

EFFECTIVE 2013



**CARBORUNDUM**



# ***Abrasives***

**FOR THE INDUSTRIAL MARKET**

**COATED ABRASIVE PRODUCTS**

**NON-WOVEN ABRASIVE PRODUCTS**

**BONDED ABRASIVE PRODUCTS**













**NON-ABRASIVE PRODUCTS**

**Better Abrasives  
Better Value**

[www.carborundumindustrial.com](http://www.carborundumindustrial.com)

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Carborundum uses BEST/BETTER/GOOD product performance tying, color-coded for easy product selection.

**BEST Products - Red**

**BETTER Products - Gold**

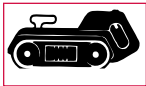
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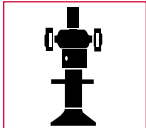
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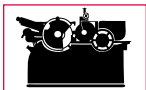
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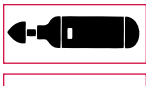
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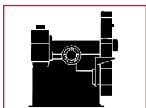
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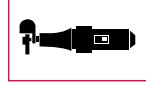
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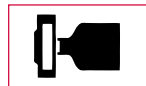
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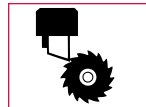
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# FastTrack Belt General Information



Carborundum FastTrack Belt Service offers you all of the advantages of an ISO 9001 quality manufacturer and the advantages of a coated abrasive belt express service.

Manufacturing lead-time is two days for narrow belts (1/2" – 12" wide) and three days for wide belts (14 – 52" wide). Please see the FastTrack chart below for complete details on availability and lead-times.



## Product Availability

### Paper Product:

- Aluminum Oxide

### Cloth Products:

- Ceramic Alumina
- Zirconia Alumina
- Aluminum Oxide
- Silicon Carbide

## Manufacturing Leeway

- +/-10%

## Size Availability

- Maximum width: 52"
- 1/2" and greater widths, for 25" and greater lengths

## Ordering is Easy!

- Check the FastTrack product availability on the next page
- Include a full description of belt required, including: quantity, size, Carborundum CAP code, and grit size
- Check splice and flex availability (see pages 5 and 6). FastTrack belt service is limited to standard joint and flex
- Verify that the quantity is within FastTrack limits
- Send order electronically, fax, or phone to customer service
- When ordering a belt that does not have an existing part number, please call Customer Service to expedite part number creation

## FastTrack Ordering Quantities and Lead-Times

WIDTH	GRIT SIZE	MINIMUM ORDER QUANTITY	CASE QUANTITY	MAXIMUM ORDER QUANTITY (EQUALS 2 CASES)	CONVERSION LEAD-TIME DAYS
<b>Narrow Belts</b>					
1/2" through 1"	All	50	200	400	2
Over 1" through 5"	All	10	50	100	2
Over 5" through 9"	All	10	20	40	2
Over 9" through 14"	All	10	10	20	2
<b>Wide Belts</b>					
Over 14" through 20"	All	5	10	20	3
Over 20" through 52"	All	5	5	10	3



## FastTrack Metalworking Belts

TIER	PRODUCT CAP CODE	SHAPE AVAILABILITY	GRIT SIZE	ABRASIVE GRAIN	BACKING	STANDARD JOINT	STANDARD FLEX	APPLICATIONS
<b>Metalworking</b>								
<b>Carborundum</b>								
Best	YP 2586 W	Narrow, Wide	36-120	Medalist Ceramic Alumina	Y-wt. Polyester	BJ	RR	Ceramic grain engineered for high-performance grinding and finishing of exotic alloys
Best	YP 2587 R	Narrow, Wide	36-80	Medalist Ceramic Alumina	Y-wt. Polyester	BJ	RR	Ceramic grain with special grinding aid, designed for grinding hard-to-grind alloys and heat-sensitive jobs
Better	YP 1186 W	Narrow, Wide	24-80	Zirconia Alumina	Y-wt. Polyester	BJ	RR	Zirconia grain designed for medium- to high-pressure grinding of welds and finishing ferrous and non-ferrous materials
Better	YP 1288 R	Narrow, Wide	24-120	Zirconia Alumina	Y-wt. Polyester	BJ	RR	Zirconia alumina grain, with grinding aid, for grinding heat-sensitive alloys: Inconel, titanium and stagness steel.
Better	XP 1176 W	Narrow, Wide	60-220	Zirconia Alumina	X-wt. Polyester	BJ	RR	Zirconia grain for weld removal and finishing ferrous and non-ferrous materials
Good	YP 0986 W	Narrow, Wide	24, 36-120	Aluminum Oxide	Y-wt. Polyester	BJ	RR	Heat-treated aluminum oxide grain and strong polyester backing for ferrous and non ferrous materials
Good	XP 0966 W	Narrow, Wide	P60-P240, P320, P400	Aluminum Oxide	X-wt. Polyester	BJ	RR	P-graded, heat-treated aluminum oxide grain and strong polyester backing for ferrous and non ferrous materials
Good	XC 0877	Narrow, Wide	36-240, 320	Aluminum Oxide	X-wt. Cotton	BJ	CF	Durable aluminum oxide grain for general purpose sanding of ferrous and non-ferrous materials
Good	JCF 0852	Narrow	P80-P320, P400, P600	Aluminum Oxide	J-wt. Cotton	BJ	TF	Aluminum oxide on flexible, lightweight cotton backing for general purpose sanding of ferrous and non-ferrous materials
Good	XP 0476 W	Narrow	80-120	Silicon Carbide	X-wt. Polyester	BJ	RR	Sharp, silicon carbide grain on medium polyester backing for grinding very hard materials – glass, stone, solid surface
Good	XC 0476	Narrow, Wide	24, 36-120, 180, 220, 320	Silicon Carbide	X-wt. Cotton	BJ	RR	Sharp, silicon carbide grain on X-wt. cotton backing for general purpose sanding of non-ferrous materials
<b>Merit</b>								
Best	SY965	Narrow, Wide	36-120	Ceramic Alumina	Y-wt. Polyester	BJ	RR	Ceramic alumina grain with grinding aid for medium-pressure grinding and finishing heat-sensitive alloys
Better	SY603	Narrow, Wide	36-120	Zirconia Alumina	Y-wt. Polyester	BJ	RR	Zirconia alumina abrasive with a Y-wt. polyester backing and a grinding aid for weld removal and finishing of hard-to-grind materials
Better	SY695	Narrow, Wide	24-80	Zirconia Alumina	Y-wt. Polyester	BJ	RR	Zirconia alumina grain designed for medium- to high-pressure grinding
Better	SX695	Narrow, Wide	60-220	Zirconia Alumina	X-wt. Polyester	BJ	RR	Zirconia alumina grain on lighter backing designed for light to medium grinding
Good	SY395	Narrow, Wide	24-120	Ceramic-coated Aluminum Oxide	Y-wt. Polyester	BJ	RR	Ceramic-coated aluminum oxide grain provides higher performance than standard aluminum oxide
Good	SX395	Narrow, Wide	P60-P240, P320, P400	Aluminum Oxide	X-wt. Polyester	BJ	RR	Higher-performance P-graded aluminum oxide grain and strong polyester backing for mild steel
Good	MX240	Narrow, Wide	P60-P150	Aluminum Oxide	X-wt. Poly/Cotton	BJ	CF, RR	P-graded heat-treated aluminum oxide X-wt. cloth with strong, but flexible, cotton/polyester backing making it an ideal multi-purpose product
Good	KX375	Narrow, Wide	36-240, 320	Aluminum Oxide	X-wt. Cotton	BJ	RR	Initial starting specification for all metalworking applications
Good	KF376	Narrow	P80-P320, P400, P600	Aluminum Oxide	J-wt. Cotton	BJ	TF	P-graded, heat-treated aluminum oxide with ceramic coating on a very flexible backing for use wherever flexibility and conformability are needed

COATED ABRASIVES

## FastTrack Woodworking Belts

TIER	PRODUCT CAP CODE	SHAPE AVAILABILITY	GRIT SIZE	ABRASIVE GRAIN	BACKING	STANDARD JOINT	STANDARD FLEX	APPLICATIONS
<b>Woodworking</b>								
<b>Carborundum</b>								
Best	YC 1186 O	Narrow, Wide	36, 50, 80, 100, 120	Premier Red Zirconia Alumina	Y-wt. Cotton	BJ	RR	Zirconia alumina open-coat product recommended for dry low-pressure applications or where loading is a problem
Good	YC 0986 AO	Narrow, Wide	P60-P180	Aluminum Oxide	Y-wt. Cotton	BJ	RR	Anti-static, open coat specification for all woodworking applications where loading is a problem
Good	XC 0776 O	Narrow, Wide	60-220	Aluminum Oxide	X-wt. Cotton	BJ	RR	Initial starting specification for all woodworking applications where loading is a problem
Good	F 0915	Narrow, Wide	P80-P220	Aluminum Oxide	F-wt. Paper	CJ	RR	Tough P-graded aluminum oxide grain for metalworking and woodworking
Good	F 0714 AO	Narrow, Wide	P80-P220	Aluminum Oxide	F-wt. Paper	CJ	RR	Anti-static, open coat wood sanding product where loading is a problem

See page 89 for the Specification Terminology Key

# FastTrack Belt General Information

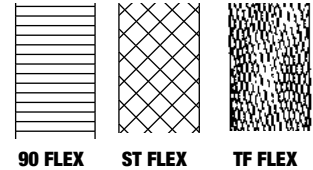
## Flexing

Flexing (controlled cracking or breaking down of the abrasive bond) is performed for:

- shape control of the product
- flexibility to conform to the workpiece contour
- control of grain breakdown and/or pullout to improve performance
- material handling during the manufacturing operation

The best abrasive life on most products can be obtained by using the least amount of flex that will do the job satisfactorily. Generally, the least amount of flex will produce a more aggressive cut and longer abrasive life. There are three basic flexes: 90 Flex, ST Flex, and TF Flex.

