFLEX	DST S6	125	6	22,23	12.200	A344431251606183	10 11	■
PREMIUMFLEX	DST S6	180	6	22,23	8.500	A344431801606183	10 11	■

**This diamond cup wheel excels in:**

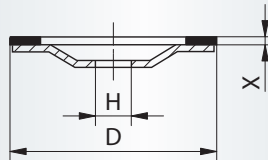
- Excellent price-performance ratio
- Optimum arrangement of segments for high grinding performance and clean surface

Please refer to the chart on page 207 for detailed information on applications.



**DST S5, the cost-effective cup wheel for numerous application**

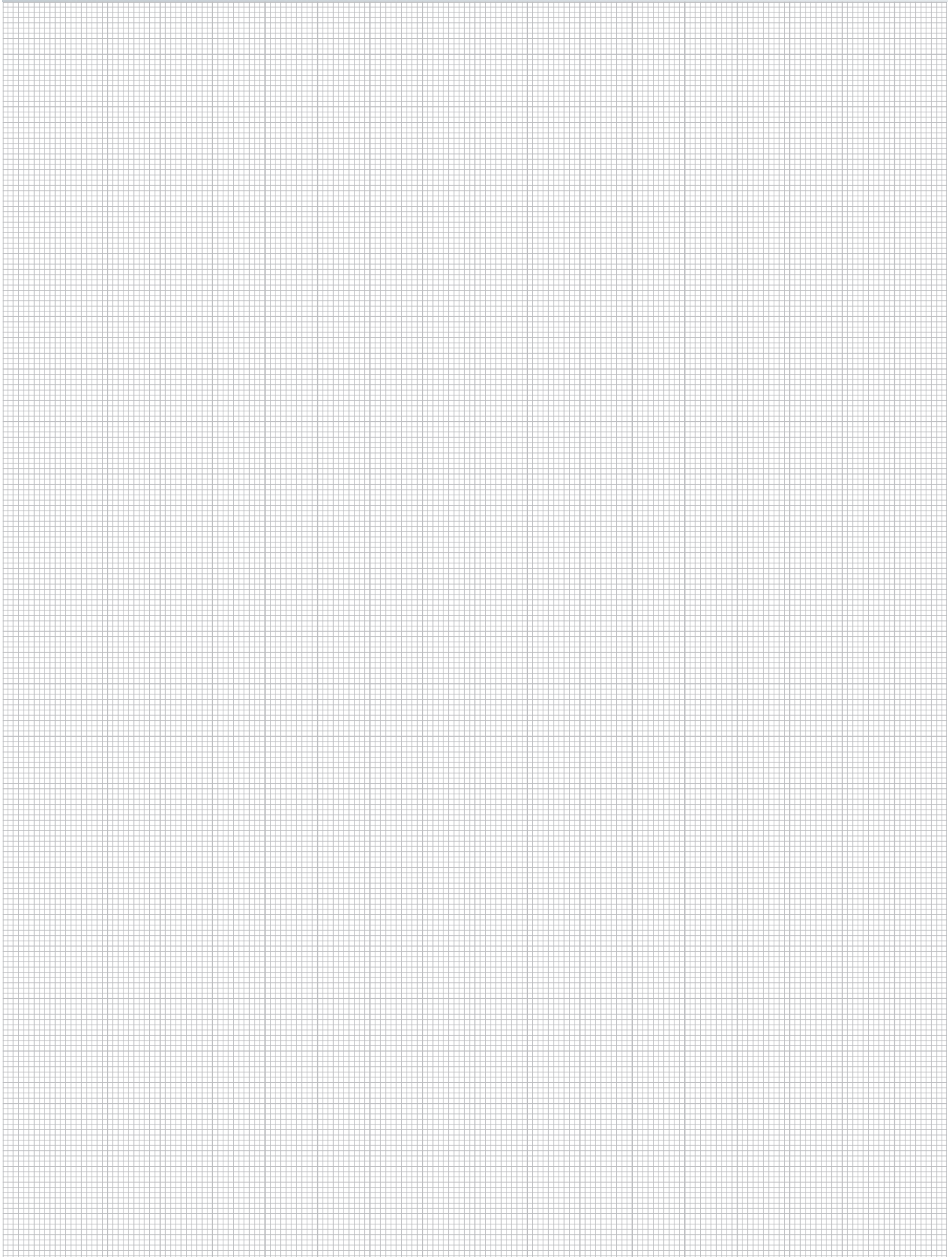
Ordering example: A345531151607185



**Packing unit:**  
1 pc.  
 $v_{max}$ : 80 m/s

Description	Quality	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for		
BASE-X	DST S5	115	5	22,23	13.300	A345531151607185	10 11	■	<b>NEW</b>
BASE-X	DST S5	125	5	22,23	12.200	A345531251607185	10 11	■	<b>NEW</b>

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid is composed of small, uniform squares.

## Flexible Grinding and Polishing Tools

**222** General Information/Qualities

**225** Lamellar Flap Discs

**251** Mounted flap wheels of abrasive cloth

**267** Flap wheel consisting of an abrasive fleece and abrasive cloth combination

**277** Flap wheels and rolls

**287** Flap rolls

**293** Abrasive Bands and Mandrels

**307** Abrasive Rolls and Mandrels

**311** Abrasive Caps and Abrasive Sleeves

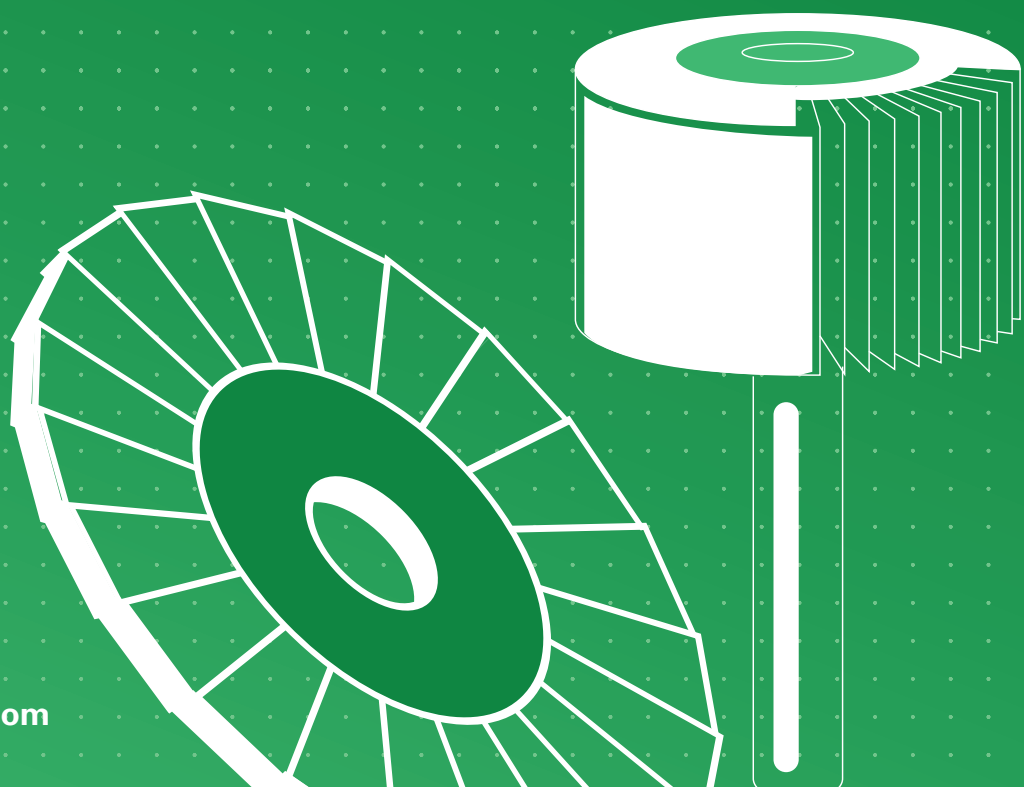
**323** Abrasive Discs and Mandrels

**341** Fibre discs, backing plates, economy rolls, abrasive sheets and fleece rolls

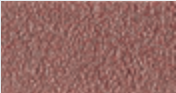
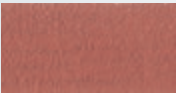





**351** AS-Cleaning fleece





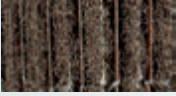




### Product line marking

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



## Qualities and Applications

Quality		Characteristics	Applications/Grinding	Available as	Page
 <b>NK</b>	Abrasive cloth with reg. Aluminium Oxide	tough grain	Forged steel, malleable iron, grey cast iron, carbon steel, deep-drawn steels, steel band, zinc die castings, nonferrous metals, wood	flap discs mounted flap wheels flap wheels flap rolls bands abrasive rolls caps abrasive sleeves discs Economy rolls fibre discs sheets of abrasive cloth	242–244 247 253–260 263–264 279–281 289 296–299 302–305 309–310 313 315–319 321 326 336–337 338 348 344–345 349
 <b>NKE</b>	Abrasive cloth using reg. Aluminium Oxide with special coating containing active grinding additives	tough grain	Chrome-nickel and other alloyed steels, deep drawn steels, titanium and titanium alloyed steels, heat resistant steels	mounted flap wheels discs	261 327
 <b>ZK</b>	Abrasive cloth with Zirconia Alum. Oxide	very tough and resilient grain	Forged steels, metals difficult to machine and with extreme hard surfaces i.e. welds, titanium and titanium alloys, heat resistant steels	flap discs abrasive belts discs fibre discs	231–235, 237, 239, 241–247 299–300, 305 328, 333–334 343
 <b>Z POWER</b>	Abrasive cloth using Zirconia Alum. Oxide with special coating containing active grinding additives	optimum stock removal rate, excellent tool life	all alloyed steels	lamellar flap discs abrasive bands abrasive discs	230, 234 295 328
 <b>ZKS</b>	Abrasive cloth using Zirconia Alum. Oxide with special coating containing active grinding additives	M-Bonding with polyester fibre excellent stock removal rate with very good tool life	Forged steels, metals difficult to machine and with extreme hard surfaces i.e. welds, titanium and titanium alloys, heat resistant steels	flap discs	235 241 246 249
 <b>NKS</b>	Abrasive cloth using reg. Aluminium Oxide with special coating containing active grinding additives	optimum stock removal rate, excellent tool life	corrosion and heat resistant steel	abrasive caps	313 315 317
 <b>SIC</b>	Abrasive cloth with Silicon carbide	cool cutting; special quality for the aircraft industry	Aluminium and aluminium alloys, brittle material, glass ceramics, titanium and titanium alloys, heat resistant steels, plastics	flap discs mounted flap wheels discs	235 262 336

Quality		Characteristics	Applications/Grinding	Available as	Page
 <b>D</b>	Diamond coated abrasive cloth	For those instances where conventional abrasive cloth provides too little stock removal	Extreme tool life benefit versus conventional abrasive cloth. Ideally suited for particularly difficult-to-machine and hard work-piece materials. Glass, GRP and CRP, carbide, titanium, stone, ceramic	abrasive belts abrasive discs	295 338
 <b>CERAMIC</b>	Abrasive cloth ceramic grain	optimum stock removal rate without shredding of grain. Very stable due to reinforced backing. Cool cutting	stainless steel, nickel alloys	flap discs abrasive belts discs fibre discs	234, 242 296 329 343
 <b>A</b>	Abrasive fleece with reg. Aluminium Oxide	polishing effect through fibre structure, consistent results due to continuous exposure of new grit particles	Chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	flap discs mounted flap wheels flap wheels fleece mops flap rolls discs fleece pads fleece rolls	250 270, 272 280–285 285 290–292 330 350
 <b>C</b>	Abrasive fleece with Silicon carbide	polishing effect through fibre structure, consistent results due to continuous exposure of new grit particles	Titanium and titanium alloys, silver and silverplated, aluminium and aluminium alloys, plastics	flap discs mounted flap wheels flap wheels flap rolls fleece pads	250 271 280–284 292 350
 <b>TF</b>	Abrasive fleece/cloth reinforced fleece	Abrasive cloth lamellars and abrasive fleece lamellars of our combined mounted flap wheels wear off more equal. Higher stock removal efficiency.	Ideal for surface finishing of metalsheet components such as stainless steel sinks and containers	mounted flap wheels flap rolls	273 291
 <b>A</b>	Abrasive fleece/abrasive cloth combined Al.-Oxide	intensified grinding action through combination of fleece and abrasive cloth	Chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	flap discs mounted flap wheels flap rolls	249 273–274 291–292
 <b>C</b>	Abrasive fleece/abrasive cloth combined Sil.-Carbide	intensified grinding action through combination of fleece and abrasive cloth	Titanium and titanium alloys, silver and silverplated, aluminium and aluminium alloys, plastics	flap discs mounted flap wheels	249 275
 <b>AS</b>	Polyamid-Fleece	impregnated with aggressive abrasive grit	removal of paint and adhesives, cement and concrete residues, derusting, restoring and polishing of a wide variety of surfaces.	AS-Tools	353–354
 <b>Z</b>	Abrasive fleece, zirconia aluminium oxide	Polishing effect through fibre structure, more aggressive	Cr-Ni and other stainless steels, zinc injection mouldings, non-ferrous metals	Mounted flap wheels	269

## Information

### General

Our flexible grinding and polishing tools are manufactured from high quality abrasive cloth and abrasive fleece. They consist of a flexible backing coated with abrasive grain (please refer to page 222 and 223)

Backings used: cloth, polyester fibre, fleece, fibre

Grain types used:

aluminium oxide (NK), silicon carbide (SIC), zirconia aluminium oxide (ZK), ceramic (ceramic)

Our flexible grinding and polishing tools are available in several different shapes and dimensions; they cover a wide spectrum of application i.e. from high stock removal to achieving an extremely fine surface finish.

### Operating recommendations

An increase in speed makes the abrasive grit act finer; a reduction in speed makes the abrasive grit act coarser.

Do not apply high pressure; performance will not increase and tool life will be reduced.

If stock removal is insufficient select a coarser grit size, do not increase pressure. The use of grinding additives can improve the efficiency.

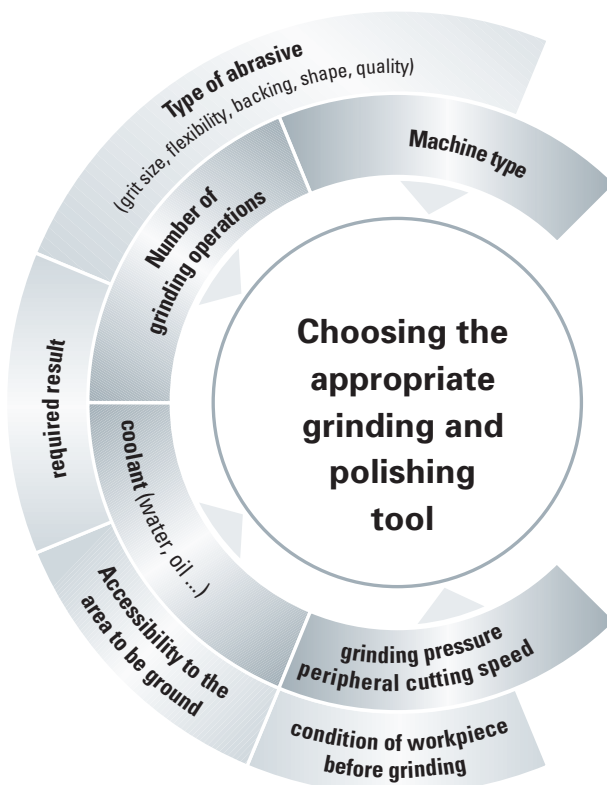
### Safety instructions

Please note our recommended operating speeds.

When using and storing flexible grinding and polishing tools, please take note of the safety regulations and regulations for prevention of accidents, including the FEPA-safety recommendations.

The tools are marked with pictograms according to FEPA recommendations for the use of coated abrasives.

## Points to consider when choosing the optimum grinding and polishing tool:





## Lamellar Flap Discs

**222** Quality and Applications

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**226** Generell Information

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**228** SLTT our turbo-flap disc – iQ-Series

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**232** V2 Power – iQ-Series

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**236** V3 Control – iQ-Series

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**238** V4 Master – Innovation for rounding off

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**240** SLTflex – The flexible innovation – iQ-Series

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**242** SLTR – with Ceramic-grit

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**242** SLTO/SLTR – reinforced fibre backing

---

**246** SLTZ – with special active grinding additives

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**246** SLTS – with vertical flaps

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**247** The robust – with steel backing

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**248** SLTK – with plastic backing

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**249** The NAWAROFLEX with the backing plate made of renewable raw materials

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**249** NAWAROFLEX® – to improve surface finish

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**250** NAWAROFLEX® – for finishing and polishing

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**250** SLTP – Polishing disc

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### Product line marking

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



## Information

### General

LUKAS offers a flap disc for almost every application. These abrasive tools are produced with a wide selection of backing materials (e.g. glass fibre, resin, metal and even with a bio-degradable raw material) to suit every application.

The large choice of grit sizes cover high stock removal applications (from grit size 36) to the finish machining application (grit size 240)

### Ergonomics

Where lamellar flap discs are used, you can achieve clear ergonomic advantages compared to conventional grinding discs.

For example, the noise level perceived is cut in half during grinding, and vibration can also be reduced considerably. In addition, the tools are generally lighter and can be used with less pressure.

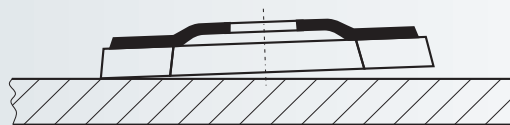
These advantages mean that they create a positive working climate and lead to fatigue-free working without impairing your health.

The flap discs are available in 100 mm diameter (with 16 mm bore) and in diameters 115 mm, 125 mm, 150 mm and 178 mm (22.23 mm bore); They fit all commonly used angle grinders.

You can choose between the flat or angled versions depending on application.

### Examples of application:

- deburring
- fettling
- derusting
- finishing
- Machining of Welds



The flat shape is designed to grind edges and flat surfaces with a working angle of 0° to 15° degrees.



The angled shape is designed for spot grinding e.g. a weld seam with an ideal working angle of 15° to 25° degrees.

Always the right tool

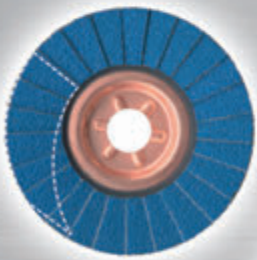


# *iq* Series

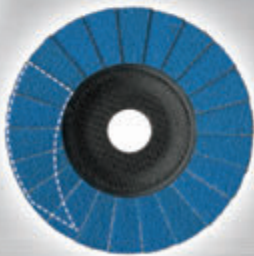
*Innovative quality*



Tools of our High Performance Line have been integrated into our iQ-Series product group. Flap Discs in this product group guarantee the highest level of grinding performance due to a patented lamella shape and orientation.



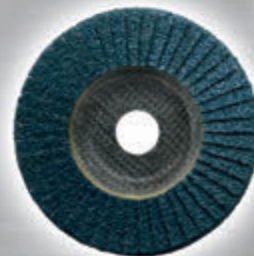
**SLTT**  
Series



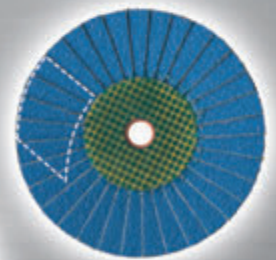
**V2 Power**  
Series



**V3 Control**  
Series

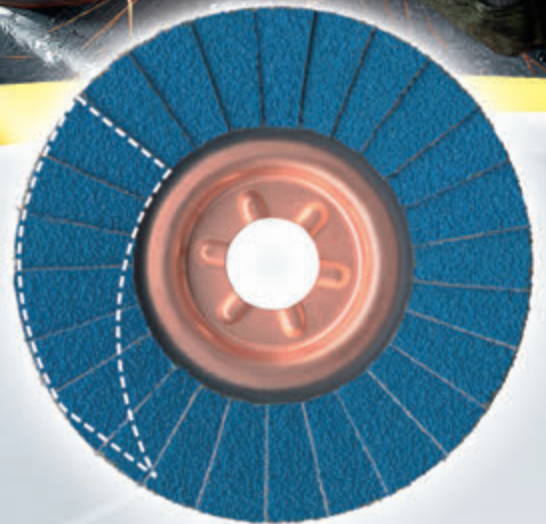


**V4 Master**  
Series



**SLTflex**  
Series

**Always the right tool**



### **SLTT – for highest chip removal!**

Feel the efficiency compared to grinding wheels or conventional lamellar flap discs.

#### **Ideal for**

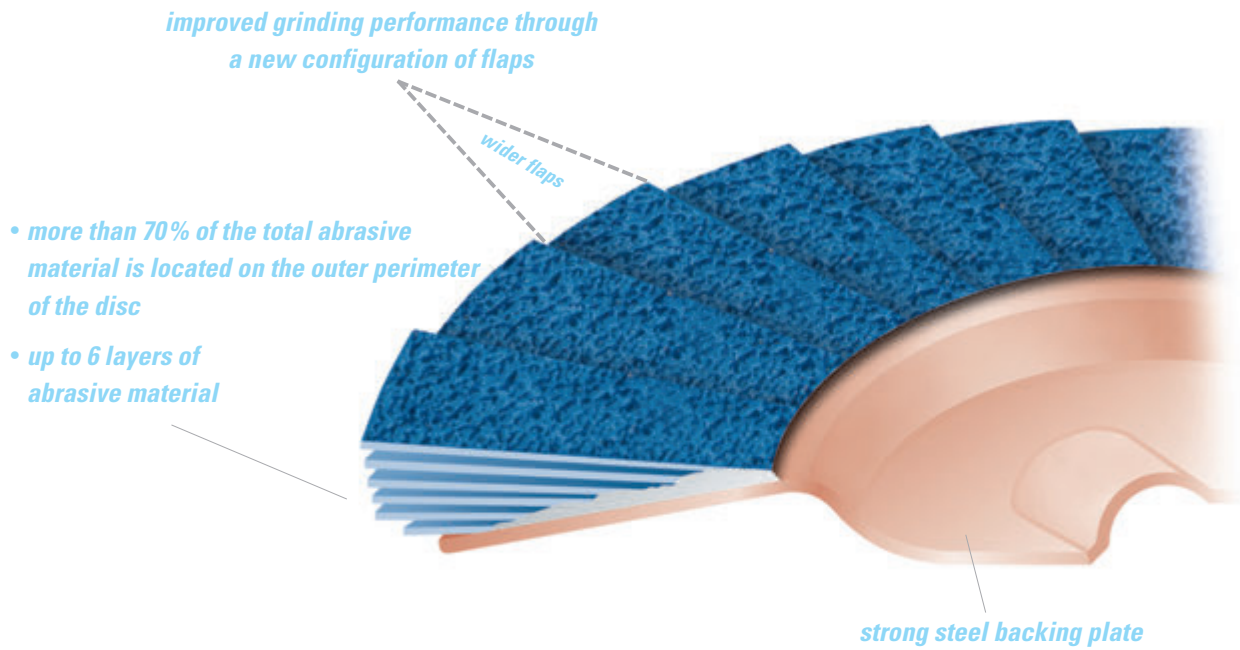
- removing weld seams
- deburring
- fettling
- fine finishing
- rust removal

**SLTT**  
*iQ Series*

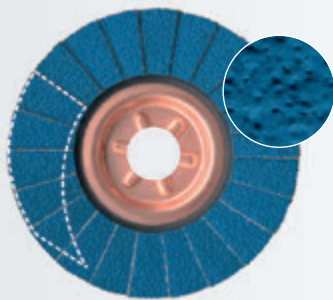
**A patented new design and configuration of flaps (more grains in action)**

#### **Characteristics**

- exceptional stock-removal capability
- enormous tool life
- strong steel backing plate
- quite
- less vibration



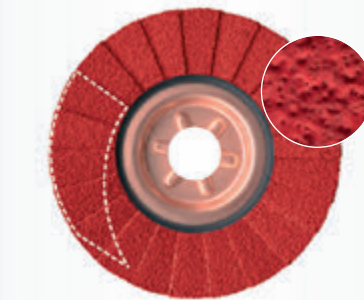
**The three qualities of the iQ series:**



**INOX**

**Z-Power coated abrasive**

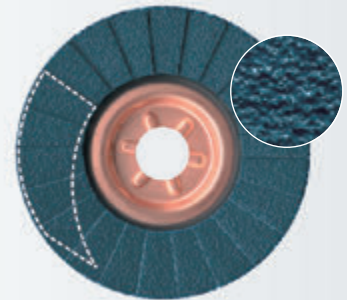
- recently developed for the machining of stainless steel
- no glazing or heating of flaps, owing to top size coating
- equally efficient for both edge and surface applications
- iron-sulphur-chlorine free



**Heavy Duty**

**Ceramic coated abrasive**

- recently developed for the most demanding and severe applications
- particularly robust for edge grinding, on heat treated steels, surface scale or coated surfaces
- iron-sulphur-chlorine free



**Steel**

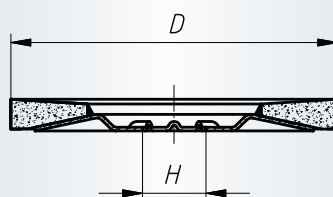
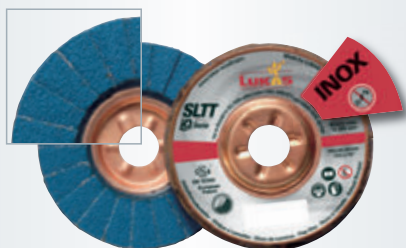
**ZK coated abrasive**

- optimized for universal application on a wide variety of steels and aluminium
- tough grain with a high degree of resistance to pressure
- quicker, more aggressive and longer tool life when compared with our current ZKS quality



### SLTT INOX, our Turbo Flap Disc to work on stainless steel

Ordering example: A27201150400045



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

Z POWER = Abrasive cloth using Zirconia Alum. Oxide with special coating containing active grinding additives



Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTT 115	Z Power 40	115	22,23	13.300	A27201150400045	① ② ③ ④	■
SLTT 115	Z Power 60	115	22,23	13.300	A27201150600045	① ② ③ ④	■
SLTT 125	Z Power 40	125	22,23	12.200	A27201250400045	① ② ③ ④	■
SLTT 125	Z Power 60	125	22,23	12.200	A27201250600045	① ② ③ ④	■
SLTT 150	Z Power 40	150	22,23	10.200	A27201500400045	① ② ③ ④	■
SLTT 178	Z Power 40	178	22,23	8.500	A27201780400045	① ② ③ ④	■
SLTT 178	Z Power 60	178	22,23	8.500	A27201780600045	① ② ③ ④	■

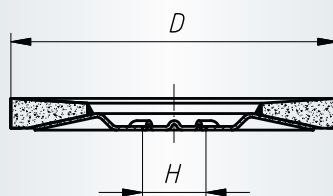
#### Eigenschaften:

- No glazing or heating of flaps, owing to top size coating
- equally efficient for both edge and surface applications
- iron-sulphur-chlorine free



### SLTT Heavy Duty, our Turbo Flap Disc for roughest application

Ordering example: A27201150400050



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

Ceramic = Abrasive cloth ceramic grain



Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTT 115	Ceramic 40	115	22,23	13.300	A27201150400050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 115	Ceramic 60	115	22,23	13.300	A27201150600050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	Ceramic 40	125	22,23	12.200	A27201250400050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	Ceramic 60	125	22,23	12.200	A27201250600050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 150	Ceramic 40	150	22,23	10.200	A27201500400050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	Ceramic 40	178	22,23	8.500	A27201780400050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	Ceramic 60	178	22,23	8.500	A27201780600050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

#### Properties:

- particularly robust for edge grinding, on heat treated steels, surface scale or coated surfaces
- iron-sulphur-chlorine free

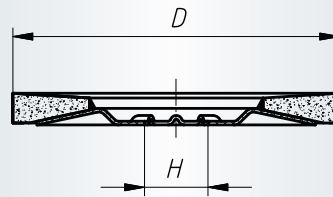
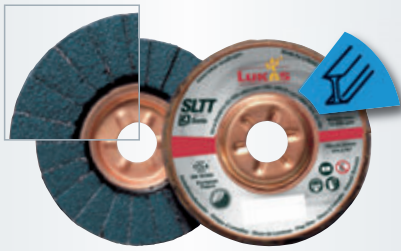




**High Performance**

**SLTT Steel, our Turbo Flap Disc for universal application on steel and aluminium**

Ordering example: A27201150400065



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

ZK = Abrasive cloth with Zirconia Alum. Oxide

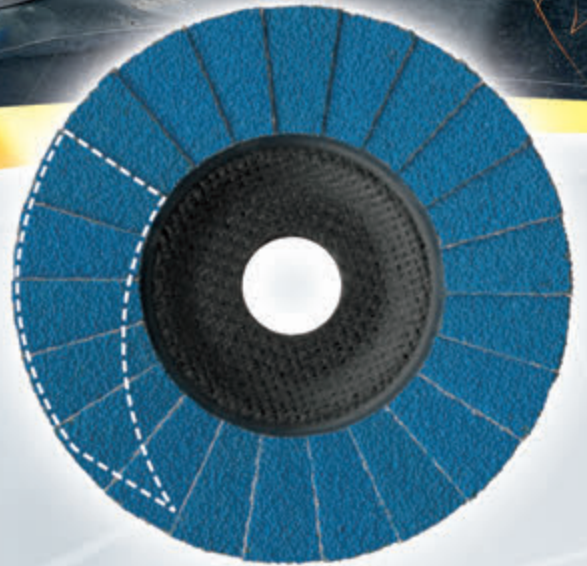


Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTT 115	ZK 40	115	22,23	13.300	A27201150400065	1 2 3 4 5 6 7 8	■
SLTT 115	ZK 60	115	22,23	13.300	A27201150600065	1 2 3 4 5 6 7 8	■
SLTT 125	ZK 40	125	22,23	12.200	A27201250400065	1 2 3 4 5 6 7 8	■
SLTT 125	ZK 60	125	22,23	12.200	A27201250600065	1 2 3 4 5 6 7 8	■
SLTT 150	ZK 40	150	22,23	10.200	A27201500400065	1 2 3 4 5 6 7 8	■
SLTT 150	ZK 60	150	22,23	10.200	A27201500600065	1 2 3 4 5 6 7 8	■
SLTT 178	ZK 40	178	22,23	8.500	A27201780400065	1 2 3 4 5 6 7 8	■
SLTT 178	ZK 60	178	22,23	8.500	A27201780600065	1 2 3 4 5 6 7 8	■

**Properties:**

- tough grain with a high degree of resistance to pressure
- quicker, more aggressive and longer tool life when compared with our current ZKS quality

**Always the right tool**



### **V2 Power – for general purpose!**

Feel the efficiency compared to conventional lamellar flap discs.

#### **Ideal for**

- removing weld seams
- deburring
- fettling
- fine finishing
- rust removal

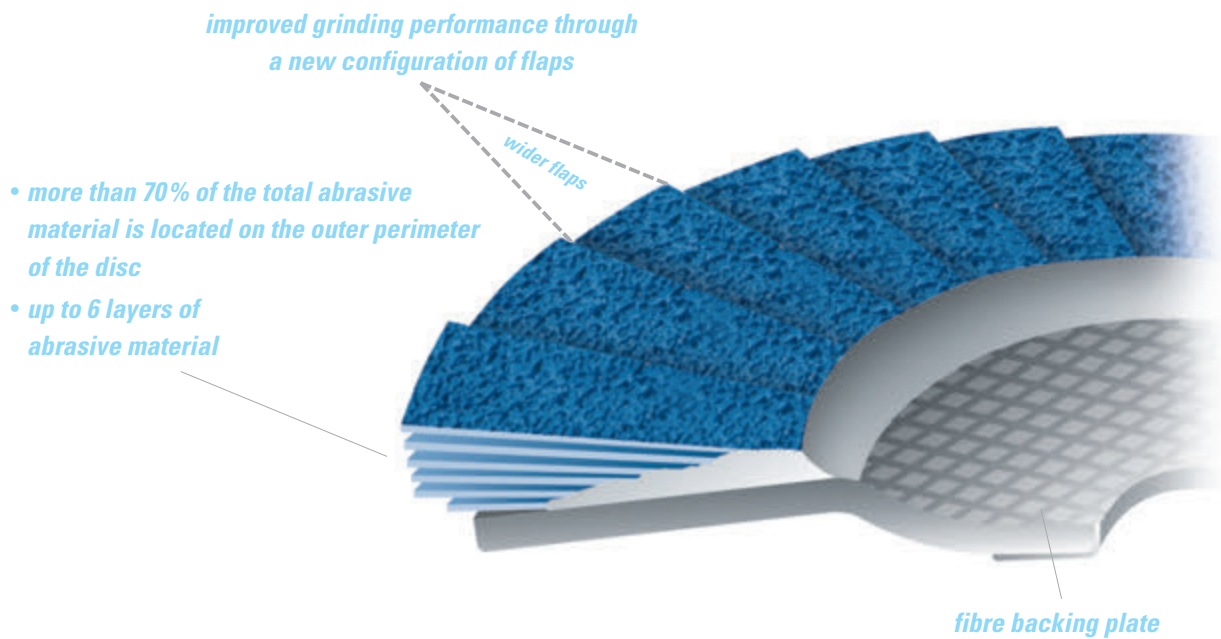
**V2 Power**  
**i@ Series**

**A patented new design and configuration of flaps (more grains in action)**

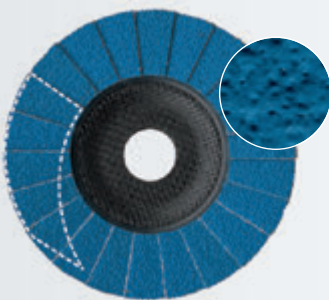
#### **Characteristics**

- exceptional stock-removal capability
- outstanding tool life
- robust fibre backing plate





**The four qualities in the iQ Series – for all materials and for every application!**



**INOX**

**Z-Power coated abrasive**

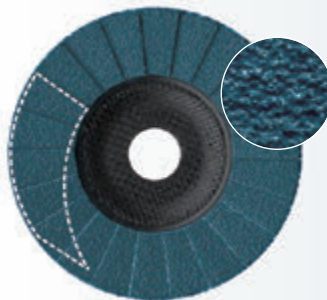
- recently developed for the machining of stainless steel
- no glazing or heating of flaps, owing to top size coating
- equally efficient for both edge and surface applications
- iron-sulphur-chlorine free



**Heavy Duty**

**Ceramic coated abrasive**

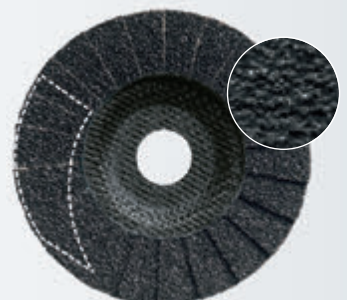
- recently developed for the most demanding and severe applications
- particularly robust for edge grinding, on heat treated steels, surface scale or coated surfaces
- iron-sulphur-chlorine free



**Steel**

**ZK coated abrasive**

- optimized for universal application on a wide variety of steels and aluminium
- tough grain with a high degree of resistance to pressure
- quicker, more aggressive and longer tool life when compared with our current ZKS quality



**ALU**

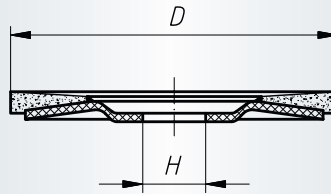
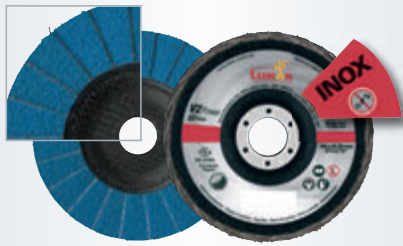
**SIC – coated abrasive**

- specially suited for weld preparation and finishing of aluminium
- also ideal for fibre reinforced materials such as CRP and GRP



### V2 Power INOX to work on stainless steel

Ordering example: A27441150401445



**Packing unit:**  
10 pcs. per type

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

Z POWER = Abrasive cloth using Zirconia Alum. Oxide with special coating containing active grinding additives



Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
V2 POWER 115	Z Power 40	115	22,23	13.300	A27441150401445	① ② ③ ④	■
V2 POWER 115	Z Power 60	115	22,23	13.300	A27441150601445	① ② ③ ④	■
V2 POWER 125	Z Power 40	125	22,23	12.200	A27441250401445	① ② ③ ④	■
V2 POWER 125	Z Power 60	125	22,23	12.200	A27441250601445	① ② ③ ④	■
V2 POWER 178	Z Power 40	178	22,23	8.500	A27441780401445	① ② ③ ④	■
V2 POWER 178	Z Power 60	178	22,23	8.500	A27441780601445	① ② ③ ④	■

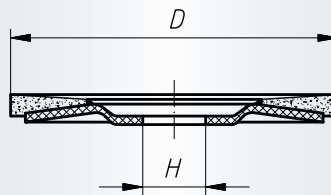
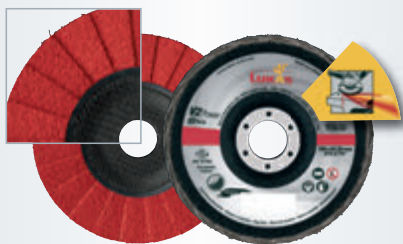
**Properties:**

- no glazing or heat generation
- iron-sulphur-chlorine free
- equally efficient for both edge and surface applications



### V2 Power Heavy Duty for roughest application

Ordering example: A27441150401450



**Packing unit:**  
10 pcs. per type

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

Ceramic = ceramic grain



Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
V2 POWER 115	Ceramic 40	115	22,23	13.300	A27441150401450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 115	Ceramic 60	115	22,23	13.300	A27441150601450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	Ceramic 40	125	22,23	12.200	A27441250401450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	Ceramic 60	125	22,23	12.200	A27441250601450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	Ceramic 40	178	22,23	8.500	A27441780401450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	Ceramic 60	178	22,23	8.500	A27441780601450	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 230	Ceramic 40	230	22,23	6.600	A27442300401428	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

**Properties:**

- particularly robust for edge grinding, on heat treated steels, surface scale or coated surfaces
- iron-sulphur-chlorine free

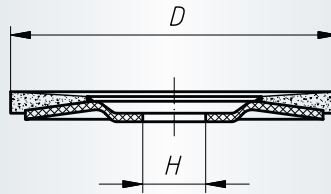
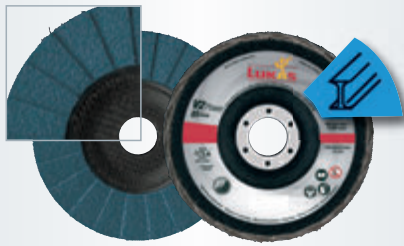




High Performance

**V2 Power Steel for universal application on steel and aluminium**

Ordering example: A27441000401465



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

ZK = Abrasive cloth with Zirconia Alum. Oxide  
ZKS = Zirconia Alum. Oxide with special coating containing active grinding additives



Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
V2 POWER 100	ZK 40	100	16	15.300	A27441000401465	1 2 3 4 5 6 7 8	■
V2 POWER 100	ZK 60	100	16	15.300	A27441000601465	1 2 3 4 5 6 7 8	■
V2 POWER 115	ZK 40	115	22,23	13.300	A27441150401465	1 2 3 4 5 6 7 8	■
V2 POWER 115	ZK 60	115	22,23	13.300	A27441150601465	1 2 3 4 5 6 7 8	■
V2 POWER 125	ZK 40	125	22,23	12.200	A27441250401465	1 2 3 4 5 6 7 8	■
V2 POWER 125	ZK 60	125	22,23	12.200	A27441250601465	1 2 3 4 5 6 7 8	■
V2 POWER 178	ZK 40	178	22,23	8.500	A27441780401465	1 2 3 4 5 6 7 8	■
V2 POWER 178	ZK 60	178	22,23	8.500	A27441780601465	1 2 3 4 5 6 7 8	■
V2 POWER 230	ZKS 40	230	22,23	6.600	A27442300401418	1 2 3 4 5 6 7 8	■

**Properties:**

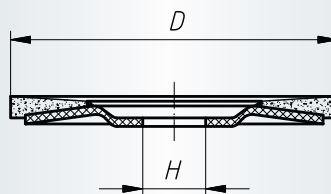
- tough grain with a high degree of resistance to pressure



High Performance

**V2 POWER ALU**

Ordering example: A27441150401434



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

SIC = Silicon carbide

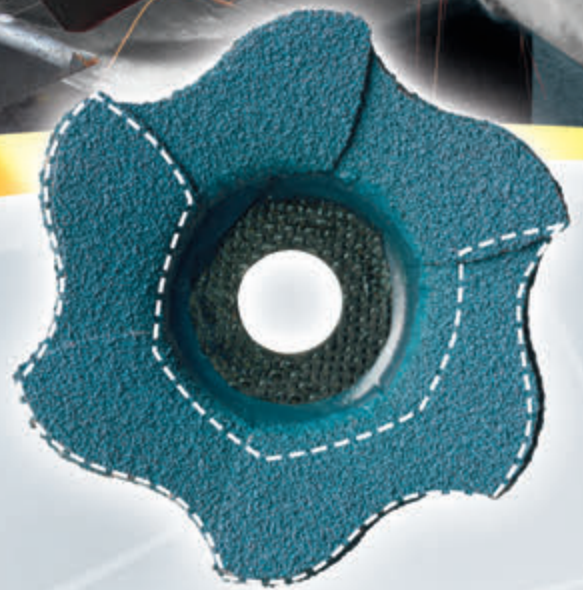


Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
V2 POWER 115	SIC 36	115	22,23	13.300	A27441150361434	6 7 8	■
V2 POWER 115	SIC 40	115	22,23	13.300	A27441150401434	6 7 8	■
V2 POWER 125	SIC 36	125	22,23	12.200	A27441250361434	6 7 8	■
V2 POWER 125	SIC 40	125	22,23	12.200	A27441250401434	6 7 8	■
V2 POWER 178	SIC 24	178	22,23	8.500	A27441780241434	6 7 8	■
V2 POWER 178	SIC 36	178	22,23	8.500	A27441780361434	6 7 8	■

**Properties:**

- silicon carbide (SIC) ideally suited for preparation and finishing of weld seams with various aluminium alloys
- Silicon carbide (SIC) ideally suited for the machining of contemporary workpiece materials such as CRP or GRP

Always the right tool



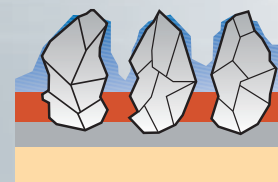
### V3 Control – see what we can do!

The V3 Control allows complete control during application.

**Ideal for:**

- finishing
- fettling
- weld seam finishing
- rust removal

**V3Control**  
**i@Series**

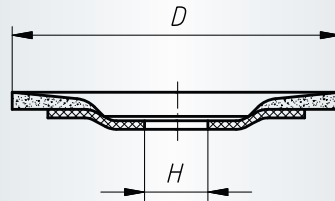
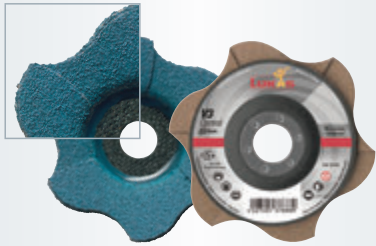


*Using a high quality coated abrasive  
(zirconia with a coating of active grinding additives)*



**V3 Control – see what needs to be done**

Ordering example: A27451150401411



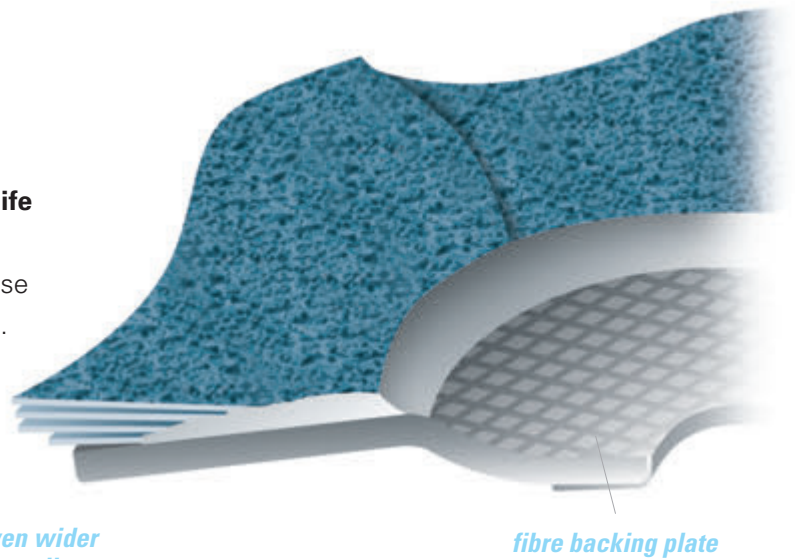
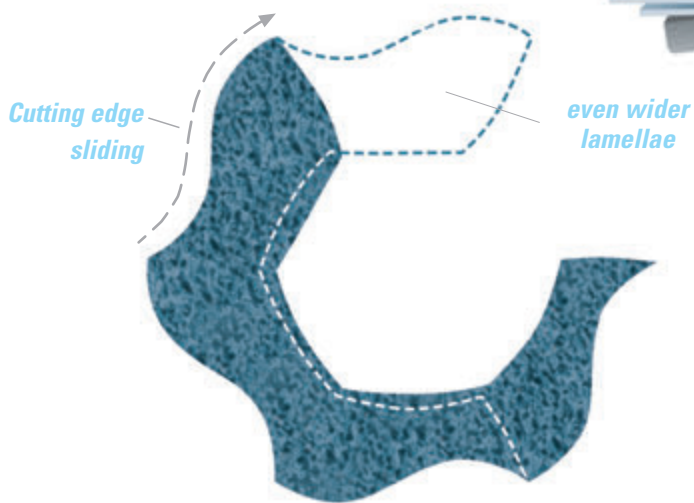
**Packing unit:**  
10 pcs. per type  
 $v_{max}$ : 80 m/s  
ZK = Zirconia Alum. Oxide



Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
V3 CONTROL 115	ZK 40	115	22,23	13.300	A27451150401411	1 2 3 4 5 6 7	■
V3 CONTROL 115	ZK 60	115	22,23	13.300	A27451150601411	1 2 3 4 5 6 7	■
V3 CONTROL 115	ZK 80	115	22,23	13.300	A27451150801411	1 2 3 4 5 6 7	■
V3 CONTROL 125	ZK 40	125	22,23	12.200	A27451250401411	1 2 3 4 5 6 7	■
V3 CONTROL 125	ZK 60	125	22,23	12.200	A27451250601411	1 2 3 4 5 6 7	■
V3 CONTROL 125	ZK 80	125	22,23	12.200	A27451250801411	1 2 3 4 5 6 7	■

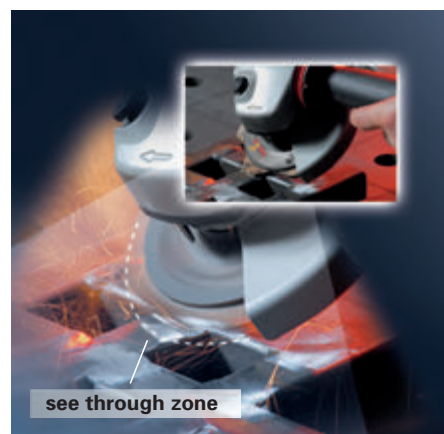
**Best stock removal rates and long tool life**

As a result of further development of this outstanding product type, an even better use of the abrasive material has been achieved.



**Safe application without snagging**

The curved geometry of the lamellae prevents snagging of the tool on the workpiece.



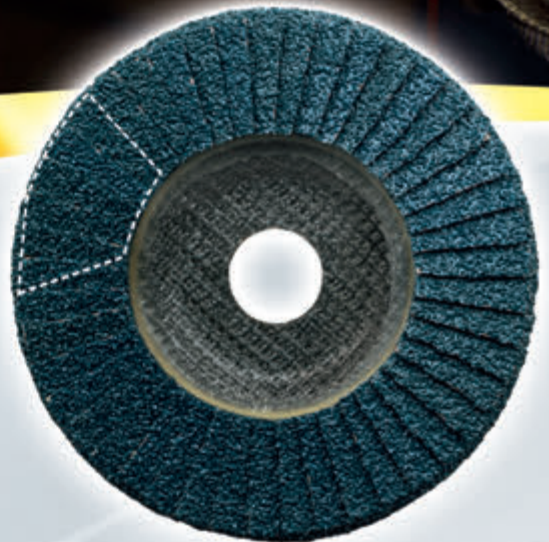
**See what we can do!** 6 laser cut abrasive flaps for exceptional stock removal.