**90 Flex:** Creates flex lines or cracks that are perpendicular to the edge of the belt or material. Provides flexibility only in the lengthwise direction.



**ST Flex:** Flex lines are at a 45° angle to the edge of the belt or material, in both directions, making a series of Xs. Provides moderate flexibility in all directions.

**TF Flex:** Three mechanical flexes are used to crack or break down the bond to provide flexibility in any direction as well as shape control.

## Belt Splices

There are two basic splice types:

### LAP SPLICES

A lap splice is simply overlapping one end of the belt over the other. There are two types of lap splices.

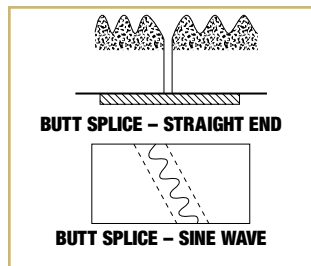
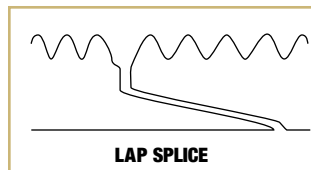
**Skived:** some or all of the abrasive is removed from the top of the splice, depending on grit size and application.

**Unskived:** no abrasive removed from the top of the splice.

### BUTT SPLICES

A butt splice, as the name implies, is created where both ends of an abrasive belt butt against each other and are then joined with a reinforced synthetic tape at the seam. There are two basic butt splices.

**Butt splice – straight end**  
**Butt splice – sine**: sine wave ends



## Belt Splice Definitions

**CB / BT (Conventional Butt)** – a straight splice joined with an extra strong, thin patch to eliminate breakage and marks on the workpiece.

**CJ (Channel)** – the thinnest, smoothest-running butt splice – available on selected F-weight wide paper belts only. The patch material is inlaid into the paper backing... making the thinnest possible butt splice design.

**CN** – elongated sine wave butt splice with a clear patch – available on selected F-weight wide paper belts only.

**CP** – straight butt splice with a clear, thin patch – available on selected F-weight wide paper belts only.

**DS (Drawer Sanding)** – a butt splice with a 45° splice angle and a strong patch – used on wooden drawer front and rear dove tail and corner joint applications.

**EJ / FT (Edge Sanding)** – This is a bump-free lap joint.

**NC (Channel sine wave)** – the thinnest, smoothest-running butt splice – available on selected F-weight wide paper belts only. The patch material is inlaid into the paper backing... making the thinnest possible butt splice design.

**NS / LP** – a lap splice that can only be run in one direction.

**NY** – sine wave butt splice joined with a thin-style patch.

**PY** – straight butt splice with a thin-style patch.

**RG (Roll Grinding)** – special butt splice for platen and roll grinding.

**SW / WA (Sine Wave)** – the two ends of butted, abrasive material are cut in an interlocking configuration, joined with a thin patch material – offering resistance to hinging and splice fatigue. The splice closely conforms to contact wheel, workpiece shape and other difficult applications.



## Stock and FastTrack Belt Competitive Cross Reference

CARBORUNDUM		3M	HERMES	KLINGSPOR	SIA	VSM
<b>METAL</b>						
YP 2586 W	CERAMIC Y WT POLYESTER; WATERPROOF	761D, 761F, 951E, 951F, 963G	CB440Y	CS612	-	SK750Y
YP 2587 R	CERAMIC Y WT POLYESTER WITH GRINDING AID; WATERPROOF	977F, 777F	-	CS6110	-	SK840X
XP 1176 W	ZIRCONIA X WT POLYESTER; WATERPROOF	561F, 551E, 741A, 741E, 761D	RB480	CS411X	-	KK715X
YP 1186 W	ZIRCONIA Y WT POLYESTER; WATERPROOF	561D, 561F, 563F, 741A, 741E, 761D, 761F	RB484TY	CS411Y	2803	KK716Y
YP 1288 R	ZIRCONIA Y WT POLYESTER WITH GRINDING AID	577F	RB486X	CS409Y	-	KK815Y
JCF 0852	A/O J WT FLEXIBLE COTTON	211K, 211T, 218K, 311T	RB232 J-FLEX	KL361, KL381	2947	KK505J
KF376	A/O J WT FLEXIBLE COTTON	-	RB406J	LS312J	-	KK532J
XC 0877	A/O X WT COTTON	241D, 251D, 261D, 248D	RB346MX	CS310X	2920, C905X, 2912	KK511X
MX240	A/O X WT POLY/COTTON, SEMI-OPEN	-	RB376TX	CS412X	-	KK711X
XP 0966 W	A/O X WT POLYESTER; WATERPROOF	353F	RB376TX	CS412X	C984 XP	KK711X
YP 0986 W	A/O Y WT POLYESTER; WATERPROOF	363F, 261F, 361F	RB376TY	CS412Y	2803	KK711Y
<b>NON-FERROUS</b>						
XC 0476	S/C X WT COTTON	441D, 451D, 451E, 464D	RB318X	CS333X	2780, C780X	CK721X
XP 0476 W	S/C Y WT POLYESTER; WATERPROOF	453 W, 451F, 461F, 451E, 460D, 463D	RB375Y	CS320	2786, C786, RB YP, C784WPX, C770XP	CK721X
<b>WOOD</b>						
YC 1186 O	ZIRCONIA Y WT COTTON, OPEN	-	-	-	2883	-
XC 0776 O	A/O X WT COTTON, OPEN	270D, 270DZ, 272DZ, 260D, 362RZ	RB316 XOP, RB316-34XOP	CS311X	2928, 2920, C903D	KK504X, KK524X
YC 0986 AO	A/O Y WT COTTON, OPEN, ANTISTAT	270D, 270DZ, 272DZ, 240A, 240D, 240DZ, 260D, 340I, 362RZ	RB316 XOP, RB316-34XOP, RB317LX	CS311X, CS413	2820	KK524X & Y
F 0915	A/O F WT PAPER, CLOSE	241, 242, 263U, 360I, 361I, 362I, 363I	BW115	PS20	1920F, 1919FO, 1904E	KP709, KP508E
F 0714 AO	A/O F WT PAPER, OPEN, ANTISTAT	260UZ, 261UZ, 255UZ, 265UZ, 360I, 461UZ	BW112, BW114	PS26	1919FO, P990, 1939	KP520F



## Medalist Ceramic Alumina Resin Cloth with Grinding Aid

### Features

- Patented ceramic alumina abrasive
- Durable Y-weight polyester waterproof cloth backing
- Grinding aid coating

### Benefits

- Exceptional life and value
- Aggressive cut rate
- Sharpness maintained throughout life of the belt
- Maximum grain adhesion, reduced edge-fray and strong body retention result in longer life and product consistency
- Cooler cut, burn-free grinding of heat-sensitive materials
- Minimizes loading

*The choice for hard-to-grind alloys and heat-sensitive applications.*



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>1/2" x 12"</b>				
66261184259	40	YP 2587 R	50	50
66261184261	80	YP 2587 R	50	50
<b>1/2" x 18"</b>				
66261184262	40	YP 2587 R	50	50
66261184263	60	YP 2587 R	50	50
66261184264	80	YP 2587 R	50	50
<b>1/2" x 24"</b>				
66261184265	40	YP 2587 R	50	50
66261184266	60	YP 2587 R	50	50
66261184267	80	YP 2587 R	50	50

PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3/4" x 18"</b>				
66261184268	40	YP 2587 R	50	50
66261184269	60	YP 2587 R	50	50
66261184270	80	YP 2587 R	50	50
<b>3/4" x 20-1/2"</b>				
66261184271	40	YP 2587 R	50	50
66261184272	60	YP 2587 R	50	50
66261184273	80	YP 2587 R	50	50

## Aluminum Oxide Resin Cloth

### Features

- Tough, P-graded, heat-treated aluminum oxide abrasive
- Full resin bond system
- Flexible, X-weight polyester/cotton backing
- Butt tape joint

### Benefits

- Aggressive yet cool cutting
- Excellent edge adhesion
- Tear and fray resistance
- Reversible, durable

*Designed for all metalworking, finishing and contour and shape sanding applications requiring flexibility and fray resistance.*




PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>1/4" x 24"</b>				
05539562863	P60	XB 0967	50	50
<b>3/8" x 13"</b>				
05539562866	P60	XB 0967	50	50
05539562867	P80	XB 0967	50	50
<b>1/2" x 12"</b>				
05539562869	P60	XB 0967	50	50
05539562870	P80	XB 0967	50	50
05539562872	P120	XB 0967	50	50
<b>1/2" x 18"</b>				
05539562873	P60	XB 0967	50	50
05539562874	P80	XB 0967	50	50
<b>1/2" x 24"</b>				
05539562877	P40	XB 0967	50	50
05539562879	P60	XB 0967	50	50
05539562880	P80	XB 0967	50	50
05539562881	P100	XB 0967	50	50
05539562882	P120	XB 0967	50	50

PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3/4" x 18"</b>				
05539562883	P40	XB 0967	50	50
05539562885	P60	XB 0967	50	50
05539562886	P80	XB 0967	50	50
05539562887	P120	XB 0967	50	50
<b>3/4" x 20-1/2"</b>				
05539562888	P40	XB 0967	50	50
05539562890	P60	XB 0967	50	50
05539562891	P80	XB 0967	50	50
05539562893	P120	XB 0967	50	50
<b>1" x 30"</b>				
05539562894	P60	XB 0967	50	50
05539562895	P80	XB 0967	50	50
05539562896	P120	XB 0967	50	50



### TechTip

A light-bodied grease applied to the belt surface will greatly enhance the belt life when grinding non-ferrous materials such as aluminum, brass, bronze and copper.