**Always the right tool**



**New: Innovation –  
for rounding off!**



**V4 Master – extremely aggressive and durable due to patented design and configuration of flaps**

**Areas of application**

- rounding sharp edges
- removing weld seams
- treatment of thermal cuts

**V4 Master**  
**i@ Series**

**Customized for your industry:**

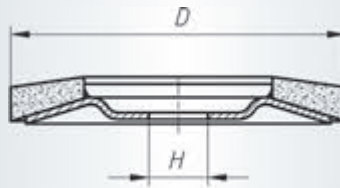
- Steel and tank construction
- Shipyards and offshore
- Machine and plant engineering



High Performance

V4 Master – Master of its class

Ordering example: A27471150401465



Packing unit:  
10 pcs. per type

$v_{max}$ : 80 m/s

ZK = Abrasive cloth with Zirconia Alum. Oxide

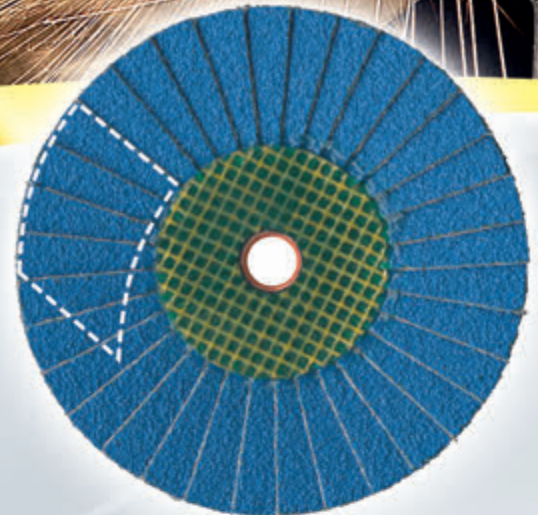
**IQ Series**

Description	Grit	D mm	Thread	n max (1/min)	Product-Number	recommended for										
V4 MASTER 115	ZK 40	115	22,23	13.300	A27471150401465	1	2	3	4		6	7			■	NEW
V4 MASTER 115	ZK 60	115	22,23	13.300	A27471150601465	1	2	3	4		6	7			■	NEW
V4 MASTER 125	ZK 40	125	22,23	12.200	A27471250401465	1	2	3	4		6	7			■	NEW
V4 MASTER 125	ZK 60	125	22,23	12.200	A27471250601465	1	2	3	4		6	7			■	NEW
V4 MASTER 178	ZK 40	178	22,23	8.500	A27471780401465	1	2	3	4		6	7			■	NEW

Characteristics:

- extreme stock removal
- deep recess around the bore
- low noise and low vibration
- good edge retention
- long tool life
- ergonomically due to less effort

Always the right tool



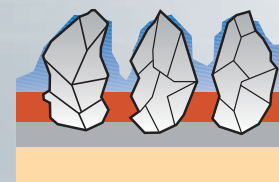
### SLTflex – for the awkward areas!

Feel the efficiency compared to conventional lamellar flap discs or fibre discs.

#### Ideal for:

- machining of fillet welds
- deburring
- fettling
- fine finishing
- rust removal

**SLTflex**  
iQ Series



Using a high quality coated abrasive  
(zirconia with a coating of active grinding additives)

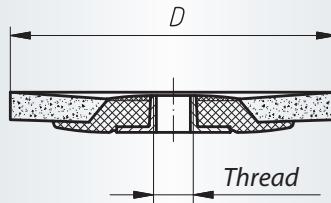




**High Performance**

## SLTfex – for radii and fillet weldings

Ordering example: A272910004018



**Packing unit:**  
10 pcs. per type

$v_{max}$ : 80 m/s

ZKS = Zirconia Alum. Oxide with special coating containing active grinding additives

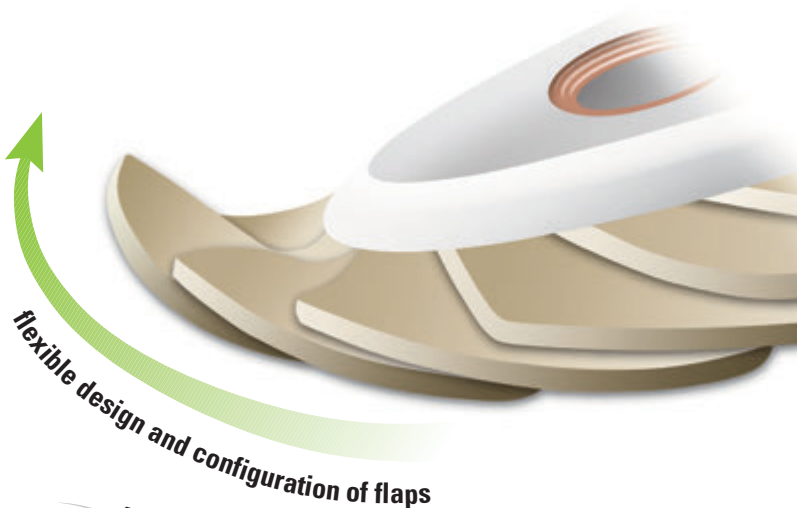
ZK = Zirconia Alum. Oxide

**IQ Series**

Description	Grits	D mm	Thread	n max (1/min)	Product-Number	recommended for	
SLTFLEX 100	ZKS 40	100	M10	15.300	A272910004018	1 2 3 4 5 6 7	■
SLTFLEX 100	ZKS 60	100	M10	15.300	A272910006018	1 2 3 4 5 6 7	■
SLTFLEX 100	ZKS 80	100	M10	15.300	A272910008018	1 2 3 4 5 6 7	■
SLTFLEX 115	ZKS 40	115	M14	13.300	A272711504018	1 2 3 4 5 6 7	■
SLTFLEX 115	ZKS 40	115	5/8"	13.300	A272811504018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 115	ZKS 60	115	M14	13.300	A272711506018	1 2 3 4 5 6 7	■
SLTFLEX 115	ZKS 60	115	5/8"	13.300	A272811506018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 115	ZK 80	115	M14	13.300	A272711508016	1 2 3 4 5 6 7	■
SLTFLEX 115	ZK 80	115	5/8"	13.300	A272811508018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 115	ZK 120	115	M14	13.300	A272711512016	1 2 3 4 5 6 7	■
SLTFLEX 115	ZK 120	115	5/8"	13.300	A272811512018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 125	ZKS 40	125	M14	12.200	A272712504018	1 2 3 4 5 6 7	■
SLTFLEX 125	ZKS 40	125	5/8"	12.200	A272812504018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 125	ZKS 60	125	M14	12.200	A272712506018	1 2 3 4 5 6 7	■
SLTFLEX 125	ZKS 60	125	5/8"	12.200	A272812506018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 125	ZK 80	125	M14	12.200	A272712508016	1 2 3 4 5 6 7	■
SLTFLEX 125	ZK 80	125	5/8"	12.200	A272812508018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 125	ZK 120	125	M14	12.200	A272712512016	1 2 3 4 5 6 7	■
SLTFLEX 125	ZK 120	125	5/8"	12.200	A272812512018	1 2 3 4 5 6 7	■ <b>NEW</b>
SLTFLEX 178	ZKS 40	178	M14	8.500	A272917804018	1 2 3 4 5 6 7	■
SLTFLEX 178	ZKS 60	178	M14	8.500	A272917806018	1 2 3 4 5 6 7	■
SLTFLEX 178	ZKS 80	178	M14	8.500	A272917808018	1 2 3 4 5 6 7	■

**Properties:**

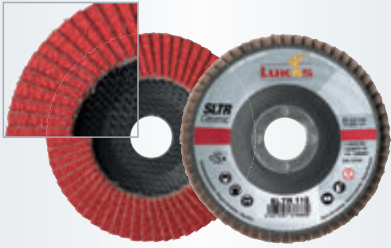
- high flexibility due to elongated flaps (no disturbing backing plate)
- simple tool change (backing plate / pad and mounting nut no longer required)
- extreme tool life

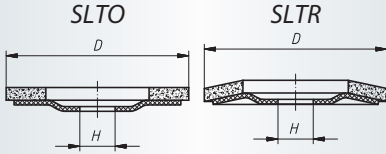




### SLTO/SLTR, the powerful performer with the glass-fibre backing plate

Ordering example: A27231150401428






**Packing unit:**  
10 pcs. per type  
v<sub>max.</sub>: 80 m/s  
ISO 15635  
Ceramic = ceramic grain  
SLTO = flat  
SLTR = dished

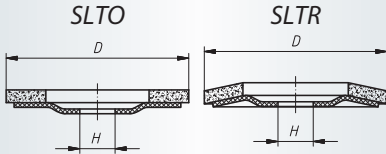
Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
SLTO 115	Ceramic 40	115	22,23	13.300	A27251150401428	1 2 3 4 5 6 7 8	■
SLTO 125	Ceramic 40	125	22,23	12.200	A27251250401428	1 2 3 4 5 6 7 8	■
SLTO 125	Ceramic 60	125	22,23	12.200	A27251250601428	1 2 3 4 5 6 7 8	■
SLTO 125	Ceramic 80	125	22,23	12.200	A27251250801428	1 2 3 4 5 6 7 8	■
SLTR 115	Ceramic 40	115	22,23	13.300	A27231150401428	1 2 3 4 5 6 7 8	■
SLTR 115	Ceramic 60	115	22,23	13.300	A27231150601428	1 2 3 4 5 6 7 8	■
SLTR 115	Ceramic 80	115	22,23	13.300	A27231150801428	1 2 3 4 5 6 7 8	■
SLTR 125	Ceramic 40	125	22,23	12.200	A27231250401428	1 2 3 4 5 6 7 8	■
SLTR 125	Ceramic 60	125	22,23	12.200	A27231250601428	1 2 3 4 5 6 7 8	■
SLTR 125	Ceramic 80	125	22,23	12.200	A27231250801428	1 2 3 4 5 6 7 8	■
SLTR 178	Ceramic 40	178	22,23	8.500	A27231780401428	1 2 3 4 5 6 7 8	■



### SLTO/SLTR, reinforced fibre backing

Ordering example: A27151000401423





**Packing unit:**  
10 pcs. per type  
v<sub>max.</sub>: 80 m/s  
ISO 15635  
ZK = Zirconia Alum. Oxide  
NK = reg. Aluminium Oxide  
SLTO = flat  
SLTR = dished

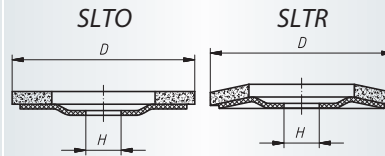
Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTO 100	ZK 40	100	16	15.300	A27151000401423	1 2 3 4 5 7	■
SLTO 100	ZK 60	100	16	15.300	A27151000601423	1 2 3 4 5 7	■
SLTO 100	ZK 80	100	16	15.300	A27151000801423	1 2 3 4 5 7	■
SLTO 115	NK 40	115	22,23	13.300	A27151150401400	1 2 3 4 5 6 7 8	■
SLTO 115	NK 60	115	22,23	13.300	A27151150601400	1 2 3 4 5 6 7 8	■
SLTO 115	NK 80	115	22,23	13.300	A27151150801400	1 2 3 4 5 6 7 8	■
SLTO 115	NK 120	115	22,23	13.300	A27151151201400	1 2 3 4 5 6 7 8	■
SLTO 115	ZK 36	115	22,23	13.300	A27151150361406	1 2 3 4 5 7	■
SLTO 115	ZK 40	115	22,23	13.300	A27151150401406	1 2 3 4 5 7	■
SLTO 115	ZK 50	115	22,23	13.300	A27151150501406	1 2 3 4 5 7	■
SLTO 115	ZK 60	115	22,23	13.300	A27151150601406	1 2 3 4 5 7	■
SLTO 115	ZK 80	115	22,23	13.300	A27151150801406	1 2 3 4 5 7	■
SLTO 115	ZK 120	115	22,23	13.300	A27151151201406	1 2 3 4 5 7	■



Industry

**SLTO/SLTR, reinforced fibre backing**

Ordering example: A27151250401400



**Packing unit:**

10 pcs. per type

v<sub>max</sub>: 80 m/s

ISO 15635

ZK = Zirconia Alum. Oxide

NK = reg. Aluminium Oxide

SLTO = flat

SLTR = dished

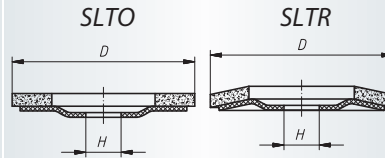
Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTO 125	NK 40	125	22,23	12.200	A27151250401400	1 2 3 4 5 6 7 8	■
SLTO 125	NK 50	125	22,23	12.200	A27151250501400	1 2 3 4 5 6 7 8	■
SLTO 125	ZK 40	125	22,23	12.200	A27151250401406	1 2 3 4 5 7	■
SLTO 125	ZK 50	125	22,23	12.200	A27151250501406	1 2 3 4 5 7	■
SLTO 125	ZK 60	125	22,23	12.200	A27151250601406	1 2 3 4 5 7	■
SLTO 125	ZK 80	125	22,23	12.200	A27151250801406	1 2 3 4 5 7	■
SLTO 178	NK 60	178	22,23	8.500	A27151780601400	1 2 3 4 5 6 7 8	■
SLTO 178	ZK 36	178	22,23	8.500	A27151780361401	1 2 3 4 5 7	■
SLTO 178	ZK 40	178	22,23	8.500	A27151780401401	1 2 3 4 5 7	■
SLTO 178	ZK 60	178	22,23	8.500	A27151780601401	1 2 3 4 5 7	■
SLTO 178	ZK 80	178	22,23	8.500	A27151780801401	1 2 3 4 5 7	■
SLTO 178	ZK 120	178	22,23	8.500	A27151781201401	1 2 3 4 5 7	■
SLTR 100	ZK 40	100	16	15.300	A27181000401423	1 2 3 4 5 7	■
SLTR 100	ZK 60	100	16	15.300	A27181000601423	1 2 3 4 5 7	■
SLTR 100	ZK 80	100	16	15.300	A27181000801423	1 2 3 4 5 7	■
SLTR 115	NK 36	115	22,23	13.300	A27181150361400	1 2 3 4 5 6 7 8	■
SLTR 115	NK 40	115	22,23	13.300	A27181150401400	1 2 3 4 5 6 7 8	■
SLTR 115	NK 60	115	22,23	13.300	A27181150601400	1 2 3 4 5 6 7 8	■
SLTR 115	NK 80	115	22,23	13.300	A27181150801400	1 2 3 4 5 6 7 8	■
SLTR 115	NK 120	115	22,23	13.300	A27181151201400	1 2 3 4 5 6 7 8	■
SLTR 115	ZK 36	115	22,23	13.300	A27181150361406	1 2 3 4 5 7	■
SLTR 115	ZK 40	115	22,23	13.300	A27181150401406	1 2 3 4 5 7	■
SLTR 115	ZK 50	115	22,23	13.300	A27181150501406	1 2 3 4 5 7	■
SLTR 115	ZK 60	115	22,23	13.300	A27181150601406	1 2 3 4 5 7	■
SLTR 115	ZK 80	115	22,23	13.300	A27181150801406	1 2 3 4 5 7	■
SLTR 115	ZK 120	115	22,23	13.300	A27181151201406	1 2 3 4 5 7	■
SLTR 125	NK 40	125	22,23	12.200	A27181250401400	1 2 3 4 5 6 7 8	■
SLTR 125	NK 60	125	22,23	12.200	A27181250601400	1 2 3 4 5 6 7 8	■
SLTR 125	NK 80	125	22,23	12.200	A27181250801400	1 2 3 4 5 6 7 8	■
SLTR 125	NK 120	125	22,23	12.200	A27181251201400	1 2 3 4 5 6 7 8	■
SLTR 125	ZK 36	125	22,23	12.200	A27181250361406	1 2 3 4 5 7	■
SLTR 125	ZK 40	125	22,23	12.200	A27181250401406	1 2 3 4 5 7	■
SLTR 125	ZK 60	125	22,23	12.200	A27181250601406	1 2 3 4 5 7	■
SLTR 125	ZK 80	125	22,23	12.200	A27181250801406	1 2 3 4 5 7	■
SLTR 125	ZK 120	125	22,23	12.200	A27181251201406	1 2 3 4 5 7	■
SLTR 150	ZK 40	150	22,23	10.200	A27181500401416	1 2 3 4 5 7	■
SLTR 150	ZK 60	150	22,23	10.200	A27181500601416	1 2 3 4 5 7	■
SLTR 150	ZK 80	150	22,23	10.200	A27181500801416	1 2 3 4 5 7	■
SLTR 178	NK 40	178	22,23	8.500	A27181780401400	1 2 3 4 5 6 7 8	■
SLTR 178	NK 60	178	22,23	8.500	A27181780601400	1 2 3 4 5 6 7 8	■





### SLTO/SLTR, reinforced fibre backing

Ordering example: A27181780801400



**Packing unit:**

10 pcs. per type

v<sub>max</sub>: 80 m/s

ISO 15635

ZK = Zirconia Alum. Oxide

NK = reg. Aluminium Oxide

SLTO = flat

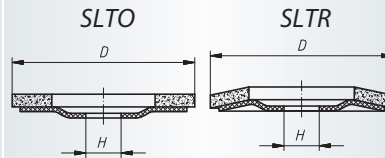
SLTR = dished

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTR 178	NK 80	178	22,23	8.500	A27181780801400	1 2 3 4 5 6 7 8	■
SLTR 178	ZK 36	178	22,23	8.500	A27181780361401	1 2 3 4 5 7	■
SLTR 178	ZK 40	178	22,23	8.500	A27181780401401	1 2 3 4 5 7	■
SLTR 178	ZK 60	178	22,23	8.500	A27181780601401	1 2 3 4 5 7	■
SLTR 178	ZK 80	178	22,23	8.500	A27181780801401	1 2 3 4 5 7	■
SLTR 178	ZK 120	178	22,23	8.500	A27181781201401	1 2 3 4 5 7	■



### SLTO/SLTR competitively priced BASE-X, reinforced fibre backing

Ordering example: A27151000401501



**Packing unit:**

10 pcs. per type

v<sub>max</sub>: 80 m/s

ISO 15635

ZK = Zirconia Alum. Oxide

SLTO = flat

SLTR = dished

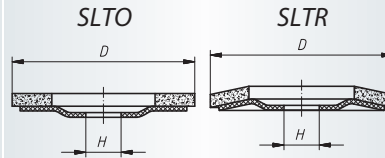
Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
<b>NEW</b> SLTO 100 BASE-X	ZK 40	100	16	15.300	A27151000401501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 100 BASE-X	ZK 60	100	16	15.300	A27151000601501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 100 BASE-X	ZK 80	100	16	15.300	A27151000801501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 100 BASE-X	ZK 120	100	16	15.300	A27151001201501	1 2 3 4 5 7	■
SLTO 115 BASE-X	ZK 40	115	22,23	13.300	A27151150401501	1 2 3 4 5 7	■
SLTO 115 BASE-X	ZK 60	115	22,23	13.300	A27151150601501	1 2 3 4 5 7	■
SLTO 115 BASE-X	ZK 80	115	22,23	13.300	A27151150801501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 115 BASE-X	ZK 120	115	22,23	13.300	A27151151201501	1 2 3 4 5 7	■
SLTO 125 BASE-X	ZK 40	125	22,23	12.200	A27151250401501	1 2 3 4 5 7	■
SLTO 125 BASE-X	ZK 60	125	22,23	12.200	A27151250601501	1 2 3 4 5 7	■
SLTO 125 BASE-X	ZK 80	125	22,23	12.200	A27151250801501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 178 BASE-X	ZK 40	178	22,23	8.500	A27151780401501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 178 BASE-X	ZK 60	178	22,23	8.500	A27151780601501	1 2 3 4 5 7	■
<b>NEW</b> SLTO 178 BASE-X	ZK 80	178	22,23	8.500	A27151780801501	1 2 3 4 5 7	■
<b>NEW</b> SLTR 100 BASE-X	ZK 40	100	16	15.300	A27181000401501	1 2 3 4 5 7	■
<b>NEW</b> SLTR 100 BASE-X	ZK 60	100	16	15.300	A27181000601501	1 2 3 4 5 7	■
<b>NEW</b> SLTR 100 BASE-X	ZK 80	100	16	15.300	A27181000801501	1 2 3 4 5 7	■



Base

**SLTO/SLTR competitively priced BASE-X, reinforced fibre backing**

Ordering example: A27181001201501



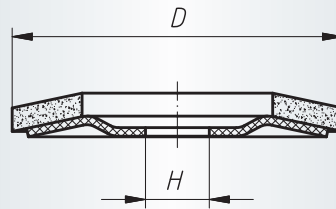
**Packing unit:**  
 10 pcs. per type  
 $v_{max}$ : 80 m/s  
 ISO 15635  
 ZK = Zirconia Alum. Oxide  
 SLTO = flat  
 SLTR = dished

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for													
SLTR 100 BASE-X	ZK 120	100	16	15.300	A27181001201501	1	2	3	4	5	7							■	NEW
SLTR 115 BASE-X	ZK 40	115	22,23	13.300	A27181150401501	1	2	3	4	5	7							■	
SLTR 115 BASE-X	ZK 60	115	22,23	13.300	A27181150601501	1	2	3	4	5	7							■	
SLTR 115 BASE-X	ZK 80	115	22,23	13.300	A27181150801501	1	2	3	4	5	7							■	
SLTR 115 BASE-X	ZK 100	115	22,23	13.300	A27181151001501	1	2	3	4	5	7							■	NEW
SLTR 125 BASE-X	ZK 40	125	22,23	12.200	A27181250401501	1	2	3	4	5	7							■	
SLTR 125 BASE-X	ZK 60	125	22,23	12.200	A27181250601501	1	2	3	4	5	7							■	
SLTR 125 BASE-X	ZK 80	125	22,23	12.200	A27181250801501	1	2	3	4	5	7							■	
SLTR 178 BASE-X	ZK 40	178	22,23	8.500	A27181780401501	1	2	3	4	5	7							■	NEW
SLTR 178 BASE-X	ZK 60	178	22,23	8.500	A27181780601501	1	2	3	4	5	7							■	NEW
SLTR 178 BASE-X	ZK 80	178	22,23	8.500	A27181780801501	1	2	3	4	5	7							■	NEW
SLTR 178 BASE-X	ZK 120	178	22,23	8.500	A27181781201501	1	2	3	4	5	7							■	NEW



### The SLTZ, with special active grinding additives

Ordering example: A27261150401418



**Packing unit:**

10 pcs. per type

$v_{max}$ : 80 m/s

ISO 15635

ZKS = Zirconia Alum. Oxide  
with special coating containing active grinding additives

SLTZ = dished

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTZ 115	ZKS 40	115	22,23	13.300	A27261150401418	2 3 4 5 7	■
SLTZ 115	ZKS 60	115	22,23	13.300	A27261150601418	2 3 4 5 7	■
SLTZ 115	ZKS 80	115	22,23	13.300	A27261150801418	2 3 4 5 7	■
SLTZ 125	ZKS 40	125	22,23	12.200	A27261250401418	2 3 4 5 7	■
SLTZ 125	ZKS 60	125	22,23	12.200	A27261250601418	2 3 4 5 7	■
SLTZ 125	ZKS 80	125	22,23	12.200	A27261250801418	2 3 4 5 7	■

**Properties:**

- high quality coated abrasive containing special active grinding additives
- top grinding performance
- outstanding tool life

**Applicaton:**

- shipbuilding
- steel construction work
- stainless steel
- and many other applications

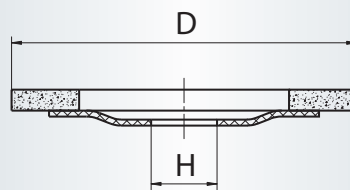
**Characteristics:**

- suitable for most materials
- can be used for deburring, fettling, derusting and finishing



### The SLTS, with flexible flaps

Ordering example: A27391150401423



**Packing unit:**

10 pcs. per type

$v_{max}$ : 80 m/s

ZK = Zirconia Alum. Oxide

SLTS = flat

Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
SLTS 115	ZK 40	115	22,23	13.300	A27391150401423	1 2 3 4 5 7	■
SLTS 115	ZK 60	115	22,23	13.300	A27391150601423	1 2 3 4 5 7	■
SLTS 115	ZK 80	115	22,23	13.300	A27391150801423	1 2 3 4 5 7	■
SLTS 125	ZK 40	125	22,23	12.200	A27391250401423	1 2 3 4 5 7	■
SLTS 125	ZK 60	125	22,23	12.200	A27391250601423	1 2 3 4 5 7	■
SLTS 125	ZK 80	125	22,23	12.200	A27391250801423	1 2 3 4 5 7	■

Due to the flexible flap configuration, the SLTS has a universal application particularly where a "soft" grinding action is required to avoid damage to the

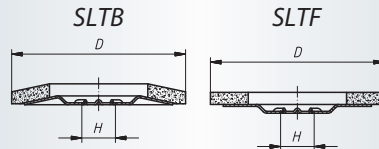
workpiece. The SLTS is used on similar applications which require a fibre discs; in addition, it is ideally suited to grind radii or corners.



Industry

The robust, with steel backing

Ordering example: A2250115120



**Packing unit:**

10 pcs. per type

v<sub>max</sub>: 80 m/s

ISO 15635

ZK = Zirconia Alum. Oxide

NK = reg. Aluminium Oxide

SLTF = flat

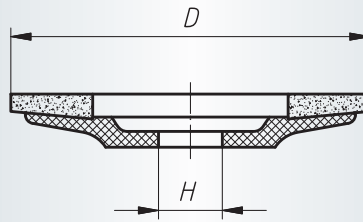
SLTB = dished

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for													
SLTB 115	ZK 36	115	22,23	13.300	A2250115030	1	2	3	4	5		7							■
SLTB 115	ZK 40	115	22,23	13.300	A2250115040	1	2	3	4	5		7						■	
SLTB 115	ZK 50	115	22,23	13.300	A2250115050	1	2	3	4	5		7						■	
SLTB 115	ZK 60	115	22,23	13.300	A2250115060	1	2	3	4	5		7						■	
SLTB 115	ZK 80	115	22,23	13.300	A2250115080	1	2	3	4	5		7						■	
SLTB 115	NK 120	115	22,23	13.300	A2250115120	1	2	3	4	5	6	7	8					■	
SLTB 125	ZK 40	125	22,23	12.200	A2250125040	1	2	3	4	5		7						■	
SLTB 125	ZK 60	125	22,23	12.200	A2250125060	1	2	3	4	5		7						■	
SLTB 125	ZK 80	125	22,23	12.200	A2250125080	1	2	3	4	5		7						■	
SLTB 178	ZK 40	178	22,23	8.500	A2250178040	1	2	3	4	5		7						■	
SLTB 178	ZK 60	178	22,23	8.500	A2250178060	1	2	3	4	5		7						■	
SLTB 178	ZK 80	178	22,23	8.500	A2250178080	1	2	3	4	5		7						■	
SLTF 115	ZK 40	115	22,23	13.300	A2251115040	1	2	3	4	5		7						■	
SLTF 115	ZK 60	115	22,23	13.300	A2251115060	1	2	3	4	5		7						■	
SLTF 115	ZK 80	115	22,23	13.300	A2251115080	1	2	3	4	5		7						■	
SLTF 115	NK 120	115	22,23	13.300	A2251115120	1	2	3	4	5	6	7	8					■	
SLTF 125	ZK 40	125	22,23	12.200	A2251125040	1	2	3	4	5		7						■	
SLTF 125	ZK 60	125	22,23	12.200	A2251125060	1	2	3	4	5		7						■	
SLTF 125	ZK 80	125	22,23	12.200	A2251125080	1	2	3	4	5		7						■	
SLTF 178	ZK 40	178	22,23	8.500	A2251178040	1	2	3	4	5		7						■	
SLTF 178	ZK 60	178	22,23	8.500	A2251178060	1	2	3	4	5		7						■	



## The SLTK, with plastic backing

Ordering example: A27111150401623



**Packing unit:**

10 pcs. per type

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

ISO 15635

ZK = Zirconia Alum. Oxide

SLTK = flat

Description	Grits	D mm	H mm	$n_{max}$ (1/min)	Product-Number	recommended for										
SLTK 115	ZK 40	115	22,23	13.300	A27111150401623	1	2	3	4	5	7					■
SLTK 115	ZK 60	115	22,23	13.300	A27111150601623	1	2	3	4	5	7					■
SLTK 115	ZK 80	115	22,23	13.300	A27111150801623	1	2	3	4	5	7					■
SLTK 115	ZK 120	115	22,23	13.300	A27111151201623	1	2	3	4	5	7					■
SLTK 125	ZK 40	125	22,23	12.200	A27111250401623	1	2	3	4	5	7					■
SLTK 125	ZK 60	125	22,23	12.200	A27111250601623	1	2	3	4	5	7					■
SLTK 125	ZK 80	125	22,23	12.200	A27111250801623	1	2	3	4	5	7					■
SLTK 178	ZK 40	178	22,23	8.500	A27111780401623	1	2	3	4	5	7					■
SLTK 178	ZK 60	178	22,23	8.500	A27111780601623	1	2	3	4	5	7					■

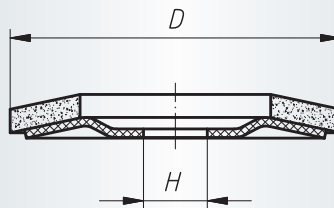
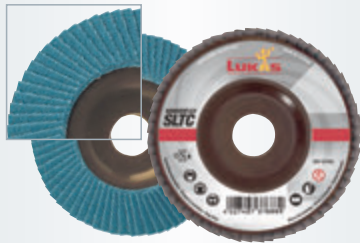




**High Performance**

**The NAWAROFLEX® with the backing plate made of renewable raw materials**

Ordering example: A27031150360127



**Packing unit:**

10 pcs. per type

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

ISO 15635

ZKS = Zirconia Alum. Oxide  
with special coating containing active grinding additives

SLTC = dished

Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
SLTC 115	ZKS 36	115	22,23	13.300	A27031150360127	2 3 4 5 7	■
SLTC 115	ZKS 40	115	22,23	13.300	A27031150400127	2 3 4 5 7	■
SLTC 115	ZKS 50	115	22,23	13.300	A27031150500127	2 3 4 5 7	■
SLTC 115	ZKS 60	115	22,23	13.300	A27031150600127	2 3 4 5 7	■
SLTC 115	ZKS 80	115	22,23	13.300	A27031150800127	2 3 4 5 7	■
SLTC 125	ZKS 40	125	22,23	12.200	A27031250400127	2 3 4 5 7	■
SLTC 125	ZKS 60	125	22,23	12.200	A27031250600127	2 3 4 5 7	■
SLTC 125	ZKS 80	125	22,23	12.200	A27031250800127	2 3 4 5 7	■

Type with special zirconia alum. oxide material (polyester based) and a coating of active grinding additives.

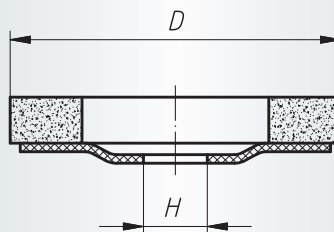
Ideally suited for stainless steel.



**Industry**

**The NAWAROFLEX® – to improve surface finish**

Ordering example: A27131151040140



**Packing unit:**

10 pcs. per type

$v_{max.}$ : 30 m/s

ISO 15635

A = Abrasive fleece/abrasive cloth combined Al.-Oxide

C = Abrasive fleece/abrasive cloth combined Sil.-Carbide

SLTM = flat

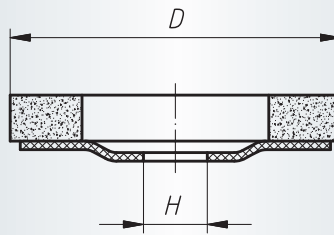
Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
SLTM 115	A 104/80	115	22,23	4.900	A27131151040140	1 2 3 4 5 6 7 8	■
SLTM 115	A 106/150	115	22,23	4.900	A27131151060140	1 2 3 4 5 6 7 8	■
SLTM 115	A 107/240	115	22,23	4.900	A27131151070140	1 2 3 4 5 6 7 8	■
SLTM 115	C 204/80	115	22,23	4.900	A27131152040141	1 2 3 4 5 6 7 8 9	■
SLTM 115	C 206/150	115	22,23	4.900	A27131152060141	1 2 3 4 5 6 7 8 9	■
SLTM 115	C 207/240	115	22,23	4.900	A27131152070141	1 2 3 4 5 6 7 8 9	■

Usable without supporting-plate on adjustable and slow-speed angle grinders.



### The NAWAROFLEX® – for finishing and polishing

Ordering example: A27221151040130



**Packing unit:**

10 pcs. per type

$v_{max}$ : 30 m/s

A = Abrasive fleece cloth combined

Al.-Oxide

C = Abrasive fleece cloth combined Sil.-Carbide

SLTV = flat

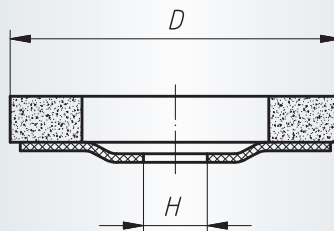
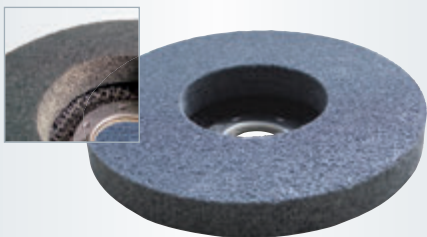
Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
SLTV 115	A 104	115	22,23	4.900	A27221151040130	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTV 115	A 106	115	22,23	4.900	A27221151060130	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTV 115	A 107	115	22,23	4.900	A27221151070130	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTV 115	C 206	115	22,23	4.900	A27221152060130	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SLTV 115	C 207	115	22,23	4.900	A27221152070130	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

Usable without supporting-plate on adjustable and slow-speed angle grinders.



### The SLTP , Polishing disc

Ordering example: A271611523



**Packing unit:**

5 pcs. per type

$v_{max}$ : 50 m/s

SLTP = dished

Description	Quality	D mm	H mm	reinforced hartness	n max. (1/min)	Product-Number	recommended for	
SLTP 115 M	SIC fine	115	22,23	medium	8.350	A271611523	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTP 115 W	SIC fine	115	22,23	soft	8.350	A271611513	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

Ideal for working on stainless steel, aluminium and other non ferrous metals.

With the SLTP deburring, cleaning and polishing applications could be accomplished.

The fleece fibre construction avoids the clogging of this tool.

The high tool life and the less edge abrasion enhance the efficiency.

Usable without supporting-plate on adjustable and slow-speed angle grinders.

# Mounted flap wheels of abrasive cloth

**222** Qualities and Applications

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**252** General Information

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**253** Mounted flap wheels of abrasive cloth, recessed

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**253** Mounted flap wheels of abrasive cloth

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**260** Mounted flap wheels of abrasive cloth, slotted

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**261** Mounted flap wheels of abrasive cloth, SFE

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**262** Mounted flap wheels of abrasive cloth, SFC

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**263** Mounted flap wheels with internal thread

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**264** Mounted flap wheels with threaded shank

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**265** Mini-Flap wheels of abrasive cloth

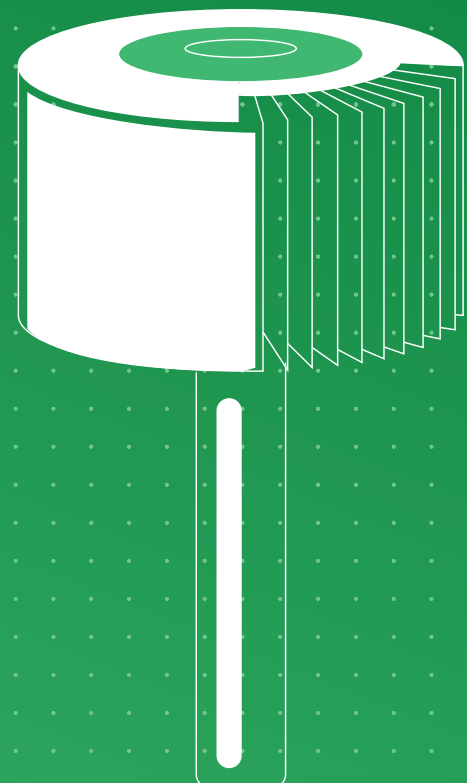
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**373** Air tools

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## Product line marking

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



## Information

### **SFL, mounted flap wheels of abrasive cloth**

These tools consist of individual flaps radially located around the hub of the tool; they are mainly used in hand-held power tools.

We offer our coated abrasive flap wheels in various qualities i.e. NK, NKE and SIC.

#### **Examples of application:**

- finishing
- derusting
- fettling
- deburring
- surface grinding
- decorative finishing
- bevelling

### **SFB, Mounted flap wheels of abrasive cloth, slotted**

By slotting the lamellas on the periphery, the flexibility of this type of mounted flap wheel is increased. The slotted flap wheel quickly profiles itself to the contour of the workpiece.

### **SFT, Mounted flap wheels of abrasive cloth, recessed**

These tools are suitable for face and peripheral grinding.

### **Adaptor for SFI and SFA**

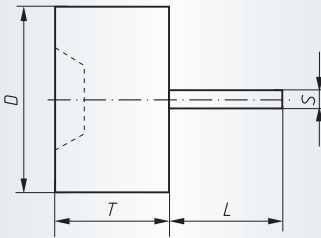
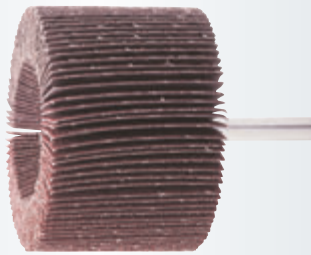
These adaptors extend the shank length and optimise down-time. Tool change is made without removing the adaptor from the machine.



High Performance

SFT, Flap wheels – recessed

Ordering example: A3100040306060



**Packing unit:**

10 pcs. per type

Further dimensions, qualities

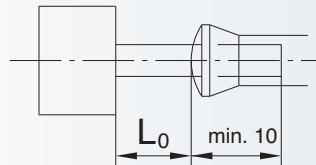
and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFT 04030.06	NK 60	40	30	6	40	12.000	18.000	A3100040306060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFT 04030.06	NK 80	40	30	6	40	12.000	18.000	A3100040306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFT 04030.06	NK 150	40	30	6	40	12.000	18.000	A3100040306150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFT 06040.06	NK 60	60	40	6	40	8.000	8.500	A3100060406060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFT 06040.06	NK 80	60	40	6	40	8.000	8.500	A3100060406080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFT 06040.06	NK 150	60	40	6	40	8.000	8.500	A3100060406150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

The stated maximum operating speed only applies to a maximum overhang

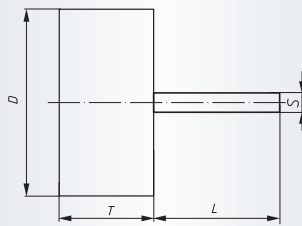
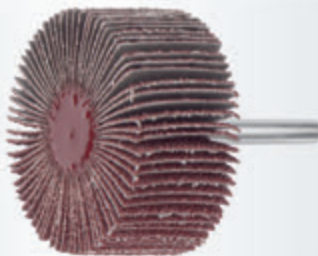
$L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



Industry

SFL, Flap wheels

Ordering example: A2200010103080



**Packing unit:**

10 pcs. per type

Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 01010.03	NK 80	10	10	3	40	26.000	35.000	A2200010103080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01010.03	NK 120	10	10	3	40	26.000	35.000	A2200010103120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01010.03	NK 150	10	10	3	40	26.000	35.000	A2200010103150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01010.03	NK 240	10	10	3	40	26.000	35.000	A2200010103240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01015.03	NK 80	10	15	3	40	24.000	35.000	A2200010153080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01510.03	NK 80	15	10	3	40	24.000	35.000	A2200015103080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01510.03	NK 150	15	10	3	40	24.000	35.000	A2200015103150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01515.03	NK 80	15	15	3	40	24.000	35.000	A2200015153080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01515.03	NK 120	15	15	3	40	24.000	35.000	A2200015153120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 01515.03	NK 150	15	15	3	40	24.000	35.000	A2200015153150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 02005.06	NK 120	20	5	6	40	20.000	28.000	A2200020056120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 02010.03	NK 80	20	10	3	40	20.000	28.000	A2200020103080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

NEW

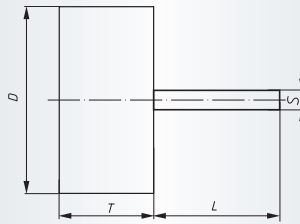
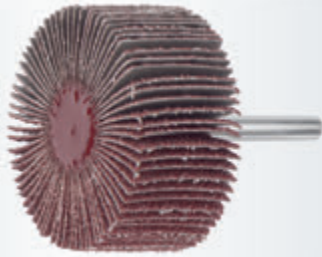
# 254 Mounted flap wheels of abrasive cloth



Industry

## SFL, Flap wheels

Ordering example: A2200020103120



**Packing unit:**

10 pcs. per type

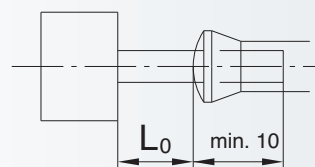
Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 02010.03	NK 120	20	10	3	40	20.000	28.000	A2200020103120	1 2 3 4 5 6 7 8	■
SFL 02010.03	NK 150	20	10	3	40	20.000	28.000	A2200020103150	1 2 3 4 5 6 7 8	■
SFL 02010.03	NK 320	20	10	3	40	20.000	28.000	A2200020103320	1 2 3 4 5 6 7 8	■
SFL 02010.06	NK 80	20	10	6	40	20.000	28.000	A2200020106080	1 2 3 4 5 6 7 8	■
SFL 02010.06	NK 120	20	10	6	40	20.000	28.000	A2200020106120	1 2 3 4 5 6 7 8	■
SFL 02015.06	NK 60	20	15	6	40	20.000	28.000	A2200020156060	1 2 3 4 5 6 7 8	■
SFL 02015.06	NK 80	20	15	6	40	20.000	28.000	A2200020156080	1 2 3 4 5 6 7 8	■
SFL 02015.06	NK 120	20	15	6	40	20.000	28.000	A2200020156120	1 2 3 4 5 6 7 8	■
SFL 02015.06	NK 150	20	15	6	40	20.000	28.000	A2200020156150	1 2 3 4 5 6 7 8	■
SFL 02015.06	NK 240	20	15	6	40	20.000	28.000	A2200020156240	1 2 3 4 5 6 7 8	■
<b>NEW</b> SFL 02020.06	NK 80	20	20	6	40	20.000	28.000	A2200020206080	1 2 3 4 5 6 7 8	■
SFL 02505.03	NK 120	25	5	3	40	16.000	18.000	A2200025053120	1 2 3 4 5 6 7 8	■
SFL 02510.03	NK 80	25	10	3	40	16.000	18.000	A2200025103080	1 2 3 4 5 6 7 8	■
SFL 02510.03	NK 120	25	10	3	40	16.000	18.000	A2200025103120	1 2 3 4 5 6 7 8	■
SFL 02510.03	NK 150	25	10	3	40	16.000	18.000	A2200025103150	1 2 3 4 5 6 7 8	■
<b>NEW</b> SFL 02510.06	NK 80	25	10	6	40	16.000	18.000	A2200025106080	1 2 3 4 5 6 7 8	■
<b>NEW</b> SFL 02510.06	NK 120	25	10	6	40	16.000	18.000	A2200025106120	1 2 3 4 5 6 7 8	■
SFL 02515.06	NK 80	25	15	6	40	16.000	18.000	A2200025156080	1 2 3 4 5 6 7 8	■
SFL 02515.06	NK 120	25	15	6	40	16.000	18.000	A2200025156120	1 2 3 4 5 6 7 8	■
SFL 02515.06	NK 150	25	15	6	40	16.000	18.000	A2200025156150	1 2 3 4 5 6 7 8	■
<b>NEW</b> SFL 02520.06	NK 80	25	20	6	40	16.000	18.000	A2200025206080	1 2 3 4 5 6 7 8	■
<b>NEW</b> SFL 02520.06	NK 120	25	20	6	40	16.000	18.000	A2200025206120	1 2 3 4 5 6 7 8	■
SFL 02525.06	NK 80	25	25	6	40	16.000	18.000	A2200025256080	1 2 3 4 5 6 7 8	■
SFL 02525.06	NK 150	25	25	6	40	16.000	18.000	A2200025256150	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 60	30	5	3	40	16.000	18.000	A2200030053060	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 80	30	5	3	40	16.000	18.000	A2200030053080	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 120	30	5	3	40	16.000	18.000	A2200030053120	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 150	30	5	3	40	16.000	18.000	A2200030053150	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 240	30	5	3	40	16.000	18.000	A2200030053240	1 2 3 4 5 6 7 8	■
SFL 03005.03	NK 320	30	5	3	40	16.000	18.000	A2200030053320	1 2 3 4 5 6 7 8	■
SFL 03005.06	NK 60	30	5	6	40	16.000	18.000	A2200030056060	1 2 3 4 5 6 7 8	■
SFL 03005.06	NK 80	30	5	6	40	16.000	18.000	A2200030056080	1 2 3 4 5 6 7 8	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

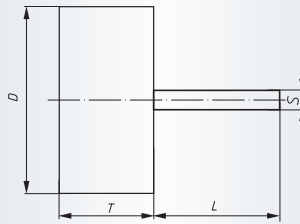
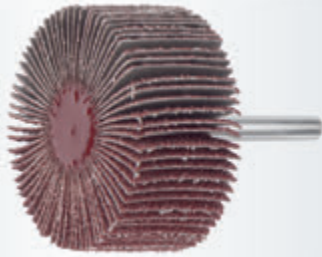




Industry

## SFL, Flap wheels

Ordering example: A2200030056120



**Packing unit:**

10 pcs. per type

Further dimensions, qualities

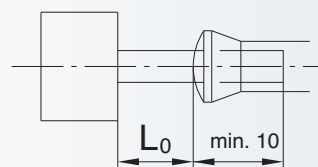
and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 03005.06	NK 120	30	5	6	40	16.000	18.000	A2200030056120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03005.06	NK 150	30	5	6	40	16.000	18.000	A2200030056150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03005.06	NK 240	30	5	6	40	16.000	18.000	A2200030056240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03005.06	NK 320	30	5	6	40	16.000	18.000	A2200030056320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 60	30	10	3	40	16.000	18.000	A2200030103060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 80	30	10	3	40	16.000	18.000	A2200030103080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 120	30	10	3	40	16.000	18.000	A2200030103120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 150	30	10	3	40	16.000	18.000	A2200030103150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 240	30	10	3	40	16.000	18.000	A2200030103240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 320	30	10	3	40	16.000	18.000	A2200030103320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 60	30	10	6	40	16.000	18.000	A2200030106060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 80	30	10	6	40	16.000	18.000	A2200030106080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 120	30	10	6	40	16.000	18.000	A2200030106120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 150	30	10	6	40	16.000	18.000	A2200030106150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 240	30	10	6	40	16.000	18.000	A2200030106240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.06	NK 320	30	10	6	40	16.000	18.000	A2200030106320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03015.06	NK 60	30	15	6	40	16.000	18.000	A2200030156060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03015.06	NK 80	30	15	6	40	16.000	18.000	A2200030156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03015.06	NK 120	30	15	6	40	16.000	18.000	A2200030156120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03015.06	NK 150	30	15	6	40	16.000	18.000	A2200030156150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03020.06	NK 40	30	20	6	40	16.000	18.000	A2200030206040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03020.06	NK 60	30	20	6	40	16.000	18.000	A2200030206060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03020.06	NK 80	30	20	6	40	16.000	18.000	A2200030206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03020.06	NK 120	30	20	6	40	16.000	18.000	A2200030206120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.03	NK 60	40	10	3	40	12.000	18.000	A2200040103060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.03	NK 80	40	10	3	40	12.000	18.000	A2200040103080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.03	NK 120	40	10	3	40	12.000	18.000	A2200040103120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.03	NK 150	40	10	3	40	12.000	18.000	A2200040103150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.06	NK 60	40	10	6	40	12.000	18.000	A2200040106060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.06	NK 80	40	10	6	40	12.000	18.000	A2200040106080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.06	NK 120	40	10	6	40	12.000	18.000	A2200040106120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.06	NK 150	40	10	6	40	12.000	18.000	A2200040106150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

NEW

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



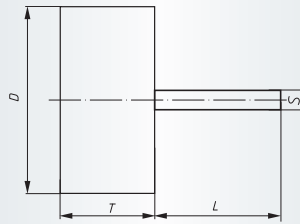
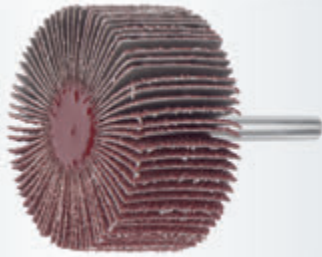
# 256 Mounted flap wheels of abrasive cloth