 It is the user's responsibility to refer to and comply with ANSI B7.7



## Premier Red Zirconia Alumina Resin Cloth Open

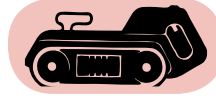
### Features

- Zirconia alumina abrasive
- Y-weight cotton backing
- Open coat
- Butt tape joint
- Packaged in convenient, durable contractor packs

### Benefits

- Aggressive, rapid cut rate
- Extended life
- Reduced loading
- Reversible, excellent durability
- Job specific labeling; easy product identification
- Ideal for walk-in trade, showroom displays

Excellent for finishing wood and non-metallic materials.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3" x 21"</b>				
05539563668	36	YC 1186 O	5	25
05539563667	50	YC 1186 O	5	25
05539563666	80	YC 1186 O	5	25
05539563665	120	YC 1186 O	5	25
<b>3" x 24"</b>				
05539563671	50	YC 1186 O	5	25
05539563670	80	YC 1186 O	5	25
05539563669	120	YC 1186 O	5	25



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>4" x 24"</b>				
05539563676	36	YC 1186 O	5	25
05539563675	50	YC 1186 O	5	25
05539563674	80	YC 1186 O	5	25
05539563673	120	YC 1186 O	5	25

## Aluminum Oxide Resin Cloth

### Features

- Aluminum oxide abrasive
- Full resin bond system
- X-weight cotton backing
- Butt tape joint

### Benefits

- Tough and durable with aggressive cutting action
- Increased strength
- Cool operating on platen sanders
- Reversible, excellent durability

Ideal for sanding metal and all species of wood.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3" x 21"</b>				
05539510759	40	XC 0877	10	50
05539510758	50	XC 0877	10	50
05539510757	60	XC 0877	10	50
05539510754	80	XC 0877	10	50
05539510753	100	XC 0877	10	50
05539510752	120	XC 0877	10	50
05539510751	150	XC 0877	10	50

PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3" x 24"</b>				
05539510772	40	XC 0877	10	50
05539510769	50	XC 0877	10	50
05539510771	60	XC 0877	10	50
05539510764	80	XC 0877	10	50
05539510767	100	XC 0877	10	50
05539510766	120	XC 0877	10	50
05539510763	150	XC 0877	10	50
<b>4" x 24"</b>				
05539510781	40	XC 0877	10	50
05539510779	50	XC 0877	10	50
05539510778	60	XC 0877	10	50
05539510775	80	XC 0877	10	50
05539510777	100	XC 0877	10	50
05539510774	120	XC 0877	10	50
05539510773	150	XC 0877	10	50



## Spec Check

### STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	HEAVY-DUTY	GENERAL-DUTY
ALUMINUM	YP 1186 W	XC 0877
CAST IRON	YP 1186 W	
BRASS/BRONZE	YP 1186 W	
DIE CASTINGS	XC 0877	
CARBON STEEL	YP 1186 W	XC 0877
GLASS, CERAMIC	YC 1186 O	
STAINLESS STEEL & ALLOYS	YP 2587 R, YP 1186 W	XC 0877
WOOD	YC 1186 O	XC 0776 O, XC 0877

### RECOMMENDED GRIT SELECTION

ROUGH/HEAVY-DUTY	INTERMEDIATE	FINISHING/POLISHING
36-50	60-100	120-180

# Narrow Belts

## Premier Red Zirconia Alumina Resin Cloth Open

### Features

- Zirconia alumina abrasive
- Y-weight cotton backing
- Open coat
- Butt tape joint

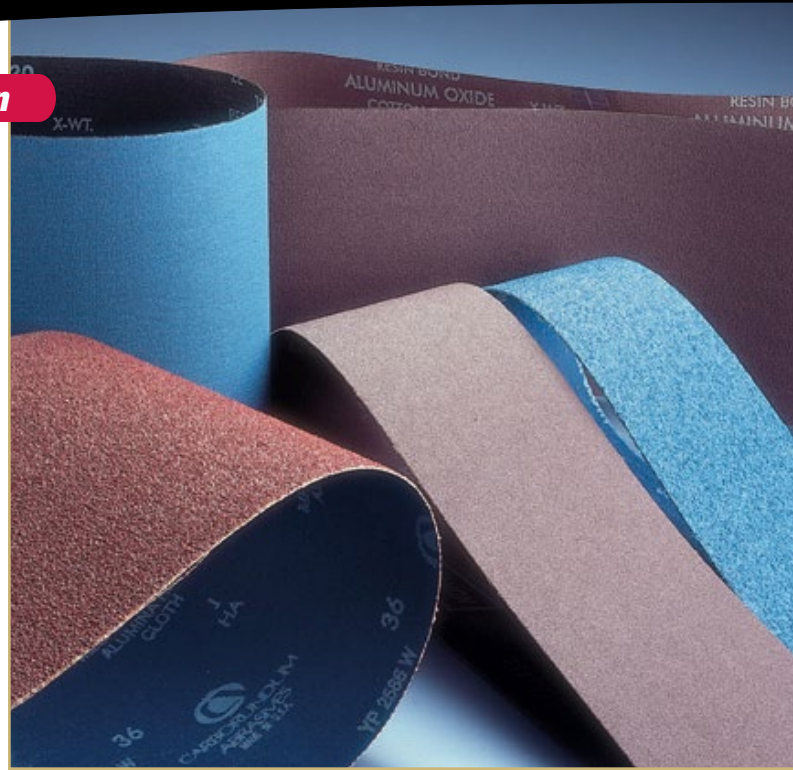
### Benefits

- Aggressive, rapid cut rate
- Extended life
- Reduced loading
- Ideal for dry grinding applications
- Reversible, excellent durability

Excellent for finishing wood and non-metallic materials.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>2" x 48"</b>				
05539563659	50	YC 1186 O	10	10
05539563658	80	YC 1186 O	10	10
<b>6" x 48"</b>				
05539563664	36	YC 1186 O	10	10
05539563663	50	YC 1186 O	10	10
05539563662	80	YC 1186 O	10	10



## Aluminum Oxide Resin Cloth

### Features

- Aluminum oxide abrasive
- Full resin bond system
- X-weight cotton backing
- Butt tape joint

### Benefits

- Versatile
- Tough and durable with aggressive cutting action
- Increased strength
- Cool operating on platen sanders
- Reversible, durable

Ideal for operations requiring a belt specification that does not generate heat, but is capable of sanding a variety of materials. Closed coat for fast metal removal.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>1" x 42"</b>				
05539510109	40	XC 0877	10	10
05539510112	60	XC 0877	10	10
05539510113	80	XC 0877	10	10
05539510114	100	XC 0877	10	10
05539510118	120	XC 0877	10	10
<b>2" x 48"</b>				
05539510124	50	XC 0877	10	10
05539510127	60	XC 0877	10	10
05539510128	80	XC 0877	10	10
05539510132	100	XC 0877	10	10
05539510133	120	XC 0877	10	10
<b>6" x 48"</b>				
05539510153	36	XC 0877	10	10
05539510154	50	XC 0877	10	10
05539510158	60	XC 0877	10	10
05539510159	80	XC 0877	10	10
05539510160	100	XC 0877	10	10
05539510161	120	XC 0877	10	10

See FastTrack Belt Program on pages 4 - 7 for additional specifications and sizes.



## Zirconia Alumina Resin Waterproof Cloth

### Features

- Zirconia alumina abrasive
- Full resin bond system
- Durable Y-weight polyester, waterproof cloth backing
- Waterproof

### Benefits

- Ultra tough, aggressive
- Self-sharpening, cool cutting
- Increased strength
- Maximum grain adhesion, reduced edge-fray and strong body retention result in longer life and product consistency
- Use wet or dry

Applications include weld removal and the finishing of ferrous and non-ferrous materials. The choice for heaviest pressure applications.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>3" x 132"</b>				
05539599679	36	YP 1186 W	10	10
<b>4" x 132"</b>				
05539599664	36	YP 1186 W	10	10



## Aluminum Oxide Resin Cloth

### Features

- Aluminum oxide abrasive
- Full resin bond system
- X-weight cotton backing

### Benefits

- Durable, with aggressive cutting action
- The economical choice for a wide range of applications
- Increased strength
- Durable
- Resistant to heat

General purpose belt for sanding ferrous and non-ferrous materials.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>2" x 72"</b>				
05539599956	36	XC 0877	10	10
05539599954	50	XC 0877	10	10
05539599953	60	XC 0877	10	10
05539599952	80	XC 0877	10	10
<b>3" x 132"</b>				
05539599864	36	XC 0877	10	10
05539599866	50	XC 0877	10	10
<b>4" x 132"</b>				
05539599851	36	XC 0877	10	10
05539599855	80	XC 0877	10	10

## Belt Cleaning Stick

This solid rubber cleaning stick is designed to remove wood and other non-metallic materials that build up on narrow belts during use. Apply it to the face of the belt while running to remove unwanted materials and increase cut rate and overall life of the belt.

PART NO.	SIZE	STD. PKG.
05539514745	8 x 1-3/4 x 1-3/4	1



See FastTrack Belt Program on pages 4 - 7 for additional specifications and sizes.