Industry

## SFL, Flap wheels

Ordering example: A2200040106240



**Packing unit:**

10 pcs. per type

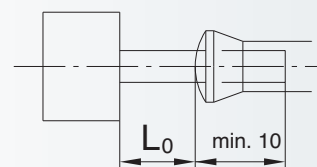
Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 04010.06	NK 240	40	10	6	40	12.000	18.000	A2200040106240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04010.06	NK 320	40	10	6	40	12.000	18.000	A2200040106320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 40	40	15	6	40	12.000	18.000	A2200040156040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 60	40	15	6	40	12.000	18.000	A2200040156060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 80	40	15	6	40	12.000	18.000	A2200040156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 120	40	15	6	40	12.000	18.000	A2200040156120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 150	40	15	6	40	12.000	18.000	A2200040156150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 240	40	15	6	40	12.000	18.000	A2200040156240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04015.06	NK 320	40	15	6	40	12.000	18.000	A2200040156320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 40	40	20	6	40	12.000	18.000	A2200040206040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 60	40	20	6	40	12.000	18.000	A2200040206060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 80	40	20	6	40	12.000	18.000	A2200040206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 120	40	20	6	40	12.000	18.000	A2200040206120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 150	40	20	6	40	12.000	18.000	A2200040206150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 240	40	20	6	40	12.000	18.000	A2200040206240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 320	40	20	6	40	12.000	18.000	A2200040206320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> SFL 04030.06	NK 40	40	30	6	40	12.000	18.000	A2200040306040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> SFL 04030.06	NK 60	40	30	6	40	12.000	18.000	A2200040306060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> SFL 04030.06	NK 80	40	30	6	40	12.000	18.000	A2200040306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05010.06	NK 60	50	10	6	40	9.000	12.000	A2200050106060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05010.06	NK 80	50	10	6	40	9.000	12.000	A2200050106080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05010.06	NK 120	50	10	6	40	9.000	12.000	A2200050106120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05010.06	NK 150	50	10	6	40	9.000	12.000	A2200050106150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05010.06	NK 240	50	10	6	40	9.000	12.000	A2200050106240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 40	50	15	6	40	9.000	12.000	A2200050156040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 60	50	15	6	40	9.000	12.000	A2200050156060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 80	50	15	6	40	9.000	12.000	A2200050156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 120	50	15	6	40	9.000	12.000	A2200050156120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 150	50	15	6	40	9.000	12.000	A2200050156150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 240	50	15	6	40	9.000	12.000	A2200050156240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05015.06	NK 320	50	15	6	40	9.000	12.000	A2200050156320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 05020.06	NK 40	50	20	6	40	9.000	12.000	A2200050206040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



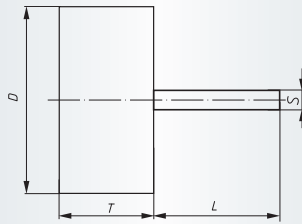
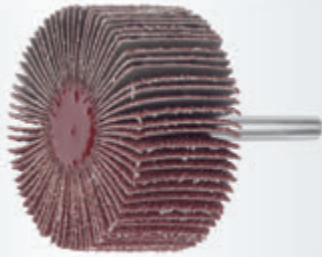




Industry

## SFL, Flap wheels

Ordering example: A2200050206060



**Packing unit:**

10 pcs. per type

Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

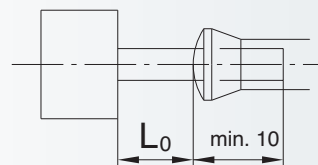
Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 05020.06	NK 60	50	20	6	40	9.000	12.000	A2200050206060	1 2 3 4 5 6 7 8	■
SFL 05020.06	NK 80	50	20	6	40	9.000	12.000	A2200050206080	1 2 3 4 5 6 7 8	■
SFL 05020.06	NK 120	50	20	6	40	9.000	12.000	A2200050206120	1 2 3 4 5 6 7 8	■
SFL 05020.06	NK 150	50	20	6	40	9.000	12.000	A2200050206150	1 2 3 4 5 6 7 8	■
SFL 05020.06	NK 240	50	20	6	40	9.000	12.000	A2200050206240	1 2 3 4 5 6 7 8	■
SFL 05020.06	NK 320	50	20	6	40	9.000	12.000	A2200050206320	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 40	50	30	6	40	9.000	12.000	A2200050306040	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 60	50	30	6	40	9.000	12.000	A2200050306060	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 80	50	30	6	40	9.000	12.000	A2200050306080	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 120	50	30	6	40	9.000	12.000	A2200050306120	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 150	50	30	6	40	9.000	12.000	A2200050306150	1 2 3 4 5 6 7 8	■
SFL 05030.06	NK 320	50	30	6	40	9.000	12.000	A2200050306320	1 2 3 4 5 6 7 8	■
SFL 06010.06	NK 60	60	10	6	40	8.000	12.000	A2200060106060	1 2 3 4 5 6 7 8	■
SFL 06010.06	NK 80	60	10	6	40	8.000	12.000	A2200060106080	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 40	60	15	6	40	8.000	12.000	A2200060156040	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 60	60	15	6	40	8.000	12.000	A2200060156060	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 80	60	15	6	40	8.000	12.000	A2200060156080	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 120	60	15	6	40	8.000	12.000	A2200060156120	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 150	60	15	6	40	8.000	12.000	A2200060156150	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 240	60	15	6	40	8.000	12.000	A2200060156240	1 2 3 4 5 6 7 8	■
SFL 06015.06	NK 320	60	15	6	40	8.000	12.000	A2200060156320	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 40	60	20	6	40	8.000	12.000	A2200060206040	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 60	60	20	6	40	8.000	12.000	A2200060206060	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 80	60	20	6	40	8.000	12.000	A2200060206080	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 120	60	20	6	40	8.000	12.000	A2200060206120	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 150	60	20	6	40	8.000	12.000	A2200060206150	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 240	60	20	6	40	8.000	12.000	A2200060206240	1 2 3 4 5 6 7 8	■
SFL 06020.06	NK 320	60	20	6	40	8.000	12.000	A2200060206320	1 2 3 4 5 6 7 8	■
SFL 06030.06	NK 40	60	30	6	40	8.000	12.000	A2200060306040	1 2 3 4 5 6 7 8	■
SFL 06030.06	NK 60	60	30	6	40	8.000	12.000	A2200060306060	1 2 3 4 5 6 7 8	■
SFL 06030.06	NK 80	60	30	6	40	8.000	12.000	A2200060306080	1 2 3 4 5 6 7 8	■
SFL 06030.06	NK 120	60	30	6	40	8.000	12.000	A2200060306120	1 2 3 4 5 6 7 8	■

NEW

NEW

NEW

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



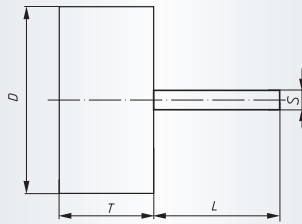
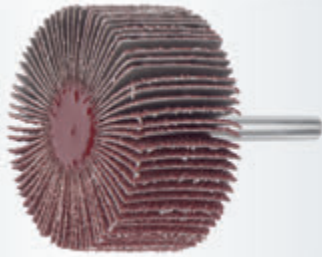
# 258 Mounted flap wheels of abrasive cloth



Industry

## SFL, Flap wheels

Ordering example: A2200060306150



**Packing unit:**

10 pcs. per type

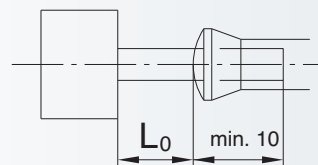
Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 06030.06	NK 150	60	30	6	40	8.000	12.000	A2200060306150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 240	60	30	6	40	8.000	12.000	A2200060306240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 320	60	30	6	40	8.000	12.000	A2200060306320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 40	60	40	6	40	8.000	12.000	A2200060406040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 60	60	40	6	40	8.000	12.000	A2200060406060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 80	60	40	6	40	8.000	12.000	A2200060406080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 120	60	40	6	40	8.000	12.000	A2200060406120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 150	60	40	6	40	8.000	12.000	A2200060406150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 240	60	40	6	40	8.000	12.000	A2200060406240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06040.06	NK 320	60	40	6	40	8.000	12.000	A2200060406320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> SFL 06050.06	NK 40	60	50	6	40	8.000	8.500	A2200060506040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06050.06	NK 60	60	50	6	40	8.000	8.500	A2200060506060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06050.06	NK 80	60	50	6	40	8.000	8.500	A2200060506080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06050.06	NK 120	60	50	6	40	8.000	8.500	A2200060506120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06050.06	NK 150	60	50	6	40	8.000	8.500	A2200060506150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06050.06	NK 240	60	50	6	40	8.000	8.500	A2200060506240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 60	80	15	6	40	6.000	9.000	A2200080156060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 80	80	15	6	40	6.000	9.000	A2200080156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 120	80	15	6	40	6.000	9.000	A2200080156120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 150	80	15	6	40	6.000	9.000	A2200080156150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 240	80	15	6	40	6.000	9.000	A2200080156240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08015.06	NK 320	80	15	6	40	6.000	9.000	A2200080156320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08020.06	NK 60	80	20	6	40	6.000	9.000	A2200080206060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08020.06	NK 80	80	20	6	40	6.000	9.000	A2200080206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08020.06	NK 120	80	20	6	40	6.000	9.000	A2200080206120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08020.06	NK 150	80	20	6	40	6.000	9.000	A2200080206150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 40	80	30	6	40	6.000	9.000	A2200080306040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 60	80	30	6	40	6.000	9.000	A2200080306060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 80	80	30	6	40	6.000	9.000	A2200080306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 120	80	30	6	40	6.000	9.000	A2200080306120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 150	80	30	6	40	6.000	9.000	A2200080306150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08030.06	NK 320	80	30	6	40	6.000	9.000	A2200080306320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

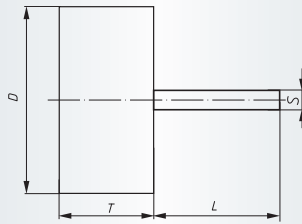
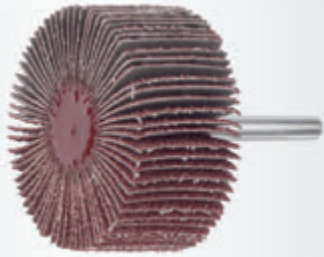
The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.





SFL, Flap wheels

Ordering example: A2200080406060



**Packing unit:**

10 pcs. per type

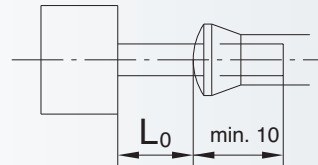
Further dimensions, qualities

and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 08040.06	NK 60	80	40	6	40	6.000	9.000	A2200080406060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08040.06	NK 80	80	40	6	40	6.000	9.000	A2200080406080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08040.06	NK 150	80	40	6	40	6.000	9.000	A2200080406150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 40	80	50	6	40	6.000	7.500	A2200080506040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 60	80	50	6	40	6.000	7.500	A2200080506060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 80	80	50	6	40	6.000	7.500	A2200080506080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 120	80	50	6	40	6.000	7.500	A2200080506120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 150	80	50	6	40	6.000	7.500	A2200080506150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 240	80	50	6	40	6.000	7.500	A2200080506240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 08050.06	NK 320	80	50	6	40	6.000	7.500	A2200080506320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 10040.08	NK 40	100	40	8	40	5.000	7.500	A2200100408040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 10040.08	NK 60	100	40	8	40	5.000	7.500	A2200100408060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 10050.08	NK 60	100	50	8	40	5.000	7.500	A2200100508060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 10050.08	NK 80	100	50	8	40	5.000	7.500	A2200100508080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 10050.08	NK 150	100	50	8	40	5.000	7.500	A2200100508150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



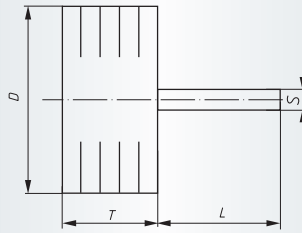
# 260 Mounted flap wheels of abrasive cloth



Industry

## SFB, Slotted flap wheel

Ordering example: A2220040206080



**Packing unit:**

10 pcs. per type

Further dimensions, qualities

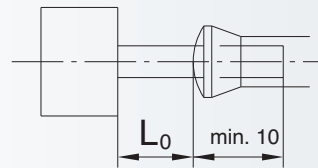
and shank lengths on request

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFB 04020.06	NK 80	40	20	6	40	12.000	18.000	A2220040206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFB 05020.06	NK 80	50	20	6	40	9.000	12.000	A2220050206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFB 05030.06	NK 120	50	30	6	40	9.000	12.000	A2220050306120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFB 06030.06	NK 80	60	30	6	40	8.000	12.000	A2220060306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFB 06030.06	NK 120	60	30	6	40	8.000	12.000	A2220060306120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

By slotting the lamellas on the periphery, the flexibility of this type of mounted wheel is increased. The slotted flap wheel quickly profiles itself to the contour of the workpiece. For special dimensions and grit sizes minimum quantity on request.

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

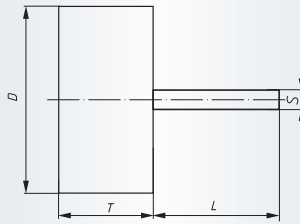
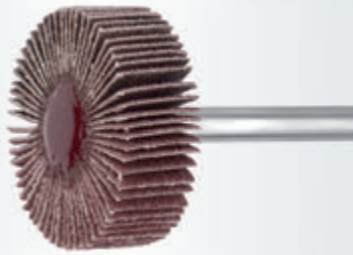




Industry

## SFE, Flap wheels of abrasive cloth, regular aluminium oxide, special bond

Ordering example: A2201030103120



**Packing unit:**

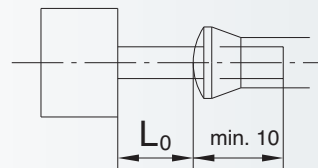
10 pcs. per type

Further dimensions, qualities and shank lengths on request

NKE = reg. Aluminium Oxide with a coating of active grinding additives

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFE 03010.03	NKE 120	30	10	3	40	16.000	18.000	A2201030103120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 03010.06	NKE 60	30	10	6	40	16.000	18.000	A2201030106060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 03010.06	NKE 80	30	10	6	40	16.000	18.000	A2201030106080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 03010.06	NKE 150	30	10	6	40	16.000	18.000	A2201030106150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 04015.06	NKE 60	40	15	6	40	12.000	18.000	A2201040156060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 04015.06	NKE 80	40	15	6	40	12.000	18.000	A2201040156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 04015.06	NKE 120	40	15	6	40	12.000	18.000	A2201040156120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 05015.06	NKE 80	50	15	6	40	9.000	12.000	A2201050156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 05015.06	NKE 150	50	15	6	40	9.000	12.000	A2201050156150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06020.06	NKE 80	60	20	6	40	8.000	12.000	A2201060206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06030.06	NKE 60	60	30	6	40	8.000	12.000	A2201060306060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06030.06	NKE 80	60	30	6	40	8.000	12.000	A2201060306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06030.06	NKE 120	60	30	6	40	8.000	12.000	A2201060306120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06030.06	NKE 150	60	30	6	40	8.000	12.000	A2201060306150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06050.06	NKE 60	60	50	6	40	8.000	8.500	A2201060506060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 06050.06	NKE 120	60	50	6	40	8.000	8.500	A2201060506120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 08030.06	NKE 80	80	30	6	40	6.000	9.000	A2201080306080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFE 08050.06	NKE 80	80	50	6	40	6.000	7.500	A2201080506080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



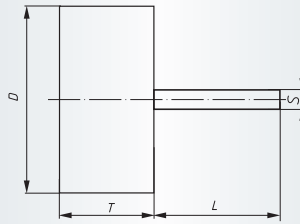
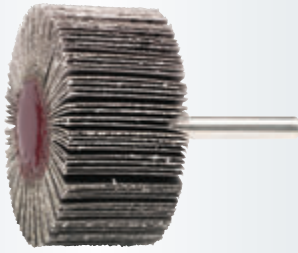
# 262 Mounted flap wheels of abrasive cloth



Industry

## SFC, Flap wheels of abrasive cloth, silicon carbide

Ordering example: A2202030106080



**Packing unit:**

10 pcs. per type

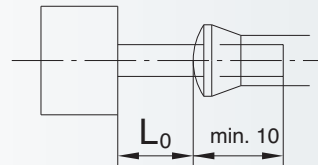
Further dimensions, qualities

and shank lengths on request

SIC = silicon carbide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFC 03010.06	SIC 80	30	10	6	40	16.000	18.000	A2202030106080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFC 03010.06	SIC 150	30	10	6	40	16.000	18.000	A2202030106150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFC 04015.06	SIC 80	40	15	6	40	12.000	18.000	A2202040156080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFC 06020.06	SIC 80	60	20	6	40	8.000	12.000	A2202060206080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFC 06020.06	SIC 120	60	20	6	40	8.000	12.000	A2202060206120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFC 06030.06	SIC 120	60	30	6	40	8.000	12.000	A2202060306120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.





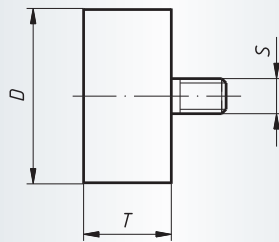
## 264 Mounted flap wheels of abrasive cloth with thread



Industry

### SFA, Flap wheels of abrasive cloth, with external thread

Ordering example: A2200015055150



**Packing unit:**

10 pcs. per type

Further dimensions and qualities on request.

NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	Thread S	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFA 01505.M5	NK 150	15	5	M5	16.000	18.000	A2200015055150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 01505.M5	NK 240	15	5	M5	16.000	18.000	A2200015055240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 02005.M5	NK 150	20	5	M5	16.000	18.000	A2200020055150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 02005.M5	NK 240	20	5	M5	16.000	18.000	A2200020055240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 03005.M5	NK 120	30	5	M5	16.000	18.000	A2200030055120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 03005.M5	NK 150	30	5	M5	16.000	18.000	A2200030055150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFA 03005.M5	NK 240	30	5	M5	16.000	18.000	A2200030055240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

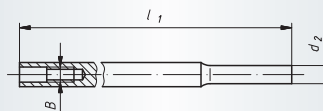
The stated maximum permissible operating speed is only valid if the correct tool adaptor is used (see table).



Industry

### Adaptor for SFA

Ordering example: A36300518



**Packing unit:**

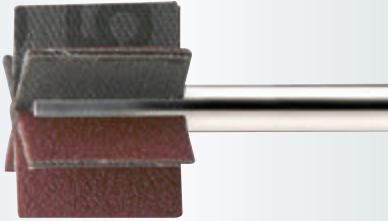
1 pc. per type

Description	d2 mm	l1 mm	B mm	Product-Number		
WADA 05	6	100	M5	A36300518		■





**MFS, Mini-Flap wheels of abrasive cloth**



**Applications:**

- Deburring of drill holes
- Production and cleaning of moulds for glass-industry
- Inside processing/machining of tubes
- Processing of light alloy rims
- Processing of the borings of turbine blades
- Manifold special applications

**Advantages:**

- Possibility of fine-grinding and finishing work
- The arrangement of the lamellars ensure high flexibility
- Good circulation of air and though cold grinding
- Processing of small borings and inner-diameters of tubes

Mini-Flap wheels with a diameter of 10–30 mm are available with different shank lengths and qualities.

available on request

**Always the right tool**

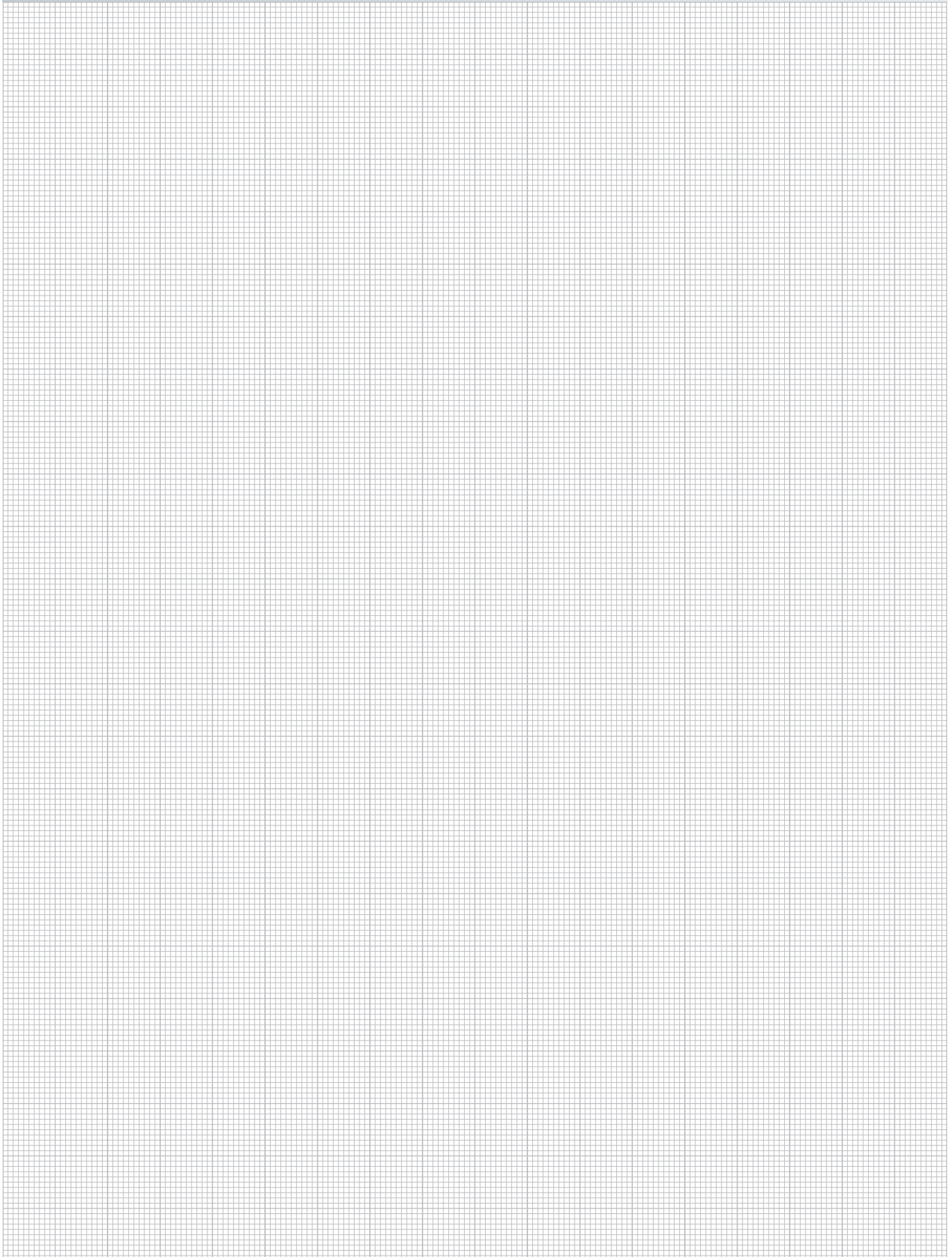


**Filing ring:** I take pride in having been involved in the development process for this thin-walled tool, starting out from a forged tool steel blank up to the finished toothed filing ring.

**Bajram Loshaj**  
Engineering Department

[www.lukas-erzett.com](http://www.lukas-erzett.com)

Notes

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

# Flap wheel consisting of an abrasive fleece and abrasive cloth combination

222 Qualities and Applications

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268 General Information

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269 Mounted flap wheels abrasive fleece lamellar inserts

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272 Mounted flap wheels abrasive fleece disc inserts

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273 Mounted flap wheels of abrasive fleece/  
abrasive cloth combination

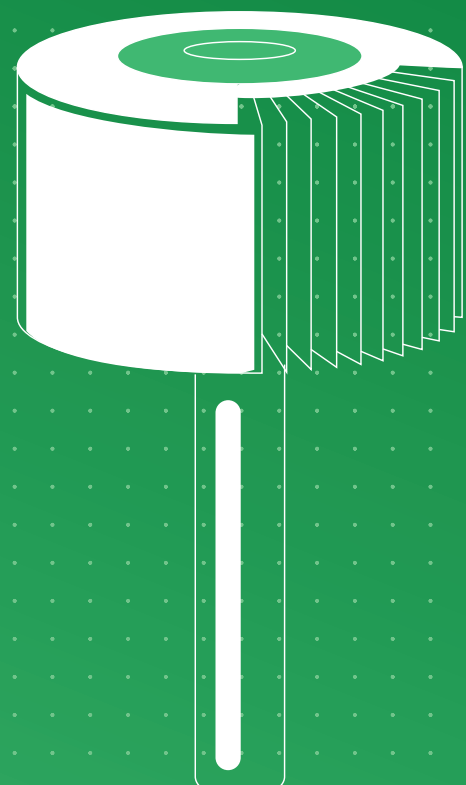
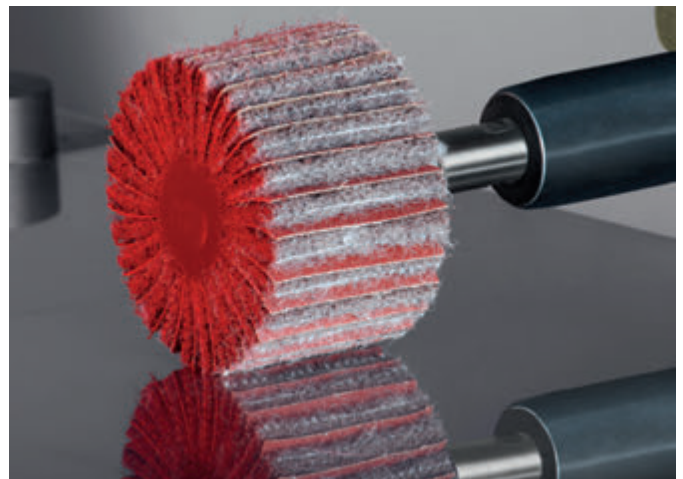
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373 Power tool

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## Product line marking

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



## Information

### SFV, Flap wheels of fleece flaps

These tools consist of individual flaps radially located around the hub of the tool. They are available in regular aluminium oxide (A), silicon carbide (C) and zirconia aluminium oxide (Z). SFV are mainly used in hand-held power tools.

#### Examples of application:

- matting
- conditioning
- polishing
- finishing
- fine surface finishing

### SFR, Mounted fleece discs

These special tools are produced by layering individual flexible round fleece sections. They are therefore ideally suited to the machining of profiles.

### SFM, Flap wheels of abrasive fleece with abrasive cloth

These tools consist of individual flaps radially located around the hub of the tool. They are available in regular aluminium oxide (A), silicon carbide (C) and zirconia aluminium oxide.

The combination of coated abrasive and abrasive fleece allows for a greater stock removal compared to the SFV product type. SFM are mainly used in hand-held power tools.

#### Examples of application:

- preparation work
- de-rusting
- pre-finishing
- graining
- keying

### SFM, spindle mounted flap wheels with TF-material

These tools are particularly suited to stainless steel applications. The reverse side of the reinforced abrasive fleece guarantees uniform wear of the fleece and the coated abrasive flaps. Please take note of the rotational direction!

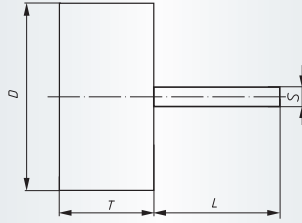
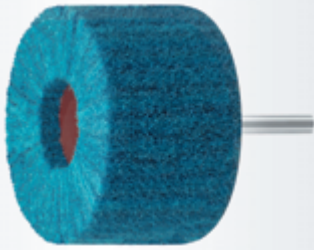
Quality	Grit sizes
A104	Aluminium oxide 100
A106	Aluminium oxide 180
A107	Aluminium oxide 280
C204	Silicon carbide 100
C206	Silicon carbide 180
C207	Silicon carbide 280
Z304	Zirconia Alum. Oxide 100
Z306	Zirconia Alum. Oxide 180
Z307	Zirconia Alum. Oxide 280



**High Performance**

**SFV, Flap wheels of fleece flaps, zirconia aluminium oxide**

Ordering example: A2203030106306



**Packing unit:**

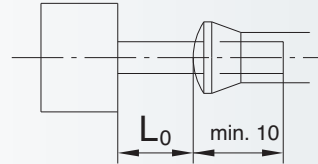
10 pcs. per type

Further dimensions, qualities and shank lengths on request.

Z = Zirconia aluminium oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for		
SFV 03010.06	Z 306	30	10	6	40	10.000	14.000	A2203030106306	1 2 3 4 5 6 7 8	■	<b>NEW</b>
SFV 04020.06	Z 306	40	20	6	40	7.500	14.000	A2203040206306	1 2 3 4 5 6 7 8	■	<b>NEW</b>
SFV 05010.06	Z 306	50	10	6	40	6.000	11.000	A2203050106306	1 2 3 4 5 6 7 8	■	<b>NEW</b>
SFV 06030.06	Z 306	60	30	6	40	5.000	9.000	A2203060306306	1 2 3 4 5 6 7 8	■	<b>NEW</b>
SFV 08050.06	Z 306	80	50	6	40	4.000	7.000	A2203080506306	1 2 3 4 5 6 7 8	■	<b>NEW</b>

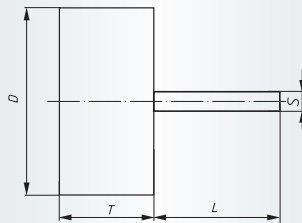
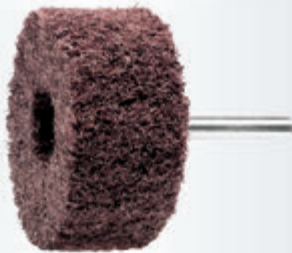
The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



**Industry**

**SFV, Flap wheels of fleece flaps, reg. Aluminium Oxide**

Ordering example: A2203030206106



**Packing unit:**

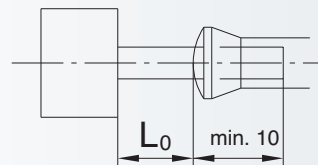
10 pcs. per type

Further dimensions, qualities and shank lengths on request.

A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for		
SFV 03020.06	A 106	30	20	6	40	7.500	14.000	A2203030206106	1 2 3 4 5 6 7 8	■	
SFV 03040.06	A 107	30	40	6	40	10.000	14.000	A2203030406107	1 2 3 4 5 6 7 8	■	
SFV 04020.06	A 104	40	20	6	40	7.500	14.000	A2203040206104	1 2 3 4 5 6 7 8	■	
SFV 04020.06	A 106	40	20	6	40	7.500	14.000	A2203040206106	1 2 3 4 5 6 7 8	■	
SFV 04020.06	A 107	40	20	6	40	7.500	14.000	A2203040206107	1 2 3 4 5 6 7 8	■	
SFV 04030.06	A 104	40	30	6	40	7.500	14.000	A2203040306104	1 2 3 4 5 6 7 8	■	
SFV 04030.06	A 106	40	30	6	40	7.500	14.000	A2203040306106	1 2 3 4 5 6 7 8	■	
SFV 04030.06	A 107	40	30	6	40	7.500	14.000	A2203040306107	1 2 3 4 5 6 7 8	■	

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



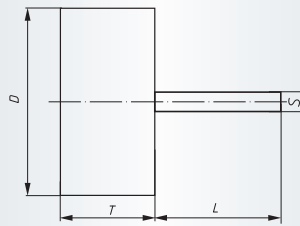
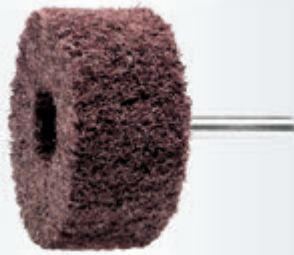
# 270 Mounted flap wheels of abrasive fleece



Industry

## SFV, Flap wheels of fleece flaps, reg. Aluminium Oxide

Ordering example: A2203050106106



**Packing unit:**

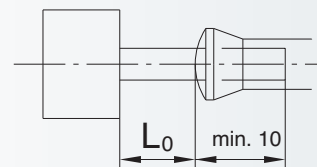
10 pcs. per type

Further dimensions, qualities and shank lengths on request.

A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFV 05010.06	A 106	50	10	6	40	6.000	11.000	A2203050106106	1 2 3 4 5 6 7 8	■
SFV 05020.06	A 104	50	20	6	40	6.000	11.000	A2203050206104	1 2 3 4 5 6 7 8	■
SFV 05020.06	A 106	50	20	6	40	6.000	11.000	A2203050206106	1 2 3 4 5 6 7 8	■
SFV 05030.06	A 104	50	30	6	40	6.000	11.000	A2203050306104	1 2 3 4 5 6 7 8	■
SFV 05030.06	A 106	50	30	6	40	6.000	11.000	A2203050306106	1 2 3 4 5 6 7 8	■
SFV 05030.06	A 107	50	30	6	40	6.000	11.000	A2203050306107	1 2 3 4 5 6 7 8	■
SFV 05040.06	A 104	50	40	6	40	6.000	11.000	A2203050406104	1 2 3 4 5 6 7 8	■
SFV 05040.06	A 106	50	40	6	40	6.000	11.000	A2203050406106	1 2 3 4 5 6 7 8	■
SFV 05040.06	A 107	50	40	6	40	6.000	11.000	A2203050406107	1 2 3 4 5 6 7 8	■
SFV 06030.06	A 104	60	30	6	40	5.000	9.000	A2203060306104	1 2 3 4 5 6 7 8	■
SFV 06030.06	A 106	60	30	6	40	5.000	9.000	A2203060306106	1 2 3 4 5 6 7 8	■
SFV 06030.06	A 107	60	30	6	40	5.000	9.000	A2203060306107	1 2 3 4 5 6 7 8	■
SFV 06040.06	A 104	60	40	6	40	5.000	9.000	A2203060406104	1 2 3 4 5 6 7 8	■
SFV 06040.06	A 106	60	40	6	40	5.000	9.000	A2203060406106	1 2 3 4 5 6 7 8	■
SFV 06040.06	A 107	60	40	6	40	5.000	9.000	A2203060406107	1 2 3 4 5 6 7 8	■
SFV 06050.06	A 104	60	50	6	40	5.000	9.000	A2203060506104	1 2 3 4 5 6 7 8	■
SFV 06050.06	A 106	60	50	6	40	5.000	9.000	A2203060506106	1 2 3 4 5 6 7 8	■
SFV 06050.06	A 107	60	50	6	40	5.000	9.000	A2203060506107	1 2 3 4 5 6 7 8	■
SFV 08040.06	A 104	80	40	6	40	4.000	7.000	A2203080406104	1 2 3 4 5 6 7 8	■
SFV 08040.06	A 106	80	40	6	40	4.000	7.000	A2203080406106	1 2 3 4 5 6 7 8	■
SFV 08050.06	A 104	80	50	6	40	4.000	7.000	A2203080506104	1 2 3 4 5 6 7 8	■
SFV 08050.06	A 106	80	50	6	40	4.000	7.000	A2203080506106	1 2 3 4 5 6 7 8	■
SFV 08050.06	A 107	80	50	6	40	4.000	7.000	A2203080506107	1 2 3 4 5 6 7 8	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

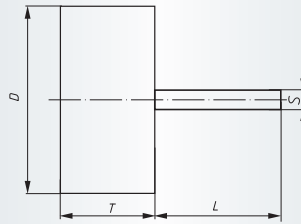




Industry

SFV, Flap wheels of fleece flaps, Silicon carbide

Ordering example: A2203020153207



Packing unit:

10 pcs. per type

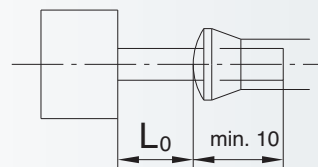
Further dimensions, qualities and shank lengths on request.

C = Silicon carbide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFV 02015.03	C 207	20	15	3	40	10.000	14.000	A2203020153207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 04020.06	C 206	40	20	6	40	7.500	14.000	A2203040206206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 04020.06	C 207	40	20	6	40	7.500	14.000	A2203040206207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 04030.06	C 207	40	30	6	40	7.500	14.000	A2203040306207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 05020.06	C 204	50	20	6	40	6.000	11.000	A2203050206204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 05020.06	C 206	50	20	6	40	6.000	11.000	A2203050206206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 05020.06	C 207	50	20	6	40	6.000	11.000	A2203050206207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 05030.06	C 207	50	30	6	40	6.000	11.000	A2203050306207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 05040.06	C 207	50	40	6	40	6.000	11.000	A2203050406207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06030.06	C 204	60	30	6	40	5.000	9.000	A2203060306204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06030.06	C 206	60	30	6	40	5.000	9.000	A2203060306206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06030.06	C 207	60	30	6	40	5.000	9.000	A2203060306207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06040.06	C 204	60	40	6	40	5.000	9.000	A2203060406204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06040.06	C 207	60	40	6	40	5.000	9.000	A2203060406207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 06050.06	C 207	60	50	6	40	5.000	9.000	A2203060506207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08040.06	C 204	80	40	6	40	4.000	7.000	A2203080406204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08040.06	C 206	80	40	6	40	4.000	7.000	A2203080406206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08040.06	C 207	80	40	6	40	4.000	7.000	A2203080406207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08050.06	C 204	80	50	6	40	4.000	7.000	A2203080506204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08050.06	C 206	80	50	6	40	4.000	7.000	A2203080506206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFV 08050.06	C 207	80	50	6	40	4.000	7.000	A2203080506207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

NEW

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



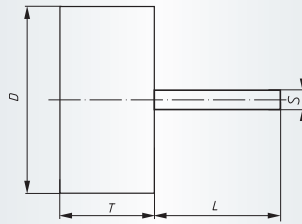
# 272 Mounted flap wheels of abrasive fleece



Industry

## SFR, Mounted fleece discs

Ordering example: A2223060506104



**Packing unit:**

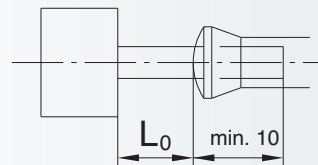
10 pcs. per type

Further dimensions, qualities and shank lengths on request.

A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFR 06050.06	A 104	60	50	6	40	5.000	9.000	A2223060506104	1 2 3 4 5 6 7 8	■
SFR 06050.06	A 106	60	50	6	40	5.000	9.000	A2223060506106	1 2 3 4 5 6 7 8	■
SFR 06050.06	A 107	60	50	6	40	5.000	9.000	A2223060506107	1 2 3 4 5 6 7 8	■
SFR 08050.06	A 104	80	50	6	40	4.000	7.000	A2223080506104	1 2 3 4 5 6 7 8	■
SFR 08050.06	A 106	80	50	6	40	4.000	7.000	A2223080506106	1 2 3 4 5 6 7 8	■
SFR 08050.06	A 107	80	50	6	40	4.000	7.000	A2223080506107	1 2 3 4 5 6 7 8	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

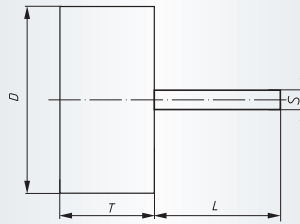
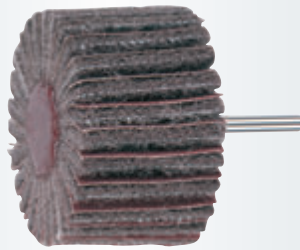






SFM, Flap wheels of abrasive fleece TF with abrasive cloth

Ordering example: A2204040206120

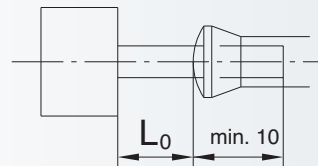


**Packing unit:**  
10 pcs. per type  
TF = Special quality for INOX

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for
SFM 04020.06	TF 120/80	40	20	6	40	7.500	14.000	A2204040206120	1 2 3 4 5 6 7 8
SFM 06030.06	TF 120/80	60	30	6	40	5.000	9.000	A2204060306120	1 2 3 4 5 6 7 8
SFM 08050.06	TF 120/80	80	50	6	40	4.000	7.000	A2204080506120	1 2 3 4 5 6 7 8

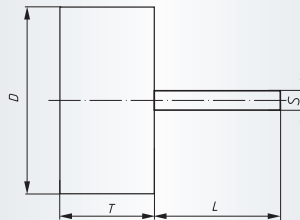
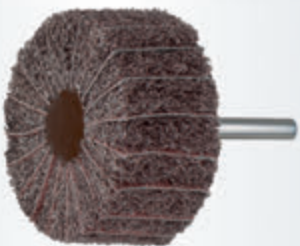
Ideal for surface finishing of metalsheet components such as stainless steel sinks and containers.

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



SFM, Flap wheels of abrasive fleece with abrasive cloth, reg. Aluminium Oxide

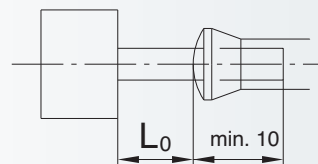
Ordering example: A2204030306104



**Packing unit:**  
10 pcs. per type  
Further dimensions, qualities and shank lengths on request.  
A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for
SFM 03030.06	A 104/80	30	30	6	40	10.000	14.000	A2204030306104	1 2 3 4 5 6 7 8
SFM 04020.06	A 104/80	40	20	6	40	7.500	14.000	A2204040206104	1 2 3 4 5 6 7 8
SFM 04020.06	A 106/150	40	20	6	40	7.500	14.000	A2204040206106	1 2 3 4 5 6 7 8
SFM 04020.06	A 107/240	40	20	6	40	7.500	14.000	A2204040206107	1 2 3 4 5 6 7 8
SFM 04030.06	A 104/80	40	30	6	40	7.500	14.000	A2204040306104	1 2 3 4 5 6 7 8
SFM 04030.06	A 106/150	40	30	6	40	7.500	14.000	A2204040306106	1 2 3 4 5 6 7 8
SFM 04030.06	A 107/240	40	30	6	40	7.500	14.000	A2204040306107	1 2 3 4 5 6 7 8
SFM 05020.06	A 104/80	50	20	6	40	6.000	11.000	A2204050206104	1 2 3 4 5 6 7 8
SFM 05020.06	A 106/150	50	20	6	40	6.000	11.000	A2204050206106	1 2 3 4 5 6 7 8

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



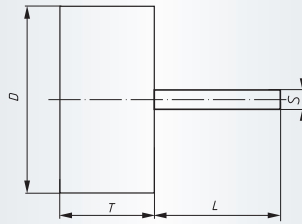
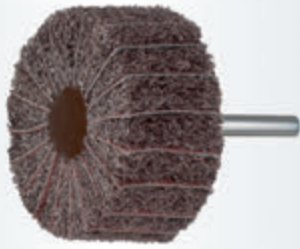
# 274 Mounted flap wheels of abrasive fleece



Industry

## SFM, Flap wheels of abrasive fleece with abrasive cloth, reg. Aluminium Oxide

Ordering example: A2204050306106



**Packing unit:**

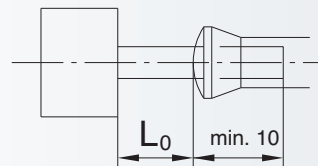
10 pcs. per type

Further dimensions, qualities and shank lengths on request.

A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFM 05030.06	A 106/150	50	30	6	40	6.000	11.000	A2204050306106	1 2 3 4 5 6 7 8	■
SFM 05030.06	A 107/240	50	30	6	40	6.000	11.000	A2204050306107	1 2 3 4 5 6 7 8	■
SFM 05040.06	A 104/80	50	40	6	40	6.000	11.000	A2204050406104	1 2 3 4 5 6 7 8	■
SFM 05040.06	A 106/150	50	40	6	40	6.000	11.000	A2204050406106	1 2 3 4 5 6 7 8	■
SFM 06030.06	A 104/80	60	30	6	40	5.000	9.000	A2204060306104	1 2 3 4 5 6 7 8	■
SFM 06030.06	A 106/150	60	30	6	40	5.000	9.000	A2204060306106	1 2 3 4 5 6 7 8	■
SFM 06030.06	A 107/240	60	30	6	40	5.000	9.000	A2204060306107	1 2 3 4 5 6 7 8	■
SFM 06040.06	A 104/80	60	40	6	40	5.000	9.000	A2204060406104	1 2 3 4 5 6 7 8	■
SFM 06040.06	A 106/150	60	40	6	40	5.000	9.000	A2204060406106	1 2 3 4 5 6 7 8	■
SFM 06040.06	A 107/240	60	40	6	40	5.000	9.000	A2204060406107	1 2 3 4 5 6 7 8	■
SFM 06050.06	A 104/80	60	50	6	40	5.000	9.000	A2204060506104	1 2 3 4 5 6 7 8	■
SFM 06050.06	A 106/150	60	50	6	40	5.000	9.000	A2204060506106	1 2 3 4 5 6 7 8	■
SFM 08040.06	A 104/80	80	40	6	40	4.000	7.000	A2204080406104	1 2 3 4 5 6 7 8	■
SFM 08040.06	A 106/150	80	40	6	40	4.000	7.000	A2204080406106	1 2 3 4 5 6 7 8	■
SFM 08040.06	A 107/240	80	40	6	40	4.000	7.000	A2204080406107	1 2 3 4 5 6 7 8	■
SFM 08050.06	A 104/80	80	50	6	40	4.000	7.000	A2204080506104	1 2 3 4 5 6 7 8	■
SFM 08050.06	A 106/150	80	50	6	40	4.000	7.000	A2204080506106	1 2 3 4 5 6 7 8	■
SFM 08050.06	A 107/240	80	50	6	40	4.000	7.000	A2204080506107	1 2 3 4 5 6 7 8	■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

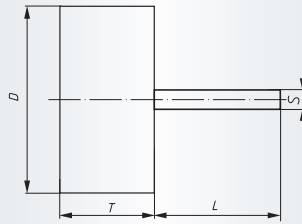




Industry

SFM, Flap wheels of abrasive fleece with abrasive cloth, Silicon carbide

Ordering example: A2204040206204



Packing unit:

10 pcs. per type

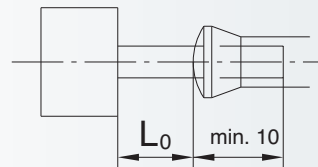
Further dimensions, qualities and shank lengths on request.

C = Silicon carbide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFM 04020.06	C 204/80	40	20	6	40	7.500	14.000	A2204040206204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 04020.06	C 206/150	40	20	6	40	7.500	14.000	A2204040206206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 04030.06	C 204/80	40	30	6	40	7.500	14.000	A2204040306204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 04030.06	C 206/150	40	30	6	40	7.500	14.000	A2204040306206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 04030.06	C 207/240	40	30	6	40	7.500	14.000	A2204040306207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 05020.06	C 204/80	50	20	6	40	6.000	11.000	A2204050206204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 05020.06	C 206/150	50	20	6	40	6.000	11.000	A2204050206206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 06030.06	C 204/80	60	30	6	40	5.000	9.000	A2204060306204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 06030.06	C 206/150	60	30	6	40	5.000	9.000	A2204060306206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 06030.06	C 207/240	60	30	6	40	5.000	9.000	A2204060306207	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 06040.06	C 204/80	60	40	6	40	5.000	9.000	A2204060406204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 08050.06	C 204/80	80	50	6	40	4.000	7.000	A2204080506204	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
SFM 08050.06	C 206/150	80	50	6	40	4.000	7.000	A2204080506206	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

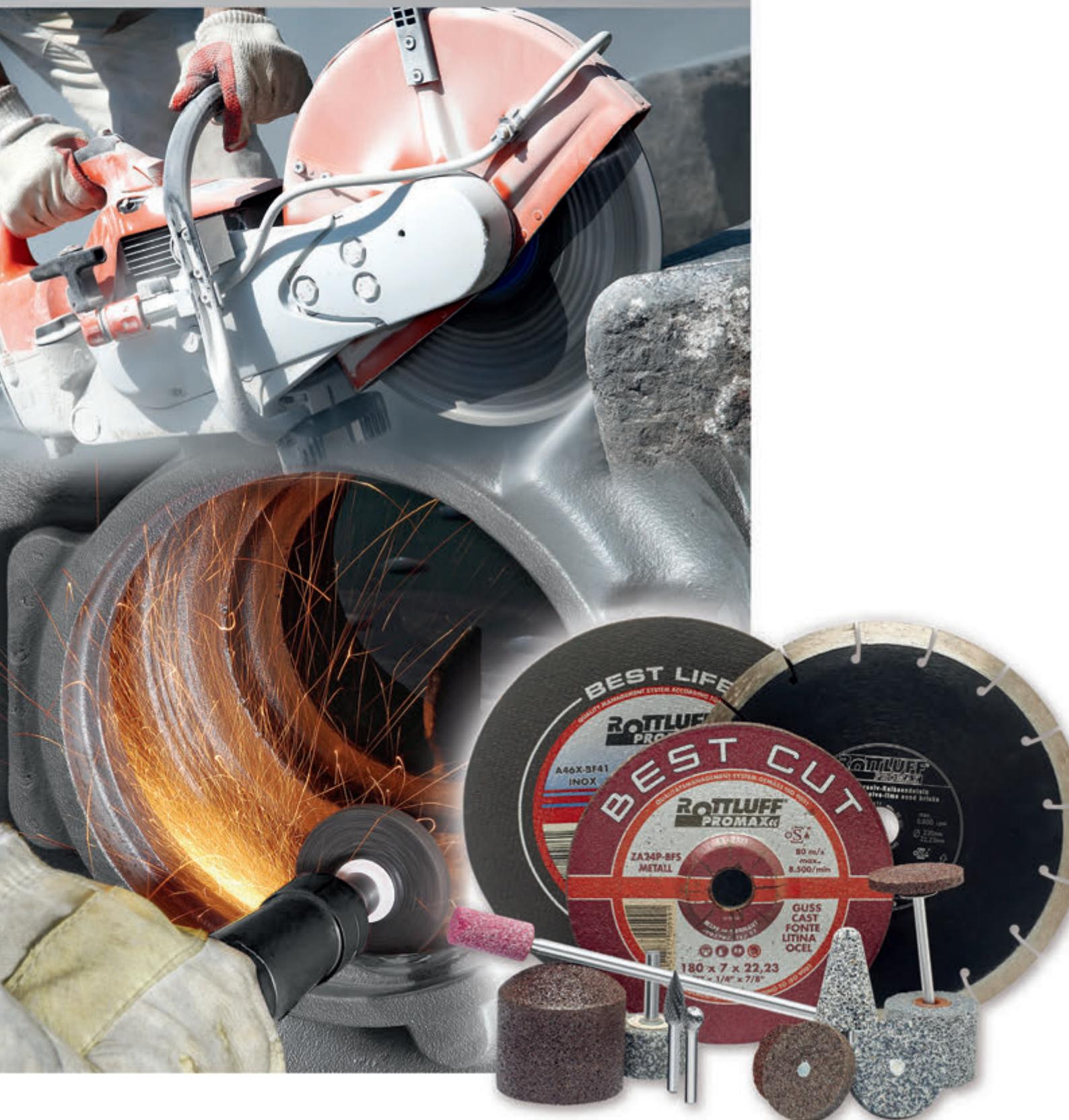
NEW

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.



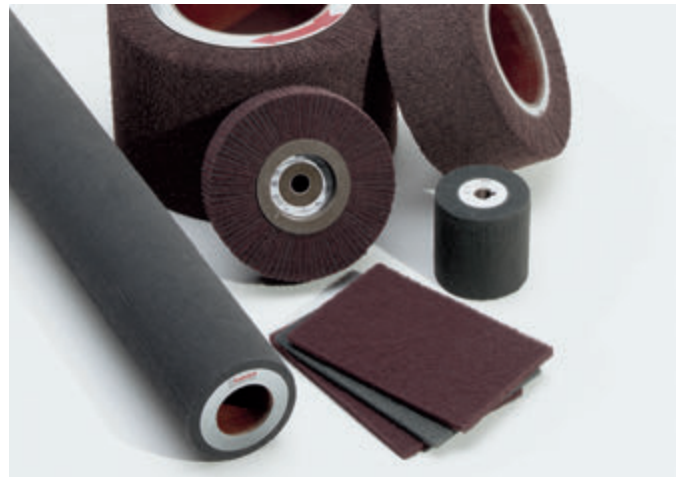
Always the right tool

# For Heavy-Duty Application!



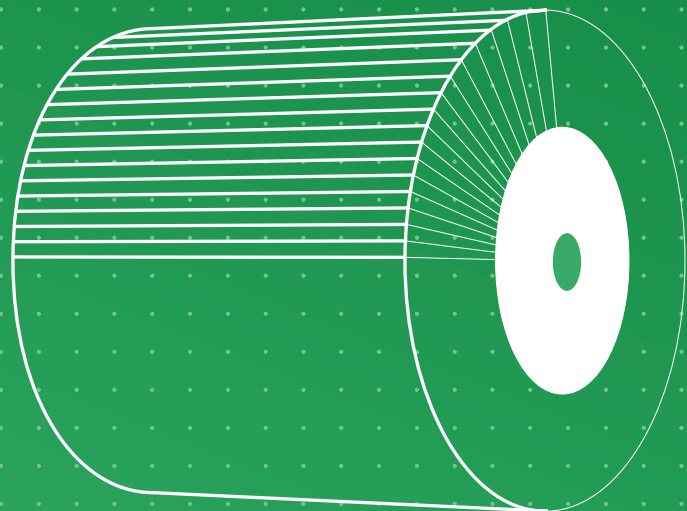
## Flap wheels and long rolls

<b>222</b>	Qualities and Applications
<b>278</b>	General Information
<b>279</b>	Flap wheels of abrasive cloth
<b>280</b>	Flap wheels of abrasive cloth for angle grinder
<b>283</b>	Flap wheels of abrasive fleece/ abrasive cloth combination
<b>285</b>	Fleece mops
<b>285</b>	Rolls manufactured of abrasive fleece



### Product line marking

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



## Information

### **LSL, Flap Wheels of abrasive cloth (tailor-made solution)**

These wheels with various bore dimensions can be used on both hand-held and floor-stand type machines. The type LSL consists of individual flaps imbedded radially into a very substantial resin-based core.

Please take note of the rotational direction!

#### **Examples of application:**

- preparation work
- deburring
- de-rusting
- prefinishing
- graining
- keying

### **LSL, Flap Wheels of abrasive cloth for angle grinder**

#### **Advantages:**

- Fits onto standard angle grinders
- Replaces the use of shaft mounted flap wheels (where no straight grinder is available)
- No flange needed
- Ideal for welding seams on Stainless Steel (tanks)

#### **Examples of application:**

- de-rusting, removal of surface coatings and oxidized layers
- cleaning of welding seams
- grinding in the tank industry and construction of railings
- grinding in the assembling industry

#### **Application info:**

Only to be used on the periphery of the wheel

### **LSV, Grinding wheels of abrasive fleece (tailor-made solution)**

These wheels with various bore dimensions can be used on both hand-held and floor-stand type machines. The LSV consists of abrasive impregnated fleece flaps. A special type of fleece gives flexibility to the tools which easily conforms to the individual workpiece profile.

#### **Examples of application:**

- matting
- conditioning
- polishing
- finishing
- final surface finishing

### **LSM, Flap wheels of abrasive fleece with abrasive cloth (tailor-made solution)**

These wheels with various bore dimensions can be used on both hand-held and floor-stand type machines.

Due to the combination of coated abrasive and abrasive fleece greater stock removal is achieved compared to the product type LSV. Please take note of the rotational direction!

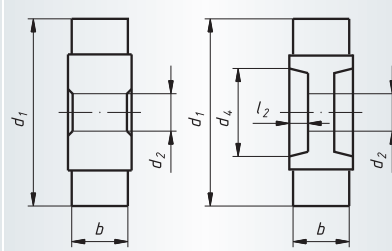
#### **Examples of application:**

- preparation work
- de-rusting
- pre-finishing
- graining
- keying



LSL, Flap Wheels of abrasive cloth, tailor-made solution

Ordering example: LSL 125025 NK 60 Bore 13



**Packing unit:**

Minimum ordering quantity 25 pcs. per type

$v_{rec.}$ : 30 m/s off-hand application

$v_{max.}$ : 50 m/s for stationary machines

\* for stationary machines

Other dimensions can be supplied on request – from 80 mm to max. 400 mm.

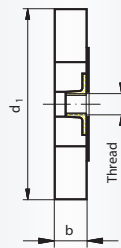
NK = reg. Aluminium Oxide

Description	Grits	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. * (1/min)	recommended for	
LSL 125025	NK 60	125	25	13-16-20	---	---	4.500	7.600	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125025	NK 80	125	25	13-16-20	---	---	4.500	7.600	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125025	NK 120	125	25	13-16-20	---	---	4.500	7.600	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125025	NK 150	125	25	13-16-20	---	---	4.500	7.600	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125025	NK 240	125	25	13-16-20	---	---	4.500	7.600	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 150050	NK 60	150	50	13-16-20	47	18	3.800	6.300	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 150050	NK 80	150	50	13-16-20	47	18	3.800	6.300	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 150050	NK 120	150	50	13-16-20	47	18	3.800	6.300	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 150050	NK 150	150	50	13-16-20	47	18	3.800	6.300	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 150050	NK 240	150	50	13-16-20	47	18	3.800	6.300	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 165050	NK 60	165	50	13-16-20	47	18	3.400	5.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 165050	NK 80	165	50	13-16-20	47	18	3.400	5.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 165050	NK 120	165	50	13-16-20	47	18	3.400	5.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 165050	NK 150	165	50	13-16-20	47	18	3.400	5.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 165050	NK 240	165	50	13-16-20	47	18	3.400	5.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200025	NK 60	200	25	20-25-32	71	10	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200025	NK 80	200	25	20-25-32	71	10	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200025	NK 120	200	25	20-25-32	71	10	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200025	NK 150	200	25	20-25-32	71	10	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200025	NK 240	200	25	20-25-32	71	10	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200050	NK 60	200	50	20-25-32	71	18	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200050	NK 80	200	50	20-25-32	71	18	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200050	NK 120	200	50	20-25-32	71	18	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200050	NK 150	200	50	20-25-32	71	18	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 200050	NK 240	200	50	20-25-32	71	18	2.800	4.700	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



## LSL, Flap Wheels of abrasive cloth for angle grinder

Ordering example: A2280125200040



**Packing unit:**

5 pcs. per type

$v_{max}$ : 80 m/s

NK = reg. Aluminium Oxide

Description	Grits	d <sub>1</sub> mm	b mm	Thread	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
LSL 125020	NK 40	125	20	M14	9.600	12.200	A2280125200040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> LSL 125020	NK 40	125	20	5/8"	9.600	12.200	A2280125200040001	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125020	NK 60	125	20	M14	9.600	12.200	A2280125200060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> LSL 125020	NK 60	125	20	5/8"	9.600	12.200	A2280125200060001	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125020	NK 80	125	20	M14	9.600	12.200	A2280125200080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> LSL 125020	NK 80	125	20	5/8"	9.600	12.200	A2280125200080001	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSL 125020	NK 120	125	20	M14	9.600	12.200	A2280125200120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> LSL 125020	NK 120	125	20	5/8"	9.600	12.200	A2280125200120001	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

**Advantages:**

- Fits onto standard angle grinders
- Replaces the use of shaft mounted flap wheels (where no straight grinder is available)
- No flange needed
- Ideal for welding seams on Stainless Steel (tanks)

**Application examples:**

- De-rusting, removal of surface coatings and oxidise layers
- Cleaning of welding seams
- Grinding in the tank industry
- Grinding in the assembling industry

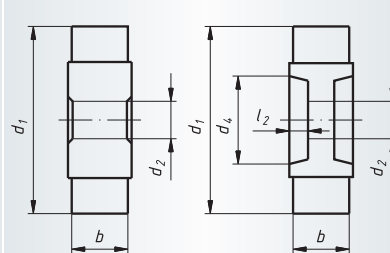
**Application info:**

Only to be used on the periphery of the wheel



## LSV, Grinding wheels of abrasive fleece, tailor-made solution

Ordering example: LSV 100050 A 104 W Bore 13



**Packing unit:**

Minimum ordering quantity 25 pcs. per type

$v_{max}$ : 35 m/s

Other dimensions, bores or qualities, e.g. "very hard" or "Poly Urethane-foamed" are available on request. Possible diameters 80 mm to max. 400 mm.

A = reg. Aluminium Oxide

C = Silicon carbide

Description	Grits	Quality	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for	
LSV 100050	A 104 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSV 100050	A 106 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSV 100050	A 107 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSV 100050	C 204 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSV 100050	C 206 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LSV 100050	C 207 W	soft	100	50	13-16-20	---	---	3.000	6.000	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

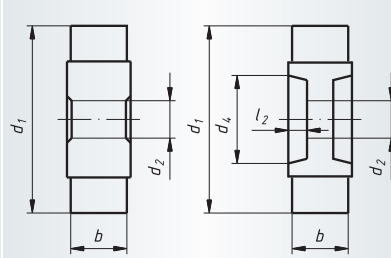




Industry

## LSV, Grinding wheels of abrasive fleece, tailor-made solution

Ordering example: LSV 100050 A 104 M Bore 13



**Packing unit:**

Minimum ordering quantity 25 pcs. per type  
 $v_{max.}$ : 35 m/s

Other dimensions, bores or qualities, e.g. "very hard" or "Poly Urethane-foamed" are available on request. Possible diameters 80 mm to max. 400 mm.

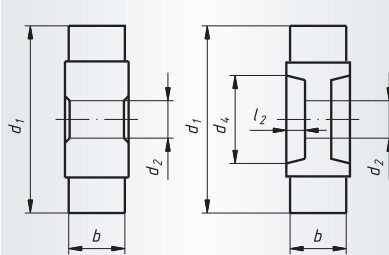
A = reg. Aluminium Oxide  
 C = Silicon carbide

Description	Grits	Quality	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for	
LSV 100050	A 104 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	A 106 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	A 107 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 204 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 206 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 207 M	medium	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	A 104 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	A 106 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	A 107 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 204 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 206 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 100050	C 207 H	hard	100	50	13-16-20	---	---	3.000	6.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 104 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 106 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 107 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 204 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 206 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 207 W	soft	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 104 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 106 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 107 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 204 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 206 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 207 M	medium	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 104 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 106 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	A 107 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 204 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 206 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 150050	C 207 H	hard	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8	■
LSV 160050	A 104 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 106 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 107 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 204 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 206 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 207 W	soft	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 104 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 106 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■



## LSV, Grinding wheels of abrasive fleece, tailor-made solution

Ordering example: LSV 160050 A 107 M Bore 13



**Packing unit:**

Minimum ordering quantity 25 pcs. per type  
 $v_{max.}$ : 35 m/s

Other dimensions, bores or qualities, e.g. "very hard" or "Poly Urethane-foamed" are available on request. Possible diameters 80 mm to max. 400 mm.

A = reg. Aluminium Oxide  
 C = Silicon carbide

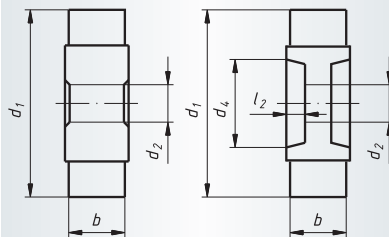
Description	Grits	Quality	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for	
LSV 160050	A 107 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 204 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 206 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 207 M	medium	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 104 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 106 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	A 107 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 204 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 206 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 160050	C 207 H	hard	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSV 200025	A 104 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 106 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 107 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 204 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 206 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 207 W	soft	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 104 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 106 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 107 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 204 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 206 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 207 M	medium	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 104 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 106 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	A 107 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 204 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 206 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200025	C 207 H	hard	200	25	20-25-32	71	10	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 104 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 106 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 107 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	C 204 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	C 206 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	C 207 W	soft	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 104 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 106 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	A 107 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSV 200050	C 204 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■



Industry

**LSV, Grinding wheels of abrasive fleece, tailor-made solution**

Ordering example: LSV 200050 C 206 M Bore 20



**Packing unit:**

Minimum ordering quantity 25 pcs. per type  
 $v_{max.}$ : 35 m/s

Other dimensions, bores or qualities, e.g. "very hard" or "Poly Urethane-foamed" are available on request. Possible diameters 80 mm to max. 400 mm.

A = reg. Aluminium Oxide  
 C = Silicon carbide

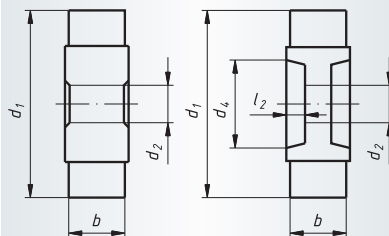
Description	Grits	Quality	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for
LSV 200050	C 206 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	C 207 M	medium	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	A 104 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	A 106 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	A 107 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	C 204 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	C 206 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8
LSV 200050	C 207 H	hard	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8



Industry

**LSM, Flap wheels of abrasive fleece with abrasive cloth, tailor-made solution**

Ordering example: LSM 080050 A 104/80 Bore 13



**Packing unit:**

Minimum ordering quantity 25 pcs. per type  
 $v_{max.}$ : 35 m/s

Other dimensions, bores or qualities are available on request. Possible diameters 80 mm to max. 400 mm.

A = reg. Aluminium Oxide  
 C = Silicon carbide

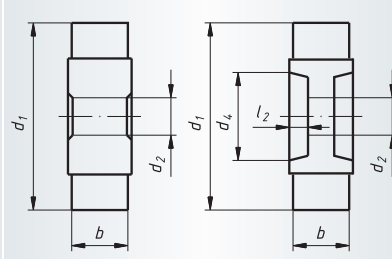
Description	Grits	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for
LSM 080050	A 104/80	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 080050	A 106/150	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 080050	A 107/240	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 080050	C 204/80	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 080050	C 206/150	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 080050	C 207/240	80	50	10-13-16	---	---	3.800	7.600	1 2 3 4 5 6 7 8
LSM 150050	A 104/80	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 150050	A 106/150	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 150050	A 107/240	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 150050	C 204/80	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 150050	C 206/150	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 150050	C 207/240	150	50	13-16-20	47	18	2.000	4.000	1 2 3 4 5 6 7 8
LSM 160050	A 104/80	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8
LSM 160050	A 106/150	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8





## LSM, Flap wheels of abrasive fleece with abrasive cloth, tailor-made solution

Ordering example: LSM 160050 A 107/240 Bore 16



**Packing unit:**

Minimum ordering quantity 25 pcs. per type

$v_{max}$ : 35 m/s

Other dimensions, bores or qualities are available on request. Possible diameters 80 mm to max. 400 mm.

A = reg. Aluminium Oxide  
C = Silicon carbide

Description	Grits	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for	
LSM 160050	A 107/240	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSM 160050	C 204/80	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSM 160050	C 206/150	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSM 160050	C 207/240	160	50	13-16-20	47	18	1.900	3.800	1 2 3 4 5 6 7 8	■
LSM 200050	A 104/80	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSM 200050	A 106/150	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSM 200050	A 107/240	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSM 200050	C 204/80	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSM 200050	C 206/150	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■
LSM 200050	C 207/240	200	50	20-25-32	71	18	1.500	3.000	1 2 3 4 5 6 7 8	■





## Always the right tool

**Tungsten-carbide burrs:** Our customers appreciate the precise running smoothness and perfectly finished gears which ensure the utmost chip removal.

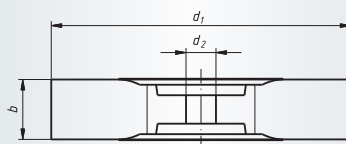
**Jayesh Shah**  
Sales Department

[www.lukas-erzett.com](http://www.lukas-erzett.com)



**FRV, Mops of abrasive fleece**

Ordering example: FRV 20005 A 104 Bore 20



**Packing unit:**  
Minimum ordering quantity 25 pcs. per type  
A = reg. Aluminium Oxide

Description	Grits	Quality	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	recommended for	
FRV 20050	A 104	medium	200	50	20-25-32	1.400	1.900	1 2 3 4 5 6 7 8	■
FRV 20050	A 106	fine	200	50	20-25-32	1.400	1.900	1 2 3 4 5 6 7 8	■
FRV 20050	A 107	very fine	200	50	20-25-32	1.400	1.900	1 2 3 4 5 6 7 8	■
FRV 25050	A 104	medium	250	50	20-25-32	1.100	1.500	1 2 3 4 5 6 7 8	■
FRV 25050	A 106	fine	250	50	20-25-32	1.100	1.500	1 2 3 4 5 6 7 8	■
FRV 25050	A 107	very fine	250	50	20-25-32	1.100	1.500	1 2 3 4 5 6 7 8	■
FRV 30060	A 104	medium	300	60	20-25-32	900	1.200	1 2 3 4 5 6 7 8	■
FRV 30060	A 106	fine	300	60	20-25-32	900	1.200	1 2 3 4 5 6 7 8	■
FRV 30060	A 107	very fine	300	60	20-25-32	900	1.200	1 2 3 4 5 6 7 8	■

LUKAS Fleece Mops are manufactured from abrasive fleece and are used when a satin polish is required on stainless, chrome, nickel and non ferrous metals. They are also ideal for cleaning-up and enhancing painted and varnished surfaces in the wood and plastic industries. Furthermore, they are suited to the manufacture of stainless and aluminium containers supplied to the food industry.

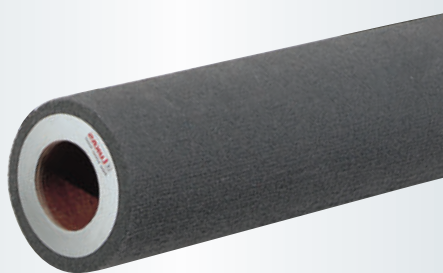
The ideal operating speed lies between 10 – 20 m/s and the fleece mops should

be used with little pressure. They can be used with or without coolant. Operating with coolant extends the life of the fleece mop.

When using water as a coolant a matt surface is achieved; oil produces a satin finish. LUKAS Fleece Mops can be clamped together on a single spindle thus giving the overall width required.



**LSW, Rolls manufactured of abrasive fleece**



Rolls with a diameter of 100 to 400 mm and a width of 100 to 1.000 mm are available with various bores and qualities of abrasive fleece.

available on request

# Always the right tool

**Cutting discs:** Our customers keep asking for thin cuts, quick, cool, precise and free from burrs: Therefore the ROTTLUFF products fit perfectly into our product range.

**Georg Klug**  
Marketing



## Flap rolls

- 222** Qualities and Applications

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- 288** General Information

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- 289** Flap rolls of abrasive cloth, LWL

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- 290** Flap rolls of abrasive fleece, LWW

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- 291** Flap rolls of abrasive fleece/abrasive cloth combination, LWM

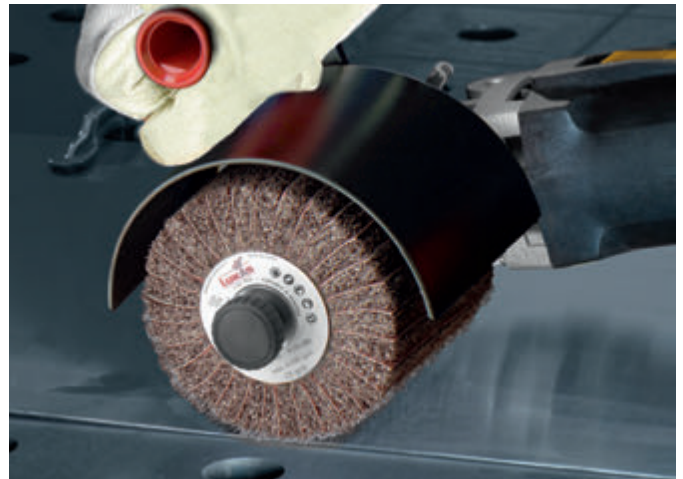
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- 292** Sinus-Abrasive rolls of abrasive fleece, LWF

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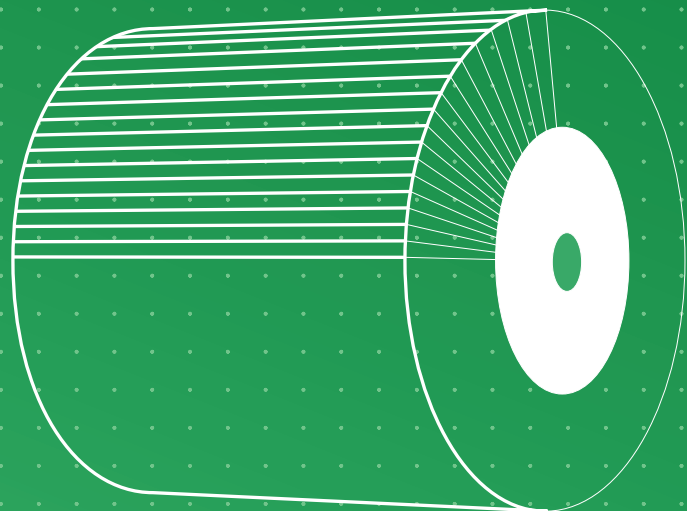
- 292** Conditioning machine

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### Product line marking

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



## Information

### General

These rolls have a nineteen mm bore with four keyways; they are used on hand-held surface conditioning machines.

### LWL, Flap rolls of abrasive cloth for conditioning machines

These tools consist of individual flaps which are radially embedded into a resin core.

Please take note of the rotational direction!

#### Examples of application:

- preparation work
- deburring
- de-rusting
- pre-finishing
- graining
- keying

### LWV, Flap rolls of abrasive fleece for conditioning machines

This product type consists of abrasive fleece flaps; the special fleece gives the tool flexibility and conforms to the individual workpiece profile.

#### Examples of application:

- matting
- conditioning
- polishing
- finishing
- final finishing of the surface

### LWF, Sinus-Abrasive rolls of abrasive fleece for conditioning machines

These tools are manufactured from strips of abrasive fleece which are wound in a wave pattern around the core; this configuration achieves an unblemished grained matt surface finish.

The special fleece makes the LWF flexible and conforms to the individual workpiece profile.

#### Examples of application:

- matting
- conditioning
- polishing
- finishing
- fine surface finishing

### LWM, Flap rolls of abrasive fleece with abrasive cloth insert for conditioning machines

Due to the combination of coated abrasive and abrasive fleece, greater stock removal is achieved compared to the product type LWV.

Please take note of the rotational direction!

#### Examples of application:

- preparation work
- de-rusting
- pre-finishing
- graining
- keying

### LWM, flap rolls using TF material

These rolls are supplied with a 19 mm bore and four key-ways, and are particularly suited for stainless steel.

The reverse side of the reinforced abrasive fleece guarantees uniform wear of the fleece and the coated abrasive flaps.

Please take note of the rotational direction!

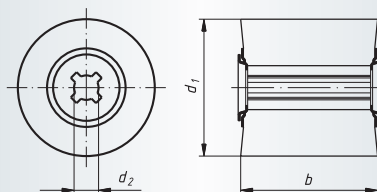




Industry

**LWL, Flap rolls of abrasive cloth for conditioning machines**

Ordering example: A2280100500040



**Packing unit:**

LWL 100050 = 2 pcs. per type

LWL 100100 = 1 pc. per type

NK = reg. Aluminium Oxide

Machines to suit: page 292

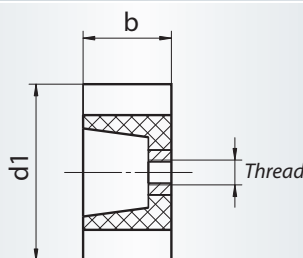
Description	Grits	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
LWL 100050	NK 40	100	50	19	3.700	6.000	A2280100500040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100050	NK 60	100	50	19	3.700	6.000	A2280100500060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100050	NK 80	100	50	19	3.700	6.000	A2280100500080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100050	NK 60	100	50	19	3.700	6.000	A2280100501060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100050	NK 80	100	50	19	3.700	6.000	A2280100501080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100100	NK 40	100	100	19	3.700	6.000	A22801001000040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100100	NK 60	100	100	19	3.700	6.000	A22801001000060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWL 100100	NK 80	100	100	19	3.700	6.000	A22801001000080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**LWL, Flap rolls of abrasive cloth with thread**

Ordering example: A2280100501060



**Packing unit:**

2 pcs. per type

NK = reg. Aluminium Oxide

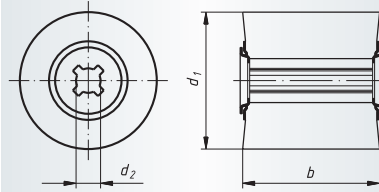
Suitable for controlled angle grinders.

Description	Grits	d <sub>1</sub> mm	b mm	Thread	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for		
LWL 100050	NK 60	100	50	M 14	3.700	6.000	A2280100501060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	NEW
LWL 100050	NK 80	100	50	M 14	3.700	6.000	A2280100501080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■	NEW



### LWV, Flap rolls of abrasive fleece for conditioning machines

Ordering example: A2286100500104



**Packing unit:**

LWV 100050 = 2 pcs. per type

LWV 100100 = 1 pc. per type

A = reg. Aluminium Oxide

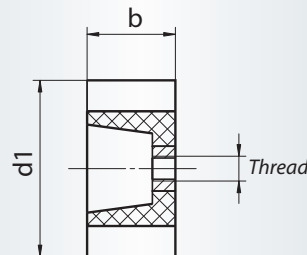
Machines to suit: page 292

Description	Grits	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
LWV 100050	A 104	100	50	19	2.800	6.000	A2286100500104	1 2 3 4 5 6 7 8	■
LWV 100050	A 106	100	50	19	2.800	6.000	A2286100500106	1 2 3 4 5 6 7 8	■
LWV 100050	A 107	100	50	19	2.800	6.000	A2286100500107	1 2 3 4 5 6 7 8	■
LWV 100100	A 104	100	100	19	2.800	6.000	A22861001000104	1 2 3 4 5 6 7 8	■
LWV 100100	A 106	100	100	19	2.800	6.000	A22861001000106	1 2 3 4 5 6 7 8	■
LWV 100100	A 107	100	100	19	2.800	6.000	A22861001000107	1 2 3 4 5 6 7 8	■



### LWV, Flap rolls of abrasive fleece with thread

Ordering example: A2286100501104



**Packing unit:**

2 pcs. per type

A = reg. Aluminium Oxide

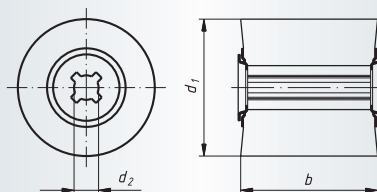
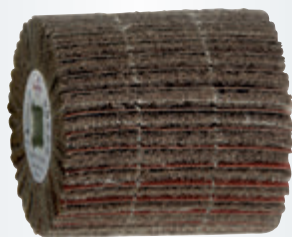
Suitable for controlled angle grinders.

Description	Grits	d <sub>1</sub> mm	b mm	Thread	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> LWV 100050	A 104	100	50	M 14	2.800	6.000	A2286100501104	1 2 3 4 5 6 7 8	■
<b>NEW</b> LWV 100050	A 106	100	50	M 14	2.800	6.000	A2286100501106	1 2 3 4 5 6 7 8	■
<b>NEW</b> LWV 100050	A 107	100	50	M 14	2.800	6.000	A2286100501107	1 2 3 4 5 6 7 8	■



LWM, Flap rolls of abrasive fleece/abrasive cloth combination

Ordering example: A22881001000120



**Packing unit:**  
1 pc. per type  
TF = Special quality for INOX  
Machines to suit: page 292

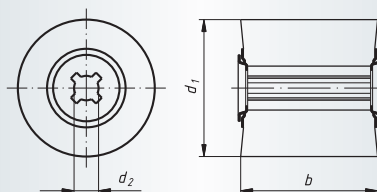
Description	Grits	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for
LWM 100100	TF 120/80	100	100	19	2.800	6.000	A22881001000120	1 2 3 4 5 6 7 8

Ideal for surface finishing of metalsheet components such as stainless steel sinks and containers



LWM, Flap rolls of abrasive fleece/abrasive cloth combination

Ordering example: A2288100500104



**Packing unit:**  
LWM 100050 = 2 pcs. per type  
LWM 100100 = 1 pc. per type  
A = reg. Aluminium Oxide  
Machines to suit: page 292

Description	Grits	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for
LWM 100050	A 104/80	100	50	19	2.800	6.000	A2288100500104	1 2 3 4 5 6 7 8
LWM 100050	A 106/150	100	50	19	2.800	6.000	A2288100500106	1 2 3 4 5 6 7 8
LWM 100050	A 107/240	100	50	19	2.800	6.000	A2288100500107	1 2 3 4 5 6 7 8
LWM 100100	A 104/80	100	100	19	2.800	6.000	A22881001000104	1 2 3 4 5 6 7 8
LWM 100100	A 106/150	100	100	19	2.800	6.000	A22881001000106	1 2 3 4 5 6 7 8
LWM 100100	A 107/240	100	100	19	2.800	6.000	A22881001000107	1 2 3 4 5 6 7 8


# 292 Flap rolls

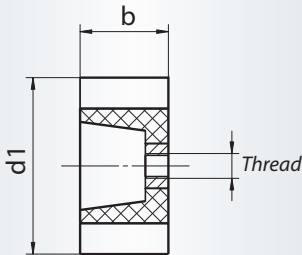


Industry

## LWM, Flap rolls of abrasive fleece/abrasive cloth combination with thread

Ordering example: A2288100501104





**Packing unit:**  
2 pcs. per type  
A = reg. Aluminium Oxide  
Suitable for controlled angle grinders.


Description	Grits	d <sub>1</sub> mm	b mm	Thread	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> LWM 100050	A 104/80	100	50	M 14	2.800	6.000	A2288100501104	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> LWM 100050	A 106/150	100	50	M 14	2.800	6.000	A2288100501106	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

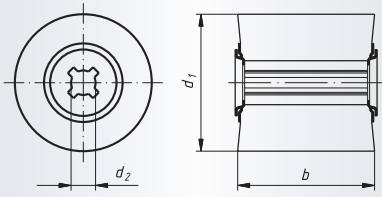


Industry

## LWF, Sinus-Abrasive rolls of abrasive fleece for conditioning machines

Ordering example: A2281100500104





**Packing unit:**  
LWF 100050 = 2 pcs. per type  
LWF 100100 = 1 pc. per type  
A = reg. Aluminium Oxide  
C = Silicon carbide  
Machines to suit: page 292

Description	Grits	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
LWF 100050	A 104	100	50	19	2.800	3.800	A2281100500104	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWF 100050	A 106	100	50	19	2.800	3.800	A2281100500106	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWF 100050	C 208	100	50	19	2.800	3.800	A2281100500208	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
LWF 100100	A 104	100	100	19	2.800	3.800	A22811001000104	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWF 100100	A 106	100	100	19	2.800	3.800	A22811001000106	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
LWF 100100	C 208	100	100	19	2.800	3.800	A22811001000208	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■



Industry

## Conditioning machine ESM 1310

Ordering example: A3995ESM1310



**Packing unit:**  
1 pc.  
**Weight:** approx. 2,9 kg

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

## Abrasive Bands and Mandrels

**222** Qualities and Applications

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**294** General Information

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**295** Abrasive Bands, cylindrical

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**301** Mandrels for cylindrical shape

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**302** Abrasive Bands, cylindrical, unlined

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**302** Mandrels for cylindrical shape, soft

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**303** Abrasive Bands, conical

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**303** Mandrels for conical shape

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**304** Grinding rolls

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**304** Mounting device for grinding rolls

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**305** Finishing belts

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**373** Power tools

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### Product line marking

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



## Information

### **SBZY, Abrasive Bands, cylindrical**

LUKAS offers a wide selection of abrasive bands and the corresponding mandrel.

They are available in numerous dimensions and qualities.

Abrasive bands are manufactured from coated abrasive material which is spirally wound onto a cloth backing. They are mounted onto the appropriate mandrel and used on hand-held machines (straight grinders or with flexible shafts)

#### **Examples of application:**

- preparation work
- light deburring
- polishing
- surface and profile grinding
- fettling

### **STZY, Mandrels for cylindrical shape**

Our mandrels serve exclusively as the means of mounting the cylindrical abrasive bands. Due to the special slots in the mandrel, the abrasive band is firmly secured to the mandrel by the increasing spindle speed.

### **SBKE, Abrasive Bands, conical**

Conical shaped abrasive bands are in principle identical to the cylindrical type with regards to the construction and application. The large taper allows the grinding of difficult-to-access areas of the workpiece.

### **STKE, Mandrels for conical shape**

Our mandrels serve exclusively as the means of mounting the conical abrasive bands. Due to the special slots in the mandrel, the abrasive band is firmly secured to the mandrel by the increasing spindle speed.

### **SBZY, Abrasive Bands, cylindrical unlined**

These particularly flexible abrasive bands are manufactured from abrasive cloth. They are used on hand-held machines (straight grinders or with flexible shaft) and are mounted onto the appropriate mandrel.

### **STWS, Mounting device for grinding rolls**

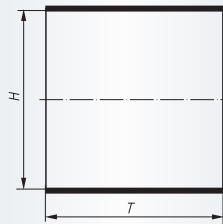
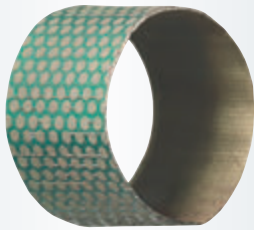
These mandrels are produced in a specially soft quality; the 19 mm bore with the four keyways mounted with the abrasive band are used on surface conditioning machines.



**High Performance**

**SBZY, Abrasive Bands, cylindrical shape, Diamond**

Ordering example: A301003030126



**Packing unit:**

5 pcs. per type

n<sub>max</sub>: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

optimal cutting speed: 10–20 m/s

D = Diamond coated abrasive cloth

Description	Grits	H mm	T mm	Product-Number	recommended for
SBZY 03030	D126	30	30	A301003030126	7 8 9 ■
SBZY 04530	D126	45	30	A301004530126	7 8 9 ■

Diamond abrasive belts are perfect for dealing with hard layers, such as wear protection coatings or armouring made from tungsten, chromium or titanium carbide.

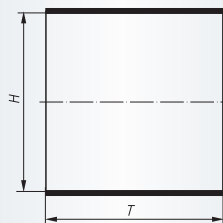
They are also great for other hard materials like glass, ceramic, stone, enamel, carbide or abrasive composite materials from glass or carbon fibre reinforced plastic. Another application is for materials used for turbines and power trains, e.g., hastelloy, inconel and titanium alloys.



**High Performance**

**SBZY, Abrasive Bands, cylindrical shape, Z Power**

Ordering example: A241203030036



**Packing unit:**

50 pcs. per type

SBZY 06030 = 25 pcs

n<sub>max</sub>: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

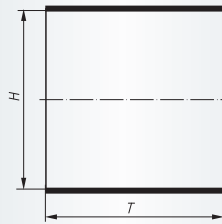
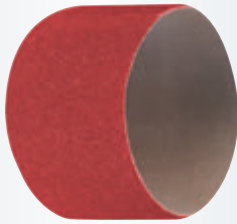
Z POWER = zirconia alum. oxide POWER

Description	Grits	H mm	T mm	Product-Number	recommended for
SBZY 03030	Z POWER 36	30	30	A241203030036	2 3 4 5 7 ■
SBZY 03030	Z POWER 50	30	30	A241203030050	2 3 4 5 7 ■
SBZY 03030	Z POWER 60	30	30	A241203030060	2 3 4 5 7 ■
SBZY 03030	Z POWER 80	30	30	A241203030080	2 3 4 5 7 ■
SBZY 04530	Z POWER 36	45	30	A241204530036	2 3 4 5 7 ■
SBZY 04530	Z POWER 50	45	30	A241204530050	2 3 4 5 7 ■
SBZY 04530	Z POWER 60	45	30	A241204530060	2 3 4 5 7 ■
SBZY 04530	Z POWER 80	45	30	A241204530080	2 3 4 5 7 ■
SBZY 06030	Z POWER 36	60	30	A241206030036	2 3 4 5 7 ■
SBZY 06030	Z POWER 50	60	30	A241206030050	2 3 4 5 7 ■
SBZY 06030	Z POWER 60	60	30	A241206030060	2 3 4 5 7 ■
SBZY 06030	Z POWER 80	60	30	A241206030080	2 3 4 5 7 ■



**SBZY, Abrasive Bands, cylindrical shape, Ceramic**

Ordering example: A240603030040



**Packing unit:**

50 pcs. per type

SBZY 06030 = 25 pcs.

n<sub>max</sub>: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

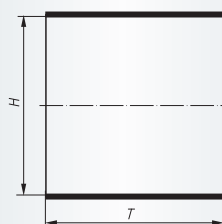
CERAMIC = Abrasive cloth ceramic grain

Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 03030	Ceramic 40	30	30	A240603030040	1 2 3 4 5 7	■
SBZY 03030	Ceramic 60	30	30	A240603030060	1 2 3 4 5 7	■
SBZY 04530	Ceramic 40	45	30	A240604530040	1 2 3 4 5 7	■
SBZY 04530	Ceramic 60	45	30	A240604530060	1 2 3 4 5 7	■
SBZY 06030	Ceramic 40	60	30	A240606030040	1 2 3 4 5 7	■
SBZY 06030	Ceramic 60	60	30	A240606030060	1 2 3 4 5 7	■



**SBZY, Abrasive Bands, cylindrical shape, reg. Aluminium Oxide**

Ordering example: A240000810150



**Packing unit:**

50 pcs. per type

n<sub>max</sub>: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

NK = reg. Aluminium Oxide

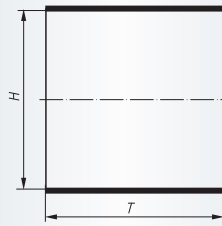
Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 00810	NK 150	8	10	A240000810150	1 2 3 4 5 6 7 8	■
SBZY 01010	NK 80	10	10	A240001010080	1 2 3 4 5 6 7 8	■
SBZY 01010	NK 150	10	10	A240001010150	1 2 3 4 5 6 7 8	■
SBZY 01010	NK 240	10	10	A240001010240	1 2 3 4 5 6 7 8	■
SBZY 01010	NK 320	10	10	A240001010320	1 2 3 4 5 6 7 8	■
SBZY 01020	NK 80	10	20	A240001020080	1 2 3 4 5 6 7 8	■
SBZY 01020	NK 150	10	20	A240001020150	1 2 3 4 5 6 7 8	■
SBZY 01020	NK 240	10	20	A240001020240	1 2 3 4 5 6 7 8	■
SBZY 01020	NK 320	10	20	A240001020320	1 2 3 4 5 6 7 8	■
SBZY 01210	NK 80	12	10	A240001210080	1 2 3 4 5 6 7 8	■
SBZY 01210	NK 150	12	10	A240001210150	1 2 3 4 5 6 7 8	■
SBZY 01210	NK 240	12	10	A240001210240	1 2 3 4 5 6 7 8	■
SBZY 01213	NK 80	12	13	A240001213080	1 2 3 4 5 6 7 8	■
SBZY 01213	NK 120	12	13	A240001213120	1 2 3 4 5 6 7 8	■
SBZY 01213	NK 240	12	13	A240001213240	1 2 3 4 5 6 7 8	■
SBZY 01225	NK 80	12	25	A240001225080	1 2 3 4 5 6 7 8	■
SBZY 01225	NK 150	12	25	A240001225150	1 2 3 4 5 6 7 8	■
SBZY 01225	NK 240	12	25	A240001225240	1 2 3 4 5 6 7 8	■





**SBZY, Abrasive Bands, cylindrical shape, reg. Aluminium Oxide**

Ordering example: A240001225320



**Packing unit:**

50 pcs. per type

n max.: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

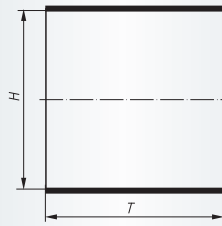
NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 01225	NK 320	12	25	A240001225320	1 2 3 4 5 6 7 8	■
SBZY 01250	NK 80	12	50	A240001250080	1 2 3 4 5 6 7 8	■
SBZY 01310	NK 80	13	10	A240001310080	1 2 3 4 5 6 7 8	■
SBZY 01310	NK 150	13	10	A240001310150	1 2 3 4 5 6 7 8	■
SBZY 01325	NK 80	13	25	A240001325080	1 2 3 4 5 6 7 8	■
SBZY 01325	NK 150	13	25	A240001325150	1 2 3 4 5 6 7 8	■
SBZY 01510	NK 60	15	10	A240001510060	1 2 3 4 5 6 7 8	■
SBZY 01510	NK 80	15	10	A240001510080	1 2 3 4 5 6 7 8	■
SBZY 01510	NK 150	15	10	A240001510150	1 2 3 4 5 6 7 8	■
SBZY 01510	NK 240	15	10	A240001510240	1 2 3 4 5 6 7 8	■
SBZY 01510	NK 320	15	10	A240001510320	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 40	15	30	A240001530040	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 50	15	30	A240001530050	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 60	15	30	A240001530060	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 80	15	30	A240001530080	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 120	15	30	A240001530120	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 150	15	30	A240001530150	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 240	15	30	A240001530240	1 2 3 4 5 6 7 8	■
SBZY 01530	NK 320	15	30	A240001530320	1 2 3 4 5 6 7 8	■
SBZY 01550	NK 50	15	50	A240001550050	1 2 3 4 5 6 7 8	■
SBZY 01925	NK 50	19	25	A240001925050	1 2 3 4 5 6 7 8	■
SBZY 01925	NK 60	19	25	A240001925060	1 2 3 4 5 6 7 8	■
SBZY 01925	NK 80	19	25	A240001925080	1 2 3 4 5 6 7 8	■
SBZY 01925	NK 150	19	25	A240001925150	1 2 3 4 5 6 7 8	■
SBZY 02210	NK 150	22	10	A240002210150	1 2 3 4 5 6 7 8	■
SBZY 02210	NK 240	22	10	A240002210240	1 2 3 4 5 6 7 8	■
SBZY 02210	NK 320	22	10	A240002210320	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 50	22	20	A240002220050	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 60	22	20	A240002220060	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 80	22	20	A240002220080	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 150	22	20	A240002220150	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 240	22	20	A240002220240	1 2 3 4 5 6 7 8	■
SBZY 02220	NK 320	22	20	A240002220320	1 2 3 4 5 6 7 8	■
SBZY 02250	NK 50	22	50	A240002250050	1 2 3 4 5 6 7 8	■
SBZY 02525	NK 40	25	25	A240002525040	1 2 3 4 5 6 7 8	■
SBZY 02525	NK 50	25	25	A240002525050	1 2 3 4 5 6 7 8	■
SBZY 02525	NK 60	25	25	A240002525060	1 2 3 4 5 6 7 8	■
SBZY 02525	NK 80	25	25	A240002525080	1 2 3 4 5 6 7 8	■
SBZY 02525	NK 150	25	25	A240002525150	1 2 3 4 5 6 7 8	■



## SBZY, Abrasive Bands, cylindrical shape, reg. Aluminium Oxide

Ordering example: A240003020150



**Packing unit:**

50 pcs. per type

n max.: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

NK = reg. Aluminium Oxide

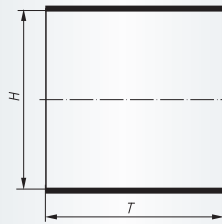
Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 03020	NK 40	30	20	A240003020040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03020	NK 50	30	20	A240003020050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03020	NK 60	30	20	A240003020060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03020	NK 80	30	20	A240003020080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03020	NK 150	30	20	A240003020150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03020	NK 240	30	20	A240003020240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 40	30	30	A240003030040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 50	30	30	A240003030050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 60	30	30	A240003030060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 80	30	30	A240003030080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 150	30	30	A240003030150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 240	30	30	A240003030240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 320	30	30	A240003030320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03825	NK 50	38	25	A240003825050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03825	NK 60	38	25	A240003825060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03825	NK 80	38	25	A240003825080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03825	NK 150	38	25	A240003825150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03825	NK 40	38	25	A240003825040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 40	45	30	A240004530040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 50	45	30	A240004530050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 60	45	30	A240004530060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 80	45	30	A240004530080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 150	45	30	A240004530150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 240	45	30	A240004530240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 320	45	30	A240004530320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 05125	NK 40	51	25	A240005125040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 05125	NK 50	51	25	A240005125050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 05125	NK 60	51	25	A240005125060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 05125	NK 80	51	25	A240005125080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 05125	NK 150	51	25	A240005125150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 06030	NK 40	60	30	A240006030040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 06030	NK 50	60	30	A240006030050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 06030	NK 60	60	30	A240006030060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 06030	NK 80	60	30	A240006030080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 06030	NK 150	60	30	A240006030150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 07530	NK 40	75	30	A240007530040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 07530	NK 50	75	30	A240007530050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 07530	NK 60	75	30	A240007530060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 07530	NK 80	75	30	A240007530080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**SBZY, Abrasive Bands, cylindrical shape, reg. Aluminium Oxide**

Ordering example: A240007530080



**Packing unit:**

50 pcs. per type

n max.: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

NK = reg. Aluminium Oxide

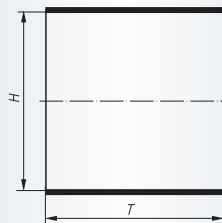
Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 07530	NK 150	75	30	A240007530150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 10040	NK 40	100	40	A240010040040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 10040	NK 50	100	40	A240010040050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 10040	NK 60	100	40	A240010040060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 10040	NK 80	100	40	A240010040080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 10040	NK 150	100	40	A240010040150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**SBZY, Abrasive Bands, cylindrical shape, Zirconia Aluminium Oxide**

Ordering example: A240201325050



**Packing unit:**

50 pcs. per type

n max.: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

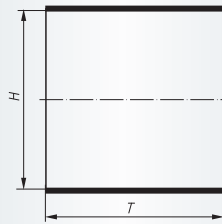
ZK = Zirconia Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 01325	ZK 50	13	25	A240201325050	① ② ③ ④ ⑤ ⑦	■
SBZY 01325	ZK 80	13	25	A240201325080	① ② ③ ④ ⑤ ⑦	■
SBZY 01530	ZK 50	15	30	A240201530050	① ② ③ ④ ⑤ ⑦	■
SBZY 01530	ZK 60	15	30	A240201530060	① ② ③ ④ ⑤ ⑦	■
SBZY 01530	ZK 80	15	30	A240201530080	① ② ③ ④ ⑤ ⑦	■
SBZY 01925	ZK 36	19	25	A240201925036	① ② ③ ④ ⑤ ⑦	■
SBZY 01925	ZK 50	19	25	A240201925050	① ② ③ ④ ⑤ ⑦	■
SBZY 01925	ZK 80	19	25	A240201925080	① ② ③ ④ ⑤ ⑦	■
SBZY 02220	ZK 36	22	20	A240202220036	① ② ③ ④ ⑤ ⑦	■
SBZY 02220	ZK 50	22	20	A240202220050	① ② ③ ④ ⑤ ⑦	■
SBZY 02220	ZK 60	22	20	A240202220060	① ② ③ ④ ⑤ ⑦	■
SBZY 02525	ZK 36	25	25	A240202525036	① ② ③ ④ ⑤ ⑦	■
SBZY 02525	ZK 50	25	25	A240202525050	① ② ③ ④ ⑤ ⑦	■
SBZY 02525	ZK 80	25	25	A240202525080	① ② ③ ④ ⑤ ⑦	■
SBZY 03030	ZK 36	30	30	A240203030036	① ② ③ ④ ⑤ ⑦	■
SBZY 03030	ZK 50	30	30	A240203030050	① ② ③ ④ ⑤ ⑦	■
SBZY 03030	ZK 60	30	30	A240203030060	① ② ③ ④ ⑤ ⑦	■



### SBZY, Abrasive Bands, cylindrical shape, Zirconia Aluminium Oxide

Ordering example: A240203030080



**Packing unit:**

50 pcs. per type

n max.: please refer to band mandrels on page 301

Further dimensions and grit sizes on request.