COATED ABRASIVES

# Wide Belts

## Aluminum Oxide Resin Cloth Open

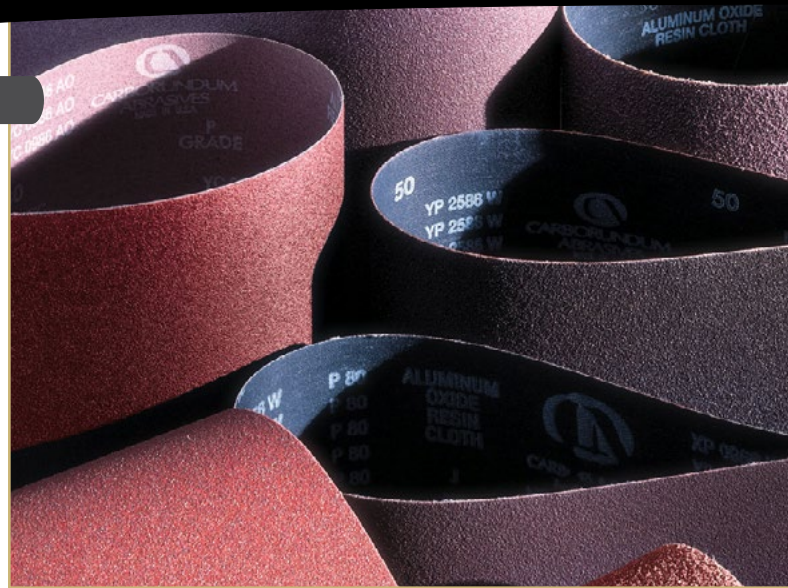
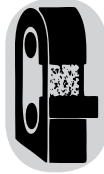
### Features

- Light brown aluminum oxide abrasive
- Full resin bond system
- X-weight cotton backing
- Open coat

### Benefits

- Uniform scratch pattern
- Increased strength
- Resists loading

Applications include finishing of wood and non-ferrous metals.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>25" x 75"</b>				
05539599963	80	XC 0776 0	3	3
<b>37" x 60"</b>				
05539599978	60	XC 0776 0	3	3
05539599977	80	XC 0776 0	3	3
05539599976	100	XC 0776 0	5	5
05539599975	120	XC 0776 0	5	5
05539599974	150	XC 0776 0	5	5
05539599973	180	XC 0776 0	5	5

PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
<b>37" x 75"</b>				
05539599992	60	XC 0776 0	3	3
05539599991	80	XC 0776 0	3	3
05539599990	100	XC 0776 0	5	5
05539599989	120	XC 0776 0	5	5
05539599988	150	XC 0776 0	5	5
05539599987	180	XC 0776 0	5	5

## Troubleshooting Guide

### SUGGESTED CORRECTION – CONTACT WHEELS

PROBLEM	HARDER WHEEL	SOFTER WHEEL	LARGER GROOVE/LAND	SMALLER GROOVE/LAND	DRESS WHEEL	HIGHER SPEED	LOWER SPEED	STANDARD SERRATION	LARGER WHEEL	SMALLER WHEEL
DULLING	•			•			•			•
LOADING			•							•
OVER-AGGRESSIVENESS		•		•				•	•	
SLOW CUTTING	•		•			•				•
SCRATCHES TOO DEEP		•		•				•	•	
BURNING	•						•			
NON-CONFORMITY		•	•				•		•	
DUBBING EDGES	•									
SHEDDING (ABRASIVES)		•		•	•	•		•	•	
CHATTER		•			•			•	•	

### SUGGESTED CORRECTION – GENERAL

PROBLEM	CORRECTION
LOADING	DECREASE INFEEED PRESSURE OR BELT SPEED
SHEDDING	REDUCE APPLIED PRESSURE USE A LESS AGGRESSIVE CONTACT WHEEL DRESS CONTACT WHEEL IF WORN OR DAMAGED USE ENTIRE SURFACE OF BELT
BELT BREAKAGE	REDUCE BELT TENSION USE LESS AGGRESSIVE CONTACT WHEEL CHECK TRACKING MECHANISM FOR BELTS TRACKING ERRATICALLY
REDUCED BELT LIFE	USE COARSER GRIT REDUCE PRESSURE





## Medalist Ceramic Alumina Dri-Lube Resin Paper Open Stick-On

NEW!

### Features

- Medalist patented ceramic alumina abrasive, P80 - P800
- Full resin bond system
- Unique fiber-reinforced, flexible B- and C-weight latex-saturated backing
- Special undyed stearate oversize
- PSA (pressure sensitive adhesive) backing
- Link disc roll, 4-pack with polybags

### Benefits

- Fastest cut rate even on hard-to-sand surfaces
- Extended life – up to 2:1 over conventional discs
- Broadest ceramic grit range available
- Improved grain adhesion and longest disc life
- 50% - 60% improvement in tear resistance, superior resistance to delamination
- Durable, yet flexible
- Superior load resistance and extended life
- No color transfer to work
- Easy application and removal
- Easy dispensing
- Minimizes storage space

**Best choice for stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass, and composites, bare wood sanding, light weld blending, preparing and finishing metal, and sanding of all gel coats and body filler compounds.**



PART NO.	GRADING	ROLLS/CASE
<b>6" x 0" Link Disc Rolls</b>		
05539599500	P80 C 2312 DO	4
05539599499	P100 C 2312 DO	4
05539599498	P120 C 2312 DO	4
05539599497	P150 B 2312 DO	4
05539599496	P180 B 2312 DO	4
05539599495	P220 B 2312 DO	4
05539599494	P240 B 2312 DO	4

continuedv

PART NO.	GRADING	ROLLS/CASE
<b>6" x 0" Link Disc Rolls (continued)</b>		
05539599493	P280 B 2312 DO	4
05539599492	P320 B 2312 DO	4
05539599491	P400 B 2312 DO	4
05539599490	P500 B 2312 DO	4
05539599489	P600 B 2312 DO	4
05539599488	P800 B 2312 DO	4

100 discs per roll. Order in multiples of 4 rolls.

See back-up pads for these discs on page 16.  
Disc roll dispenser available on page 20.

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Stick-On

EXPANDED OFFERING!

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Ultra fine grits P1000, P1200, P1500
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- PSA (pressure sensitive adhesive) backing
- Special, undyed stearate oversize and an open coat
- Link disc roll, 4-pack with polybags
- 5" and 6" individual PSA discs have a tabbed, white, translucent liner

### Benefits

- 30% to 50% faster cut rate than other discs
- Consistent scratch pattern and finish
- Excellent cut rate and total cut, while minimizing loading = maximum life
- Create fine finishes
- Improved grain adhesion and longest disc life
- 50% - 60% improvement in tear strength, superior resistance to delamination
- Easy application and removal
- Superior load resistance and extended life
- No color transfer to work
- Easy dispensing
- Minimizes storage space
- The PSA adhesive is protected from air-borne contaminants
- The tab allows easier removal of the paper liner

**Best choice for sanding all paints, primers, plastics and fiberglass. Also suited for sealer and wash coats in wood furniture.**

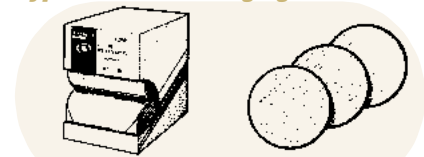


PART NO.	GRADING	ROLLS/CASE	MIN. QTY.
<b>3-1/2" x 0" Link Disc Rolls</b>			
05539520624	P80 B 0912 DO	4	4
05539520623	P100 B 0912 DO	4	4
05539520622*	P120 B 0912 DO	4	60
05539520621*	P150 B 0912 DO	4	60
05539520620	P180 B 0912 DO	4	4
05539520619	P220 B 0912 DO	4	4
05539520618*	P240 B 0912 DO	4	60
05539520617*	P280 B 0912 DO	4	60
05539520616*	P320 B 0912 DO	4	60
05539520615	P400 B 0912 DO	4	4

100 discs per roll. Order in multiples of 4 rolls.

\* Non-stock. Ask your Carborundum representative for current lead times.  
continued

### Types of Disc Packaging



4-PACK LINK DISC ROLL

INDIVIDUAL DISCS

EXPANDED OFFERING!

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Stick-On (cont'd)

PART NO.	GRADING		ROLLS/CASE
<b>5" x 0" Link Disc Rolls</b>			
05539518114	P80	B 0912 DO	4
05539518113	P100	B 0912 DO	4
05539518112	P120	B 0912 DO	4
05539518111	P150	B 0912 DO	4
05539518110	P180	B 0912 DO	4
05539518109	P220	B 0912 DO	4
05539518108	P240	B 0912 DO	4
05539518107	P280	B 0912 DO	4
05539518106	P320	B 0912 DO	4
05539518105	P400	B 0912 DO	4
05539563779	P500	B 0912 DO	4
05539518104	P600	B 0912 DO	4
05539518101	P800	B 0712 DO	4

100 discs per roll. Order in multiples of 4 rolls.

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Tabbed Discs</b>				
05539520293	P1000	B 0712 DO	100	400
05539520292	P1200	B 0712 DO	100	400
05539520291	P1500	B 0712 DO	100	400

PART NO.	GRADING		ROLLS/CASE
<b>6" x 0" Link Disc Rolls</b>			
05539518173	P80	B 0912 DO	4
05539518172	P100	B 0912 DO	4
05539518171	P120	B 0912 DO	4
05539518170	P150	B 0912 DO	4
05539518169	P180	B 0912 DO	4
05539518168	P220	B 0912 DO	4
05539518167	P240	B 0912 DO	4
05539518166	P280	B 0912 DO	4
05539518165	P320	B 0912 DO	4
05539518164	P400	B 0912 DO	4
05539563780	P500	B 0912 DO	4
05539518163	P600	B 0912 DO	4
05539518162	P800	B 0712 DO	4

100 discs per roll. Order in multiples of 4 rolls.

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Tabbed Discs</b>				
05539570564	P80	B 0712 DO	100	100
05539570565	P100	B 0712 DO	100	100
05539570566	P120	B 0712 DO	100	100
05539570567	P150	B 0712 DO	100	100
05539570568	P180	B 0712 DO	100	100
05539570569	P220	B 0712 DO	100	100
05539570570	P240	B 0712 DO	100	100
05539570571	P320	B 0712 DO	100	100
05539570572	P400	B 0712 DO	100	100
05539520296	P1000	B 0712 DO	100	400
05539520295	P1200	B 0712 DO	100	400
05539520294	P1500	B 0712 DO	100	400

PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>8" x 0" Link Disc Rolls</b>				
05539561110	P80	B 0912 DO	4	4
05539561109	P100	B 0912 DO	4	4
05539561108	P120	B 0912 DO	4	4
05539561106	P180	B 0912 DO	4	4
05539561104*	P240	B 0912 DO	4	60
05539561102	P320	B 0912 DO	4	4

100 discs per roll. Order in multiples of 4 rolls.

\* Non-stock. Ask your Carborundum representative for current lead times.

See back-up pads for these discs on page 16.  
Disc roll dispenser available on page 20.

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Stick-On

### Features

- Premium, P-graded, light brown aluminum oxide abrasive
- Durable, C-weight backing
- PSA (pressure sensitive adhesive) backing
- Special, water-based stearate oversize and open coat
- Link disc roll; 4-pack with polybags

### Benefits

- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance
- Easy dispensing
- Minimizes storage space
- Protects individual rolls

Ideal for sanding paints, primers, plastics and fiberglass as well as whitewood sanding, clean-up and repair.



PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>5" x 0" Link Disc Rolls</b>				
77696060029*	P60	C 0712 DO	4	60
05539510555	P80	C 0712 DO	4	4
05539510554	P100	C 0712 DO	4	4
05539510553	P120	C 0712 DO	4	4
05539510552	P150	C 0712 DO	4	4
05539510550	P180	C 0712 DO	4	4
05539510549	P220	C 0712 DO	4	4
05539510548	P240	C 0712 DO	4	4
05539510546	P320	C 0712 DO	4	4
05539510545	P400	C 0712 DO	4	4

PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>6" x 0" Link Disc Rolls</b>				
05539510567	P80	C 0712 DO	4	4
05539510566	P100	C 0712 DO	4	4
05539510565	P120	C 0712 DO	4	4
05539510563	P150	C 0712 DO	4	4
05539510562	P180	C 0712 DO	4	4
05539510561	P220	C 0712 DO	4	4
05539510560	P240	C 0712 DO	4	4
05539510558	P320	C 0712 DO	4	4
05539510557	P400	C 0712 DO	4	4

100 discs per roll. Order in multiples of 4 rolls.

\* Non-stock. Ask your Carborundum representative for current lead times.

**NEW!**

## Silicon Carbide Dri-Lube Paper Open Stick-On

### Features

- P-graded, hard silicon carbide abrasive
- Heavy, B-weight paper
- PSA backing
- Water-based stearate anti-loading oversize and an open coat
- Link disc roll

### Benefits

- Sharp cut, excellent for finishing
- Tear resistance and flexibility
- Easy application and removal
- Improved load resistance
- Easy dispensing

Machine sanding metal primer coats and between finish coats. Also for whitewood between wash, sealer, and lacquer coats.



PART NO.	GRADING		ROLLS/CASE
<b>5" x 0" Link Disc Rolls</b>			
05539510526	P80	B 0412 D0	4
05539510525	P100	B 0412 D0	4
05539510523	P120	B 0412 D0	4

continued

PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>5" x 0" Link Disc Rolls (continued)</b>				
05539510522	P150	B 0412 D0	4	4
05539510521	P180	B 0412 D0	4	4
05539510520*	P220	B 0412 D0	4	60
05539510519*	P240	B 0412 D0	4	60
05539510517	P320	B 0412 D0	4	4
05539510516	P400	B 0412 D0	4	4

### 6" x 0" Link Disc Rolls

05539510544*	P80	B 0412 D0	4	60
05539510543*	P100	B 0412 D0	4	60
05539510542*	P120	B 0412 D0	4	60
05539510540	P180	B 0412 D0	4	4
05539510539	P220	B 0412 D0	4	4
05539510535*	P320	B 0412 D0	4	60

150 grit and coarser: 125 discs per roll; 180 grit and finer: 250 discs per roll.

\* Non-stock. Ask your Carborundum representative for current lead times.

## Premier Red Zirconia Alumina Resin Paper Open Stick-On

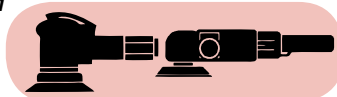
### Features

- Premium zirconia alumina abrasive and an open coat
- Full, phenolic resin bond system plus latex
- E-weight, latex paper backing
- PSA backing

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Greater flexibility
- Easy application and removal

Best choice for stripping paint and rust, as well as blending welds.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Discs</b>				
05539521302	36	E 1214 O	50	200
05539521301	40	E 1214 O	50	200
05539521300	80	E 1214 O	50	200

### 8" x 0" Individual Discs

05539521305	36	E 1214 O	25	100
05539521304	40	E 1214 O	25	100
05539521303	80	E 1214 O	25	100

## Carbo Gold Aluminum Oxide Resin Paper Open Stick-On

### Features

- P-graded, heat-treated, aluminum oxide abrasive and an open coat
- Resin bond
- E-weight paper backing
- PSA backing

### Benefits

- Fast, aggressive cut and long life
- Increased life, reduced loading and reduced edge wear
- Increased strength and durability
- Easy application and removal

Ideal for stripping all paints and rust, as well as blending welds.

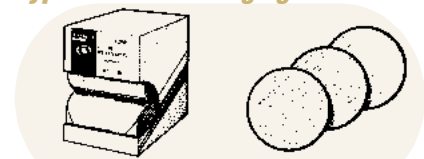


PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Discs</b>				
05539512376	P36	E 0912 O	50	200
05539512375	P40	E 0912 O	50	200
05539512374	P80	E 0912 O	50	200

### 8" x 0" Individual Discs

05539512379	P36	E 0912 O	50	200
05539512378	P40	E 0912 O	50	200
05539512377	P80	E 0912 O	50	200

### Types of Disc Packaging



4-PACK LINK DISC ROLL

INDIVIDUAL DISCS



# Stick-On Paper Discs

## Premier Red Aluminum Oxide Resin Paper Stick-On

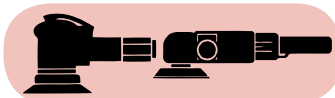
### Features

- Tough, P-graded, heat-treated, aluminum oxide abrasive
- Full resin bond system
- High strength, F-weight paper backing
- PSA backing
- Link disc roll

### Benefits

- Aggressive yet cool cut
- Increased strength and durability
- Increased durability and reduced edge wear
- Easy application and removal
- Easy dispensing

Ideally suited for weld blending, metal polishing and whitewood sanding, clean-up and repair.



PART NO.	GRADING		ROLLS/CASE
<b>5" x 0" Link Disc Rolls</b>			
05539512549	P60	F 0915	4
05539512550	P80	F 0915	4
05539512551	P100	F 0915	4
<b>6" x 0" Link Disc Rolls</b>			
05539512556	P60	F 0915	4
05539512557	P80	F 0915	4

100 discs per roll. Order in multiples of 4 rolls.

## Back-up Pads and PSA Conversion Discs and Strips for Stick-On Discs



### Back-up Pads for Stick-On Discs

Vinyl-faced pads for use with Stick-On discs or conventional discs using disc adhesive. 5" and 6" pads have a riveted 5/16"-24 threaded shank. 8" pads have a 5/8"-11 threaded female hub.



29418



29420

### PSA Conversion Discs and Strips

Permanent adhesive on textile hook backing allows for low cost conversion of Stick-On pads to Grip-On.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Stick-On Discs</b>			
05539599304	5" Low Profile - Soft	12,000	5*
05539599309	5" Low Profile - Medium	15,000	5*
05539599317	5" Tapered - Medium	15,000	5*
05539599305	6" Low Profile - Soft	12,000	5*
05539599311	6" Low Profile - Medium	15,000	5*
05539599319	6" Tapered - Medium	15,000	5*
05539512023	8" x 1/2" Tapered - Medium	4,800	1
<b>Stick-On to Grip-On Conversion Discs and Strips</b>			
05539529420	2-3/4" x 16-1/2"		20
05539529418	6"		20

\* Packaged in individual clamshells

## Disc Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	SIA	VSM
<b>PAPER DISCS</b>						
B 2312 DO, C 2312 DO	735U, 734U	-	PS36	-	1950 SIASPEED	-
B 0912 DO, B 0712 DO	216U, 255L, 260L, 334U	VC154-LL	PS73	Q-SILVER, ROYAL	1950, 1940	MPG
PB273	214U, 316U, RED, NX	-	PL36	BASECUT	-	MP10
C 0712 DO	236U, 316U	HCAB, HC135-LL, VC151-LL	PS33	BULLDOG GOLD	1947	KP911
B 0412 DO	414N, 415N, 415U, 426U	PSF-LL, SA168	PL35	CARATFLEX, POLARSTAR	1748	CP131A
E 0912 O	245N, 246U, 296O, 251U, 253N, 346U	-	PS23	-	-	KP510E
E 1214 O	750U, 751U, 740I, 745I	-	-	ROYAL COARSE CUT	-	KP510E, KP709
F 0915	241, 242, 263U, 360I, 361I, 362I, 363I	BW115	PS20	-	-	KP709, KP508E

### Types of Disc Packaging



4-PACK LINK DISC ROLL



INDIVIDUAL DISCS

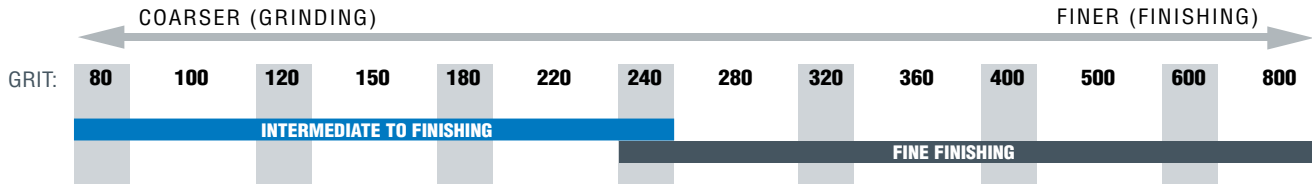




For use on random orbital and rotary sanders.