ZK = Zirconia Aluminium Oxide

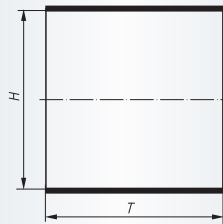
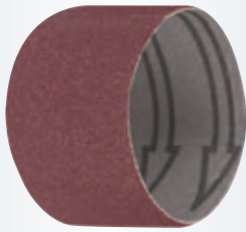
Description	Grits	H mm	T mm	Product-Number	recommended for									
SBZY 03030	ZK 80	30	30	A240203030080	1	2	3	4	5	7				■
SBZY 03825	ZK 36	38	25	A240203825036	1	2	3	4	5	7				■
SBZY 03825	ZK 50	38	25	A240203825050	1	2	3	4	5	7				■
SBZY 03825	ZK 80	38	25	A240203825080	1	2	3	4	5	7				■
SBZY 04530	ZK 36	45	30	A240204530036	1	2	3	4	5	7				■
SBZY 04530	ZK 50	45	30	A240204530050	1	2	3	4	5	7				■
SBZY 04530	ZK 60	45	30	A240204530060	1	2	3	4	5	7				■
SBZY 04530	ZK 80	45	30	A240204530080	1	2	3	4	5	7				■
SBZY 05125	ZK 36	51	25	A240205125036	1	2	3	4	5	7				■
SBZY 05125	ZK 50	51	25	A240205125050	1	2	3	4	5	7				■
SBZY 05125	ZK 80	51	25	A240205125080	1	2	3	4	5	7				■
SBZY 06030	ZK 36	60	30	A240206030036	1	2	3	4	5	7				■
SBZY 06030	ZK 50	60	30	A240206030050	1	2	3	4	5	7				■
SBZY 06030	ZK 60	60	30	A240206030060	1	2	3	4	5	7				■
SBZY 06030	ZK 80	60	30	A240206030080	1	2	3	4	5	7				■





### SBZY, Abrasive Bands, cylindrical, unlined

Ordering example: A300003030080



**Packing unit:**

50 pcs. per type

SBZY 06030 = 25 psc.

$n_{max}$ : please refer to band mandrels on page 301 and 302

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 03030	NK 80	30	30	A300003030080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 120	30	30	A300003030120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 03030	NK 150	30	30	A300003030150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 80	45	30	A300004530080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 120	45	30	A300004530120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 04530	NK 150	45	30	A300004530150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

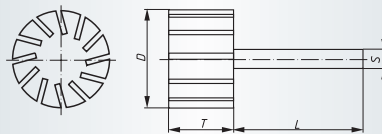
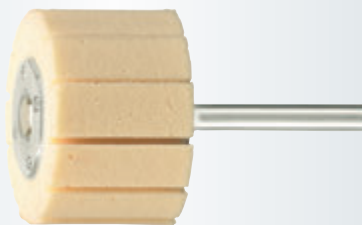
**Characteristics:**

- Particularly flexible



### STZY, Mandrels for cylindrical shape, soft

Ordering example: A2502030306

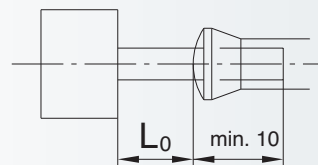


**Packing unit:**

5 pcs. per type

Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ (1/min)	Product-Number		
STZY 03030.06	Soft	30	30	6	40	9.500	A2502030306		■
STZY 04530.06	Soft	45	30	6	40	6.300	A2502045306		■
STZY 06030.06	Soft	60	30	6	40	4.700	A2502060306		■

The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.

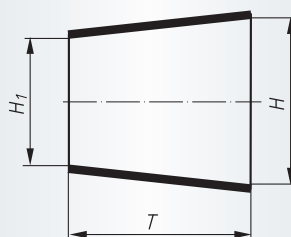




Industry

**SBKE, Abrasive Bands, conical shape**

Ordering example: A300002063040



**Packing unit:**

50 pcs. per type

n<sub>max</sub> : please refer to band mandrels on page 303

NK = reg. Aluminium Oxide

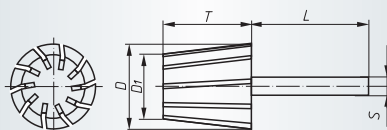
Description	Grits	H mm	T mm	H <sub>1</sub> mm	Product-Number	recommended for	
SBKE 02063	NK 40	20	63	14	A300002063040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02063	NK 60	20	63	14	A300002063060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02063	NK 80	20	63	14	A300002063080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02063	NK 150	20	63	14	A300002063150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02930	NK 40	29	30	22	A300002930040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02930	NK 50	29	30	22	A300002930050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02930	NK 60	29	30	22	A300002930060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02930	NK 80	29	30	22	A300002930080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 02930	NK 150	29	30	22	A300002930150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 03660	NK 40	36	60	22	A300003660040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 03660	NK 50	36	60	22	A300003660050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 03660	NK 60	36	60	22	A300003660060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 03660	NK 80	36	60	22	A300003660080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBKE 03660	NK 150	36	60	22	A300003660150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**STKE, Mandrels for conical shape**

Ordering example: A2500020636

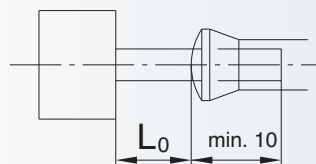


**Packing unit:**

5 pcs. per type

Description	D mm	T mm	S mm	D <sub>1</sub> mm	L mm	Type	n <sub>max</sub> (1/min)	Product-Number	
STKE 02063.06	20	63	6	14	40	Hart	21.000	A2500020636	■
STKE 02930.06	29	30	6	22	40	Hart	21.000	A2500029306	■
STKE 03660.06	36	60	6	22	40	Hart	13.500	A2500036606	■

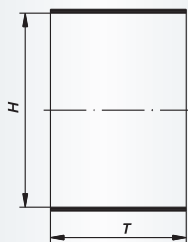
The stated maximum operating speed only applies to a maximum overhang L<sub>0</sub> of 20 mm. Other overhang dimensions must be calculated separately.





### SBZY, Grinding rolls

Ordering example: A2400100100060



**Packing unit:**

6 pcs. per type

$n_{max}$ : please refer to band mandrels on page 304

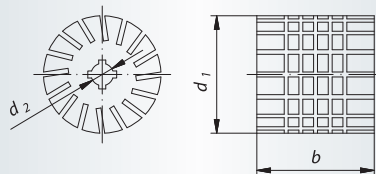
NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SBZY 100100	NK 60	100	100	A2400100100060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 100100	NK 80	100	100	A2400100100080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 100100	NK 120	100	100	A2400100100120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBZY 100100	NK 150	100	100	A2400100100150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



### STWS, Mounting device for grinding rolls

Ordering example: A2502100100



**Packing unit:**

1 pcs. per type

The bore  $\varnothing$  19 mm has a keyway of 6 mm.

Machines to suit: Page 390

Description	Grits	$d_1$ mm	b mm	Bore $d_2$ mm	$n_{max}$ (1/min)	Product-Number	
STWS 100100	Soft	100	100	19	2.800	A2502100100	■





Industry

**SBL, finishing belts**

Ordering example: A3000130305040T01

**Packing unit:**  
100 pcs. per type

Used on our pneumatic belt grinder  
AMIN 30 BSH, page 305.

Peripheral speed: 28 m/s

NK = reg. Aluminium Oxide  
ZK = Zirconia Alum. Oxide

Description	Grits	B mm	Length mm	Lining	Product-Number	recommended for	
SBLT	ZK 40	13	305	robust-flexible	A3000130305040T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 60	13	305	robust-flexible	A3000130305060T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLT	ZK 60	13	305	robust-flexible	A3000130305060T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 80	13	305	robust-flexible	A3000130305080T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLX	NK 80	13	305	robust	A3000130305080X	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLT	ZK 80	13	305	robust-flexible	A3000130305080T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 120	13	305	robust-flexible	A3000130305120T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLX	NK 120	13	305	robust	A3000130305120X	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**Abrasive belt grinder – insulated**

Ordering example: A3993302113

**Length:** approx. 325 mm

**Height:** approx. 86 mm

**Weight:** approx. 0,90 kg

**Drive:** vane motor

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Belt peripheral speed m/s	Hose-nominal size mm	Product-Number	
AMIN 30 BSH	Lever	30.000	0,3	0,45	28	6	A3993302113	■

**Included with the machine:**

an abrasive belt mounting arm for long belts in dimension 13 x 305 mm, inlet and exhaust air hoses plus silencer, collet for 6 mm, spanner

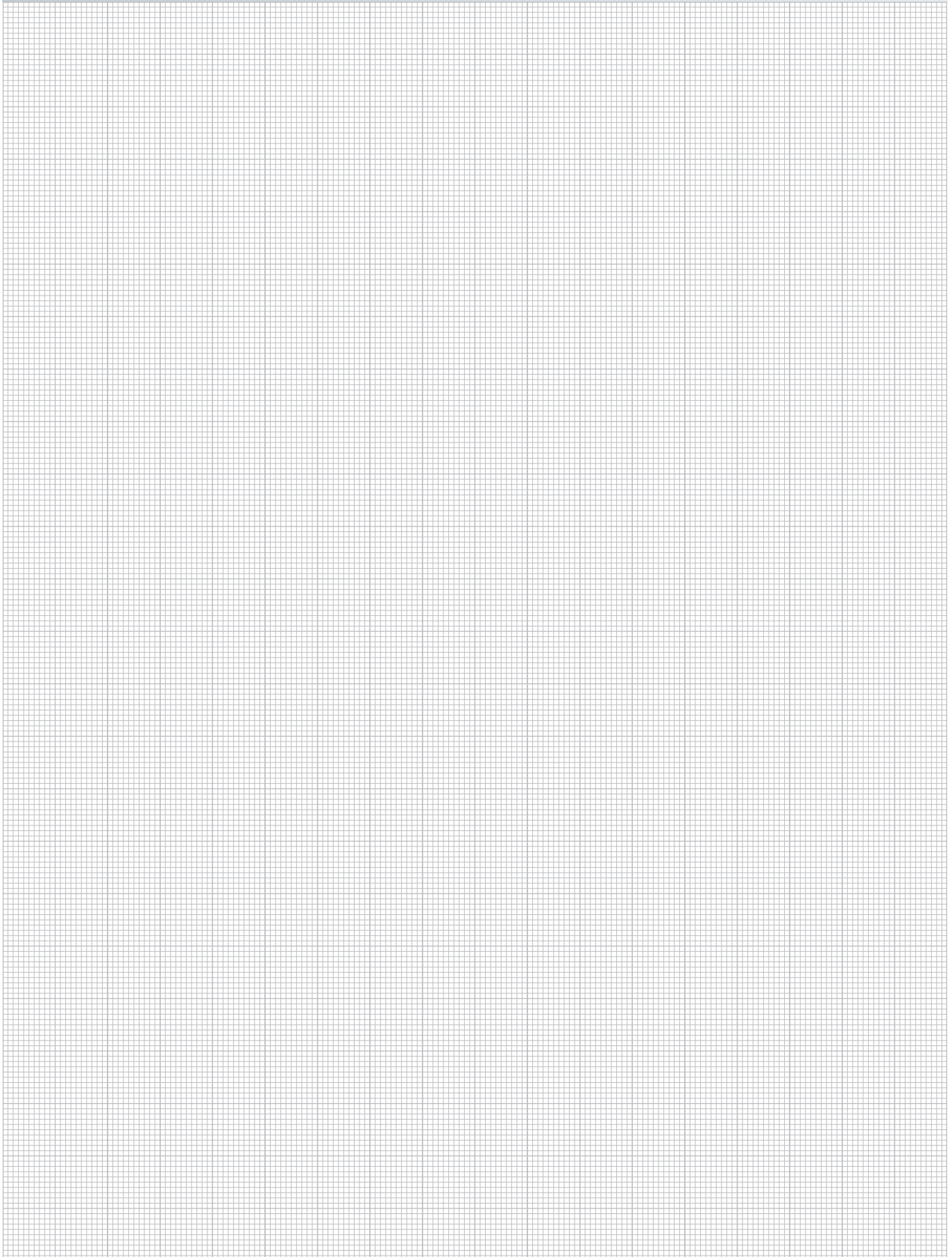
**Extra equipment:**

collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"  
Abrasive belt extensions in various dimensions

**Available ex-stock:**

long belts 13 x 305 mm

Notes

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

# Abrasive Rolls and Mandrels

**222** Qualities and Applications

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**308** General Information

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**309** Abrasive rolls, cylindrical

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**310** Abrasive rolls, conical

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**310** Mandrels

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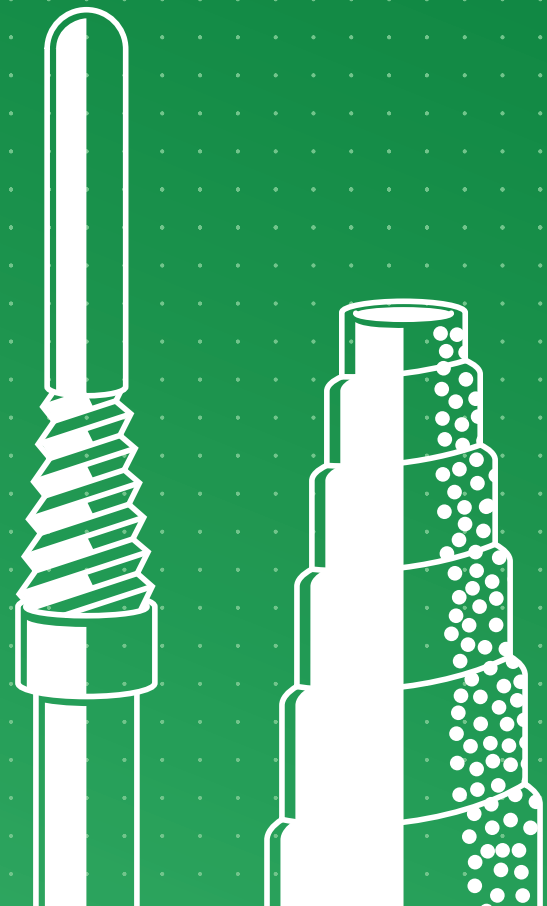
**373** Power tools

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## Product line marking

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



## Information

### **SRZY, Abrasive rolls, cylindrical and SRKE Abrasive rolls, conical**

These abrasive rolls consist of wound coated abrasive material. Their construction guarantees a free-cutting tool; the outer coating wears during the grinding process which then allows new grain particle to be exposed. Please take note of the rotational direction- particularly due to the method of construction!

#### **Examples of applicatin:**

- deburring
- preparation work
- fettling

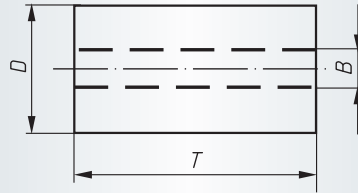
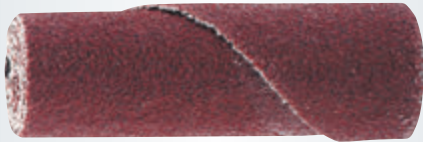
### **SRTR, Mandrels**

Reusable mandrels for the safe mounting of cylindrical and conical abrasive rolls.



**SRZY, Abrasive rolls, cylindrical**

Ordering example: A240300625080



**Packing unit:**  
50 pcs. per type  
NK = reg. Aluminium Oxide

Description	Grits	D mm	T mm	B mm	n max. (1/min)	Suitable mandrels	Product-Number	recommended for									
SRZY 0625 B.03	NK 80	6	25	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240300625080	1	2	3	4	5	6	7	8		■
SRZY 0625 B.03	NK 150	6	25	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240300625150	1	2	3	4	5	6	7	8		■
SRZY 0638 B.03	NK 80	6	38	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240300638080	1	2	3	4	5	6	7	8		■
SRZY 0638 B.03	NK 150	6	38	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240300638150	1	2	3	4	5	6	7	8		■
SRZY 1025 B.03	NK 50	10	25	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240301025050	1	2	3	4	5	6	7	8		■
SRZY 1025 B.03	NK 80	10	25	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240301025080	1	2	3	4	5	6	7	8		■
SRZY 1025 B.03	NK 150	10	25	3	26.000	SRTR 3063.03 or SRTR 3063.06	A240301025150	1	2	3	4	5	6	7	8		■
SRZY 1038 B.03	NK 50	10	38	3	26.000	SRTR 3070.06	A240301038050	1	2	3	4	5	6	7	8		■
SRZY 1038 B.03	NK 80	10	38	3	26.000	SRTR 3070.06	A240301038080	1	2	3	4	5	6	7	8		■
SRZY 1038 B.03	NK 150	10	38	3	26.000	SRTR 3070.06	A240301038150	1	2	3	4	5	6	7	8		■
SRZY 1325 B.03	NK 50	13	25	3	26.000	SRTR 3063.06	A240301325050	1	2	3	4	5	6	7	8		■
SRZY 1325 B.03	NK 80	13	25	3	26.000	SRTR 3063.06	A240301325080	1	2	3	4	5	6	7	8		■
SRZY 1325 B.03	NK 150	13	25	3	26.000	SRTR 3063.06	A240301325150	1	2	3	4	5	6	7	8		■
SRZY 1338 B.03	NK 50	13	38	3	26.000	SRTR 3070.06	A240301338050	1	2	3	4	5	6	7	8		■
SRZY 1338 B.03	NK 80	13	38	3	26.000	SRTR 3070.06	A240301338080	1	2	3	4	5	6	7	8		■
SRZY 1338 B.03	NK 150	13	38	3	26.000	SRTR 3070.06	A240301338150	1	2	3	4	5	6	7	8		■
SRZY 2038 B.05	NK 50	20	38	5	18.000	SRTR 5085.06	A240302038050	1	2	3	4	5	6	7	8		■
SRZY 2038 B.05	NK 80	20	38	5	18.000	SRTR 5085.06	A240302038080	1	2	3	4	5	6	7	8		■
SRZY 2038 B.05	NK 150	20	38	5	18.000	SRTR 5085.06	A240302038150	1	2	3	4	5	6	7	8		■
SRZY 2050 B.05	NK 50	20	50	5	18.000	SRTR 5085.06	A240302050050	1	2	3	4	5	6	7	8		■
SRZY 2050 B.05	NK 80	20	50	5	18.000	SRTR 5085.06	A240302050080	1	2	3	4	5	6	7	8		■



## Abrasive Caps and Abrasive Sleeves

**222** Qualities and Applications

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**312** General Information

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**313** Abrasive caps, cylindrical

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**314** Mandrel, cylindrical

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**315** Abrasive caps, cylindrical round nose

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**316** Mandrel, cylindrical round nose

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**317** Abrasive caps, cylindrical pointed nose

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**318** Mandrel, cylindrical pointed nose

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**319** Abrasive caps, conical round nose

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**320** Mandrel, conical round nose

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**321** Abrasive sleeves, tapered

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**321** Mandrel, tapered

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**322** Abrasive caps, assortment

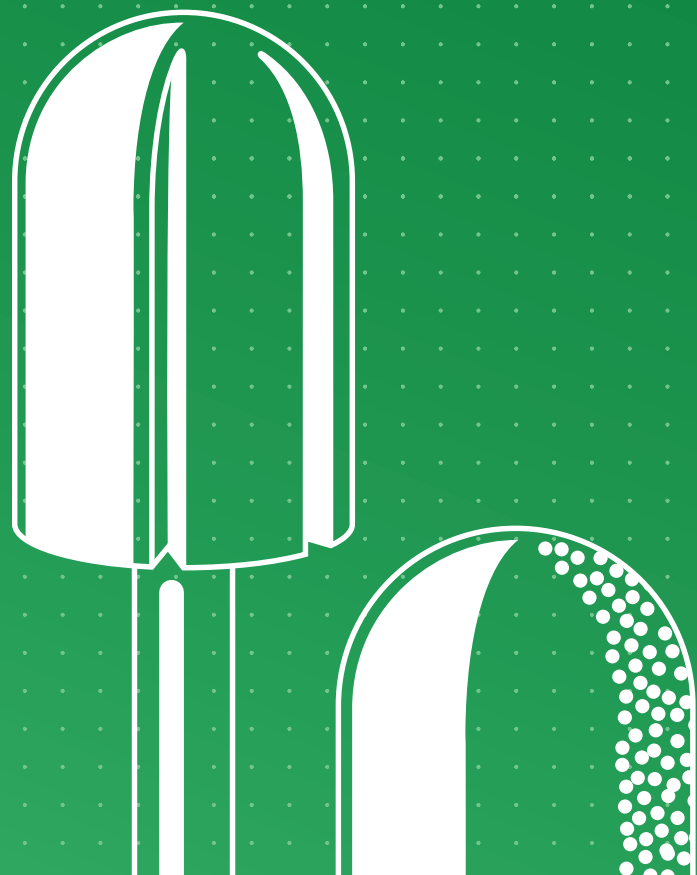
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**373** Power tools

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### Product line marking

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



## Information

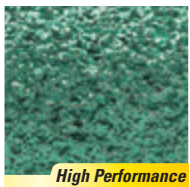
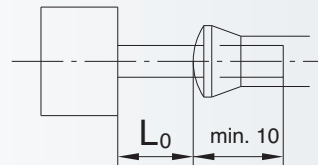
The LUKAS abrasive caps and sleeves are manufactured from high quality coated abrasive material, and are used in conjunction with the appropriate high precision mandrel. We offer a great variety of different tools and mandrels which covers a wide spectrum of applications.

### Examples of application:

- fine and extremely fine machining particularly in areas difficult to access
- tool, mould and model making

## Maximum operating speed

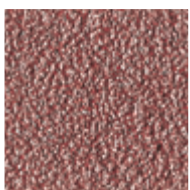
The maximum operating speed for abrasive caps is stated in the respective table of mandrels. The indicated maximum operating speeds are only valid for a maximum overhang length  $L_0$  of 15 mm. Other overhang dimensions must be calculated separately.



High Performance

### Abrasive caps, special, NKS

Special quality for the machining of corrosion and heat-resistant steels for tool and mould making. The top size coating with reactive fillers leads to higher stock removal and increased service life.



### Abrasive caps, universal, NK

Universal quality for the machining of metal, plastics, wood and many other materials.

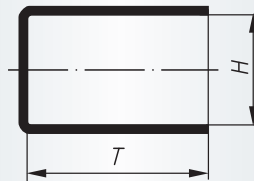




**High Performance**

**SKZYS, Abrasive caps special, Cylindrical shape**

Ordering example: A21020051080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 314

NKS = Aluminium Oxide with special coating

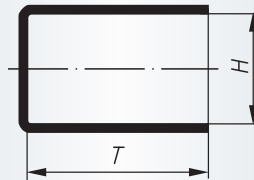
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKZYS 0510	NKS 80	5	10	A21020051080	1 2 3 4 5 6 7 8	■
SKZYS 0510	NKS 150	5	10	A21020051150	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 60	7	12	A21020071060	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 80	7	12	A21020071080	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 150	7	12	A21020071150	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 60	10	15	A21020101060	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 80	10	15	A21020101080	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 150	10	15	A21020101150	1 2 3 4 5 6 7 8	■



**Industry**

**SKZY, Abrasive caps universal, Cylindrical shape**

Ordering example: A21000051080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 314

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKZY 0510	NK 80	5	10	A21000051080	1 2 3 4 5 6 7 8	■
SKZY 0510	NK 150	5	10	A21000051150	1 2 3 4 5 6 7 8	■
SKZY 0510	NK 320	5	10	A21000051320	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 60	7	12	A21000071060	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 80	7	12	A21000071080	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 150	7	12	A21000071150	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 320	7	12	A21000071320	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 60	10	15	A21000101060	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 80	10	15	A21000101080	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 150	10	15	A21000101150	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 320	10	15	A21000101320	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 60	13	17	A21000131060	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 80	13	17	A21000131080	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 150	13	17	A21000131150	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 320	13	17	A21000131320	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 60	16	26	A21000161060	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 80	16	26	A21000161080	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 150	16	26	A21000161150	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 320	16	26	A21000161320	1 2 3 4 5 6 7 8	■

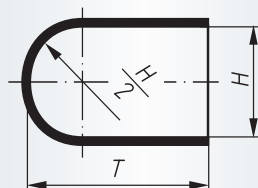




High Performance

**SKWRS, Abrasive caps special, Cylindrical round nose**

Ordering example: A21020052080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 316

Aluminium Oxide with special coating

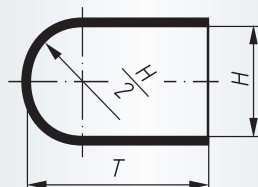
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWRS 0511	NKS 80	5	11	A21020052080	1 2 3 4 5 6 7 8	■
SKWRS 0511	NKS 150	5	11	A21020052150	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 60	7	13	A21020072060	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 80	7	13	A21020072080	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 150	7	13	A21020072150	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 60	10	15	A21020102060	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 80	10	15	A21020102080	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 150	10	15	A21020102150	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 60	13	19	A21020132060	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 80	13	19	A21020132080	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 150	13	19	A21020132150	1 2 3 4 5 6 7 8	■



Industry

**SKWR, Abrasive caps universal, Cylindrical round nose**

Ordering example: A21000052080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 316

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWR 0511	NK 80	5	11	A21000052080	1 2 3 4 5 6 7 8	■
SKWR 0511	NK 150	5	11	A21000052150	1 2 3 4 5 6 7 8	■
SKWR 0511	NK 320	5	11	A21000052320	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 60	7	13	A21000072060	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 80	7	13	A21000072080	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 150	7	13	A21000072150	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 320	7	13	A21000072320	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 60	10	15	A21000102060	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 80	10	15	A21000102080	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 150	10	15	A21000102150	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 320	10	15	A21000102320	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 60	13	19	A21000132060	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 80	13	19	A21000132080	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 150	13	19	A21000132150	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 320	13	19	A21000132320	1 2 3 4 5 6 7 8	■

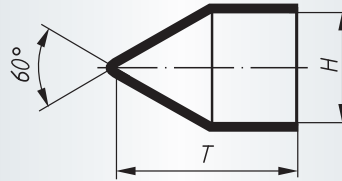
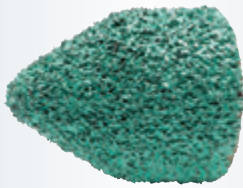




High Performance

**SKWKS, Abrasive caps special, Cylindrical pointed nose**

Ordering example: A21020053080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 318

NKS = Aluminium Oxide with special coating

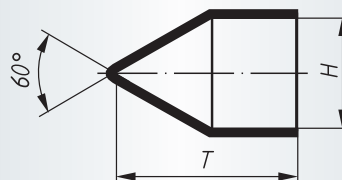
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWKS 0511	NKS 80	5	11	A21020053080	1 2 3 4 5 6 7 8	■
SKWKS 0511	NKS 150	5	11	A21020053150	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 60	7	13	A21020073060	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 80	7	13	A21020073080	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 150	7	13	A21020073150	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 60	10	15	A21020103060	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 80	10	15	A21020103080	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 150	10	15	A21020103150	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 60	13	19	A21020133060	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 80	13	19	A21020133080	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 150	13	19	A21020133150	1 2 3 4 5 6 7 8	■



Industry

**SKWK, Abrasive caps universal, Cylindrical pointed nose**

Ordering example: A21000053080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 318

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWK 0511	NK 80	5	11	A21000053080	1 2 3 4 5 6 7 8	■
SKWK 0511	NK 150	5	11	A21000053150	1 2 3 4 5 6 7 8	■
SKWK 0511	NK 320	5	11	A21000053320	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 60	7	13	A21000073060	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 80	7	13	A21000073080	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 150	7	13	A21000073150	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 320	7	13	A21000073320	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 60	10	15	A21000103060	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 80	10	15	A21000103080	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 150	10	15	A21000103150	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 320	10	15	A21000103320	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 60	13	19	A21000133060	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 80	13	19	A21000133080	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 150	13	19	A21000133150	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 320	13	19	A21000133320	1 2 3 4 5 6 7 8	■

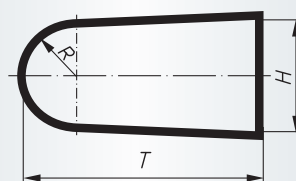




**High Performance**

**SKKES, Abrasive caps special, Conical round nose**

Ordering example: A2102163060



**Packing unit:**

25 pcs. per type

n<sub>max</sub>: please refer to the corresponding mandrel, page 320

NKS = Aluminium Oxide with special coating

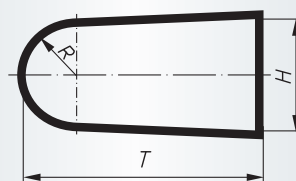
Description	Grits	H mm	T mm	≈R mm	Product-Number	recommended for	
SKKES 1632	NKS 60	16	32	7,5	A2102163060	1 2 3 4 5 6 7 8	■
SKKES 1632	NKS 80	16	32	7,5	A2102163080	1 2 3 4 5 6 7 8	■
SKKES 1632	NKS 150	16	32	7,5	A2102163150	1 2 3 4 5 6 7 8	■



**Industry**

**SKKE, Abrasive caps universal, Conical round nose**

Ordering example: A2100051080



**Packing unit:**

up to Ø 11 mm = 100 pcs. per type  
from Ø 16 mm = 25 pcs. per type

n<sub>max</sub>: please refer to the corresponding mandrel, page 320

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	≈R mm	Product-Number	recommended for	
SKKE 0515	NK 80	5	15	2	A2100051080	1 2 3 4 5 6 7 8	■
SKKE 0515	NK 150	5	15	2	A2100051150	1 2 3 4 5 6 7 8	■
SKKE 0515	NK 280	5	15	2	A2100051280	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 60	11	25	5	A2100112060	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 80	11	25	5	A2100112080	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 150	11	25	5	A2100112150	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 280	11	25	5	A2100112280	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 60	16	32	7,5	A2100163060	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 80	16	32	7,5	A2100163080	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 150	16	32	7,5	A2100163150	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 280	16	32	7,5	A2100163280	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 60	21	40	9,5	A2100224060	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 80	21	40	9,5	A2100224080	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 150	21	40	9,5	A2100224150	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 280	21	40	9,5	A2100224280	1 2 3 4 5 6 7 8	■



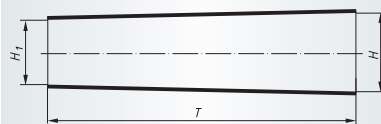




Industry

**SHKE, Abrasive sleeves, Conical shape**

Ordering example: A2101108080



**Packing unit:**

50 pcs. per type

n max. : please refer to the corresponding mandrel, page 321

NK = reg. Aluminium Oxide

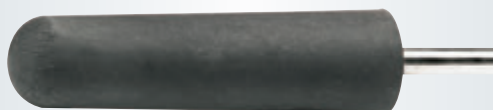
Description	Grits	H mm	T mm	H <sub>1</sub> mm	Product-Number	recommended for	
SHKE 0885	NK 80	8	85	4,5	A2101108080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 0885	NK 150	8	85	4,5	A2101108150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1385	NK 80	13	85	9,5	A2101158080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1385	NK 150	13	85	9,5	A2101158150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1885	NK 80	18	85	14,5	A2101208080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1885	NK 150	18	85	14,5	A2101208150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 2385	NK 80	23	85	19,5	A2101258080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 2385	NK 150	23	85	19,5	A2101258150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**GTKE, Mandrel, Conical shape**

Ordering example: A25001081



**Packing unit:**

5 pcs. per type

Description	D mm	T mm	L mm	≈R mm	Shank Ø x length mm	n max. (1/min)	Product-Number	
GTKE 0885	8	85	40	2	6 X 40	24.000	A25001086	■
GTKE 0885	8	85	40	2	1/4" X 40	24.000	A25001081	■
GTKE 1385	13	85	40	5	6 X 40	17.000	A25001586	■
GTKE 1885	18	85	40	7,5	6 X 40	12.000	A25002086	■
GTKE 2385	23	85	40	9,5	6 X 40	10.000	A25002586	■

For inaccessible areas, use abrasive caps conical shape (see page 319) in conjunction with a mandrel of head length 85 mm.



## Abrasive caps-Assortments

Ordering example: A210000065



**Packing unit:**

1 pc. per type

**Assortment containing:**

640 pcs. Abrasive Caps

23 pcs. Mandrels

Outside dimension of box: 372 x 189 x 46 mm

NK = reg. Aluminium Oxide

Description	pc.	Contents	Product-Number	recommended for	
WS 65	50 pcs. 100 pcs. of 50 pcs. of 20 pcs. of 10 pcs.	<p><b>Abrasive Caps, grit NK 150</b></p> <p>SKKE 0515</p> <p>SKZY 0510, SKWR 0511, SKWK 0511</p> <p>SKZY 0712, SKWR 0713, SKWK 0713</p> <p>SKZY 1015, SKWR 1015</p> <p>SKKE 1125</p> <p><b>Abrasive Caps, grit NK 80</b></p> <p>SKWK 1015</p> <p>SKZY 1317, SKWR 1319, SKWK 1319, SKKE 1632</p> <p>SKWK 1626, SKWR 1626</p> <p><b>Mandrels, Shank 3 mm</b></p> <p>GTZY 0510, GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713</p> <p>GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319</p> <p><b>Mandrels, Shank 6 mm</b></p> <p>GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632</p>	A210000065	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">6</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">7</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">8</span>	■
WS 65 Z	2 pcs. of 1 pc. of 1 pc. of	<p><b>Abrasive Caps, see WS 65</b></p> <p><b>Mandrels, Shank 1/8 inch</b></p> <p>GTZY 0510, GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713</p> <p>GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319</p> <p><b>Mandrels, Shank 1/4 inch</b></p> <p>GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632</p>	A210000065Z	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">6</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">7</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">8</span>	■

## Abrasive Discs and Mandrels

**222** Qualities and Applications

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**324** General Information

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**326** Abrasive discs, quick-change type

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**331** Mandrels for quick-change abrasive discs

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**333** Abrasive discs with plastic thread, quick-change type

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**334** Flap Discs, quick-change type

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**335** Mandrels with plastic thread, quick-change type

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**336** Abrasive discs, self-adhesive

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**337** Mandrels for self-adhesive abrasive discs

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**338** Abrasive discs, self-fixing

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**338** Mandrels for self-fixing abrasive discs

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**373** Power tool

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### Product line marking

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



## Information

### **Abrasive Discs, quick-change type, PSG/PSR**

LUKAS-Abrasive discs- PSG/PSR- are designed for quick mounting; a quick locking metal centre is integrated into the backing of the abrasive disc. A quick twisting movement secures the disc to the mandrel.

The PSG abrasive disc provides us with the most comprehensive selection in this product group.

A choice of diameter, different grit sizes and qualities covering every imaginable application, helps solve your particular grinding problem.

### **Abrasive Discs, self-adhesive PSK**

LUKAS abrasive discs PSK are self-adhesive. The adhesive backing of the disc is covered with a protective foil; after the removal of the foil the disc can be fixed to the rubber mandrel.

The self-adhesive LUKAS abrasive discs can be used on a wide variety of surfaces. After the removal of the disc from the backing, the disc cannot be re-used. The self-adhesive discs are available in various grit sizes of regular aluminium oxide (NK) as detailed on following pages.

### **Abrasive Discs, self-fixing PSH**





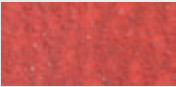
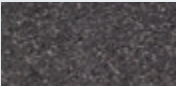



LUKAS abrasive discs PSH are self-fixing. The back face of the disc and the front face of the rubber mandrel are coated with Velcro.

The self-fixing LUKAS abrasive discs can be used on both flat and curved surfaces. Due to the velcro fixing, a partly worn disc can easily be removed and re-used at a later date.

The self-fixing abrasive discs are available in various grit sizes of regular aluminium oxide (NK), as detailed on following pages.



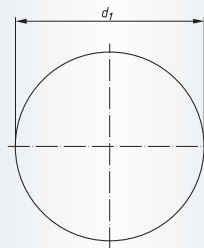
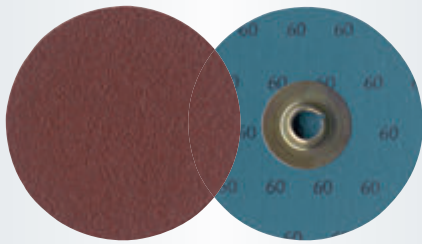
## PSG, Qualities and Applications

Quality	Characteristics	Applications	Page
 <b>NK</b> Abrasive cloth with reg. Aluminium Oxide	tough grain	Universal grinding and deburring	326
 <b>NKE</b> Abrasive cloth using reg. Aluminium Oxide with special coating	tough grain	Due to the reinforcement suited even for highest demands and edge working.	327
 <b>ZK</b> Abrasive cloth with Zirconia Alum. Oxide	very tough and resilient grain	Ideal for hastelloy, inconel, stainless and steels difficult to machine.	328
 <b>Z POWER</b> Zirconia Alum. Oxide with active grinding additives	optimum stock removal rate, excellent tool life	Ideal for stainless. Special topsize coating prevents clogging.	328
 <b>Ceramic</b> Abrasive cloth ceramic grain	optimum stock removal rate without shredding of grain. Very stable due to reinforced backing. Cool cutting	Ideal for stainless and nickel alloys.	329
 <b>SIC</b> Abrasive cloth with Silicon carbide	cool cutting; special quality for the aircraft industry	Ideal for titanium, titanium alloys and aluminium (aerospace industry). Also suitable for plastic and ceramic materials.	329
 Fleece Reg. Aluminium oxide coarse/brown  medium/red-brown  fine/blue	Polishing effect through the fibre structure, constant working results due to steadily discharge of abrasive particles. Outstanding tool life.	Ideal for removing rust or paint, scratches and pre-machining marks. A general improvement of the surface finish.	330



## PSG, Abrasive discs, quick-change, reg. Aluminium Oxide

Ordering example: A3371020060



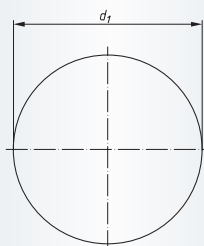
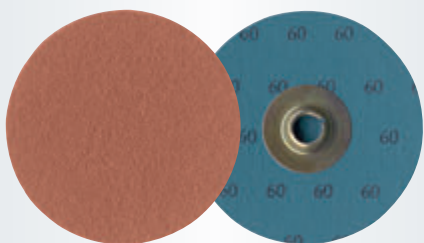
**Packing unit:**  
100 pcs. per type  
from Ø 75 mm: 50 pcs. per type

Description	Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 020	NK 60	19	40.000	GTG 020	A3371020060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 020	NK 80	19	40.000	GTG 020	A3371020080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 020	NK 120	19	40.000	GTG 020	A3371020120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 025	NK 36	25	40.000	GTG 025	A3371025036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 025	NK 60	25	40.000	GTG 025	A3371025060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 025	NK 80	25	40.000	GTG 025	A3371025080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 025	NK 120	25	40.000	GTG 025	A3371025120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 36	38	30.000	GTG 038	A3371038036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 60	38	30.000	GTG 038	A3371038060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 80	38	30.000	GTG 038	A3371038080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 120	38	30.000	GTG 038	A3371038120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 180	38	30.000	GTG 038	A3371038180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	NK 240	38	30.000	GTG 038	A3371038240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 36	51	30.000	GTG 038 and GTG 050	A3371050036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 50	51	30.000	GTG 038 and GTG 050	A3371050050	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 60	51	30.000	GTG 038 and GTG 050	A3371050060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 80	51	30.000	GTG 038 and GTG 050	A3371050080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 120	51	30.000	GTG 038 and GTG 050	A3371050120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 180	51	30.000	GTG 038 and GTG 050	A3371050180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	NK 240	51	30.000	GTG 038 and GTG 050	A3371050240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	NK 36	76	20.000	GTG 075	A3371075036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	NK 60	76	20.000	GTG 075	A3371075060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	NK 80	76	20.000	GTG 075	A3371075080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	NK 120	76	20.000	GTG 075	A3371075120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	NK 180	76	20.000	GTG 075	A3371075180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



**PSG, Abrasive discs, quick-change, reg. Aluminium Oxide with special coating**

Ordering example: A3352025060



**Packing unit:**  
100 Scs. per type,  
from Ø 75 mm: 50 Spcs. per type

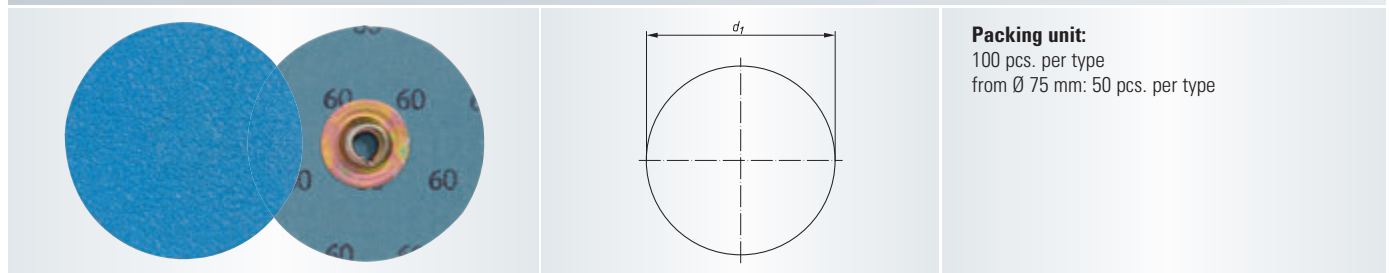
Description	Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for								
						1	2	3	4	5	6	7	8	
PSG 025	NKE 60	25	40.000	GTG 025	A3352025060	1	2	3	4	5	6	7	8	■
PSG 025	NKE 80	25	40.000	GTG 025	A3352025080	1	2	3	4	5	6	7	8	■
PSG 025	NKE 120	25	40.000	GTG 025	A3352025120	1	2	3	4	5	6	7	8	■
PSG 025	NKE 180	25	40.000	GTG 025	A3352025180	1	2	3	4	5	6	7	8	■
PSG 025	NKE 240	25	40.000	GTG 025	A3352025240	1	2	3	4	5	6	7	8	■
PSG 038	NKE 60	38	30.000	GTG 038	A3352038060	1	2	3	4	5	6	7	8	■
PSG 038	NKE 80	38	30.000	GTG 038	A3352038080	1	2	3	4	5	6	7	8	■
PSG 038	NKE 120	38	30.000	GTG 038	A3352038120	1	2	3	4	5	6	7	8	■
PSG 050	NKE 36	51	30.000	GTG 038 and GTG 050	A3352050036	1	2	3	4	5	6	7	8	■
PSG 050	NKE 60	51	30.000	GTG 038 and GTG 050	A3352050060	1	2	3	4	5	6	7	8	■
PSG 050	NKE 80	51	30.000	GTG 038 and GTG 050	A3352050080	1	2	3	4	5	6	7	8	■
PSG 050	NKE 120	51	30.000	GTG 038 and GTG 050	A3352050120	1	2	3	4	5	6	7	8	■
PSG 050	NKE 180	51	30.000	GTG 038 and GTG 050	A3352050180	1	2	3	4	5	6	7	8	■
PSG 050	NKE 240	51	30.000	GTG 038 and GTG 050	A3352050240	1	2	3	4	5	6	7	8	■
PSG 075	NKE 60	76	20.000	GTG 075	A3352075060	1	2	3	4	5	6	7	8	■
PSG 075	NKE 80	76	20.000	GTG 075	A3352075080	1	2	3	4	5	6	7	8	■



Industry

## PSG, Abrasive discs, quick-change, Zirconia Alum. Oxide

Ordering example: A3353025060



**Packing unit:**  
100 pcs. per type  
from Ø 75 mm: 50 pcs. per type

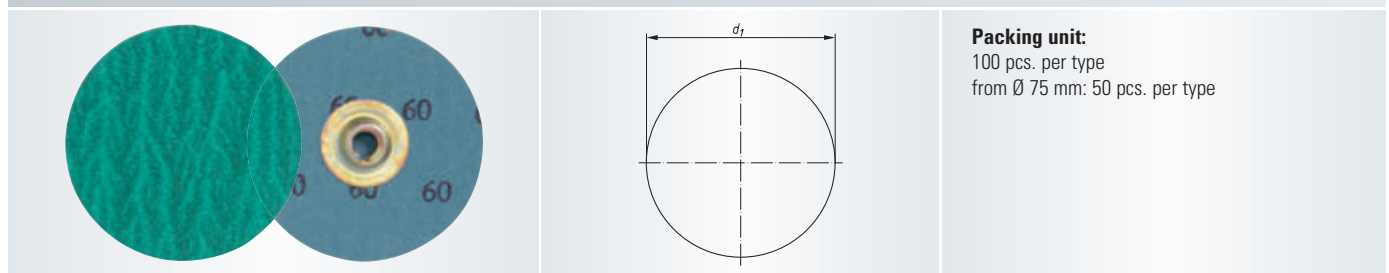
Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 025	ZK 60	25	40.000	GTG 025	A3353025060	1 2 3 4 5 7	■
PSG 025	ZK 80	25	40.000	GTG 025	A3353025080	1 2 3 4 5 7	■
PSG 038	ZK 60	38	30.000	GTG 038	A3353038060	1 2 3 4 5 7	■
PSG 038	ZK 80	38	30.000	GTG 038	A3353038080	1 2 3 4 5 7	■
PSG 050	ZK 36	51	30.000	GTG 038 and GTG 050	A3353050036	1 2 3 4 5 7	■
PSG 050	ZK 60	51	30.000	GTG 038 and GTG 050	A3353050060	1 2 3 4 5 7	■
PSG 050	ZK 80	51	30.000	GTG 038 and GTG 050	A3353050080	1 2 3 4 5 7	■
PSG 075	ZK 36	76	20.000	GTG 075	A3353075036	1 2 3 4 5 7	■
PSG 075	ZK 60	76	20.000	GTG 075	A3353075060	1 2 3 4 5 7	■
PSG 075	ZK 80	76	20.000	GTG 075	A3353075080	1 2 3 4 5 7	■



Industry

## PSG, Abrasive discs, quick-change, Zirconia Alum. Oxide with active grinding additives

Ordering example: A3377038036



**Packing unit:**  
100 pcs. per type  
from Ø 75 mm: 50 pcs. per type

Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 038	Z Power 36	38	30.000	GTG 038	A3377038036	1 2 3 4 5 7	■
PSG 038	Z Power 60	38	30.000	GTG 038	A3377038060	1 2 3 4 5 7	■
PSG 038	Z Power 80	38	30.000	GTG 038	A3377038080	1 2 3 4 5 7	■
PSG 038	Z Power 120	38	30.000	GTG 038	A3377038120	1 2 3 4 5 7	■
PSG 050	Z Power 36	51	30.000	GTG 038 and GTG 050	A3377050036	1 2 3 4 5 7	■
PSG 050	Z Power 60	51	30.000	GTG 038 and GTG 050	A3377050060	1 2 3 4 5 7	■
PSG 050	Z Power 80	51	30.000	GTG 038 and GTG 050	A3377050080	1 2 3 4 5 7	■
PSG 050	Z Power 120	51	30.000	GTG 038 and GTG 050	A3377050120	1 2 3 4 5 7	■
PSG 075	Z Power 36	76	20.000	GTG 075	A3377075036	1 2 3 4 5 7	■
PSG 075	Z Power 60	76	20.000	GTG 075	A3377075060	1 2 3 4 5 7	■
PSG 075	Z Power 80	76	20.000	GTG 075	A3377075080	1 2 3 4 5 7	■
PSG 075	Z Power 120	76	20.000	GTG 075	A3377075120	1 2 3 4 5 7	■

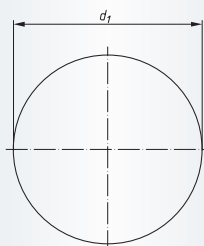
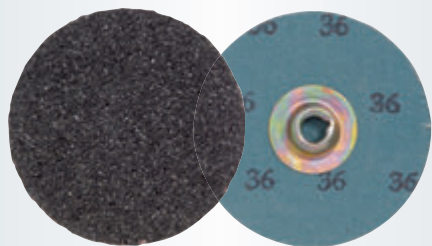




Industry

**PSG, Abrasive discs, quick-change, Silicon carbide**

Ordering example: A3378038036



**Packing unit:**  
100 pcs. per type  
from Ø 75 mm: 50 pcs. per type

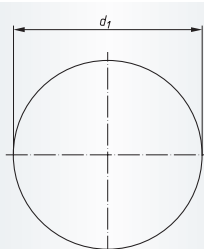
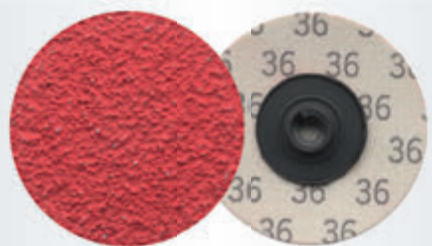
Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 038	SIC 36	38	30.000	GTG 038	A3378038036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 038	SIC 60	38	30.000	GTG 038	A3378038060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 038	SIC 80	38	30.000	GTG 038	A3378038080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 038	SIC 120	38	30.000	GTG 038	A3378038120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 050	SIC 36	51	30.000	GTG 038 and GTG 050	A3378050036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 050	SIC 60	51	30.000	GTG 038 and GTG 050	A3378050060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 050	SIC 80	51	30.000	GTG 038 and GTG 050	A3378050080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 050	SIC 120	51	30.000	GTG 038 and GTG 050	A3378050120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 075	SIC 36	76	20.000	GTG 075	A3378075036	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 075	SIC 60	76	20.000	GTG 075	A3378075060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
PSG 075	SIC 80	76	20.000	GTG 075	A3378075080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■



Industry

**PSG, Abrasive discs, quick-change, Ceramic grain**

Ordering example: A3379038036



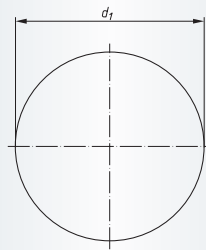
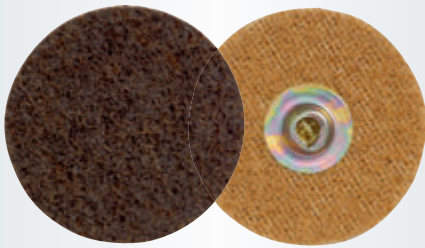
**Packing unit:**  
100 pcs. per type  
from Ø 75 mm: 50 pcs. per type

Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 038	Ceramic 36	38	30.000	GTG 038	A3379038036	② ③ ④ ⑤ ⑦	■
PSG 038	Ceramic 60	38	30.000	GTG 038	A3379038060	② ③ ④ ⑤ ⑦	■
PSG 038	Ceramic 80	38	30.000	GTG 038	A3379038080	② ③ ④ ⑤ ⑦	■
PSG 038	Ceramic 120	38	30.000	GTG 038	A3379038120	② ③ ④ ⑤ ⑦	■
PSG 050	Ceramic 36	51	30.000	GTG 038 and GTG 050	A3379050036	② ③ ④ ⑤ ⑦	■
PSG 050	Ceramic 60	51	30.000	GTG 038 and GTG 050	A3379050060	② ③ ④ ⑤ ⑦	■
PSG 050	Ceramic 80	51	30.000	GTG 038 and GTG 050	A3379050080	② ③ ④ ⑤ ⑦	■
PSG 050	Ceramic 120	51	30.000	GTG 038 and GTG 050	A3379050120	② ③ ④ ⑤ ⑦	■
PSG 075	Ceramic 36	76	20.000	GTG 075	A3379075036	② ③ ④ ⑤ ⑦	■
PSG 075	Ceramic 60	76	20.000	GTG 075	A3379075060	② ③ ④ ⑤ ⑦	■
PSG 075	Ceramic 80	76	20.000	GTG 075	A3379075080	② ③ ④ ⑤ ⑦	■
PSG 075	Ceramic 120	76	20.000	GTG 075	A3379075120	② ③ ④ ⑤ ⑦	■



### PSG, Abrasive discs, quick-change, Fleece Reg. Aluminium oxide

Ordering example: A3374038005



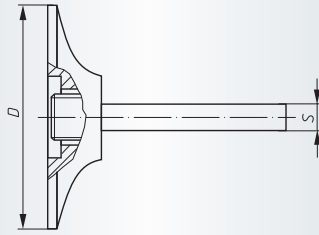
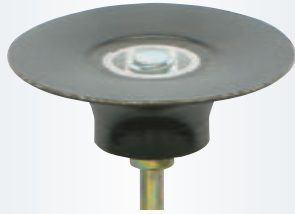
**Packing unit:**  
50 pcs. per type,  
from Ø 75 mm: 25 pcs. per type

Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSG 038	Fleece fine	38	10.000	GTG 038	A3374038005	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	Fleece coarse	38	10.000	GTG 038	A3374038004	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 038	Fleece medium	38	10.000	GTG 038	A3374038002	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	Fleece fine	51	8.000	GTG 038 and GTG 050	A3374050005	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	Fleece coarse	51	8.000	GTG 038 and GTG 050	A3374050004	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 050	Fleece medium	51	8.000	GTG 038 and GTG 050	A3374050002	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	Fleece fine	75	5.500	GTG 075	A3374075005	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	Fleece coarse	75	5.500	GTG 075	A3374075004	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSG 075	Fleece medium	75	5.500	GTG 075	A3374075002	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



**GTG, Mandrels for quick-change abrasive discs**

Ordering example: A33500200026



**Packing unit:**

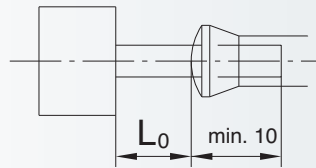
1 pc. per type

n max.: please also refer to Abrasive discs, PSG, page 326–330





Description	D mm	S mm	Type	n max. (1/min)	Product-Number																	
GTG 020.06	18	6	medium	40.000	A33500200026																■	
GTG 025.06	23	6	medium	40.000	A33500250026																	■
GTG 038.06	33	6	medium	25.000	A33500380026																	■
GTG 050.06	45	6	medium	25.000	A33500500026																	■
GTG 050.06	45	6	hard	30.000	A33500500036																	■
GTG 075.06	70	6	medium	20.000	A33500750026																	■
GTG 075.06	70	6	hard	20.000	A33500750036																	■

The mandrels are supplied in a **medium** hardness for universal application. For severe applications (when using Z POWER and CERAMIC) please use **hard** quality mandrels.