- APPLICATIONS:** Stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass and composites, and bare wood sanding.
- SIZE RANGE:** 5" and 6" disc rolls, 5" tabbed individual discs
- GRIT RANGE:** 80 – 800
- ABRASIVE GRAIN:** Aluminum Oxide
- ATTACHMENT SYSTEMS:** PSA (pressure-sensitive adhesive)
- PAPER WEIGHTS:** Lightweight – B

## APPLICATION/GRIT RECOMMENDATION GUIDE



### MERIT NO-LOAD PB273

GOOD CHOICE FOR SANDING PAINT, PRIMER, PLASTICS, FIBERGLASS, AND WHITEWOOD AT A LOW INITIAL PRICE

#### FEATURES

- P-graded, aluminum oxide abrasive
- Flexible latex B-wt. backing, with a full resin bond and open coat
- Water-based stearate, non-pigmented, anti-load coating

#### BENEFITS

- Fast cutting action and extended life with consistent finish
- Improved resistance to delamination; no delamination to back-up pad
- Can be used moist or wet
- Provides improved load resistance
- No color transfer to work



**GOOD**



**GOOD**

TIER: Merit  
 BRAND: Merit  
 CAP CODE: PB273 NO-LOAD  
 ABRASIVE: Aluminum Oxide  
 PAPER BACKING WEIGHT: B-Weight  
 FASTENING: PSA Roll  
 OTHER: P-Graded

TIER: Merit  
 BRAND: Merit  
 CAP CODE: PB273 NO-LOAD  
 ABRASIVE: Aluminum Oxide  
 PAPER BACKING WEIGHT: B-Weight  
 FASTENING: PSA Tabbed Individual  
 OTHER: P-Graded

SIZE	GRIT	ROLLS/ STD. PKG.	DISCS/ ROLL	PART NO.	MIN./ STD. PKG.	PART NO.
5	80	4	100	66623362930	100/400	69957348198
	100					69957348200
	120			66623362929		69957348201
	150			66623362928		69957348202
	180			66623362927		69957348203
	220			66623362926		69957348204
	240			66623362925		69957348205
	320			66623362924		69957348206
	400			66623362923		69957348207
	600			66623362922		69957348223
	800			66623362921		69957348224*
6	80	4	100	66623362940		
	100			69957352447		
	120			66623362939		
	150			66623362938		
	180			66623362937		
	220			66623362936		
	240			66623362935		
	320			66623362934		
	400			66623362933		
	600			66623362932		
	800			66623362931		

\*NON-STOCK: STD. PKG. = 2000 DISCS

# Vacuum Stick-On Paper Discs

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Vacuum Stick-On

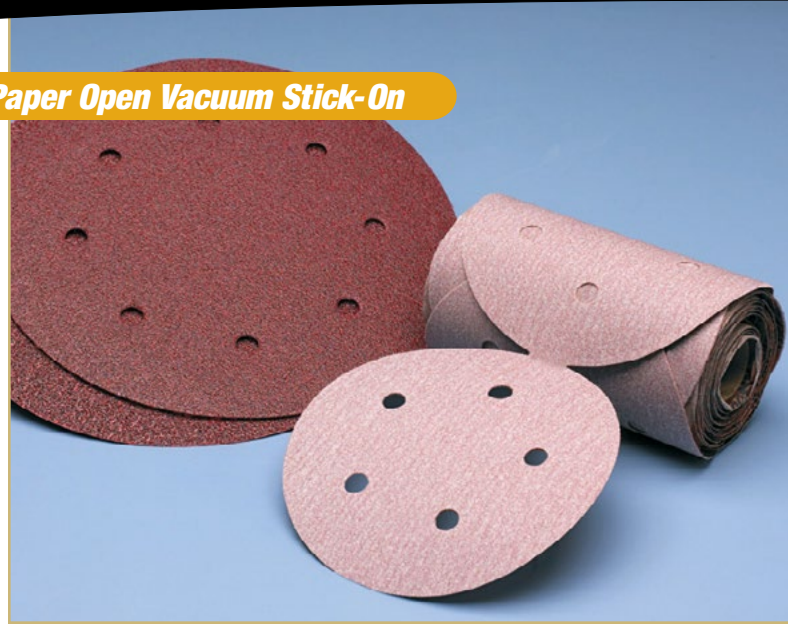
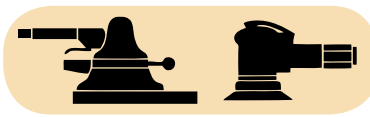
### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- PSA (pressure sensitive adhesive) backing
- Special, undyed stearate oversize, and an open coat
- Vacuum holes
- Link disc roll, 4-pack with polybags

### Benefits

- 30% to 50% faster cut rate than other discs
- Consistent scratch pattern and finish
- Improved grain adhesion and longest disc life
- 50% – 60% improvement in tear strength, superior resistance to delamination
- Easy application and removal
- Superior load resistance and extended life
- No color transfer to work
- Dust-free sanding environment
- Extended life
- Easy dispensing
- Minimizes storage space
- Protects individual rolls

**Best choice for sanding all paints, primers, plastics and fiberglass. Also suited for sealer and wash coats in wood furniture.**



PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>5" x 5 Hole Vacuum Link Disc Rolls D-3329</b>				
05539515295	P80	B 0912 DO	4	4
05539515294	P100	B 0912 DO	4	4
05539515293	P120	B 0912 DO	4	4
05539515292	P150	B 0912 DO	4	4
05539515291	P180	B 0912 DO	4	4
05539515287	P220	B 0912 DO	4	4
05539515286	P240	B 0912 DO	4	4
05539515285*	P280	B 0912 DO	4	60
05539515284	P320	B 0912 DO	4	4
05539515282	P400	B 0912 DO	4	4
05539515281*	P600	B 0912 DO	4	60
69957351548*	P800	B 0712 DO	4	60

PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>6" x 6 Hole Vacuum Link Disc Rolls D-3333</b>				
05539515317	P80	B 0912 DO	4	4
05539515316	P100	B 0912 DO	4	4
05539515315	P120	B 0912 DO	4	4
05539515313	P150	B 0912 DO	4	4
05539515312	P180	B 0912 DO	4	4
05539515311	P220	B 0912 DO	4	4
05539515304	P240	B 0912 DO	4	4
05539515301*	P280	B 0912 DO	4	60
05539515300	P320	B 0912 DO	4	4
05539515298	P400	B 0912 DO	4	4
05539515297	P600	B 0912 DO	4	4
05539515296*	P800	B 0712 DO	4	60

100 discs per roll. Order in multiples of 4 rolls.

\* Non-stock. Ask your Carborundum representative for current lead times.

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Vacuum Stick-On

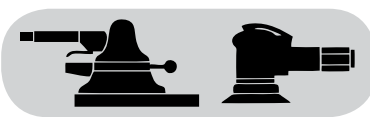
### Features

- Premium, P-graded, light brown aluminum oxide abrasive
- Durable C-weight backing
- PSA (pressure sensitive adhesive) backing
- Special, water-based stearate oversize, and an open coat
- Vacuum holes
- Link disc roll
- 4-pack with polybags

### Benefits

- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance
- Dust-free sanding environment
- Easy dispensing
- Minimizes storage space
- Reduces cardboard waste
- Protects individual rolls

**Ideal for sanding paints, primers, plastics and fiberglass, as well as whitewood sanding, clean-up and repair.**



PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
<b>5" x 5 Hole Vacuum Link Disc Rolls D-3329</b>				
05539563612	P80	C 0712 DO	4	4
05539563611*	P120	C 0712 DO	4	60
05539563610*	P150	C 0712 DO	4	60
05539563609	P180	C 0712 DO	4	4
05539563608*	P220	C 0712 DO	4	60
05539563606	P320	C 0712 DO	4	4
05539563605*	P400	C 0712 DO	4	60
<b>6" x 6 Hole Vacuum Link Disc Rolls D-3333</b>				
05539563620*	P80	C 0712 DO	4	60
05539563616*	P220	C 0712 DO	4	60
05539563614*	P320	C 0712 DO	4	60

100 discs per roll. Order in multiples of 4 rolls.

\* Non-stock. Ask your Carborundum representative for current lead times.

See back-up pads for these discs on page 19.  
Disc roll dispenser available on page 20.



## Premier Red Zirconia Alumina Resin Paper Open Vacuum Stick-On

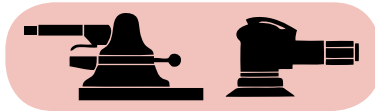
### Features

- Premium, zirconia alumina abrasive and an open coat
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing
- PSA (pressure sensitive adhesive) backing
- Vacuum holes

### Benefits

- Fast removal rates, extended life
- Maximum durability plus flexibility  
Excellent grain adhesion
- Reduced edge shed
- Greater flexibility
- Easy application and removal
- Dust-free sanding environment

**Best choice for stripping paint and rust, as well as blending welds.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>8" x 8 Hole Individual Vacuum Discs D-3370</b>				
05539521311	36	E 1214 0	25	100
05539521309	80	E 1214 0	25	100

## Back-up Pads for Vacuum Stick-On Discs



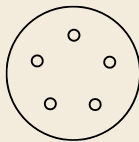
*Vinyl-faced pads for use with Stick-On discs with standard vacuum hole patterns. These pads have a riveted 5/16"-24 threaded shank.*

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pad for Stick-On Vacuum Discs</b>			
05539599310	5" x 5 Hole Low Profile - Medium	15,000	5*
05539599318	5" x 5 Hole Tapered - Medium	15,000	5*
05539599312	6" x 6 Hole Low Profile - Medium	15,000	5*
05539599320	6" x 6 Hole Tapered - Medium	15,000	5*

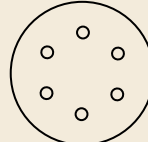
\* Packaged in Individual Clamshells

### Die Patterns

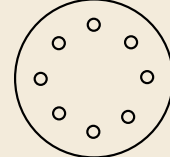
Die pattern numbers showing hole patterns on Vacuum Stick-On Discs.