The stated maximum operating speed is calculated using the maximum mandrel diameter and maximum overhang  $L_0$  of 5 mm. For other overhangs and smaller mandrel diameters, the maximum operating speed must be re-calculated.



## PSR, Qualities and Applications

Quality	Characteristics	Applications/Grinding	Page
 <p>Abrasive cloth with Zirconia Alum. Oxide</p> <p><b>ZK</b></p>	<p>very tough and resilient grain</p>	<p>Ideal for hastelloy, inconel, stainless and steels difficult to machine.</p>	<p>333</p>
 <p>Fleece Reg. Aluminium oxide coarse/brown</p>  <p>medium/red-brown</p>  <p>fine/blue</p>	<p>Polishing effect through the fibre structure, constant working results due to steadily discharge of abrasive particles. Outstanding tool life.</p>	<p>Ideal for removing rust or paint, scratches and pre-machining marks. A general improvement of the surface finish.</p>	<p>333</p>



Industry

**PSR, Abrasive discs with plastic thread, quick-change**

Ordering example: A3363038060

				<b>Packing unit:</b> 100 pcs. per type			
Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSR 038	ZK 60	38	30.000	GTR 038	A3363038060	1 2 3 4 5 7	■
PSR 038	ZK 80	38	30.000	GTR 038	A3363038080	1 2 3 4 5 7	■
PSR 050	ZK 36	51	30.000	GTR 038 and GTR 050	A3363050036	1 2 3 4 5 7	■
PSR 050	ZK 60	51	30.000	GTR 038 and GTR 050	A3363050060	1 2 3 4 5 7	■
PSR 050	ZK 80	51	30.000	GTR 038 and GTR 050	A3363050080	1 2 3 4 5 7	■
PSR 075	ZK 36	76	20.000	GTR 075	A3363075036	1 2 3 4 5 7	■
PSR 075	ZK 60	76	20.000	GTR 075	A3363075060	1 2 3 4 5 7	■
PSR 075	ZK 80	76	20.000	GTR 075	A3363075080	1 2 3 4 5 7	■



Industry

**PSR, Abrasive discs with plastic thread, quick-change heavy duty fleece**

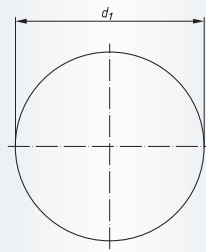
Ordering example: A3375038005

				<b>Packing unit:</b> 50 pcs. per type from Ø 75 mm: 25 pcs. per type			
Description	Quality Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for	
PSR 038	Fleece fine	38	10.000	GTR 038	A3375038005	1 2 3 4 5 6 7 8	■
PSR 038	Fleece medium	38	10.000	GTR 038	A3375038002	1 2 3 4 5 6 7 8	■
PSR 050	Fleece coarse	51	8.000	GTR 038 and GTR 050	A3375050004	1 2 3 4 5 6 7 8	■
PSR 050	Fleece fine	51	8.000	GTR 038 and GTR 050	A3375050005	1 2 3 4 5 6 7 8	■
PSR 050	Fleece medium	51	8.000	GTR 038 and GTR 050	A3375050002	1 2 3 4 5 6 7 8	■
PSR 075	Fleece coarse	76	5.500	GTR 038, GTR 050 and GTR 075	A3375075004	1 2 3 4 5 6 7 8	■
PSR 075	Fleece fine	76	5.500	GTR 038, GTR 050 and GTR 075	A3375075005	1 2 3 4 5 6 7 8	■
PSR 075	Fleece medium	76	5.500	GTR 038, GTR 050 and GTR 075	A3375075002	1 2 3 4 5 6 7 8	■



## SLTG, Flap Disc, quick-change type

Ordering example: A33310500401623



**Packing unit:**

10 pcs. per type

$v_{max}$ : 50 m/s

ZK = Zirconia Alum. Oxide

Description	Grits	d <sub>1</sub> mm	n max. (1/min)	Suitable carriers	Product-Number	recommended for									
SLTG 050 R	ZK 40	50	19.000	GTR 038.06	A33310500401623	1	2	3	4	5		7			■
SLTG 050 R	ZK 60	50	19.000	GTR 038.06	A33310500601623	1	2	3	4	5		7			■
SLTG 050 R	ZK 80	50	19.000	GTR 038.06	A33310500801623	1	2	3	4	5		7			■
SLTG 050 R	ZK 120	50	19.000	GTR 038.06	A33310501201623	1	2	3	4	5		7			■
SLTG 065 R	ZK 40	65	14.700	GTR 050.06	A33310650401623	1	2	3	4	5		7			■
SLTG 065 R	ZK 60	65	14.700	GTR 050.06	A33310650601623	1	2	3	4	5		7			■
SLTG 065 R	ZK 80	65	14.700	GTR 050.06	A33310650801623	1	2	3	4	5		7			■
SLTG 075 R	ZK 40	75	12.700	GTR 050.06	A33310750401623	1	2	3	4	5		7			■
SLTG 075 R	ZK 60	75	12.700	GTR 050.06	A33310750601623	1	2	3	4	5		7			■
SLTG 075 R	ZK 80	75	12.700	GTR 050.06	A33310750801623	1	2	3	4	5		7			■
SLTG 075 R	ZK 120	75	12.700	GTR 050.06	A33310751201623	1	2	3	4	5		7			■

**Properties**

- excellent cutting action
- aggressive, even with minimum grinding pressure
- long tool life (compared to fibre discs)
- lamellar projection
- flexible

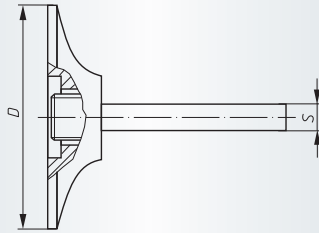
**Application:**

- deburring
- fettling
- rust removal
- finishing
- cleaning of weld seams



GTR, Mandrels for quick-change abrasive discs and SLTG with plastic thread

Ordering example: A33600380026



Packing unit:

1 pc. per type

n max.: please also refer to Abrasive discs, PSR, page 333 and flap disc SLTG, page 334

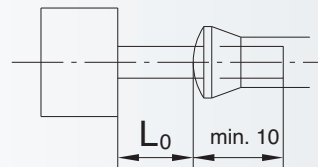
Description	D mm	S mm	Type	n max. (1/min)	Product-Number																	
GTR 038.06	33	6	medium	25.000	A33600380026																■	
GTR 050.06	45	6	medium	25.000	A33600500026																	■
GTR 075.06	70	6	medium	20.000	A33600750026																	■

The mandrels are supplied with a hardness for universal application; our **medium** type is suitable for nearly all applications.

Depending on the ordered quantities, other hardnesses are available on request.

The stated maximum operating speed is calculated using the maximum mandrel diameter and maximum overhang  $L_0$  of 5 mm.


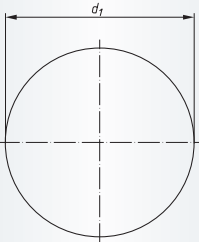
For other overhangs and smaller mandrel diameters, the maximum operating speed must be re-calculated.





### PSK, Abrasive discs, self-adhesive, Silicon carbide

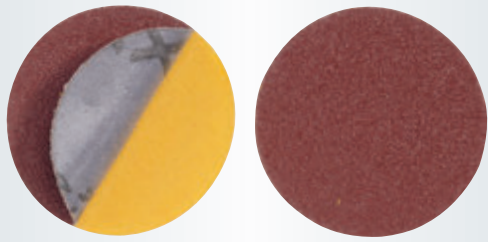
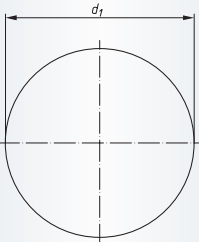
Ordering example: A2305018080

				<b>Packing unit:</b> 100 pcs. per type n max.: please refer to the mandrels self-adhesive GTK, page 337 SIC = Silicon carbide									
Description	Grits	d <sub>1</sub> mm	Product-Number	recommended for									
PSK 018	SIC 80	21	A2305018080	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 018	SIC 120	21	A2305018120	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 030	SIC 60	33	A2305030060	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 030	SIC 80	33	A2305030080	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 030	SIC 120	33	A2305030120	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 045	SIC 60	48	A2305045060	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 045	SIC 80	48	A2305045080	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■
PSK 045	SIC 120	48	A2305045120	①	②	③	④	⑤	⑥	⑦	⑧	⑨	■



### PSK, Abrasive discs, self-adhesive, reg. Aluminium Oxide

Ordering example: A2300018060

				<b>Packing unit:</b> 100 pcs. per type n max.: please refer to the mandrels self-adhesive GTK, page 337 NK = reg. Aluminium Oxide								
Description	Grits	d <sub>1</sub> mm	Product-Number	recommended for								
PSK 018	NK 60	21	A2300018060	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 018	NK 80	21	A2300018080	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 018	NK 120	21	A2300018120	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 018	NK 150	21	A2300018150	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 018	NK 180	21	A2300018180	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 018	NK 240	21	A2300018240	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 60	33	A2300030060	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 80	33	A2300030080	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 120	33	A2300030120	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 150	33	A2300030150	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 180	33	A2300030180	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 030	NK 240	33	A2300030240	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 045	NK 60	48	A2300045060	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 045	NK 80	48	A2300045080	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 045	NK 120	48	A2300045120	①	②	③	④	⑤	⑥	⑦	⑧	■
PSK 045	NK 150	48	A2300045150	①	②	③	④	⑤	⑥	⑦	⑧	■

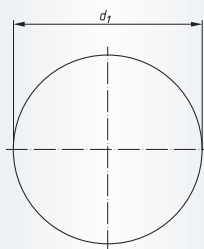
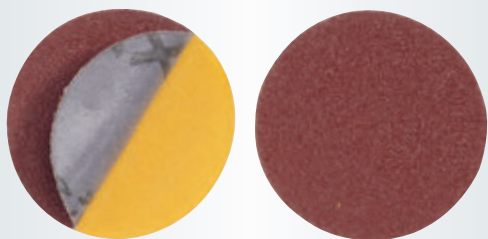




Industry

**PSK, Abrasive discs, self-adhesive, reg. Aluminium Oxide**

Ordering example: A2300045180



**Packing unit:**

100 pcs. per type

n max.: please refer to the mandrels self-adhesive  
GTK, page 337

NK = reg. Aluminium Oxide

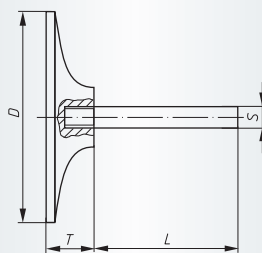
Description	Grits	d <sub>1</sub> mm	Product-Number	recommended for	
PSK 045	NK 180	48	A2300045180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 045	NK 240	48	A2300045240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 060	NK 60	63	A2300060060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 060	NK 80	63	A2300060080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 060	NK 120	63	A2300060120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 060	NK 150	63	A2300060150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 075	NK 60	78	A2300075060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 075	NK 80	78	A2300075080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 075	NK 120	78	A2300075120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSK 075	NK 150	78	A2300075150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**GTK, Mandrels, for self-adhesive abrasive discs**

Ordering example: A250301830001



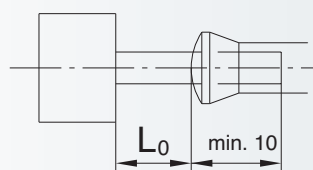
**Packing unit:**

5 pcs. per type,

from Ø 75 mm = 2 pcs. per type

Description	D mm	S mm	T mm	L mm	n max. (1/min)	Product-Number		
GTK 018.03	18	3	11	30	20.000	A250301830001		■
GTK 030.03	30	3	12	30	12.500	A250303030001		■
GTK 030.06	30	6	12	40	12.500	A250303060001		■
GTK 045.06	45	6	11	40	10.000	A250304560001		■
GTK 060.06	60	6	13	40	8.000	A250306060001		■
GTK 075.06	75	6	15	40	6.000	A250307560001		■

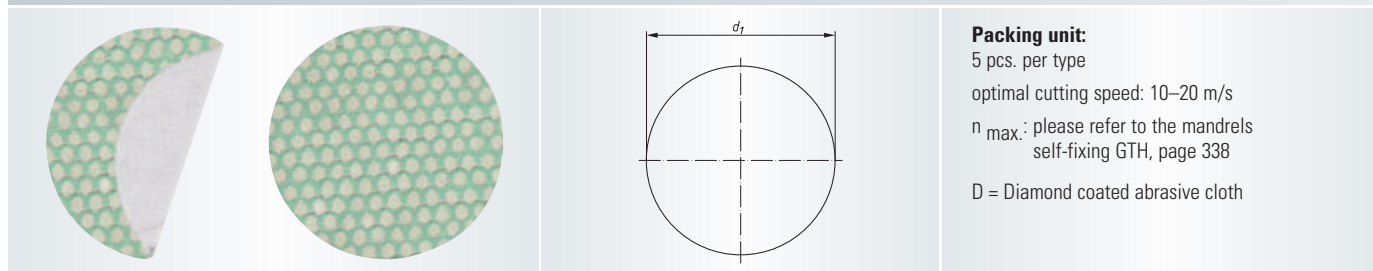
The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.





### PSH, Abrasive discs, self-adhesive, Diamond

Ordering example: A3301050126



**Packing unit:**  
5 pcs. per type  
optimal cutting speed: 10–20 m/s  
 $n_{max}$ : please refer to the mandrels  
self-fixing GTH, page 338  
D = Diamond coated abrasive cloth

Description	Grits	d <sub>1</sub> mm	Product-Number	recommended for
PSH 050	D126	50	A3301050126	7 8 9 ■
PSH 075	D126	75	A3301075126	7 8 9 ■

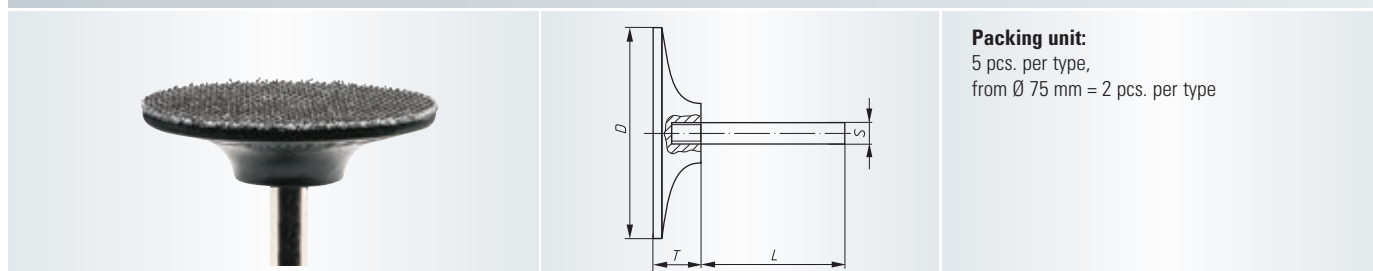
Diamond abrasive discs are perfect for dealing with hard layers, such as wear protection coatings or armouring made from tungsten, chromium or titanium carbide.

They are also great for other hard materials like glass, ceramic, stone, enamel, carbide or abrasive composite materials from glass or carbon fibre reinforced plastic. Another application is for materials used for turbines and power trains, e.g., hastelloy, inconel and titanium alloys.



### GTH, Mandrels, for self-fixing abrasive discs

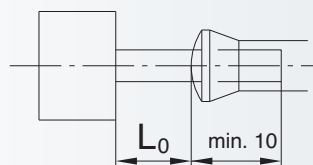
Ordering example: A250401830001



**Packing unit:**  
5 pcs. per type,  
from Ø 75 mm = 2 pcs. per type

Description	D mm	S mm	T mm	L mm	n max. (1/min)	Product-Number	recommended for
GTH 018.03	18	3	11	30	20.000	A250401830001	■
GTH 030.03	30	3	12	30	12.500	A250403030001	■
GTH 030.06	30	6	12	40	12.500	A250403060001	■
GTH 045.06	45	6	11	40	10.000	A250404560001	■
GTH 060.06	60	6	13	40	8.000	A250406060001	■
GTH 075.06	75	6	15	40	6.000	A250407560001	■
GTH 120.06	120	6	20	25	4.000	A25041206	■
GTH 120.08	120	8	20	25	4.000	A25041208	■

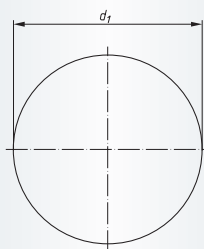
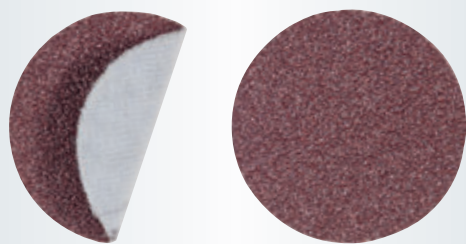
The stated maximum operating speed only applies to a maximum overhang  $L_0$  of 20 mm. Other overhang dimensions must be calculated separately.





PSH, Abrasive discs, self-fixing

Ordering example: A3300018060



**Packing unit:**

100 pcs. per type

n max.: please refer to the mandrels self-fixing GTH, page 338

NK = reg. Aluminium Oxide

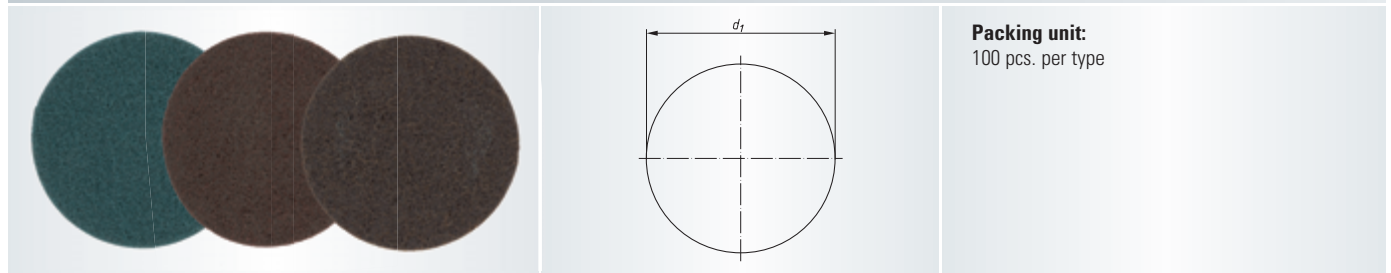
Description	Grits	d <sub>1</sub> mm	Product-Number	recommended for	
PSH 018	NK 60	20	A3300018060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 80	20	A3300018080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 120	20	A3300018120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 150	20	A3300018150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 180	20	A3300018180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 240	20	A3300018240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 018	NK 320	20	A3300018320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 60	33	A3300030060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 80	33	A3300030080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 120	33	A3300030120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 150	33	A3300030150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 180	33	A3300030180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 240	33	A3300030240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 030	NK 320	33	A3300030320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 60	48	A3300045060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 80	48	A3300045080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 120	48	A3300045120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 150	48	A3300045150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 180	48	A3300045180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 045	NK 240	48	A3300045240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 60	63	A3300060060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 80	63	A3300060080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 120	63	A3300060120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 150	63	A3300060150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 180	63	A3300060180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 240	63	A3300060240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 060	NK 320	63	A3300060320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 60	78	A3300075060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 80	78	A3300075080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 120	78	A3300075120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 150	78	A3300075150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 180	78	A3300075180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 240	78	A3300075240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 075	NK 320	78	A3300075320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 125	NK 60	125	A3300120060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
PSH 125	NK 80	125	A3300120080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

# 340 Abrasive discs, self-fixing and Mandrels, for self-fixing abrasive discs



Industry

## PSH, Quick-change abrasive discs with non-woven material, Velcro self fixing system *Ordering example: A3380115102*



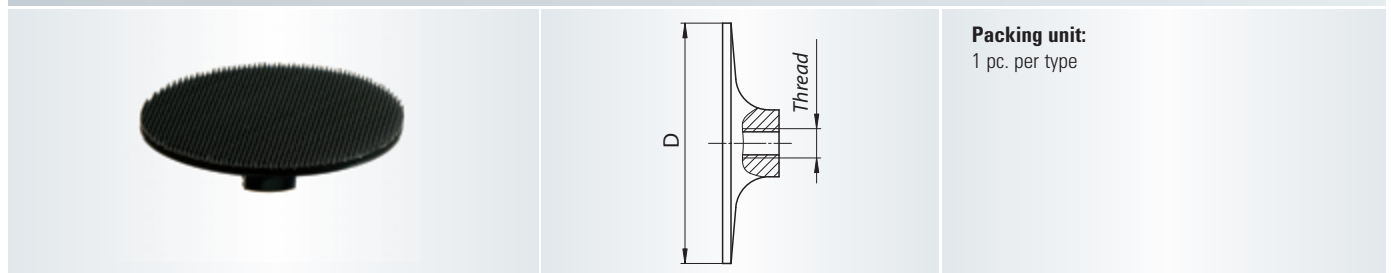
**Packing unit:**  
100 pcs. per type

Description	Grits	d <sub>1</sub> mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> PSH 115	Fleece coarse	115	4.000	8.000	A3380115102	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> PSH 115	Fleece medium	115	4.000	8.000	A3380115104	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> PSH 115	Fleece fine	115	4.000	8.000	A3380115107	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> PSH 125	Fleece coarse	125	3.800	7.650	A3380125102	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> PSH 125	Fleece medium	125	3.800	7.650	A3380125104	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
<b>NEW</b> PSH 125	Fleece fine	125	4.800	7.650	A3380125107	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

## GTH, Mandrels for abrasive discs with non-woven material *Ordering example: A38311151003*



**Packing unit:**  
1 pc. per type

Description	D mm	Thread	n max. (1/min)	Product-Number		
GTH 115	115	M14	8.000	A38311151003		■
GTH 125	125	M14	7.650	A38311251003		■

## Fibre discs, backing plates, economy rolls, abrasive sheets and fleece rolls

**222** Qualities and Applications

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**342** General Information

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**343** FIS, Fibre Discs with slotted hole

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**348** Economy rolls

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**349** SLB, sheets of abrasive cloth

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**350** Fleece pads

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**350** Fleece rolls

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**347** STF, Fibre Disc Backing Pad

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### Product line marking

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



## Information

### **FIS, Fibre Discs**

Fibre-backed discs FIS are used on angle grinders with a backing pad STF. We offer this very popular product in NK, ZK and Ceramic for universal application.

### **SHF semi-flexible grinding disc**

The SHF semi-flexible grinding disc consists of a stable fibre backing with a structured abrasive coating of silicon carbide. This combination is particularly suitable for coarse grinding work on the biggest variety of materials. Typical applications are the removal of paint, rust and adhesives, but also the processing of glass-fibre reinforced plastics such as GRP and CRP (e.g. during the manufacture of wind turbine blades). Like fibre discs, semi-flexible grinding discs for angle grinders are only used with an STF backing plate.

### **SPR, Economy rolls**

We supply economy rolls manufactured from flexible coated abrasive for off-hand application. The appropriate length can be cut from the roll.

### **SVB, Fleece pads and SVR, Fleece rolls**

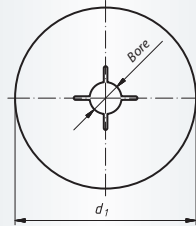
We supply abrasive fleece economy rolls and pads used off-hand or on vibratory finishing machines. These can be used wet or dry.



**High Performance**

**FIS, Fibre Disc with slotted hole, Ceramic grain**

Ordering example: A38301150243



**Packing unit:**  
25 pcs. per type  
 $v_{max.}$ : 80 m/s  
ISO 16057  
Ceramic = ceramic grain

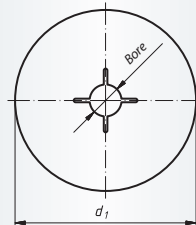
Description	Grits	d <sub>1</sub> mm	Bore mm	n max. (1/min)	Product-Number	recommended for	
FIS 115	Ceramic 24	115	22	13.000	A38301150243	1 2 3 4 5 6 7	■
FIS 115	Ceramic 36	115	22	13.000	A38301150363	1 2 3 4 5 6 7	■
FIS 115	Ceramic 60	115	22	13.000	A38301150603	1 2 3 4 5 6 7	■
FIS 115	Ceramic 80	115	22	13.000	A38301150803	1 2 3 4 5 6 7	■
FIS 125	Ceramic 24	125	22	12.000	A38301250243	1 2 3 4 5 6 7	■
FIS 125	Ceramic 36	125	22	12.000	A38301250363	1 2 3 4 5 6 7	■
FIS 125	Ceramic 60	125	22	12.000	A38301250603	1 2 3 4 5 6 7	■
FIS 125	Ceramic 80	125	22	12.000	A38301250803	1 2 3 4 5 6 7	■
FIS 180	Ceramic 24	180	22	8.500	A38301800243	1 2 3 4 5 6 7	■
FIS 180	Ceramic 36	180	22	8.500	A38301800363	1 2 3 4 5 6 7	■



**Industry**

**FIS, Fibre Disc with slotted hole, Zirconia Alum. Oxide**

Ordering example: A38301150242



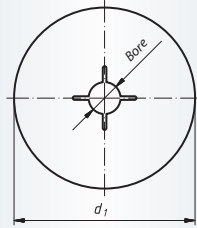
**Packing unit:**  
25 pcs. per type  
 $v_{max.}$ : 80 m/s  
ISO 16057  
ZK = Zirconia Alum. Oxide

Description	Grits	d <sub>1</sub> mm	Bore mm	n max. (1/min)	Product-Number	recommended for	
FIS 115	ZK 24	115	22	13.000	A38301150242	2 3 4 5 7	■
FIS 115	ZK 36	115	22	13.000	A38301150362	2 3 4 5 7	■
FIS 115	ZK 40	115	22	13.000	A38301150402	2 3 4 5 7	■
FIS 115	ZK 60	115	22	13.000	A38301150602	2 3 4 5 7	■
FIS 115	ZK 80	115	22	13.000	A38301150802	2 3 4 5 7	■
FIS 125	ZK 24	125	22	12.000	A38301250242	2 3 4 5 7	■
FIS 125	ZK 36	125	22	12.000	A38301250362	2 3 4 5 7	■
FIS 125	ZK 40	125	22	12.000	A38301250402	2 3 4 5 7	■
FIS 125	ZK 60	125	22	12.000	A38301250602	2 3 4 5 7	■
FIS 125	ZK 80	125	22	12.000	A38301250802	2 3 4 5 7	■



### FIS, Fibre Disc with slotted hole, reg. Aluminium Oxide

Ordering example: A38301150241



**Packing unit:**

25 pcs. per type

$v_{max}$ : 80 m/s

ISO 16057

NK = reg. Aluminium Oxide

Description	Grits	d <sub>1</sub> mm	Bore mm	n max. (1/min)	Product-Number	recommended for	
FIS 115	NK 24	115	22	13.000	A38301150241	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 36	115	22	13.000	A38301150361	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 40	115	22	13.000	A38301150401	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 50	115	22	13.000	A38301150501	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 60	115	22	13.000	A38301150601	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 80	115	22	13.000	A38301150801	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115	NK 120	115	22	13.000	A38301151201	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 24	125	22	12.000	A38301250241	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 36	125	22	12.000	A38301250361	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 40	125	22	12.000	A38301250401	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 50	125	22	12.000	A38301250501	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 60	125	22	12.000	A38301250601	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125	NK 80	125	22	12.000	A38301250801	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 150	NK 40	150	22	10.000	A38301500401	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 150	NK 60	150	22	10.000	A38301500601	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 16	180	22	8.500	A38301800161	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 24	180	22	8.500	A38301800241	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 36	180	22	8.500	A38301800361	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 40	180	22	8.500	A38301800401	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 60	180	22	8.500	A38301800601	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180	NK 80	180	22	8.500	A38301800801	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

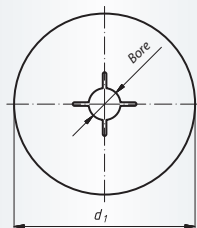




Base

**FIS BASE-X, Fibre Disc with slotted hole, reg. Aluminium Oxide**

Ordering example: A7830115024101



**Packing unit:**

25 pcs. per type

$v_{max}$ : 80 m/s

ISO 16057

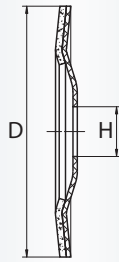
NK = reg. Aluminium Oxide

Description	Grits	d <sub>1</sub> mm	Bore mm	n max. (1/min)	Product-Number	recommended for	
FIS 115 BASE-X	NK 24	115	22	13.000	A7830115024101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115 BASE-X	NK 36	115	22	13.000	A7830115036101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115 BASE-X	NK 40	115	22	13.000	A7830115040101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115 BASE-X	NK 60	115	22	13.000	A7830115060101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115 BASE-X	NK 80	115	22	13.000	A7830115080101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 115 BASE-X	NK 120	115	22	13.000	A7830115120101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 24	125	22	12.000	A7830125024101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 36	125	22	12.000	A7830125036101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 40	125	22	12.000	A7830125040101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 60	125	22	12.000	A7830125060101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 80	125	22	12.000	A7830125080101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 125 BASE-X	NK 120	125	22	12.000	A7830125120101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180 BASE-X	NK 24	180	22	8.500	A7830180024101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180 BASE-X	NK 36	180	22	8.500	A7830180036101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180 BASE-X	NK 40	180	22	8.500	A7830180040101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180 BASE-X	NK 60	180	22	8.500	A7830180060101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
FIS 180 BASE-X	NK 80	180	22	8.500	A7830180080101	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



## SHF semi-flexible grinding disc

Ordering example: A38351150164



**Packing unit:**  
25 pcs. per type  
C = Silicon carbide

Description	Grits	D mm	H mm	n max. (1/min)	Product-Number	recommended for	
<b>NEW</b> SHF 115	C16	115	22,23	13.300	A38351150164	1 2 5 6 8 10	■
<b>NEW</b> SHF 115	C24	115	22,23	13.300	A38351150244	1 2 5 6 8 10	■
<b>NEW</b> SHF 115	C36	115	22,23	13.300	A38351150364	1 2 5 6 8 10	■
<b>NEW</b> SHF 115	C60	115	22,23	13.300	A38351150604	1 2 5 6 8 10	■
<b>NEW</b> SHF 125	C24	125	22,23	12.200	A38351250244	1 2 5 6 8 10	■
<b>NEW</b> SHF 125	C36	125	22,23	12.200	A38351250364	1 2 5 6 8 10	■

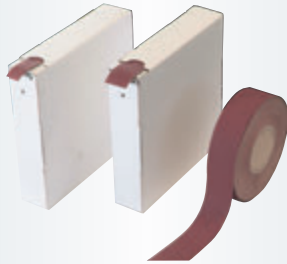
Use only with backing plate.





## SPR, Economy Rolls, reg. Aluminium Oxide

Ordering example: A3821025040



**Packing unit:**

1 pc. per type

NK = reg. Aluminium Oxide

Description	Grits	wide mm	long m	Product-Number	recommended for	
SPR 025	NK 40	25	50	A3821025040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 60	25	50	A3821025060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 80	25	50	A3821025080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 100	25	50	A3821025100	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 120	25	50	A3821025120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 150	25	50	A3821025150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 180	25	50	A3821025180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 240	25	50	A3821025240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 320	25	50	A3821025320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 025	NK 400	25	50	A3821025400	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 40	40	50	A3821040040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 60	40	50	A3821040060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 80	40	50	A3821040080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 100	40	50	A3821040100	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 120	40	50	A3821040120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 150	40	50	A3821040150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 180	40	50	A3821040180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 240	40	50	A3821040240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 320	40	50	A3821040320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SPR 040	NK 400	40	50	A3821040400	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

LUKAS Economy Rolls with their great grinding characteristics help to manage your manual grinding at optimum level.



Industry

**SLB, Sheets of abrasive cloth**

Ordering example: A3825230280040



**Packing unit:**  
50 pcs. per type  
NK = reg. Aluminium Oxide

Description	Quality	wide mm	long mm	Product-Number	recommended for	
SLB 230280	NK 40	230	280	A3825230280040	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 60	230	280	A3825230280060	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 80	230	280	A3825230280080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 100	230	280	A3825230280100	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 120	230	280	A3825230280120	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 150	230	280	A3825230280150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 180	230	280	A3825230280180	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 220	230	280	A3825230280220	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 240	230	280	A3825230280240	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 320	230	280	A3825230280320	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 400	230	280	A3825230280400	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLB 230280	NK 999	230	280	A3825230280999	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

The LUKAS-sheets of abrasive cloth with optimum abrasive properties will enable you to achieve outstanding results with your manual grinding applications.

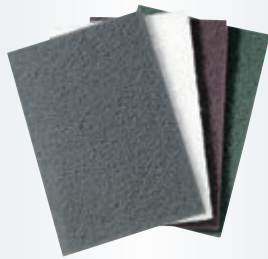
# 350 Fleece Pads and Rolls



Industry

## SVB, Fleece pads

Ordering example: A380115023011



**Packing unit:**

50 pcs. per type

A = reg. Aluminium Oxide

C = Silicon carbide

Description	Quality	Type	wide mm	long mm	Product-Number	recommended for	
SVB 150230	A Medium	red-brown	150	210	A380115023011	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SVB 150230	A Fine	green	150	210	A380115023012	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SVB 150230	A Very Fine	red-brown	150	210	A380115023013	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SVB 150230	C Ultra Fine	grey	150	210	A380115023024	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

LUKAS-fleece pads are used to remove corrosion and stain from metal surfaces as well as to clean and polish surfaces of any kind of material.



Industry

## SVR, Fleece rolls

Ordering example: A382011501012



**Packing unit:**

1 pc. per type

A = reg. Aluminium Oxide

C = Silicon carbide

Description	Quality	Type	wide mm	long m	Product-Number	recommended for	
SVR 115	A Fine	green	115	10	A382011501012	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SVR 115	A Very Fine	red-brown	115	10	A382011501013	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SVR 115	C Ultra fine	grey	115	10	A382011501024	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

LUKAS-fleece rolls are used to remove corrosion and stain from metal surfaces as well as to clean and polish surfaces of any kind of material.

## AS-Cleaning fleece

**222** Qualities and Applications

**352** General Information

**353** ASVS, abrasive discs for flexible boring and drilling machines

**353** ASB, mounting arbor for ASVS

**354** ASVT, for right angle grinders, with reinforced fibre backing



### Product line marking

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



## Information

### General Information

Our AS surface preparation fleece consists of a coarse Polyamide fleece impregnated with aggressive abrasive grit particles.

### Recommendations for use

Products using our AS surface preparation fleece are ideally suited for the following applications:

- removal of paint and adhesives
- removal of cement and concrete residues
- de-rusting, restoring and polishing of a wide variety of surfaces
- graining and the finishing of wood
- de-rusting and preparation work on boats and ships, eg, removing barnacles

- surface preparation of floors and various applications for car-body repair work
- preparation work on welding seams – before and after welding

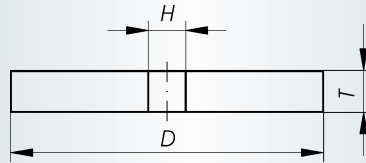
### Safety regulations

Please take care that our recommended cutting speed is not exceeded.

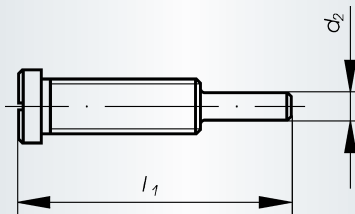
### Characteristics

- less generation heat
- “soft” grinding action
- no glazing/loading
- no damage to workpieces




**Industry**
**ASVS, Abrasive discs for flexible boring and drilling machines**
*Ordering example: A22900601201*

**Packing unit:**  
 10 pcs. per type,  
 from Ø 150 mm = 5 pcs. per type

Description	D mm	T mm	H mm	n recom. (1/min)	n max. (1/min)	Retaining bolt	Product-Number	recommended for	
ASVS 060	60	13	10	8.000	9.500	ASB 6	A22900601201	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
ASVS 100	100	13	13	5.000	5.700	ASB 6	A22901001201	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
ASVS 125	125	13	13	4.000	4.500	ASB 8	A22901251201	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
ASVS 150	150	13	13	3.000	3.800	ASB 8	A22901501201	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■


**Industry**
**ASB, Mounting arbor for ASVS, incl. spring washer and nut**
*Ordering example: A1610021007301*

**Packing unit:**  
 1 pc. per type

Description	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number																		
ASB 06	6	60	A1610021007301																		■
ASB 08	8	60	A1610021007302																		■



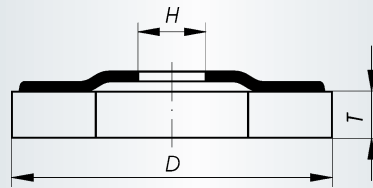
# 354 AS-Cleaning fleece



Industry

## ASVT, for angle grinder, with reinforced fibre backing

Ordering example: A270111500114



Packing unit:  
10 pcs. per type

Description	D mm	T mm	H mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
ASVT 115	115	13	22,3	5.300	10.500	A270111500114	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■
ASVT 125	125	13	22,3	4.900	9.600	A270112500114	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	■

Usable without supporting-plate on adjustable and slow-speed angle grinders.

# CBN- and diamond tools for precision machining

356 Technical Information

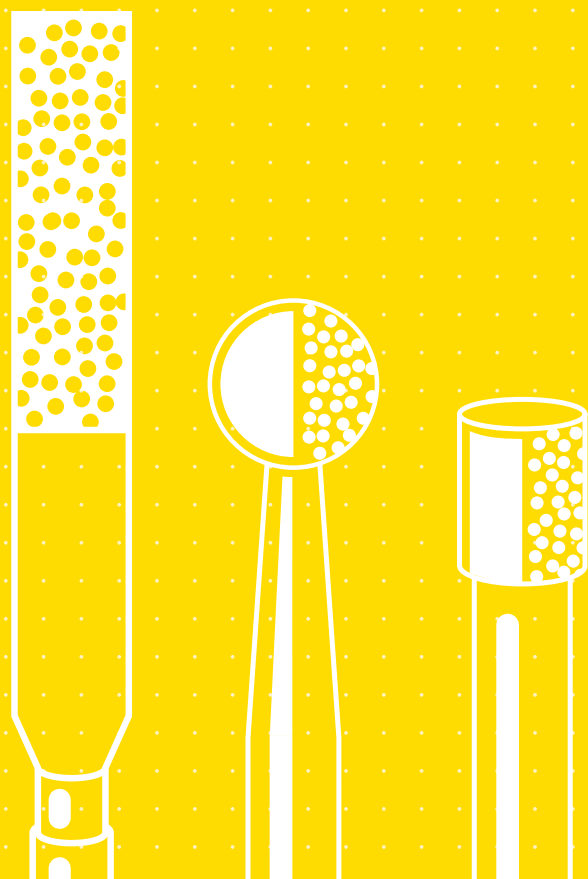
359 CBN/Diamond Grinding Tools, vitrified bonded

365 CBN/Diamond Grinding Tools, electro-plated



## Product line marking

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



## Technical information

### General

The product group which includes CBN and diamond tools for precision machining is of ever increasing importance in relation to tools consisting of the usual grain types i.e. aluminium oxide and silicon carbide and their further developments e.g. zirconia, mono-crystal and SOL-GEL (SG grain). These super hard grain types include natural and synthetic diamond in „D“ and synthetic cubic boron nitride (CBN) „B“.

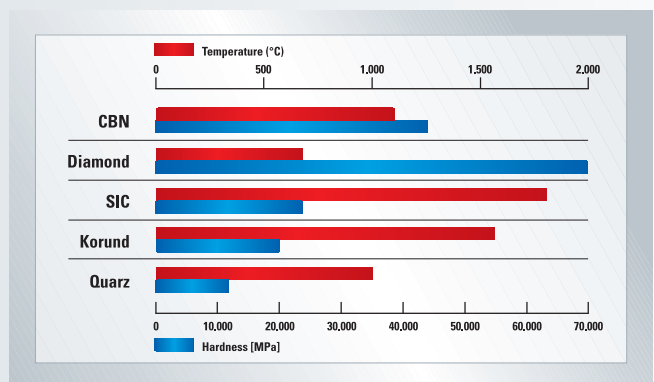
Diamond is used for a wide range of hard materials (except steel), eg, carbides, oxides, nitrides and even diamond itself. Various types of plastic and rubber can also be economically machined.

### Hardness

The ultrahard grain is considerably more expensive than conventional abrasive. Due to the extreme hardness, greater performance can be achieved when used in conjunction with modern manufacturing techniques; this can produce significant cost reductions.

### Micro-Hardness – Temperature stability

The extreme differences in micro-hardness can be identified in the adjoining diagram.



## Technical Information

### Bond

The following bondings are used in the manufacture of LUKAS CBN and diamond tools:

### Vitrified bond

Due to the substantial layer of usable abrasive, vitrified bonded wheels give long tool life. They can be easily dressed and require little grinding pressure. These tools are manufactured in a variety of dimensions and in different structures. They must be used with coolant. A fine surface finish can be achieved.

### Electro-Plated

An electro-plated bond provides a low cost tool. Electro-plating allows the manufacture of a large variety of profiles. They can be used wet or dry; coolant improves tool life.

### Types of grain

Basically, we must differentiate between mono and polycrystalline types of grain. In the case of diamond, it must also be decided whether to use natural or synthetic types. Many applications require a grain coating of nickel or titanium. The physical and chemical properties, including the shape of individual grit particles,

are the decisive factors when selecting the most suitable grit type. LUKAS vitrified bonded CBN-/diamond tools are identified by a quality code which contains all data determining the specification. The customer also receives this basic information regarding grit size and CBN-/diamond concentration.

Based on ISO 6106 and the corresponding FEPA standard, the grit sizes have been categorized as stated below. Contrary to the grit size classification of conventional grain, cubic-boron nitride and diamond grain are specified based on the following: the smaller the number, the finer the grit – the larger the number, the coarser the grit.

The prefix "B" specifies CBN, the prefix "D" denotes Diamond; the US equivalents in Standard Mesh are also shown below.

## Grit Size based on ISO 6106 resp. FEPA and US-Standard

CBN	Diamond	Grit size $\mu\text{m}$	US-Standard Mesh
B 46	D 46	38–45	325/400
B 54	D 54	45–53	270/325
B 64	D 64	53–63	230/270
B 76	D 76	63–75	200/230
B 91	D 91	75–90	170/200
B 107	D 107	90–106	140/170
B 126	D 126	106–125	120/140
B 151	D 151	125–150	100/120
B 181	D 181	150–180	80/100
B 213	D 213	180–212	70/80
B 251	D 251	212–250	60/70

When selecting the grit size, it must be remembered that ultrahard abrasive grain gives a coarser surface finish than conventional grit types; this is due to the extremely low wear rate. The most widely used grit sizes lie between 54 and 91 microns.

Always the right tool

# For Highest Precision and Safety!



## CBN-/Diamond Grinding Tools, vitrified bonded

**361** Special features of the vitrified bond

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**361** Selection of qualities

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**362** Selection of mounted point dimensions

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**362** Chart for tungsten carbide shanks

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**363** Selection of wheel dimensions

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### Product line marking

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

## Technical Information

### Shanks

The various types of CBN mounted points in a vitrified bond are, without exception, supplied with tungsten carbide shanks; carbide has a module of elasticity three times greater than steel.

The elasticity module denotes the extent to which a body deforms under pressure. Carbide has a high module of elasticity and therefore the deflection of the tools resulting from grinding pressure is kept to a minimum.

#### There are considerable advantages, eg:

- Reduction of spark-out time; this means a shorter grinding cycle
- Considerable improvement in tool life
- Reduction in tooling and setting costs
- Improvement in surface finish of the workpiece
- Improvement in workpiece geometry

The following table illustrates the rigidity of steel and tungsten carbide shank material in relation to diameter and overhang. A 3 mm diameter steel shank with an overhang of 40 mm is used as the base rigidity value of „1“.

### Dressing

There are two main reasons for dressing CBN/diamond tools:

1. To achieve geometrical accuracy.
2. To prevent dulling of the abrasive grain and to free the surface from loading, ie, to maintain a free-cutting tool.

These tools must be dressed wet with ample coolant!

Various dressing methods are used depending on the hardness of the tool. The softer wheel qualities can be dressed with either a single point diamond dresser, or a rotary silicon carbide/diamond wheel. Dressing infeeds are typically in the range of 0.2 mm.

The single point diamond dresser cannot be used for the „medium hard“ qualities. Dressing infeed is in the range of 50 – 200 µm. The harder specifications require dressing after only 50 – 500 workpieces depending on grinding parameters used. Dressing infeed is normally very small, ie, in the range of 2 to 10 microns.

A rotary diamond wheel dresser is used. Very hard qualities which require heavy dressing, need an additional dressing operation to „sharpen“ the tool; a soft silicon carbide rotary dresser is used. The cutting speed should not exceed 10 m/s.

## Relative rigidity of steel/tungsten carbide shank

Steel shank 3 mm x 40 mm overhang represents the base rigidity value „1“

overhang mm	shank							
	3		6		8		10	
	Steel	TC	Steel	TC	Steel	TC	Steel	TC
10	64	183	1024	2932	3237	9266	7900	22635
20	8	23	128	367	405	1159	988	2828
40	1	2,9	16	46	51	145	123	354

unstable      very stable



## Technical Information

### Selection of Qualities/CBN/Diamond abrasive tools, vitrified bonded

LUKAS vitrified bonded diamond tools are identified by a quality code which contains all data determining the specification. Please see below some typical specifications:

Quality code CBN	Size	Concentration	Characteristic
53.5*	B 46	C 175	medium
29*	B 54	C 150	universal
34.5	B 54	C 170	
71.1	B 54	C 185	
50.3*	B 64	C 200	very hard
70.7	B 76	C 190	hard
57.7*	B 76	C 175	fine
54.8*	B 91	C 140	medium
70.1	B 91	C 185	hard
46.3*	B 151	C 175	medium

Quality code Diamond	Size	Concentration	Characteristic
15 D	D 91	C 120	
15.4 D	D 91	C 165	hard
18 D*	D 151	C 120	

\* = widely used specifications

LFG-bond = Low Force Grinding

We can recommend a suitable quality following receipt of application details.

## Special features of the vitrified bond

### Concentration

The letter "C" in the specification represents the grit concentration; this can vary quite considerably depending on the application. The concentration denotes the volume of ultrahard abrasive grain used in the tool; this determines the grinding effectiveness and the price.

The opposite table illustrates the range of concentration; the most popular are shown in bold figures.

### Range of concentration

C	40	60	100	120	<b>160</b>	<b>200</b>	220
V*	100	150	250	300	<b>400</b>	<b>500</b>	550
Vol%	10	15	25	30	<b>40</b>	<b>50</b>	55

V\* = Vol% x 10; this is also used to express concentration

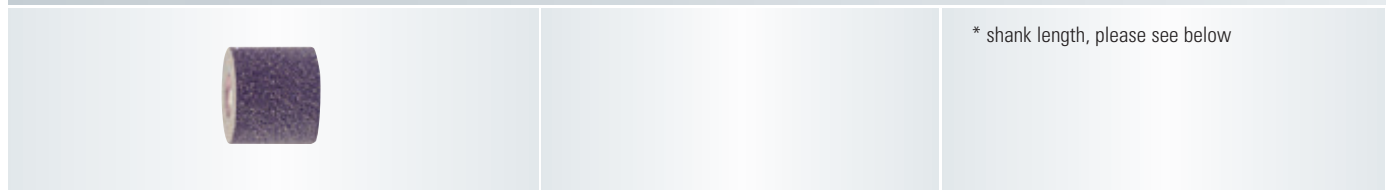
# 362 CBN-/Diamond Grinding Tools, vitrified bonded, tailor-made solution



**Industry**

## Selection of mounted point dimensions

Ordering example: CBN-Mounted Point, Quality 50.3, D 11 mm, Shank 8 x 70



\* shank length, please see below

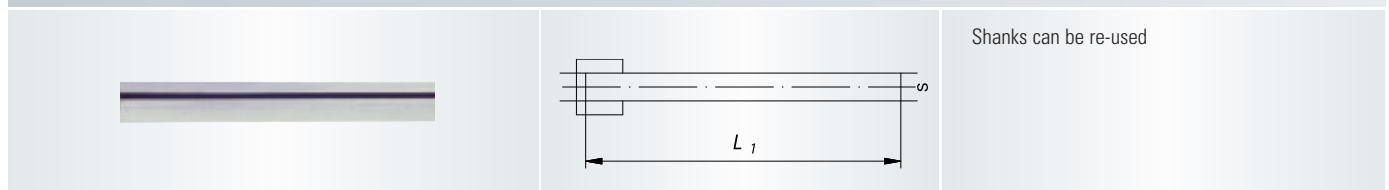
Diameter D	In Increments of	Width T	Shank options*/Diameter S
1,8 – 2,0 mm	0,1 mm	3 mm	2 – 3 mm
2,0 – 2,6 mm	0,1 mm	4 mm	2 – 3 mm
3,0 – 5,0 mm	0,1 mm	5 mm	2 – 5 mm
5,1 – 10,0 mm	0,1 mm	as D taken to nearest mm	4 – 10 mm
10,0 – 40,0 mm	1 mm	10 mm	4 – 12 mm



**Industry**

## Chart for Tungsten carbide shanks

Ordering example: CBN-Mounted Point, Quality 50.3, D 11 mm, Shank 8 x 70

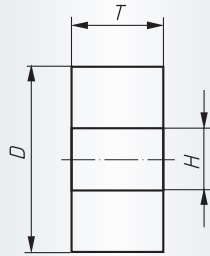
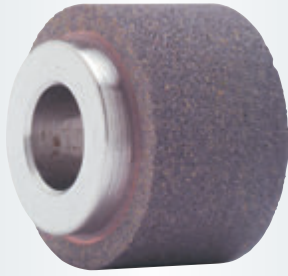


Shanks can be re-used

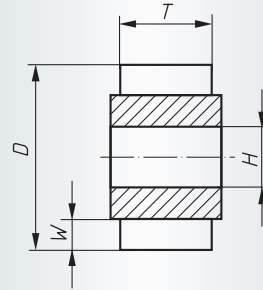
Shank-diameter S	Shank length (blank length) L <sub>1</sub> mm									
	30	40	50	60	70	80	100	120	130	150
2 mm	30	40	50							
2,5 mm	30	40	55							
3 mm	30	40	50	60						
4 mm		40	50	60	70					
5 mm			50	60	70					
6 mm			50	60	70	80	100	120		
8 mm			50	60	70	80	100	120		
10 mm				60	70	80	100	120	130	150
12 mm						80	100	120		150

Bore and facegrinding possible see drawing above.

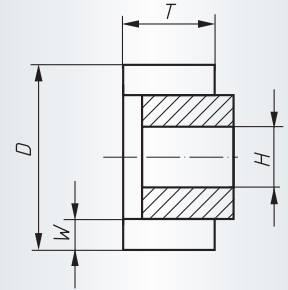
**Selection of wheel dimensions and shapes**



Type 1  
unfinished (as fired)



Type 2  
plain steel core



Type 3  
steel core, 3 mm recessed

Due to technical reasons, the smallest dimensions for W is 5 mm.



**Industry**

**Dimensions**

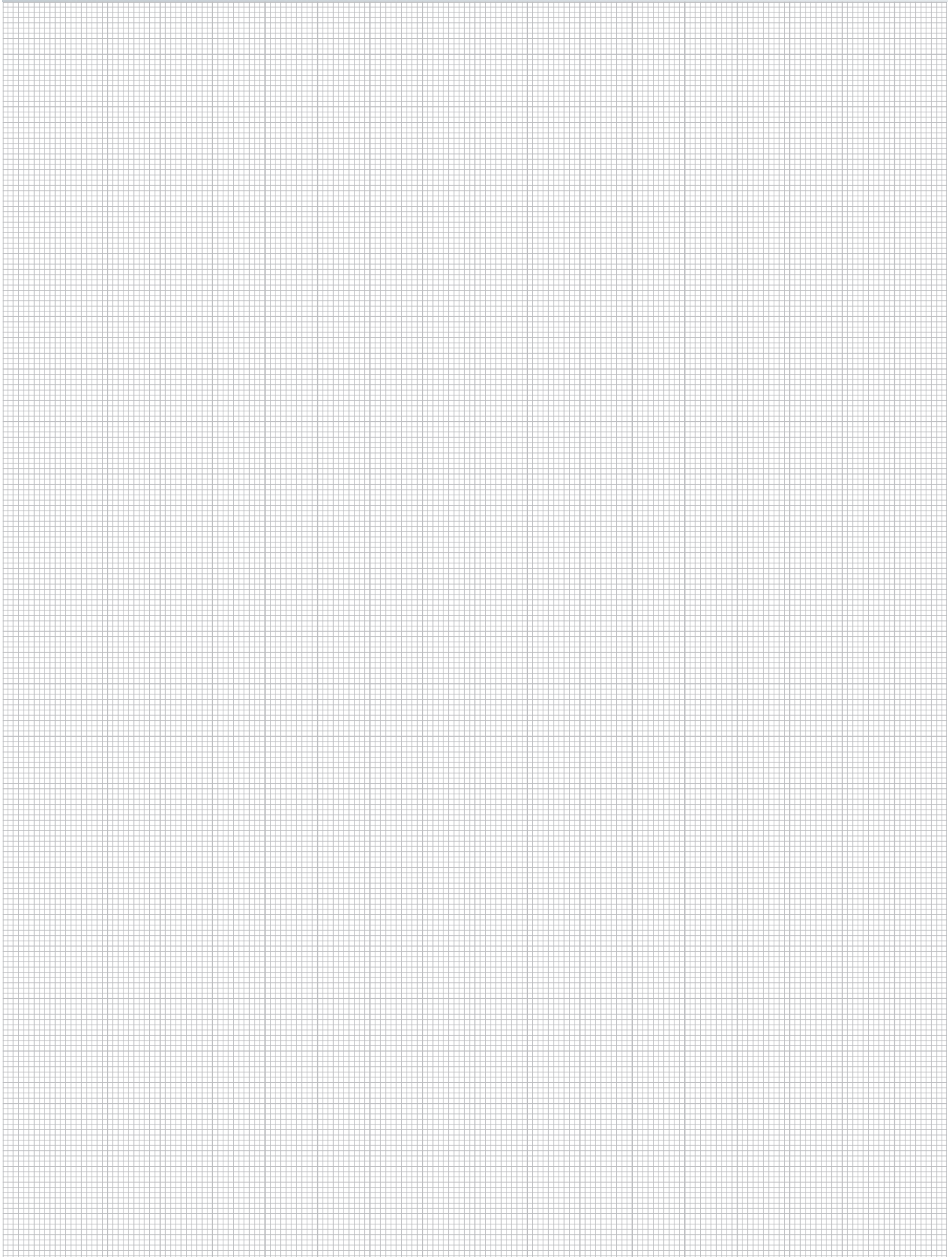
Ordering example: CBN Wheel, Quality B 54 C 150 29, Type 3: D 35 x 10 mm, H 8 mm

When ordering please specify bore size „H“.

Minimum order quantity 10 pieces

Dimension D	In increments of D	Width		
		10 mm	12 mm	15 mm
14 to 25 mm	1 mm	10 mm	12 mm	15 mm
25 to 40 mm	5 mm	10 mm	12 mm	15 mm

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid is composed of small, uniform squares.

## CBN-/Diamond Mounted Points, electro-plated

**366** CBN-/Diamond points, cylindrical shape

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**367** Diamond points using solid carbide

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**367** CBN-/Diamond points, spherical shape

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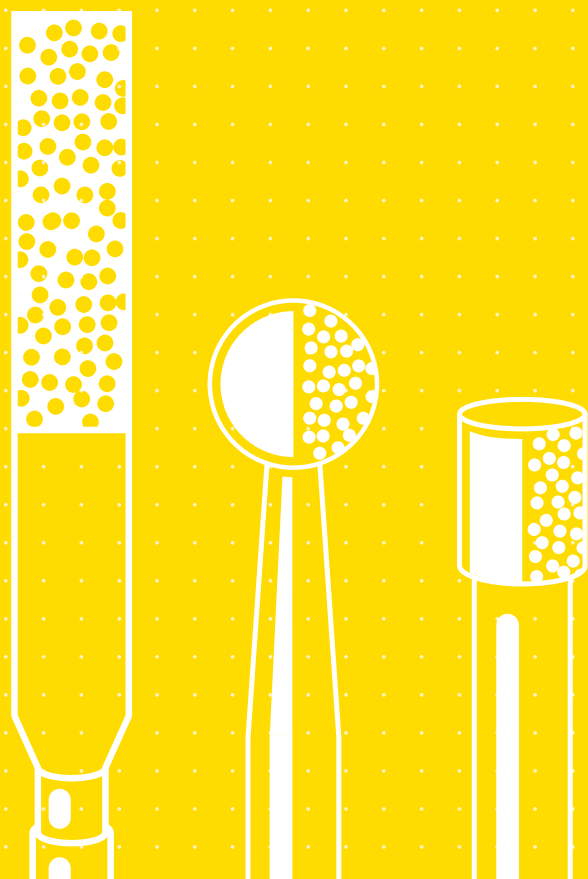
**373** Power tool

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### Product line marking

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





Industry

## Diamond points cylindrical shape

Ordering example: A34013050126

Description		grit sizes	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	Packing unit: 1 pc. per type									recommended for
DS 01003	D 126	1	3	3	40	A34013050126	①	②	③	④	⑤	⑦	⑨	■			
DS 01503	D 126	1,5	3	3	40	A34013051126	①	②	③	④	⑤	⑦	⑨	■			
DS 02005	D 126	2	5	3	40	A34013052126	①	②	③	④	⑤	⑦	⑨	■			
DS 02505	D 126	2,5	5	3	40	A34013053126	①	②	③	④	⑤	⑦	⑨	■			
DS 03005	D 126	3	5	3	40	A34013054126	①	②	③	④	⑤	⑦	⑨	■			
DS 03505	D 126	3,5	5	3	40	A3401305412601	①	②	③	④	⑤	⑦	⑨	■			
DS 04005	D 126	4	5	3	40	A34013055126	①	②	③	④	⑤	⑦	⑨	■			
DS 04505	D 126	4,5	5	3	40	A3401305512601	①	②	③	④	⑤	⑦	⑨	■			
DS 05006	D 126	5	6	3	40	A34013056126	①	②	③	④	⑤	⑦	⑨	■			
DS 06007	D 126	6	7	3	40	A34013057126	①	②	③	④	⑤	⑦	⑨	■			
DS 08010	D 126	8	10	6	60	A34013058126	①	②	③	④	⑤	⑦	⑨	■			
DS 10010	D 126	10	10	6	60	A34013059126	①	②	③	④	⑤	⑦	⑨	■			
DS 12015	D 126	12	15	6	60	A34013060126	①	②	③	④	⑤	⑦	⑨	■			



Industry

## CBN points, cylindrical shape

Ordering example: A34033050126

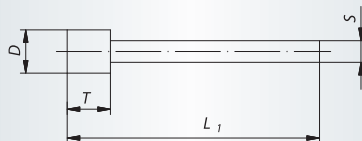
Description		grit sizes	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	Packing unit: 1 pc. per type									recommended for
CS 01003	B 126	1	3	3	40	A34033050126			③	④				■			
CS 01503	B 126	1,5	3	3	40	A34033051126			③	④				■			
CS 02005	B 126	2	5	3	40	A34033052126			③	④				■			
CS 02505	B 126	2,5	5	3	40	A34033053126			③	④				■			
CS 03005	B 126	3	5	3	40	A34033054126			③	④				■			
CS 03505	B 126	3,5	5	3	40	A3403305412601			③	④				■			
CS 04005	B 126	4	5	3	40	A34033055126			③	④				■			
CS 04505	B 126	4,5	5	3	40	A3403305512601			③	④				■			
CS 05006	B 126	5	6	3	40	A34033056126			③	④				■			
CS 06007	B 126	6	7	3	40	A34033057126			③	④				■			
CS 08010	B 126	8	10	6	60	A34033058126			③	④				■			
CS 10010	B 126	10	10	6	60	A34033059126			③	④				■			
CS 12015	B 126	12	15	6	60	A34033060126			③	④				■			



Industry

**Diamond points using solid carbide shanks, cylindrical shape**

Ordering example: A340202305126



**Packing unit:**  
1 pc. per type

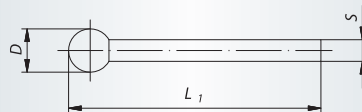
Description	grit sizes	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
DSH 02303	D 126	2,3	3	2	75	A340202305126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSH 03304	D 126	3,3	4	3	75	A340203303126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSH 04305	D 126	4,3	5	4	75	A340204305126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSH 06307	D 126	6,3	7	6	75	A340206307126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSH 08310	D 126	8,3	10	8	75	A340208310126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSH 10310	D 126	10,3	10	10	75	A340210310126	① ② ③ ④ ⑤ ⑦ ⑨	■



Industry

**Diamond points, spherical shape**

Ordering example: A34013090126



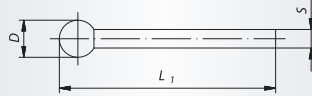
**Packing unit:**  
1 pc. per type

Description	grit sizes	D mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
DSK 02020	D 126	2	3	40	A34013090126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSK 03030	D 126	3	3	40	A34013091126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSK 04040	D 126	4	3	40	A34013092126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSK 05050	D 126	5	3	40	A34013093126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSK 06060	D 126	6	3	40	A34013094126	① ② ③ ④ ⑤ ⑦ ⑨	■
DSK 08080	D 126	8	6	60	A34013095126	① ② ③ ④ ⑤ ⑦ ⑨	■



**CBN points, spherical shape**

Ordering example: A34033090126



**Packing unit:**  
1 pc. per type

Description	grit sizes	D mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for																		
CSK 0202	B 126	2	3	40	A34033090126			③	④															■
CSK 0303	B 126	3	3	40	A34033091126			③	④															■
CSK 0404	B 126	4	3	40	A34033092126			③	④															■
CSK 0505	B 126	5	3	40	A34033093126			③	④															■
CSK 0606	B 126	6	3	40	A34033094126			③	④															■
CSK 0808	B 126	8	6	60	A34033095126			③	④															■



## Diamond Files, electro-plated

**370** Diamond files for off-hand filing machines

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**370** Diamond needle files

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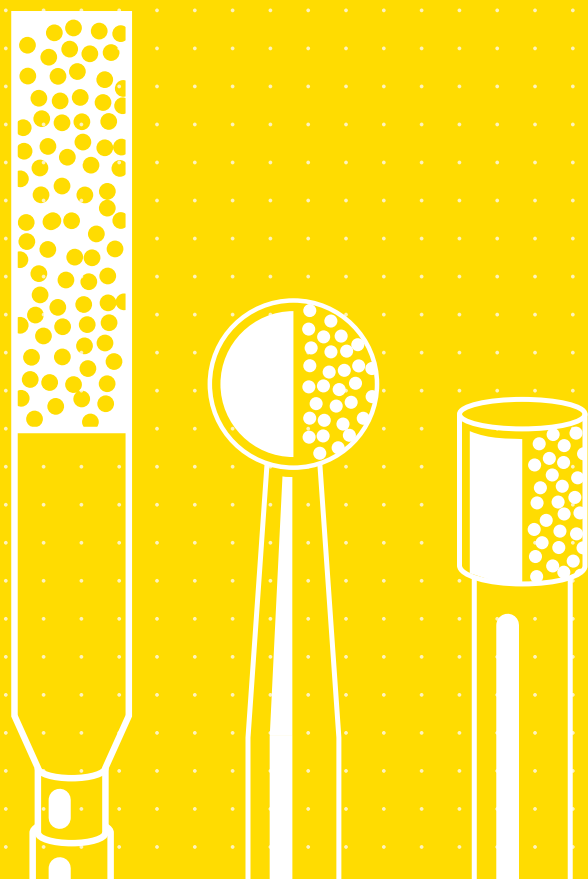
**371** Diamond riffler files

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### Product line marking

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




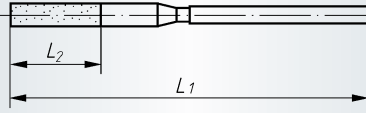


# 370 Diamond Files, electro-plated



Industry

## Diamond files for off-hand filing machines

Ordering example: A34003122126


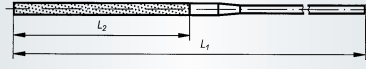








Description		Available profiles	A summary of available shapes	grit sizes	Cross section mm	L <sub>2</sub> mm	L <sub>1</sub> mm	Product-Number	recommended for	
 		<b>Packing unit:</b> 1 pc. per type								
DF 3122	flat, one side coated		D 126	4 x 1	15	50	A34003122126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3130	round		D 126	4	15	50	A34003130126	① ② ③ ④ ⑤ ⑦ ⑨	■	



Industry

## Diamond needle files

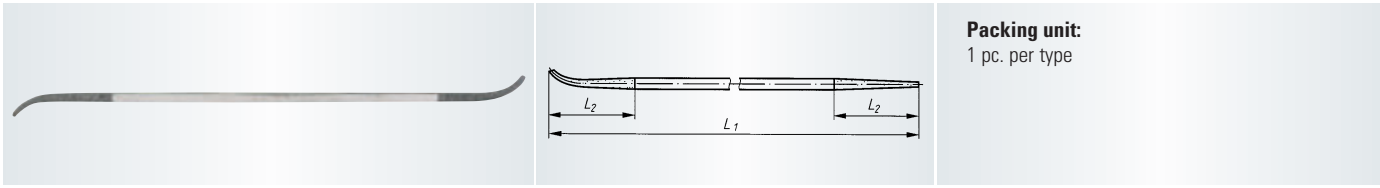
Ordering example: A34003140091

Description		Available profiles	A summary of available shapes	grit sizes	Cross section mm	L <sub>2</sub> mm	L <sub>1</sub> mm	Product-Number	recommended for	
 		<b>Packing unit:</b> 1 pc. per type								
DF 3140	flat		D 91	5,0 x 1,4	70	140	A34003140091	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3140	flat		D 126	5,0 x 1,4	70	140	A34003140126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3142	triangular		D 91	3,5 x 3,5	70	140	A34003142091	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3142	triangular		D 126	3,5 x 3,5	70	140	A34003142126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3143	square		D 126	2,5 x 2,5	70	140	A34003143126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3144	half-round		D 126	5,2 x 1,9	70	140	A34003144126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3145	round		D 126	3	70	140	A34003145126	① ② ③ ④ ⑤ ⑦ ⑨	■	
DF 3146	knife		D 126	5,0 x 1,4	70	140	A34003146126	① ② ③ ④ ⑤ ⑦ ⑨	■	



Diamond files, Rifflers

Ordering example: A34003110126



Packing unit:  
1 pc. per type

Description	Available profiles	A summary of available shapes	grit sizes	Cross section mm	L <sub>2</sub> mm	L <sub>1</sub> mm	Product-Number	recommended for	
DF 3110	bird tongue		D 126	4 x 2	25	150	A34003110126	① ② ③ ④ ⑤ ⑦ ⑨	■
DF 3111	flat		D 126	3 x 1,5	25	150	A34003111126	① ② ③ ④ ⑤ ⑦ ⑨	■
DF 3112	square		D 126	2 x 2	25	150	A34003112126	① ② ③ ④ ⑤ ⑦ ⑨	■
DF 3113	triangular		D 126	3	25	150	A34003113126	① ② ③ ④ ⑤ ⑦ ⑨	■

What is your experience when using this tool?

**SLTR Ceramic:**  
As a metal worker, I need a tool that lasts and that grinds quickly and easily. I'm really happy with SLTR Ceramic!



**Moses Kasura**  
Engineering Department

[www.lukas-erzett.com](http://www.lukas-erzett.com)

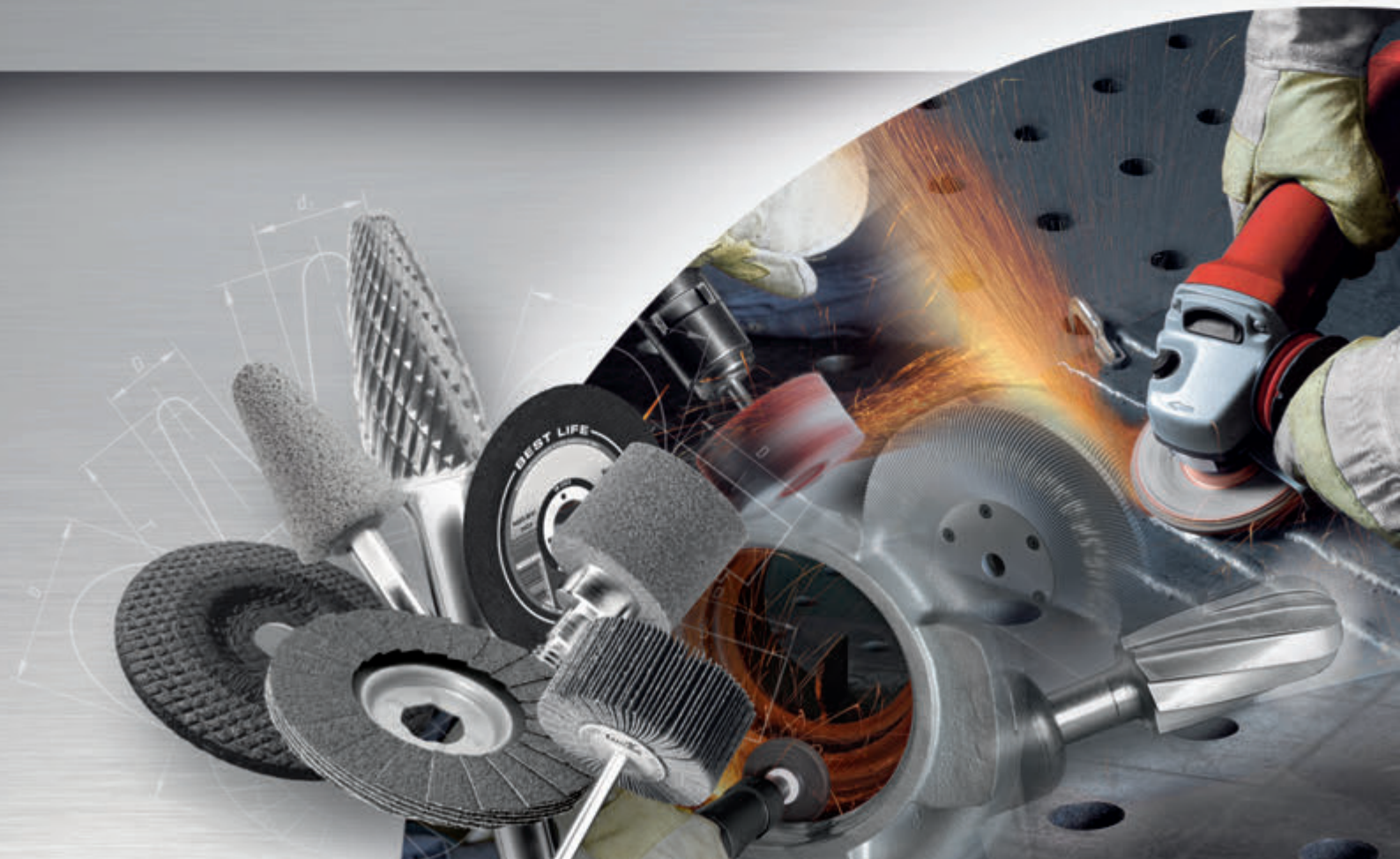


**My surface finishing expert**

**Multi faceted.  
Diverse competence.  
A network.**



**Individual. Problem solver.  
Innovative.**



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## Air tools

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Air tools

### 375 Angle grinder

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Power tools

### 390 Conditioning machine

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### Product line marking

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



## Technical Information

### General information

High performance and low air consumption are the major features of LUKAS air tools. The robust vane motors can be stopped under load without causing any damage.

Speed governors are used to prevent exceeding of the idling speed within the specified tolerance.

The tool design is maintenance and service friendly. It facilitates the change of wear parts.

### Compressed air supply

Power tools already achieve maximum performance levels from a flow pressure of 0.63 MPa (= 6.3 bar). We are more than happy to provide advise when it comes to the optimum design of your compressed air supply. Please refer to the technical information for initial specifications on line cross sections (diagram).

Air consumption (see machine data)	Connection thread
0,05–0,5 m <sup>3</sup> /min	¼" thread
0,15–0,9 m <sup>3</sup> /min	⅜" thread
0,5–1,5 m <sup>3</sup> /min	½" thread
0,8–6,0 m <sup>3</sup> /min	¾" thread

### Vane motor lubrication

A maintenance unit consisting of a water trap and lubricator reliably protects the vane motors against wear, reduces the maintenance effort and increases the service life.

### Turbo drive lubrication

#### **Machines with a turbo drive are always operated without a lubricator!**

As the rotation of the rotor in the machine housing is a widely non-contact motion, the results are particularly low friction losses and higher energy efficiency during grinding and milling.

### Ergonomics and safety

#### Vibration

All air tools are tested and labelled in accordance with the current European noise and vibration directive to protect the user.

Vibrations are recorded and calculated three-dimensionally in this respect.

#### Ergonomics

When compared to electric power tools, pneumatic tools offer a higher level of performance and lower weight. Ergonomically shaped, insulated handles mean that the machines can be held easily, thus enabling fatigue-free working.

Machining of workpieces which are difficult to access also presents no problem with LUKAS pneumatic tools, as the spindle length, air outlet and valve design of many machines can be optimized to suit user requirements.

#### Safety

Use is even possible in potentially hazardous atmospheres.

#### Quality

All machines have a robust aluminium housing and are designed for use in a harsh environment. Motors do not overheat, even during continuous operation at a maximum performance level. In the context of 100% quality control all machines undergo speed and performance measurements prior to delivery.

#### Safety instruction

Only tools which are safe and approved for operation at the peripheral speeds achieved with respective tools should be used.



**Turbo driven angle grinder – insulated**

Ordering example: A3993202212001



**Length:** approx. 295 mm  
**Weight:** approx. 1,9 kg  
**Peripheral speed:** max. 80 m/s  
**Wheel arbour:** 22,23 mm  
**Drive:** turbo  
 integral speed regulator  
**Vibration ISO 8662:** < 2,5 m/s<sup>2</sup>  
**Sound pressure level ISO 15744:** 86 dB (A)

Description	Valve	Threaded spindle	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Tool max. Ø mm	Hose-nominal size (min.) mm	Product-Number	
AMIN 12-125 TWH	Lever	M 14	12.200	2,2	1,8	125	13	A3993202212001	■

**Features:**

- **Oil-free** and low maintenance
- Optimum weight for performance for fatigue-free working
- Low air consumption
- Vibration dampening on handle
- High regard to health and safety – integral speed regulator – automatic overspeed preventer
- Tool-free setting of wheel guard
- Spindle emergency stop button
- Tool-free wheel change possible

- recommended for IQ series
- high stock removal level

**Included with the machine:**

Connector DN 10, R 1/2", wheel guard and spanner

**Special equipment:**

Inlet hose including quick release coupling and connector DN 10

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Fibre Disc FIS	Ø 115 mm	from 343
All SLT lamellar flap discs (except SLTV/M/P and ASVT)	Ø 115 mm und 125 mm	from 230
Cutting discs	Ø 115 mm und 125 mm	from 184
Grinding discs	Ø 115 mm und 125 mm	from 195
Diamond cutting discs	Ø 115 mm und 125 mm	from 208
Diamond cup wheels	Ø 115 mm und 125 mm	from 218



### Abrasive belt grinder – insulated

Ordering example: A3993302113



**Length:** approx. 325 mm  
**Height:** approx. 86 mm  
**Weight:** approx. 0,90 kg  
**Drive:** vane motor

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Belt peripheral speed m/s	Hose-nominal size mm	Product-Number	
AMIN 30 BSH	Lever	30.000	0,3	0,45	28	6	A3993302113	■

**Included with the machine:**

an abrasive belt mounting arm for long belts in dimension 13 x 305 mm, inlet and exhaust air hoses plus silencer, collet for 6 mm, spanner

**Extra equipment:**

collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"  
 Abrasive belt extensions in various dimensions

**Available ex-stock:**

long belts 13 x 305 mm

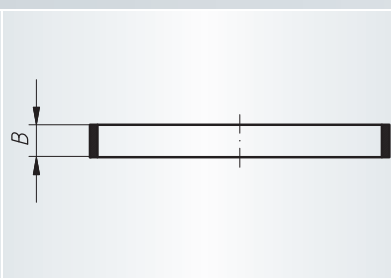
**Suited to LUKAS tools:**

Please take note of the relevant RPM stated on our packing material.



### SBL, finishing belts

Ordering example: A3000130305040T01



**Packing unit:**

100 pcs. per type  
 Peripheral speed: 28 m/s  
 NK = reg. Aluminium Oxide  
 ZK = Zirconia Alum. Oxide

Description	Grits	B mm	Length mm	Lining	Product-Number	recommended for	
SBLT	ZK 40	13	305	robust-flexible	A3000130305040T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 60	13	305	robust-flexible	A3000130305060T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLT	ZK 60	13	305	robust-flexible	A3000130305060T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 80	13	305	robust-flexible	A3000130305080T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLX	NK 80	13	305	robust	A3000130305080X	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLT	ZK 80	13	305	robust-flexible	A3000130305080T01	① ② ③ ④ ⑤ ⑧	■
SBLT	NK 120	13	305	robust-flexible	A3000130305120T	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SBLX	NK 120	13	305	robust	A3000130305120X	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■





**Straight grinder – insulated**

Ordering example: A3993101112



**Length:** approx. 175 mm  
**Diameter:** 34,5 mm  
**Weight:** approx. 0,90 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 12-030 GD	Twist	12.000	0,3	0,49	6	8	A3993101112	■
AMIN 12-030 GH	Lever	12.000	0,3	0,49	6	8	A3993102112	■
AMIN 15-030 GD	Twist	15.000	0,3	0,52	6	8	A3993101115003	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, 6 mm collet and spanner

**Extra equipment:**

collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
<b>AMIN 12-030 GD/GH</b>		
Tungsten Carbide Burrs	up to Ø 20 mm	from 25
Burrs of HSS	up to Ø 8 mm	from 63
Mounted flap wheels SFV/M	Ø 40 mm	from 269
Mounted flap wheels SFI	Ø 30 mm	263
Mounted flap wheels SFA	Ø 15 mm, 20 mm, 30 mm	264
Abrasive Belts SBZY	up to Ø 30 mm	from 295
Abrasive Belts SBKE	up to Ø 36 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 20 mm	from 309
Abrasive Caps SK...	up to Ø 21 mm	from 313
Abrasive Sleeves SHKE	0885, 1385, 1885	321
Polishing Points P1	4020	137
Polishing Points P2	Ø 20 mm	140
Polishing Points P5	Ø 40 mm	153
<b>AMIN 15-030 GD</b>		
Tungsten Carbide Burrs	up to Ø 16 mm	from 25
Burrs of HSS	up to Ø 6 mm	from 63
Mounted flap wheels SFI	Ø 30 mm	263
Mounted flap wheels SFA	Ø 15 mm, 20 mm, 30 mm	264
Abrasive Belts SBZY	up to Ø 25 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 20 mm	from 309
Abrasive Caps SK...	up to Ø 16 mm	from 313
Abrasive Sleeves SHKE	0885, 1385	321



### Straight grinder – insulated

Ordering example: A3993102115



**Length:** approx. 310 mm  
**Diameter:** 52 mm  
**Weight:** approx. 2,3 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consump- tion under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 15-100 GH	Lever	15.300	1	1	6	12	A3993102115	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, 6 mm collet and spanner

**Extra equipment:**

collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 16 mm	from 25
Burrs of HSS	up to Ø 6 mm	from 63
Mounted Points	up to Ø 60 mm	from 93
Polishing Points P2	up to Ø 16 mm	from 140
Polishing Points P3	up to Ø 16 mm	from 144
Polishing Points P6	up to Ø 30 mm	from 155
Mounted flap wheels SFL/SFE/SFB/SFT/SFC	up to Ø 40 mm	from 253
Abrasive Caps SK...	up to Ø 16 mm	from 313
Abrasive Rolls SR...	up to Ø 20 mm	from 309
Abrasive Belts SBZY	up to Ø 22 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303



**Straight grinder with spindle extension – insulated**

Ordering example: A3993102115002



**Length:** approx. 615 mm<sup>1)</sup>  
**Diameter:** 47 mm  
**Weight:** approx. 2,1 kg  
**Drive:** vane motor  
 Integral speed regulator

<sup>1)</sup> Dimension with two spindle extensions

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 15-070 GH2L	Lever	15.300	0,7	0,7	6	10	A3993102115002	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, two spindle extensions (each 200 mm long), collet 6 mm and spanner

**Extra equipment:**

spindle extension: 200 mm (max. length of spindle extensions up to 1.200 mm), collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"



Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Mounted flap wheels SFL/B/T/E/C	up to Ø 40 mm	from 253
Mounted flap wheels SFI	Ø 30 mm	263
Mounted flap wheels SFA	Ø 15 mm, 20 mm, 30 mm	264
Abrasive Belts SBZY	up to Ø 25 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 20 mm	from 309
Abrasive Caps SK...	up to Ø 16 mm	from 313
Abrasive Sleeves SHKE	0885, 1385	321
Polishing Points P1	Ø 32 mm	from 137
Polishing Points P2	Ø 16 mm	from 140



### Straight grinder – insulated

Ordering example: A3993102115001



**Length:** approx. 310 mm  
**Diameter:** 52 mm  
**Weight:** approx. 2,2 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 15-100 GHl	Lever	15.300	1	1	6	12	A3993102115001	■
AMIN 19-100 GHl	Lever	19.000	1	1	6	12	A3993102119002	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

**Extra equipment:**

collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
<b>AMIN 15-100 GHl</b>		
Mounted flap wheels SFL/B/T/E/C	up to Ø 40 mm	from 253
Mounted flap wheels SFl	Ø 30 mm	263
Mounted flap wheels SFA	Ø 15 mm, 20 mm, 30 mm	264
Abrasive Belts SBZY	up to Ø 25 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 20 mm	from 309
Abrasive Caps SK...	up to Ø 16 mm	from 313
Abrasive Sleeves SHKE	0885, 1385	321
<b>AMIN 19-100 GHl</b>		
Mounted Points	Ø 50 mm	from 93
Mounted flap wheels SFL	Ø 20 mm	from 253
Abrasive Belts SBZY	up to Ø 19 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 13 mm	from 309
Abrasive Caps SK...	up to Ø 13 mm	from 313
Abrasive Sleeves SHKE	0885	321



**Straight grinder – insulated**

Ordering example: A3993102119



**Length AMIN 19-100 GH:** approx. 310 mm  
**Length AMIN 19-100 GHK:** approx. 190 mm  
**Diameter:** 52 mm  
**Weight GH:** approx. 2,3 kg  
**Weight GHK:** approx. 1,7 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 19-100 GH	Lever	19.000	1	1	6	12	A3993102119	■
AMIN 19-100 GHK	Lever	19.000	1	1	6	12	A3993102119001	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

**Extra equipment:**

collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 12 mm	from 25
Burrs of HSS	up to Ø 4 mm	from 63
Mounted Points	up to Ø 50 mm	from 93
Polishing Points P1	up to Ø 50 mm	from 137
Polishing Points P2	up to Ø 12 mm	from 140
Polishing Points P3	up to Ø 10 mm	from 144
Polishing Points P5	up to Ø 50 mm	from 153
Polishing Points P6	up to Ø 16 mm	from 155
Abrasive Caps SK...	up to Ø 13 mm	from 313
Abrasive Rolls SR...	up to Ø 13 mm	from 309
Abrasive Belts SBZY	up to Ø 19 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303



### Straight grinder – insulated

Ordering example: A3993101120



**Length:** approx. 175 mm  
**Diameter:** 34,5 mm  
**Weight:** approx. 0,90 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 20-030 GD	Twist	20.000	0,3	0,53	6	8	A3993101120	■
AMIN 20-030 GH	Lever	20.000	0,3	0,45	6	8	A3993102120	■
AMIN 23-030 GD	Twist	23.000	0,3	0,54	6	8	A3993101123	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

**Extra equipment:**

collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
<b>AMIN 20-030 GD/GH</b>		
Tungsten Carbide Burrs	up to Ø 12 mm	from 25
Burrs of HSS	up to Ø 4 mm	from 63
Mounted flap wheels SFL	Ø 20 mm	from 253
Abrasive Belts SBZY	up to Ø 19 mm	from 295
Abrasive Belts SBKE	up to Ø 29 mm	303
Abrasive Rolls SRZY/SRKE	up to Ø 13 mm	from 309
Abrasive Caps SK...	up to Ø 13 mm	from 313
Abrasive Sleeves SHKE	0885	321
Mounted Points Shank 6 mm	Ø 22 mm, 25 mm, 32 mm, 40 mm	from 93
Polishing Points P2	Ø 13 mm	from 140
<b>AMIN 23-030 GD</b>		
Tungsten Carbide Burrs	up to Ø 12 mm	from 25
Burrs of HSS	up to Ø 4 mm	from 63
Abrasive Belts SFL	Ø 20 mm	from 253
Abrasive Belts SBZY	up to Ø 15 mm	from 295
Abrasive Rolls SRZY/SRKE	up to Ø 13 mm	from 303
Abrasive Caps SK...	up to Ø 13 mm	from 313
Abrasive Sleeves SHKE	0885	321
Mounted Points	up to Ø 40 mm	from 93
Polishing Points P1	Ø 10–20 mm	from 137
Polishing Points P2	Ø 5–10 mm	from 140
Polishing Points P5	Ø 8–20 mm	from 153



**Straight grinder – insulated**

Ordering example: A3993101130



**Length:** approx. 175 mm  
**Diameter:** 34,5 mm  
**Weight:** approx. 0,70 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 30-030 GD	Twist	30.000	0,3	0,45	6	6	A3993101130	■
AMIN 30-030 GH	Lever	30.000	0,3	0,45	6	6	A3993102130	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

**Extra equipment:**

collets for Ø 3 mm, 3,25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 8 mm	from 25
Burrs of HSS	up to Ø 3 mm	from 63
Mounted Points	up to Ø 32 mm	from 93
Polishing Points P1	up to Ø 32 mm	from 137
Polishing Points P2	up to Ø 10 mm	from 140
Polishing Points P3	up to Ø 10 mm	from 144
Polishing Points P5	up to Ø 32 mm	from 153
Polishing Points P6	up to Ø 12 mm	from 155
Abrasive Caps SK...	up to Ø 10 mm	from 313
Abrasive Rolls SR...	up to Ø 12 mm	from 309
Abrasive Belts SBZY	up to Ø 12 mm	from 295



### Straight grinder, insulated

Ordering example: A3993101132



**Length:** approx. 206 mm  
**Body diameter:** approx. 30 mm  
**Spindle casing diameter:** approx. 23 mm  
**Weight:** approx. 0,40 Kg  
**Drive:** vane motor  
**Partial front exhaust (can be restricted)**

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 32-027 GD	Twist	32.000	0,27	0,3	6	6	A3993101132	■

#### Included with the machine:

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

#### Extra equipment:

collets for Ø 3 mm, 1/8", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 8 mm	from 25
Burrs of HSS	up to Ø 3 mm	from 63
Mounted Points	up to Ø 32 mm	from 93
Polishing Points P1	up to Ø 32 mm	from 137
Polishing Points P2	up to Ø 10 mm	from 140
Polishing Points P3	up to Ø 10 mm	from 144
Polishing Points P5	up to Ø 32 mm	from 153
Polishing Points P6	up to Ø 12 mm	from 155
Abrasive Caps SK...	up to Ø 10 mm	from 313
Abrasive Rolls SR...	up to Ø 12 mm	from 309
Abrasive Belts SBZY	up to Ø 12 mm	from 295





**Straight grinder – insulated**

Ordering example: A3993101145



**Length:** approx. 175 mm  
**Diameter:** 34,5 mm  
**Weight:** approx. 0,70 kg  
**Drive:** vane motor

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 45-030 GD	Twist	45.000	0,3	0,5	6	6	A3993101145	■
AMIN 45-030 GH	Lever	45.000	0,3	0,5	6	6	A3993102145	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 6 mm and spanner

**Extra equipment:**

collets for Ø 3 mm, 3,25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 6 mm	from 25
Mounted Points	up to Ø 20 mm	from 93
Polishing Points P1	up to Ø 20 mm	from 137
Polishing Points P2	up to Ø 6 mm	from 140
Polishing Points P3	up to Ø 6 mm	from 144
Polishing Points P5	up to Ø 20 mm	from 153
Polishing Points P6	up to Ø 10 mm	from 155
Abrasive Caps SK...	up to Ø 5 mm	from 313
Abrasive Belts SBZY	up to Ø 12 mm	from 295



### Straight grinder – insulated

Ordering example: A3993101155



**Length:** approx. 130 mm  
**Diameter:** 16 mm  
**Weight:** approx. 0,24 kg  
**Drive:** vane motor

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consump- tion under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 55-011 GD	Twist	55.000	0,11	0,15	3	5	A3993101155	■

#### Included with the machine:

inlet and exhaust air hoses plus silencer, collet 3 mm and spanner

#### Extra equipment:

collets for Ø 2 mm, 3,25 mm, 1/8", 3/32"

#### Characteristics:

- Highest powered machine in its class
- Compact design
- Lockable rotary switch

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 5 mm	from 25
Mounted Points	up to Ø 16 mm	from 93
Polishing Points P1	up to Ø 16 mm	from 137
Polishing Points P2	up to Ø 5 mm	from 140
Polishing Points P5	up to Ø 16 mm	from 153
Abrasive Caps SK...	up to Ø 5 mm	from 313
Abrasive Belts SBZY	up to Ø 10 mm	from 295



**Straight grinder – insulated**

Ordering example: A3993101172



**Length:** approx. 154 mm  
**Diameter:** 27,5 mm  
**Weight:** approx. 0,45 kg  
**Drive:** vane motor

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 72-013 GD	Twist	72.000	0,13	0,21	3	5	A3993101172	■

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 3 mm and spanner

**Extra equipment:**

collets for Ø 2 mm, 3,25 mm, 1/8", 3/32"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 4 mm	from 25
Mounted Points	up to Ø 13 mm	from 93
Polishing Points P1	up to Ø 13 mm	from 137
Polishing Points P2	up to Ø 4 mm	from 140
Polishing Points P5	up to Ø 13 mm	from 153



**Turbo driven straight grinder – insulated**

Ordering example: A3993101170



**Length:** approx. 170 mm  
**Diameter:** Ø 20,6 mm, Ø 41,5 mm  
**Weight:** approx. 0,6 kg  
**Drive:** turbo  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	Collet dia Ø mm	Hose-nominal size mm	Product-Number	
AMIN 70-025 TGD	Twist	70.000	0,25	0,43	3	6	A3993101170	■

**Features:**

- **Oil-free** and low maintenance
- Optimum weight for performance
- Integrated speed controller
- Automatic braking system to prevent overrun
- Lockable rotary switch

**Included with the machine:**

inlet and exhaust air hoses plus silencer, collet 3 mm and spanner

**Extra equipment:**

collets for Ø 4 mm, 5 mm, 6 mm, 1/8", 3/16", 1/4"

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
Tungsten Carbide Burrs	up to Ø 4 mm	from 25
Mounted Points	up to Ø 13 mm	from 93
Polishing Points P1	up to Ø 8 mm	from 137
Polishing Points P2	up to Ø 4 mm	from 140
Polishing Points P5	up to Ø 6 mm	from 153



**Straight grinder for grinding wheels tapered both sides**

Ordering example: A79901021076



**AM 07/100 GH**

**Length:** approx. 530 mm  
**Diameter:** 74 mm  
**Weight:** approx. 3,8 kg  
**Drive:** vane motor  
 Integral speed regulator

**AM 11/080 GH**

**Length:** approx. 498 mm  
**Diameter:** 62 mm  
**Weight:** approx. 2,2 kg  
**Drive:** vane motor  
 Integral speed regulator

Description	Valve	Idle speed min <sup>-1</sup>	Power consumption KW	Air consumption under load m <sup>3</sup> /min	max. grinding wheel Ø mm	tool fitting mm	Hose-nominal size mm	max. peripheral speed m/s	Product-Number	
AM 07/100 GH	Lever	7.600	1,5	1,6	125 x 25	20	13	50	A79901021076	■
AM 11/080 GH	Lever	10.700	1,1	1,3	80 x 20	20	13	50	A39901012115001	■

**Included with the machine:**

connector for inlet hose with internal Ø 13 mm, mounting flange to suit grinding wheels tapered both sides and spanner

These straight grinders in conjunction with LUKAS grinding wheels are ideal for removing weld seams and flashes on castings. Grinding with double-sided tapered fettling wheels is permitted without the use of a wheel guard, but only when the special flanges are used; wheel blotters are not necessary. This type of machine is

equipped with safety flanges. Both flanges cannot be loosened due to the rotational direction of the spindle; even if the machine becomes jammed, the wheel will not become loose.