**DIE D-3329 – DISCS ROLLS  
5" PAD WITH  
5 VACUUM HOLES**



**DIE D-3333 – DISC ROLLS  
6" PAD WITH  
6 VACUUM HOLES**

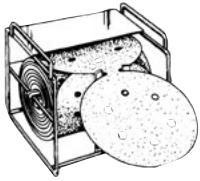


**DIE D-3370  
8" PAD WITH  
8 VACUUM HOLES**

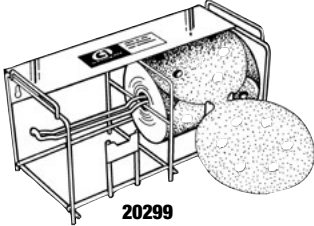


# Disc Dispensers

## Disc Roll Dispensers



20361



20299

*These convenient disc roll dispensers feature heavy-duty construction and a rubberized finish to protect your product. Designed to accommodate any 5" or 6" disc rolls or sheet rolls, they can be easily moved from one work station to another, attached to a wall, or stacked for multi-grit or multi-diameter operations.*

*Discs are individually removed from the roll by a cutter bar.*



PART NO.	DESCRIPTION	DISPENSERS/CASE
<b>Disc Roll Dispenser</b>		
05539520361	Disc Roll Dispenser – Single	1
05539520299	Disc Roll Dispenser – Double	1



## Medalist Ceramic Alumina Dri-Lube Resin Paper Open Grip-On

**NEW!**

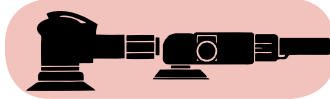
### Features

- Medalist patented ceramic alumina abrasive, P80 - P800
- Full resin bond system
- Unique fiber-reinforced, flexible B- and C-weight latex-saturated backing
- Special undyed stearate oversize
- Hook and loop fastening system

### Benefits

- Fastest cut rate even on hard-to-sand surfaces
- Extended life – up to 2:1 over conventional discs
- Broadest ceramic grit range available
- Improved grain adhesion and longest disc life
- 50% - 60% improvement in tear resistance, superior resistance to delamination
- Durable, yet flexible
- Superior load resistance and extended life
- No color transfer to work
- Neat, clean application and removal
- Can be re-used

**Best choice for stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass, and composites, bare wood sanding, light weld blending, preparing and finishing metal, and sanding of all gel coats and body filler compounds.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Discs</b>				
05539599513	P80	C 2312 DO	50	200
05539599512	P100	C 2312 DO	50	200
05539599511	P120	C 2312 DO	50	200
05539599510	P150	B 2312 DO	50	200
05539599509	P180	B 2312 DO	50	200
05539599508	P220	B 2312 DO	50	200
05539599507	P240	B 2312 DO	50	200
05539599506	P280	B 2312 DO	50	200
05539599505	P320	B 2312 DO	50	200
05539599504	P400	B 2312 DO	50	200
05539599503	P500	B 2312 DO	50	200
05539599502	P600	B 2312 DO	50	200
05539599501	P800	B 2312 DO	50	200

See back-up pads for these discs on page 23.

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Discs</b>				
05539599526	P80	C 2312 DO	50	200
05539599525	P100	C 2312 DO	50	200
05539599524	P120	C 2312 DO	50	200
05539599523	P150	B 2312 DO	50	200
05539599522	P180	B 2312 DO	50	200
05539599521	P220	B 2312 DO	50	200
05539599520	P240	B 2312 DO	50	200
05539599519	P280	B 2312 DO	50	200
05539599518	P320	B 2312 DO	50	200
05539599517	P400	B 2312 DO	50	200
05539599516	P500	B 2312 DO	50	200
05539599515	P600	B 2312 DO	50	200
05539599514	P800	B 2312 DO	50	200
05539599423	P1000	B 2312 DO	50	200
05539599444	P1500	B 2312 DO	50	200





## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Grip-On

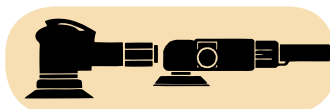
### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Ultra fine grits P1000, P1200, and P1500
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- Hook and loop fastening system
- Special, undyed stearate oversize and an open coat

### Benefits

- 30% to 50% faster cut rate than other discs
- Consistent scratch pattern and finish
- Excellent cut rate and total cut, while minimizing loading = maximum life
- Create fine finishes
- Improved grain adhesion and longest disc life
- 50% – 60% improvement in tear strength, superior resistance to delamination
- Neat, clean application and removal
- Can be re-used
- Superior load resistance and extended life
- No color transfer to work

**Best choice for sanding all paints, primers, plastics and fiberglass. Also suited for sealer and wash coats in wood furniture.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>3" x 0" Individual Discs</b>				
05539570019	P80	B 0912 DO	50	200
05539599427	P120	B 0912 DO	50	200
05539570020	P180	B 0912 DO	50	200
05539570021	P320	B 0912 DO	50	200
05539570022	P800	B 0712 DO	50	200
05539569926	P1000	B 0712 DO	50	200
05539569927	P1500	B 0712 DO	50	200

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Discs</b>				
05539520269	P80	B 0912 DO	100	400
05539520267	P100	B 0912 DO	100	400
05539520266	P120	B 0912 DO	100	400
05539520264	P150	B 0912 DO	100	400
05539520263	P180	B 0912 DO	100	400
05539520262	P220	B 0912 DO	100	400
05539520260	P240	B 0912 DO	100	400
05539520259	P280	B 0912 DO	100	400
05539520258	P320	B 0912 DO	100	400
05539520257	P400	B 0912 DO	100	400
05539563781	P500	B 0912 DO	100	400
05539520256	P600	B 0912 DO	100	400
05539520255	P800	B 0712 DO	100	400
05539520254	P1000	B 0712 DO	100	400
05539520253	P1200	B 0712 DO	100	400
05539520252	P1500	B 0712 DO	100	400

### 6" x 0" Individual Discs

05539520289	P80	B 0912 DO	100	400
05539520288	P100	B 0912 DO	100	400
05539520287	P120	B 0912 DO	100	400
05539520285	P150	B 0912 DO	100	400
05539520284	P180	B 0912 DO	100	400
05539520283	P220	B 0912 DO	100	400
05539520282	P240	B 0912 DO	100	400
05539520278	P280	B 0912 DO	100	400
05539520277	P320	B 0912 DO	100	400
05539520276	P400	B 0912 DO	100	400
05539563782	P500	B 0912 DO	100	400
05539520275	P600	B 0912 DO	100	400
05539520274	P800	B 0712 DO	100	400
05539520272	P1000	B 0712 DO	100	400
05539520271	P1200	B 0712 DO	100	400
05539520270	P1500	B 0712 DO	100	400

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Grip-On

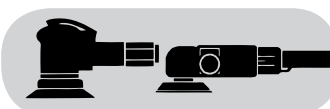
### Features

- P-graded, light brown, aluminum oxide abrasive
- C-weight backing
- Hook and loop fastening system
- Special, water-based stearate oversize and an open coat

### Benefits

- Fast cut, long life
- Durable, high tear resistance
- Neat, clean application and removal
- Excellent load resistance

**Ideal for sanding paints, primers, plastics and fiberglass, as well as whitewood sanding, clean-up and repair.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Discs</b>				
05539520123	P80	C 0712 DO	100	400
05539520122	P100	C 0712 DO	100	400
05539520121	P120	C 0712 DO	100	400

*continued*

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Discs (cont'd)</b>				
05539520120	P150	C 0712 DO	100	400
05539520119	P180	C 0712 DO	100	400
05539520118	P220	C 0712 DO	100	400
05539520115	P320	C 0712 DO	100	400

### 6" x 0" Individual Discs

05539520134	P80	C 0712 DO	100	400
05539520133	P100	C 0712 DO	100	400
05539520132	P120	C 0712 DO	100	400
05539520131	P150	C 0712 DO	100	400
05539520130	P180	C 0712 DO	100	400
05539520129	P220	C 0712 DO	100	400
05539520126	P320	C 0712 DO	100	400
05539520125	P400	C 0712 DO	100	400

## Premier Red Zirconia Alumina Resin Paper Open Grip-On

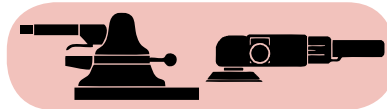
### Features

- Premium zirconia alumina abrasive and an open coat
- Full phenolic resin bond system plus latex
- E-weight latex paper backing
- Hook and loop fastening system

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Greater flexibility
- Neat, clean application and removal
- Can be re-used

**Best choice for stripping paint and rust, as well as blending welds.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Discs</b>				
05539521316	40	E 1214 O	25	100
05539521315	80	E 1214 O	25	100
<b>8" x 0" Individual Discs</b>				
05539521320	36	E 1214 O	25	100
05539521319	40	E 1214 O	25	100
05539521318	80	E 1214 O	25	100

## Back-up Pads and Interface Pads for Grip-On Discs



### Back-Up Pad

Back-up pads for use with Grip-On discs. Incorporates unique hook and loop fastening system for neat, clean application and removal. 5" and 6" pads have a riveted 5/16"-24 threaded shank. 8" pads have a 5/8-11 threaded female hub.