Suited to LUKAS tools: Please take note of the relevant RPM stated on our packing material.	Dimension	Page
<b>AMIN 07/100 GH</b> Grinding wheel SE4	Ø 100–125 mm, Bore 20 mm	201
<b>AMIN 11/080 GH</b> Grinding wheel SE4	Ø 80 mm, Bore 20 mm	201



### Conditioning machine

Ordering example: A3995ESM1310



**Weight:** approx. 2,8 kg

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

**In conjunction with the appropriate tool, ideal for:**

- Satin finishing
- Polishing
- Smoothing
- Matt finishing
- Conditioning
- Brushing
- Deburring

**Special features :**

- Highly resilient motor (stable)
- Dual gear reduction (long service life)
- Dust-protected bearings (low wear)

Versatility due to electric motor allowing a wide selection of spindle speeds. In conjunction with the optimal tooling, a shadow free and uniform surface can be achieved on metal, wood and plastic.

**Electronic control:**

- Soft start
- Infinitely variable speed control
- Temperature and overload cut-off

Suited to LUKAS tools:	Dimension	Page
Please take note of the relevant RPM stated on our packing material.		
Polishing Roll P6	100 x 50 mm, 100 x 100 mm	160
Grinding Rolls SBZY	100 x 100 mm	304
Flap Rolls LWL, LWV, LWM, LWF	100 x 50 mm, 100 x 100 mm	from 289

## Product selection for retailers, assortments and accessories

**392** Sales promotion and Product selection for retailers

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**402** Arbors for Felt Polishing Wheels

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**402** Arbors for tools with internal thread

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**403** Mounting arbors for small cutting-off wheels

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**403** Mounting system for polishing wheels

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**404** Adapter for SFI and SFA

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**404** Reducing bushes

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**405** Handstones

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**406** Tool-sets

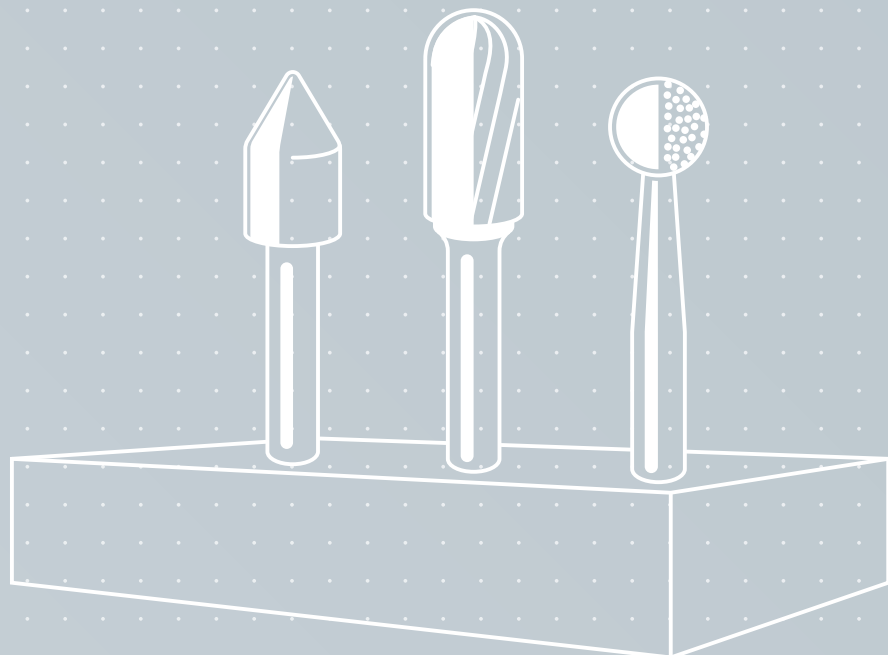
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**416** Health and safety equipment

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### Product line marking

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



# Your added value through sales promotion by Lukas

As a specialised dealer, you are well aware of your customers' requests! That is why you also want to present and sell Lukas products in a manner individually tailored to suit these customer requests. Take advantage of Lukas presentation options to enhance your sales of industrial tools for cutting, milling, grinding or polishing on a sustainable level!



## **The Lukas display panel**

Stable self-supporting presentation stand with perforated panel. Assemble your own individual display panel with hook hangers for Euro hole packaging, hook hangers for all products with a hole, a brochure pocket for further information or suspended shelves for carton packaging to create a consistent product presentation.

## **The POS cardboard counter display for cutting discs or mounted flap wheels**

Rapidly assembled for your presentation of unique Lukas mounted flap wheels or cutting and grinding discs on your sales counter. Selectively available for tools with a diameter of 115 mm or 125 mm

## **The POS counter display for tungsten carbide burrs**

Lockable display for presentation and individual sale of valuable Lukas tungsten carbide burrs with a 3 mm or 6 mm shank. Suitable for your counter or sales shelves.

## **Attractive and informative individual packing**

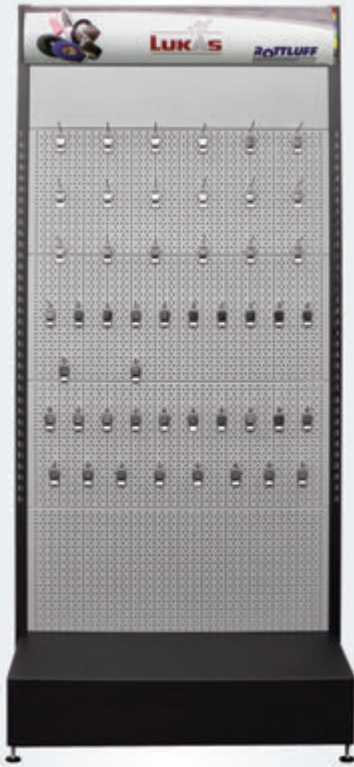
for the most popular Lukas tools, such as flap discs in the patented iQ-Series, tungsten carbide burrs, mounted flap wheels with shank made of abrasive cloth, abrasive fleece or a combination and the mounted points assortment for steel or stainless steel, all individually packaged and with a Euro hole, is available for your individual "module" to exactly the same extent as cutting discs, diamond cutting discs, grinding discs or conventional flap discs (which we call lamellar flap discs) which are simply suspended by their hole.





Industry

## Display panel



**Stable self-supporting presentation stand with perforated panel**

**Accessories**

- Hook hangers for Euro hole packaging
- Hook hangers for all products with a hole
- Suspended shelf
- Brochure pouch

**Dimensions:**  
1 x 2,20 x 0,4 m

**Product-Number:**  
A89403

Individual configuration



Industry

## Counter display



**Counter display, cardboard,  
for tool Ø 115 mm**

**Dimensions:**  
225 x 118 x 118/30 mm

**Product-Number:**  
A896225118118

**Counter display, cardboard,  
for tool Ø 125 mm**

**Dimensions:**  
225 x 128 x 128/30 mm

**Product-Number:**  
A896225128128



Counter display, lockable

Ordering example: A5039004022

	<p><b>Counter display for tungsten carbide burrs</b>  <b>Content:</b>                  Tungsten carbide burrs, 2x each                  HFA 0313.03 ZX, HFA 0820.06 ZX,                  HFA 1020.06 ZX, HFA 1225.06 ZX,                  HFC 0313.03 ZX, HFC 0820.06 ZX,                  HFC 1020.06 ZX, HFC 1225.06 ZX,                  HFD 0605.03 ZX, HFD 0807.06 ZX,                  HFD 1009.06 ZX, HFD 1210.06 ZX,                  HFG 0313.03 ZX, HFG 0820.06 ZX,                  HFG 1020.06 ZX, HFG 1225.06 ZX,                  HFM 0311.03 ZX, HFF 0820.06 ZX,                  HFF 1020.06 ZX, HFF 1225.06 ZX</p>	<p><b>Dimensions:</b>                  235 x 250 x 400 mm</p> <p><b>Product-Number:</b>                  A5039004022</p>
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BASE-X product range for retailers

Ordering example: A50010313322F

		<p><b>Packing unit:</b>                  5 pcs. per type</p>
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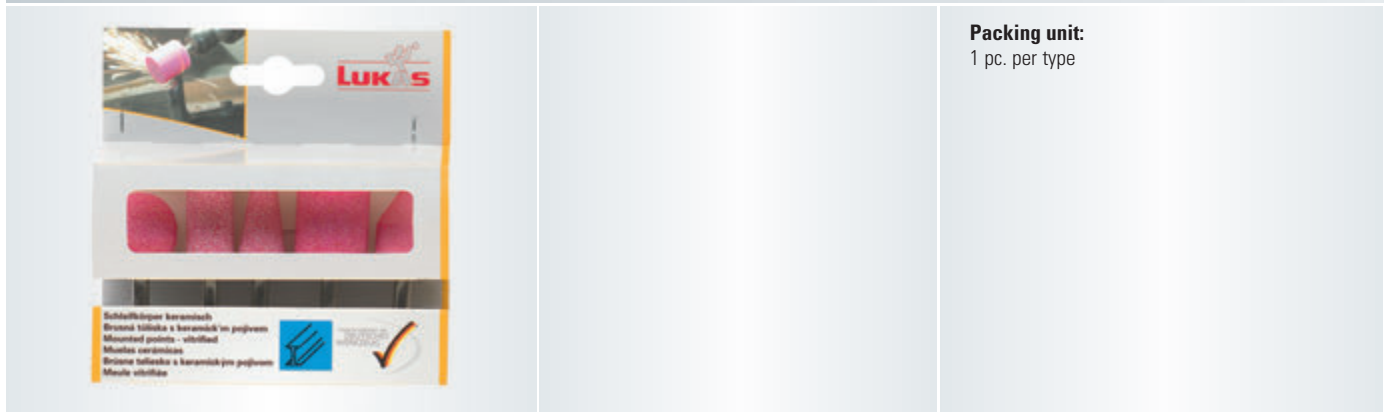
Description	Cut	Overview of shapes	similar DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Product-Number	recommended for	
HFA 0313.03 BASE-X	ZX		ZYA 0313	3	13	3	40	A50010313322F	1 2 3 4 5 7	■
HFA 0820.06 BASE-X	ZX		ZYA 0820	8	20	6	60	A50010820622F	1 2 3 4 5 7	■
HFA 1225.06 BASE-X	ZX		ZYA 1225	12	25	6	65	A50011225622F	1 2 3 4 5 7	■
HFC 0313.03 BASE-X	ZX		WRC 0313	3	13	3	40	A50020313322F	1 2 3 4 5 7	■
HFC 0820.06 BASE-X	ZX		WRC 0820	8	20	6	60	A50020820622F	1 2 3 4 5 7	■
HFC 1225.06 BASE-X	ZX		WRC 1225	12	25	6	65	A50021225622F	1 2 3 4 5 7	■
HFD 0605.03 BASE-X	ZX		KUD 0605	6	5	3	35	A50030605322F	1 2 3 4 5 7	■
HFD 0807.06 BASE-X	ZX		KUD 0807	8	7	6	47	A50030807622F	1 2 3 4 5 7	■
HFD 1210.06 BASE-X	ZX		KUD 1210	12	10	6	51	A50031210622F	1 2 3 4 5 7	■
HFG 0313.03 BASE-X	ZX		SPG 0313	3	13	3	40	A50040313322F	1 2 3 4 5 7	■
HFG 0820.06 BASE-X	ZX		---	8	20	6	60	A50040820622F	1 2 3 4 5 7	■
HFG 1225.06 BASE-X	ZX		SPG 1225	12	25	6	65	A50041225622F	1 2 3 4 5 7	■
HFM 0311.03 BASE-X	ZX		SKM 0311	3	11	3	40	A50050311322F	1 2 3 4 5 7	■
HFF 0820.06 BASE-X	ZX		---	8	20	6	60	A50100820622F	1 2 3 4 5 7	■
HFF 1225.06 BASE-X	ZX		RBF 1225	12	25	6	65	A50101225622F	1 2 3 4 5 7	■



Industry

**Mounted point assortment – STEEL**

Ordering example: A20480005602



**Packing unit:**  
1 pc. per type

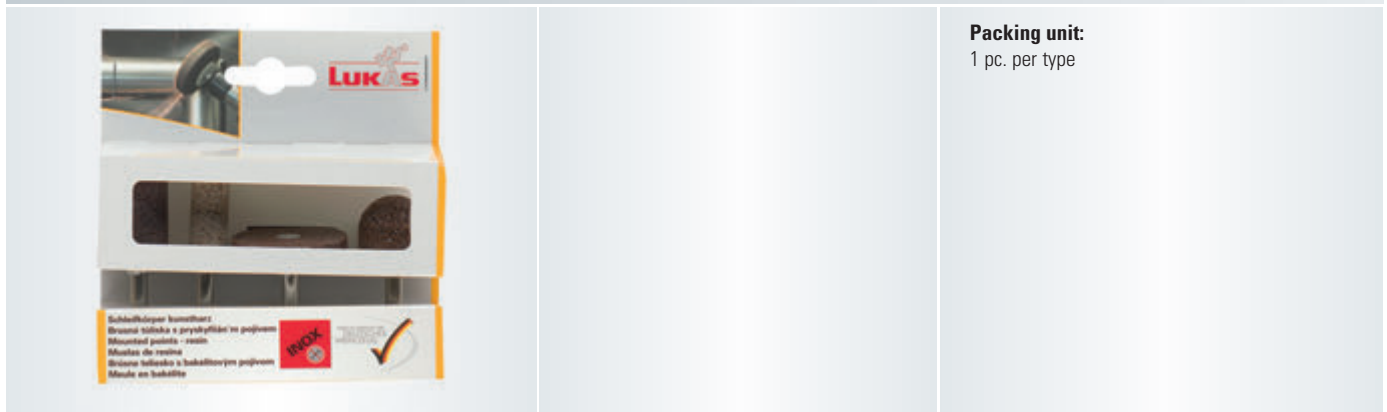
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment STAHL	6	EKR	5-pieces	ZY 1632.06, EKR 46 N V4, ZY 2525.06, EKR 36 N V4, WKS 2025.06, EKR 60 N V4, KU 2525.06, EKR 36 N V4, KE 1632.06, EKR 46 N V4	A20480005602	① ② ③	■



Industry

**Mounted point assortment – INOX**

Ordering example: A20480004627W



**Packing unit:**  
1 pc. per type

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



Lamellar Flap Discs, SLTT

Ordering example: A27201150400045F



**Packing unit:**

20 pcs. per type  
from Ø 178 = 10 pcs. per type

v<sub>max.</sub>: 80 m/s

Z POWER = Abrasive cloth using Zirconia Alum.  
Oxide with special coating containing  
active grinding additives

Ceramic = Abrasive cloth ceramic grain

ZK = Abrasive cloth with Zirconia Alum. Oxide

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
SLTT 115	Z Power 40	115	22,23	13.300	A27201150400045F	① ② ③ ④	■
SLTT 115	Ceramic 40	115	22,23	13.300	A27201150400050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 115	ZK 40	115	22,23	13.300	A27201150400065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 115	Z Power 60	115	22,23	13.300	A27201150600045F	① ② ③ ④	■
SLTT 115	Ceramic 60	115	22,23	13.300	A27201150600050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 115	ZK 60	115	22,23	13.300	A27201150600065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	Z Power 40	125	22,23	12.200	A27201250400045F	① ② ③ ④	■
SLTT 125	Ceramic 40	125	22,23	12.200	A27201250400050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	ZK 40	125	22,23	12.200	A27201250400065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	Z Power 60	125	22,23	12.200	A27201250600045F	① ② ③ ④	■
SLTT 125	Ceramic 60	125	22,23	12.200	A27201250600050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 125	ZK 60	125	22,23	12.200	A27201250600065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	Z Power 40	178	22,23	8.500	A27201780400045F	① ② ③ ④	■
SLTT 178	Ceramic 40	178	22,23	8.500	A27201780400050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	ZK 40	178	22,23	8.500	A27201780400065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	Z Power 60	178	22,23	8.500	A27201780600045F	① ② ③ ④	■
SLTT 178	Ceramic 60	178	22,23	8.500	A27201780600050F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SLTT 178	ZK 60	178	22,23	8.500	A27201780600065F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

Please refer to page 228 for detailed information on the advantages of SLTT.



**High Performance**

**Lamellar Flap Discs, V2 Power**

Ordering example: A27441150401445F



**Packing unit:**

20 pcs. per type  
from Ø 178 = 10 pcs. per type

v<sub>max</sub>: 80 m/s

Z POWER = Abrasive cloth using Zirconia Alum.  
Oxide with special coating containing  
active grinding additives

Ceramic = Abrasive cloth ceramic grain

ZK = Abrasive cloth with Zirconia Alum. Oxide

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
V2 POWER 115	Z Power 40	115	22,23	13.300	A27441150401445F	① ② ③ ④	■
V2 POWER 115	Ceramic 40	115	22,23	13.300	A27441150401450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 115	ZK 40	115	22,23	13.300	A27441150401465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 115	Z Power 60	115	22,23	13.300	A27441150601445F	① ② ③ ④	■
V2 POWER 115	Ceramic 60	115	22,23	13.300	A27441150601450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 115	ZK 60	115	22,23	13.300	A27441150601465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	Z Power 40	125	22,23	12.200	A27441250401445F	① ② ③ ④	■
V2 POWER 125	Ceramic 40	125	22,23	12.200	A27441250401450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	ZK 40	125	22,23	12.200	A27441250401465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	Z Power 60	125	22,23	12.200	A27441250601445F	① ② ③ ④	■
V2 POWER 125	Ceramic 60	125	22,23	12.200	A27441250601450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 125	ZK 60	125	22,23	12.200	A27441250601465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	Z Power 40	178	22,23	8.500	A27441780401445F	① ② ③ ④	■
V2 POWER 178	Ceramic 40	178	22,23	8.500	A27441780401450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	ZK 40	178	22,23	8.500	A27441780401465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	Z Power 60	178	22,23	8.500	A27441780601445F	① ② ③ ④	■
V2 POWER 178	Ceramic 60	178	22,23	8.500	A27441780601450F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
V2 POWER 178	ZK 60	178	22,23	8.500	A27441780601465F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■

Please refer to page 232 for detailed information on the advantages of V2 Power.



**High Performance**

**Lamellar Flap Discs, V3 Control**

Ordering example: A27451150401411F



**Packing unit:**

8 pcs. per type  
from Ø 125 = 16 pcs. per type

v<sub>max</sub>: 80 m/s

ZK = Abrasive cloth with Zirconia Alum. Oxide

Description	Grits	D mm	H mm	n max (1/min)	Product-Number	recommended for	
V3 Control 115	ZK 40	115	22,23	13.300	A27451150401411F	① ② ③ ④ ⑤ ⑥ ⑦	■
V3 Control 115	ZK 60	115	22,23	13.300	A27451150601411F	① ② ③ ④ ⑤ ⑥ ⑦	■
V3 Control 125	ZK 40	125	22,23	12.200	A27451250401411F	① ② ③ ④ ⑤ ⑥ ⑦	■
V3 Control 125	ZK 60	125	22,23	12.200	A27451250601411F	① ② ③ ④ ⑤ ⑥ ⑦	■

Please refer to page 236 for detailed information on the advantages of V3 Control.



Lamellar Flap Discs, V4 Master

Ordering example: A27471250401465F



**Packing unit:**  
20 pcs. per type  
 $v_{max}$ : 80 m/s  
ZK = Abrasive cloth with Zirconia Alum. Oxide

Description	Grits	D mm	H mm	$n_{max}$ (1/min)	Product-Number	recommended for	
V4 MASTER 125	ZK 40	125	22,23	12.200	A27471250401465F	1 2 3 4 5 6 7	■
V4 MASTER 125	ZK 60	125	22,23	12.200	A27471250601465F	1 2 3 4 5 6 7	■

Please refer to page 238 for detailed information on the advantages of V4 Master.



Lamellar Flap Discs, SLTflex

Ordering example: A272711504018F



**Packing unit:**  
20 pcs. per type  
 $v_{max}$ : 80 m/s  
ZKS = Zirconia Alum. Oxide with special coating containing active grinding additives

Description	Grits	D mm	H mm	$n_{max}$ (1/min)	Product-Number	recommended for	
SLTflex 115	ZKS 40	115	22,23	13.300	A272711504018F	1 2 3 4 5 6 7	■
SLTflex 115	ZKS 60	115	22,23	13.300	A272711506018F	1 2 3 4 5 6 7	■
SLTflex 125	ZKS 40	125	22,23	12.200	A272712504018F	1 2 3 4 5 6 7	■
SLTflex 125	ZKS 60	125	22,23	12.200	A272712506018F	1 2 3 4 5 6 7	■

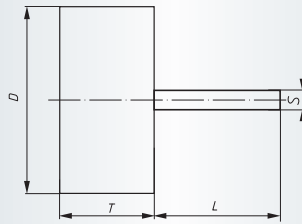
Please refer to page 240 for detailed information on the advantages of SLTflex.



**Industry**

**Mounted flap wheels of abrasive cloth**

Ordering example: A2200030103060F



**Packing unit:**  
10 pcs. per type  
NK = reg. Aluminium Oxide

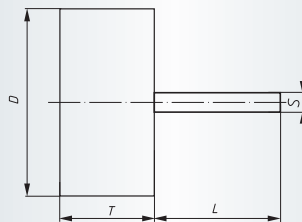
Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFL 03010.03	NK 60	30	10	3	40	16.000	18.000	A2200030103060F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 80	30	10	3	40	16.000	18.000	A2200030103080F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 03010.03	NK 120	30	10	3	40	16.000	18.000	A2200030103120F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 60	40	20	6	40	12.000	18.000	A2200040206060F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 80	40	20	6	40	12.000	18.000	A2200040206080F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 04020.06	NK 120	40	20	6	40	12.000	18.000	A2200040206120F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 40	60	30	6	40	8.000	12.000	A2200060306040F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 60	60	30	6	40	8.000	12.000	A2200060306060F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 80	60	30	6	40	8.000	12.000	A2200060306080F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFL 06030.06	NK 120	60	30	6	40	8.000	12.000	A2200060306120F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



**Industry**

**Mounted flap wheels of abrasive fleece**

Ordering example: A2203040206104F



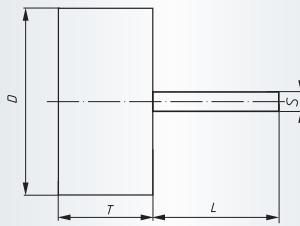
**Packing unit:**  
10 pcs. per type  
A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for	
SFV 04020.06	A 104	40	20	6	40	7.500	14.000	A2203040206104F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFV 04020.06	A 106	40	20	6	40	7.500	14.000	A2203040206106F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFV 06030.06	A 104	60	30	6	40	5.000	9.000	A2203060306104F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SFV 06030.06	A 106	60	30	6	40	5.000	9.000	A2203060306106F	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



### Flap wheels of abrasive fleece with abrasive cloth

Ordering example: A2204040206104F



**Packing unit:**

10 pcs. per type

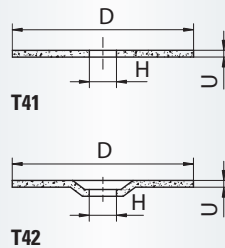
A = reg. Aluminium Oxide

Description	Grits	D mm	T mm	S mm	L mm	n recom. (1/min)	n max. (1/min)	Product-Number	recommended for
SFM 04020.06	A 104/80	40	20	6	40	7.500	14.000	A2204040206104F	1 2 3 4 5 6 7 8
SFM 04020.06	A 106/150	40	20	6	40	7.500	14.000	A2204040206106F	1 2 3 4 5 6 7 8
SFM 06030.06	A 104/80	60	30	6	40	5.000	9.000	A2204060306104F	1 2 3 4 5 6 7 8
SFM 06030.06	A 106/150	60	30	6	40	5.000	9.000	A2204060306106F	1 2 3 4 5 6 7 8



### Cutting discs BASE-X for stainless steel and metal

Ordering example: A3890101150122002



**Packing unit:**

see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

v<sub>max.</sub>: 80 m/s

Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for
<b>NEW</b> T41 BASE-X	A60T-BF INOX	115	1,0	22,23	13.300	A3890101150122002	1 2 3 4 5 6 7
<b>NEW</b> T41 BASE-X	A60T-BF	115	1,0	22,23	13.300	A3890101150122001	1 2 3 5
<b>NEW</b> T41 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322002	1 2 3 5
<b>NEW</b> T42 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322001	1 2 3 5
<b>NEW</b> T41 BASE-X	A60T-BF INOX	125	1,0	22,23	12.200	A3890101250122002	1 2 3 4 5 6 7
<b>NEW</b> T41 BASE-X	A60T-BF	125	1,0	22,23	12.200	A3890101250122001	1 2 3 5
<b>NEW</b> T41 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322002	1 2 3 5
<b>NEW</b> T42 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322001	1 2 3 5
<b>NEW</b> T41 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322002	1 2 3 5
<b>NEW</b> T42 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322001	1 2 3 5
<b>NEW</b> T41 BASE-X	A46T-BF INOX	230	1,8	22,23	6.600	A3890102300122002	1 2 3 4 5 6 7
<b>NEW</b> T41 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322002	1 2 3 5
<b>NEW</b> T42 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322001	1 2 3 5





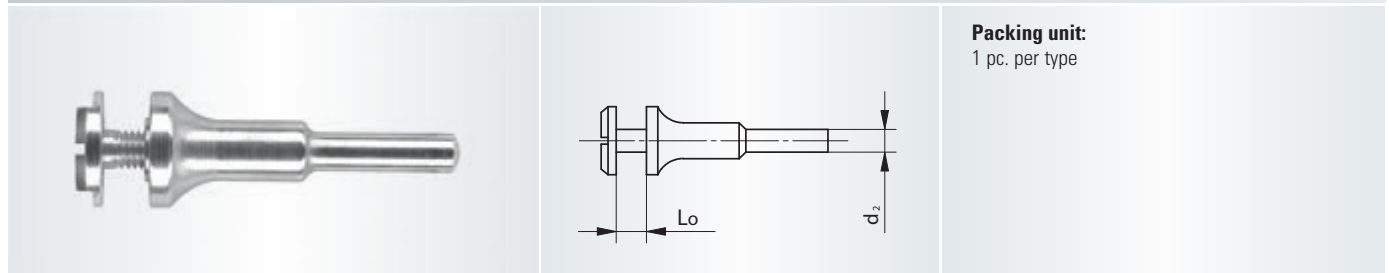




**Industry**

**Mounting arbors for small cutting-off wheels**

Ordering example: A36600060604



**Packing unit:**  
1 pc. per type

Description	Tools' internal diameter mm	L <sub>0</sub>	d <sub>2</sub> mm	Product-Number																		
ASB 6/6	6	0-4	6	A36600060604																	■	
ASB 6/10	10	0-4	6	A36600061004																		■
ASB 8/10	10	4-8	8	A36600081048																		■

**NEW**



**Industry**

**Mounting system for polishing wheels**

Ordering example: A6981008000



**Packing unit:**  
1 pc. per type

Description	Product-Number	recommended for																				
Mounting system MCA + K25	A6981008000																					■

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

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











### Tool-sets Tungsten Carbide Burrs, cut 7, shank 3 mm

Ordering example: A10390010



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut mm	Contents	1 piece each	Product-Number	recommended for	
F10 S3	3	Z7	10-pieces	HFA 0313, HFA 0613, HFC 0313, HFC 0613, HFD 0302, HFD 0605, HFG 0313, HFG 0613, HFM 0613, HFF 0313	A10390010	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input type="checkbox"/> 6 <input checked="" type="checkbox"/> 7 <input type="checkbox"/> 8 <input type="checkbox"/> 9 <input type="checkbox"/> 10	■



### Tool-sets Tungsten Carbide Burrs, cut 7, shank 6 mm

Ordering example: A1039001006



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut mm	Contents	1 piece each	Product-Number	recommended for	
F10 S6	6	Z7	10-pieces	HFAS 0616, HFAS 1225, HFC 0616, HFC 1225, HFD 0605, HFD 1210, HFG 0618, HFG 1225, HFF 0820, HFF 1225	A1039001006	<input checked="" type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 3 <input type="checkbox"/> 4 <input checked="" type="checkbox"/> 5 <input type="checkbox"/> 6 <input checked="" type="checkbox"/> 7 <input type="checkbox"/> 8 <input type="checkbox"/> 9 <input type="checkbox"/> 10	■





Base

**Tool-set, BASE-X, F5 S3**

Ordering example: A10390053



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut mm	Contents	1 piece each	Product-Number	recommended for	
F5 S3 BASE-X	3	ZX	5-pieces	HFA 0313, HFC 0313, HFD 0605, HFF 0313, HFG 0313	A10390053	<span style="border: 1px solid red; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">7</span>	<span style="background-color: black; color: black;">■</span>

**NEW**



Base

**Tool-set, BASE-X, F5 S6**

Ordering example: A10390056



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut mm	Contents	1 piece each	Product-Number	recommended for	
F5 S6 BASE-X	6	ZX	5-pieces	HFA 1225, HFC 1225, HFD 1210, HFF 1225, HFG 1225	A10390056	<span style="border: 1px solid red; border-radius: 50%; padding: 2px;">1</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">2</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">3</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">4</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">5</span> <span style="border: 1px solid red; border-radius: 50%; padding: 2px;">7</span>	<span style="background-color: black; color: black;">■</span>

**NEW**



## Tool-sets Burrs of HSS, cut 5, shank 3 mm

Ordering example: A1239000110



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for	
F1	3	Z5	10-pieces	MF 807, MF 813, MF 841, MF 845, MF 850, MF 853, MF 864, MF 866, MF 872, MF 874	A1239000110	① ② ⑥	■



## Tool-sets Burrs of HSS, cut 3, shank 6 mm

Ordering example: A123900003



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for	
F3	6	Z3	10-pieces	MFA 0616, MFA 1225, MFC 1225, MFD 0403, MFD 1210, MFE 1220, MFG 1230, MFH 1230, MFK 0620, MFM 0618	A123900003	① ② ⑥	■



Industry

**Tool-sets Burrs of HSS, cut 3 and cut 5, shank 6 mm**

Ordering example: A12390004



**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Cut	Contents	1 piece each	Product-Number	recommended for															
F4	6	Z3/Z5	20-pieces	Z3 MFA 0616, MFA 1013, MFA 1225, MFC 1225, MFD 0807, MFD 1210, MFE 1220, MFE 1625, MFG 1220, MFG 1230, MFK 1230, MFL 1630, MFM 0618, MFM 1230, MFN 1213, MFN 1230 Z5 MFA 0304, MFA 0607, MFN 0303, MFN 0606	A12390004	①	②							⑥							■



Industry

**Assortment, Polishing points, group P1**

Ordering example: A2600114



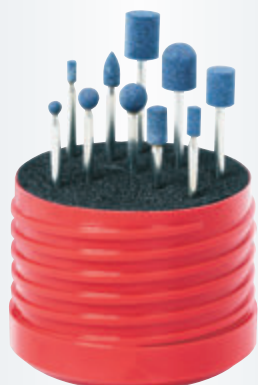
**Packing unit:**  
1 pc. per type  
v<sub>max.</sub>: 50 m/s

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



### Mounted points-Assortments, Quality NDW

Ordering example: A20100000353



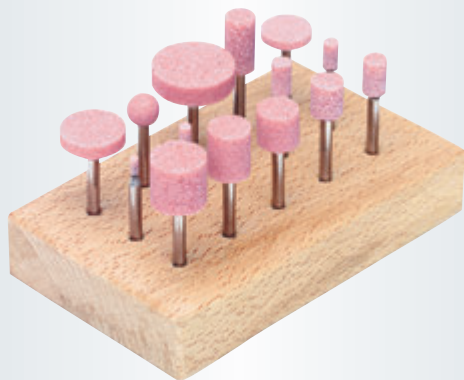
**Packing unit:**  
1 pc. per type

Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 10	3 x 50	NDW	10-pieces	ZY 0408, ZY 0610, ZY 0810, ZY 1013, SP 0510, SP 0810, KU 0404, KU 0606, KU 0808, WR 1013	A20100000353	② ③	■



### Mounted points-Assortments, Quality EKR

Ordering example: A204700001402



**Packing unit:**  
1 pc. per type

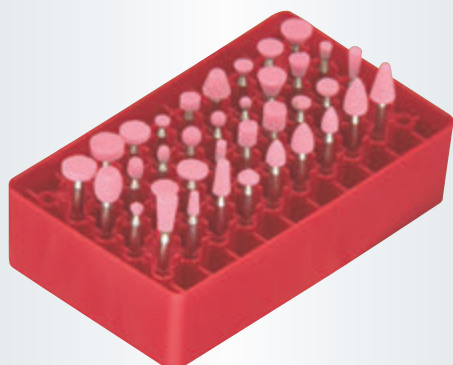
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 14	3	EKR	14-pieces	ZY 0205, ZY 0306, ZY 0408, ZY 0510, ZY 0610, ZY 0810, ZY 0816, ZY 1010, ZY 1013, ZY 1313, KU 0808, ZY 1303, ZY 1604, ZY 2006	A204700001402	① ② ③	■



Industry

**Mounted points-Assortments, Quality EKR**

Ordering example: A204800003602



**Packing unit:**  
1 pc. per type

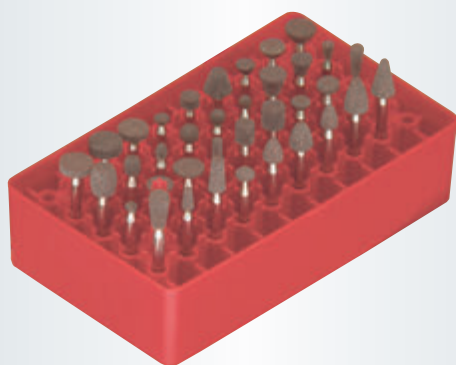
Description	Shank Ø mm	Quality	Contents	1 piece each	Product-Number	recommended for	
Assortment 36	3	EKR	36-pieces	D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11, D12, D13, D14, D15, D16, D17, D18, D19, D20, D21, D22, D23, D24, D25, D26, D27, D28, D29, D30, D31, D32, D33, D34, D35, D36	A204800003602	①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



Industry

**Mounted points-Assortments, Quality EKBR**

Ordering example: A204800003611



**Packing unit:**  
1 pc. per type

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





Mounted caps-Assortments

Ordering example: A210000065



**Packing unit:**

1 pc. per type

**Assortment containing:**

640 pcs. Abrasive Caps

23 pcs. Mandrels

Outside dimension of box: 272 x 189 x 46 mm


NK = regular Aluminium Oxide

Description	piece	Contents	Product-Number	recommended for	
WS 65	50 pcs. 100 pcs. of 50 pcs. of 20 pcs. of 10 pcs.	<b>Abrasive Caps, grit NK 150</b> SKKE 0515 SKZY 0510, SKWR 0511, SKWK 0511 SKZY 0712, SKWR 0713, SKWK 0713 SKZY 1015, SKWR 1015 SKKE 1125	A210000065	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
	20 pcs. 10 pcs. of 15 pcs. of	<b>Abrasive Caps, grit NK 80</b> SKWK 1015 SKZY 1317, SKWR 1319, SKWK 1319, SKKE 1632 SKWK 1626, SKWR 1626			
	2 pcs. of 1 pc. of	<b>Mandrels, Shank 3 mm</b> GTZY 0510, GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713 GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319			
	1 pc. of	<b>Mandrels, Shank 6 mm</b> GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632			
WS 65 Z	2 pcs. of 1 pc. of 1 pc. of	<b>Abrasive Caps, see WS 65</b>  <b>Mandrels, Shank 1/8 inch</b> GTZY 0510, GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713 GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319  <b>Mandrels, Shank 1/4 inch</b> GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632	A210000065Z	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



**Safety glasses, UVEX i-vo**

Ordering example: A364110

		<p><b>Packing unit:</b> 1 pc. per type</p>
---	--	--


Description	Product-Number		
UVEX i-vo	A364110		■

This UVEX-safety glasses provide you an optimum protection and because of the unique two-component technology they are very comfortably to wear.



**Safety gloves, UVEX TOP GRADE**

Ordering example: A364310

		<p><b>Packing unit:</b> 10 pcs. per type</p>
---	--	--

Description	Size	Product-Number		
UVEX TOP GRADE	10	A364310		■

Split-leather safety glove with high wearing comfort

**Characteristics:**

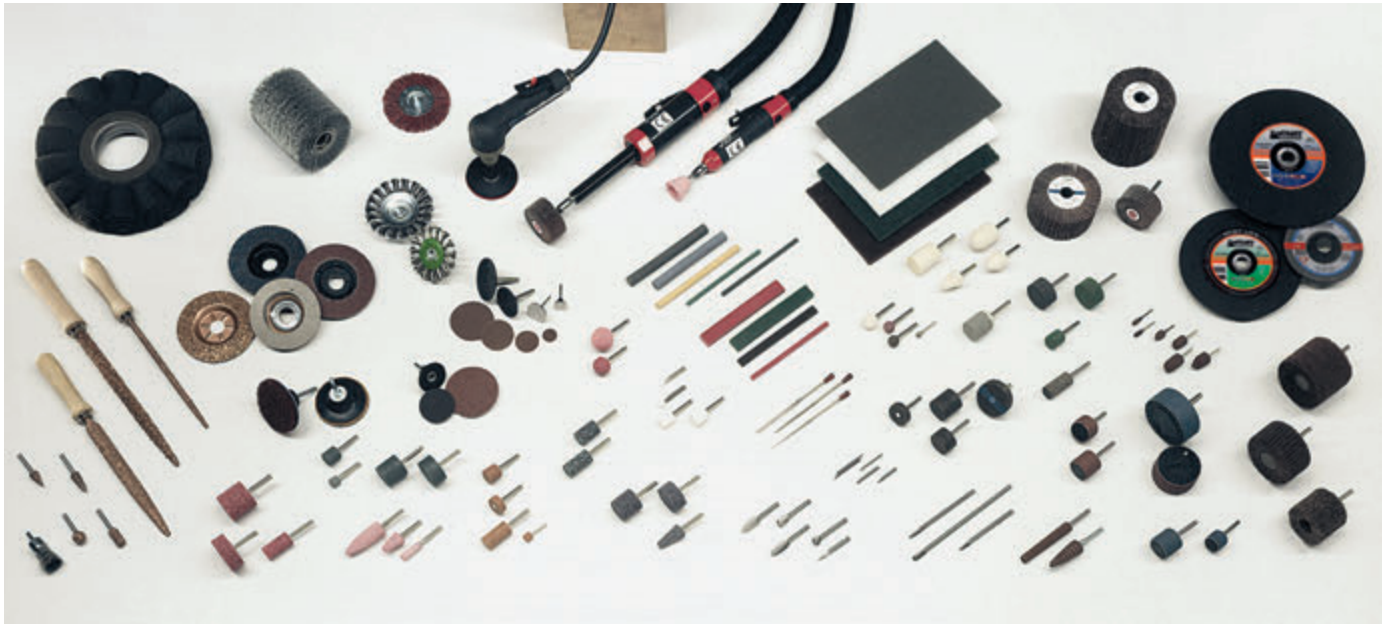
- Cut resistance, soft, supple leather
- Index finger, fingertips, knuckle trim and thumb







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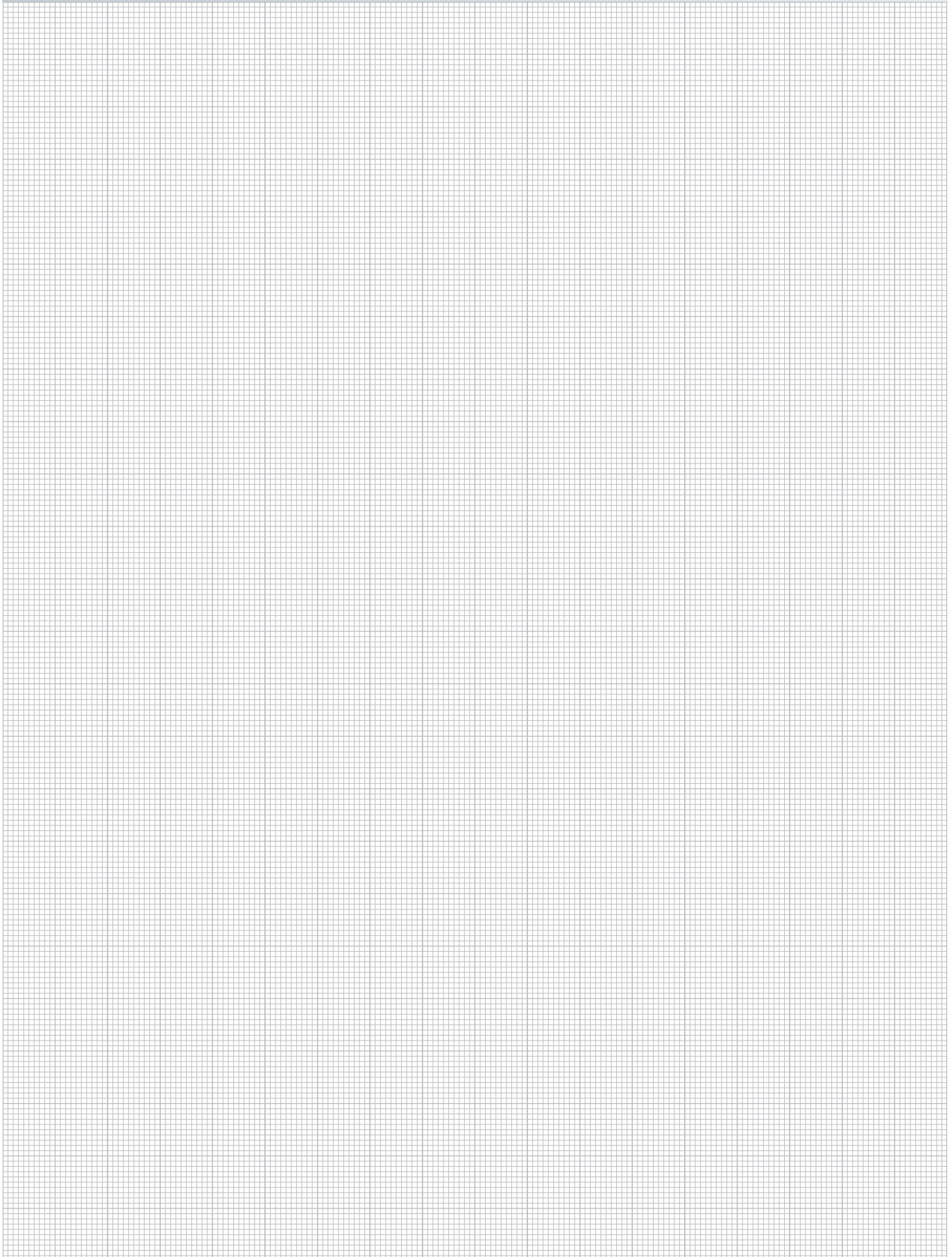
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Notes

A large, empty grid area for taking notes, consisting of a fine grid of small squares. The grid is bounded by a light gray header bar at the top and a light gray footer bar at the bottom.



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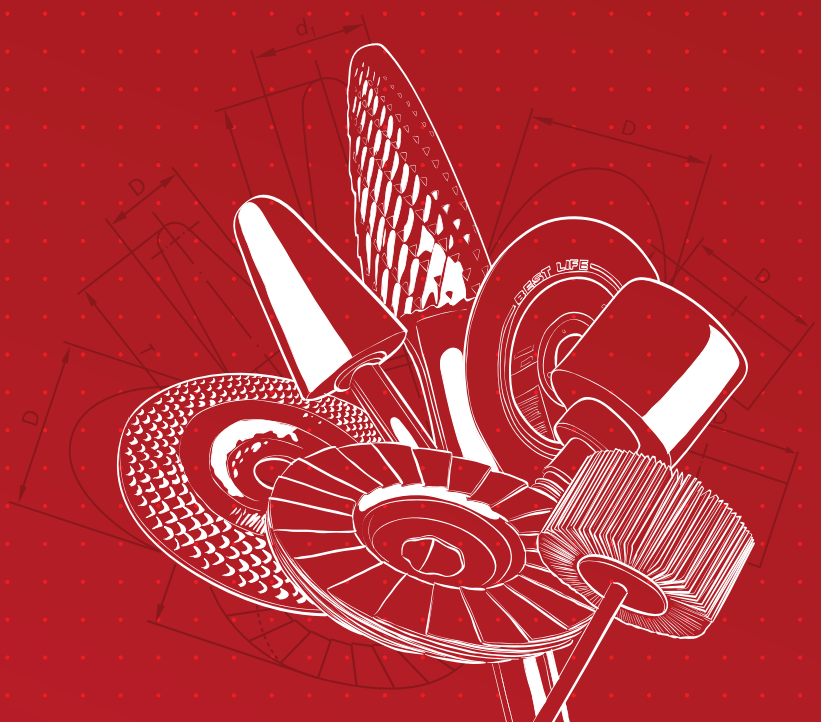
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#### **Conditions**

List prices quoted are ex-works Engelskirchen excluding packing and value added tax. Surcharges and discounts will be individually applied to the list price. This price list is for the sole use of the recipient, and duplication in part or whole for a third party is not permitted. In all other aspects, our general terms and conditions apply as detailed on the last page.

#### **Minimum order value**

130,- € net  
For orders below 130,- € net we have to invoice 15,- € handling charge.

#### **Terms of payment**

14 days less 2 % cash-discount or 30 days net.

#### **Minimum order quantity**

Packing unit

#### **Special production**

Minimum quantity/-order quantity on request. For production reasons, excess and short deliveries of up to 15 % of the ordered quantity shall be admissible for products which are not available ex stock. The quantity dispatched will be invoiced.

#### **Call-off order**

Call-off orders can cover a maximum period of 12 months from the date of acknowledgement. We have the right to manufacture the complete order, and any quantity not taken by the end of the contract period will be despatched and invoiced in full.

#### **Returns and exchanges**

Any returns or exchanges, for whatever reason, must be received by us carriage paid within 4 weeks after receipt, stating batch number under which the goods were supplied. In such events, a handling charge of 25,- € will apply.

#### **Technical alterations**

We reserve the right to make any technical alterations to our products resulting from our continuous research and development programme.

Please note the contents of this and the last page to avoid any dispute.

Misprints reserved.

# Material classification

## 1 STEELS AND CAST STEELS Rm up to 800 N/mm<sup>2</sup>

- common structural steels
- free cutting steels
- case hardened steels
- fine grained structural steels
- extruded steels
- toughened structural steels
- boiler plate
- nitrided steels
- cast steels
- heat treated steels
- heat resistant structural steels

## 2 ALLOYED, TEMPERED STEELS Rm 800 up to 1200 N/mm<sup>2</sup>

- case hardened steels
- spring steels
- fine grained structural steels
- nitrided steels
- heat treated steels
- wear resistant steels
- bearing steels

## 3 TOOL STEELS Rm up to 1300 N/mm<sup>2</sup>

- 60 - 65 HRC
- high-speed steels
- non-alloyed tool steels
- cold working tool steels
- hot working tool steels

## 4 RUST, ACID AND HEAT RESISTANT STEELS AND CAST STEELS

- austenitic
- ferritic
- ferritic-austenitic
- heat-resistant
- martensitic
- stainless, sulphurized

## 5 CAST IRON

## 6 ALUMINIUM, MAGNESIUM AND COPPER ALLOYS

- over 300 HB
- 200-300 HB
- up to 200 HB
- over 15% Si
- 10-15% Si
- 0,5-10% Si
- below 0,5% Si

## 7 TITANIUM AND NICKEL ALLOYS

- Rm 900 up to 1500 N/mm<sup>2</sup>
- Rm up to 900 N/mm<sup>2</sup>

## 8 PLASTICS, WOOD, RUBBER

## 9 GLASS / CARBIDES

## 10 STONE / TILES / GAS CEMENT

## 11 CONCRETE / REINFORCED CONCRETE

## 12 CERAMIC / FLOOR TILES

## 13 MARBLE

## 14 GRANITE

## 15 FRESHLY POURED CONCRETE

## 16 ASPHALT

- best suitable
- suitable
- delivery ex-stock
- ▲ delivery on request
- Ⓢ regrind service, please enquire

# Safety Symbols

(Depending on the product these symbols may vary)



Wear eye protection



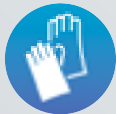
Wear hearing protection



Wear a respirator



Read the instructions



Wear gloves



Only permitted with a back-up pad



Not permitted for wet grinding



Not permitted for face grinding



Do not use if damaged



Do not use for freehand cutting