20521, 20520

### Interface Pad

Soft, pliable foam pad which fastens to the standard 5" and 6" Grip-On back-up pad using a hook and loop system. It converts the standard pad into a fine finishing pad and enhances P1000, P1200 and P1500 fine sanding random orbital applications.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Grip-On Discs</b>			
05539599306	3" Low Profile - Soft	12,000	10*
05539599307	5" Low Profile - Soft	12,000	5*
05539599313	5" Low Profile - Medium	15,000	5*
05539599321	5" Tapered - Medium	15,000	5*
05539599308	6" Low Profile - Soft	12,000	5*
05539599315	6" Low Profile - Medium	15,000	5*
05539599323	6" Tapered - Medium	15,000	5*
05539512030	8" Tapered - Medium	4,800	1
<b>Interface Pads for Grip-On Discs</b>			
05539520521	5" Interface Pad	—	20
05539520520	6" Interface Pad	—	20

\* Packaged in Individual Clamshells



## Spec Check

### PAPER DISC STARTING RECOMMENDATIONS BY MATERIAL/APPLICATION

MATERIAL	BEST PERFORMANCE	GENERAL-DUTY
UNFINISHED METAL	E 1214 O, F 0915	E 0912 O
PRIMED AND PAINTED SURFACES	C 2312 DO / B 2312 DO	C 0712 DO, PB273
FIBERGLASS / COMPOSITES	C 2312 DO / B 2312 DO, E 1214 O	C 0712 DO, PB273, E 0912 O
BARE WOOD	C 2312 DO / B 2312 DO	C 0712 DO, PB273
SEALER SANDING	C 2312 DO / B 2312 DO	B 0412 DO
PAINT STRIPPING	C 2312 DO / B 2312 DO, E 1214 O	C 0712 DO, PB273, E 0912 O

## Disc Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	SIA	VSM
<b>PAPER DISCS</b>						
B 2312 DO, C 2312 DO	735U, 734U	—	PS36	—	1950 SIASPEED	—
B 0912 DO, B 0712 DO	216U, 255L, 260L, 334U	VC154-LL	PS73	Q-SILVER, ROYAL	1950, 1940	MPG
PB273	214U, 316U, RED, NX	—	PL36	BASECUT	—	MP10
C 0712 DO	236U, 316U	HCAB, HC135-LL, VC151-LL	PS33	BULLDOG GOLD	1947	KP911
B 0412 DO	414N, 415N, 415U, 426U	PSF-LL, SA168	PL35	CARATFLEX, POLARSTAR	1748	CP131A
E 0912 O	245N, 246U, 296O, 251U, 253N, 346U	—	PS23	—	—	KP510E
E 1214 O	750U, 751U, 740I, 745I	—	—	ROYAL COARSE CUT	—	KP510E, KP709
F 0915	241, 242, 263U, 360I, 361I, 362I, 363I	BW115	PS20	—	—	KP709, KP508E

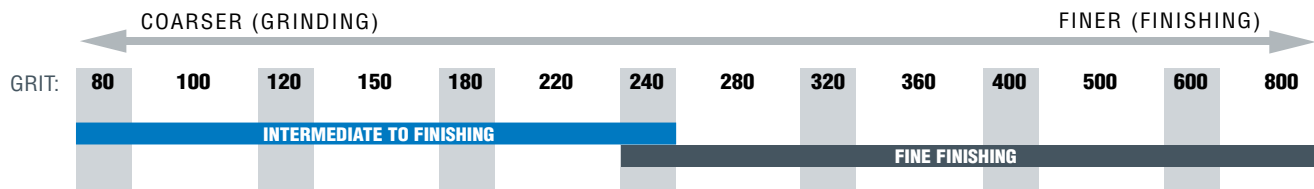
# Grip-On Paper Discs



For use on random orbital and rotary sanders.

<b>APPLICATIONS:</b>	Stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass and composites, and bare wood sanding
<b>SIZE RANGE:</b>	5" and 6"
<b>GRIT RANGE:</b>	80 – 800
<b>ABRASIVE GRAIN:</b>	Aluminum Oxide
<b>ATTACHMENT SYSTEMS:</b>	Hook and loop
<b>PAPER WEIGHTS:</b>	Lightweight – B

## APPLICATION/GRIT RECOMMENDATION GUIDE



### MERIT NO-LOAD PB273

GOOD CHOICE FOR SANDING PAINT, PRIMER, PLASTICS, FIBERGLASS, AND WHITEWOOD AT A LOW INITIAL PRICE

#### FEATURES

- P-graded, aluminum oxide abrasive
- Flexible latex B-wt. backing, with a full resin bond and open coat
- Water-based stearate, non-pigmented, anti-loading coating

#### BENEFITS

- Fast cutting action and extended life with consistent finish
- Improved resistance to delamination; no delamination to back-up pad
- Can be used moist or wet
- Provides improved load resistance
- No color transfer to work



TIER:	<b>GOOD</b>
BRAND:	Merit
CAP CODE:	<b>PB273 NO-LOAD</b>
ABRASIVE:	Aluminum Oxide
PAPER BACKING WEIGHT:	B-Weight
OTHER:	P-Graded

SIZE	GRIT	MIN./STD. PKG.	PART NO.
5	80	100/400	66623362950
	100		66623365788
	120		66623362949
	150		66623362948
	180		66623362947
	220		66623362946
	240		66623362945
	320		66623362944
	400		66623362943
	600		66623362942
800	66623362941		
6	80	100/400	66623362960
	100		66623365789
	120		66623362959
	150		66623362958
	180		66623362957
	220		66623362956
	240		66623362955
	320		66623362954
	400		66623362953
	600		66623362952
800	66623362951		



## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Vacuum Grip-On

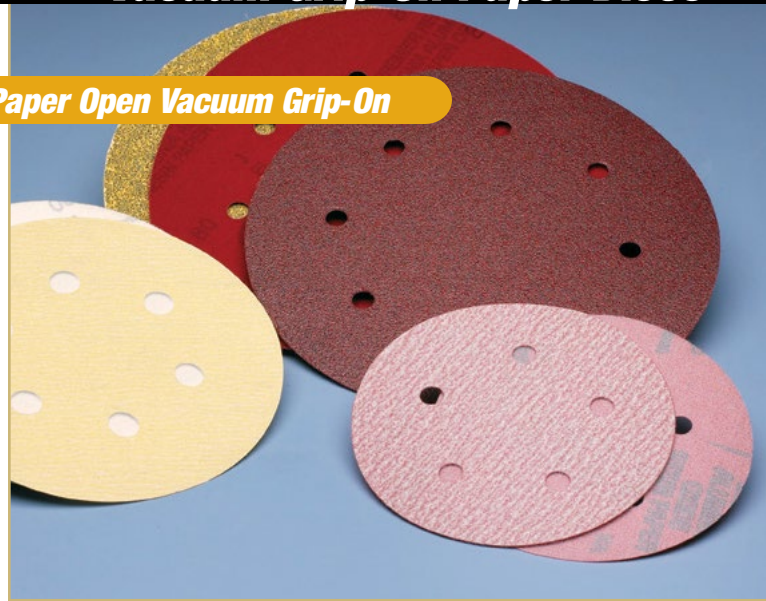
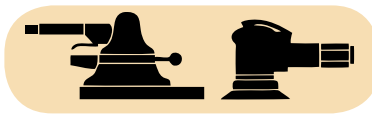
### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Ultra fine grit P1000
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- Hook and loop fastening system
- Special, undyed stearate oversize and an open coat
- Vacuum holes

### Benefits

- 30% to 50% faster cut rate than other discs
- Consistent scratch pattern and finish
- Excellent cut rate and total cut, while minimizing loading = maximum life
- Creates fine finishes
- Improved grain adhesion and longest disc life
- 50% – 60% improvement in tear strength, superior resistance to delamination
- Neat, clean application and removal
- Can be re-used
- Superior load resistance and extended life
- No color transfer to work
- Dust-free sanding environment
- Extended life

**Best choice for sanding all paints, primers, plastics and fiberglass. Also suited for sealer and wash coats in wood furniture.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 5 Hole Individual Vacuum Discs D-3328</b>				
05539520315	P80	B 0912 D0	100	400
05539520314	P100	B 0912 D0	100	400
05539520313	P120	B 0912 D0	100	400
05539520312	P150	B 0912 D0	100	400
05539520311	P180	B 0912 D0	100	400
05539520310	P220	B 0912 D0	100	400
05539520307	P320	B 0912 D0	100	400
05539520306	P400	B 0912 D0	100	400
05539520305	P600	B 0912 D0	100	400

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 6 Hole Individual Vacuum Discs D-3371</b>				
05539520331	P80	B 0912 D0	100	400
05539520330	P100	B 0912 D0	100	400
05539520329	P120	B 0912 D0	100	400
05539520328	P150	B 0912 D0	100	400
05539520326	P180	B 0912 D0	100	400
05539520325	P220	B 0912 D0	100	400
05539520324	P240	B 0912 D0	100	400
05539520323	P280	B 0912 D0	100	400
05539520322	P320	B 0912 D0	100	400
05539520321	P400	B 0912 D0	100	400
05539563784	P500	B 0912 D0	100	400
05539520320	P600	B 0912 D0	100	400
05539520319	P800	B 0712 D0	100	400
05539520318	P1000	B 0712 D0	100	400

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Vacuum Grip-On

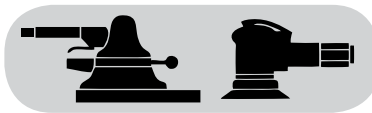
### Features

- P-graded, light brown, aluminum oxide abrasive
- C-weight backing
- Hook and loop fastening system
- Special, water-based stearate oversize and an open coat
- Vacuum holes

### Benefits

- Fast cut, long life
- Durable, high tear resistance
- Neat, clean application and removal
- Excellent load resistance
- Dust-free sanding environment

**Ideal for sanding paints, primers, plastics and fiberglass, as well as whitewood sanding, clean-up and repair.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 5 Hole Individual Vacuum Discs D-3328</b>				
05539563628	P80	C 0712 D0	50	200
05539563627	P120	C 0712 D0	50	200
05539563626	P150	C 0712 D0	50	200
05539563625	P180	C 0712 D0	50	200
05539563624	P220	C 0712 D0	50	200
05539563623*	P240	C 0712 D0	50	200*
<b>6" x 6 Hole Individual Vacuum Discs D-3371</b>				
05539563641*	P180	C 0712 D0	50	200*
05539563640*	P220	C 0712 D0	50	200*

\* Non-stock. Minimum order quantity is 2000. Ask your Carborundum representative for current lead times.

See back-up pads for these discs on page 26.

# Vacuum Grip-On Paper Discs

## Premier Red Zirconia Alumina Resin Paper Open Vacuum Grip-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight latex paper backing
- Hook and loop fastening system
- Vacuum holes

### Benefits

- Faster removal rates than aluminum oxide discs
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Greater flexibility
- Neat, clean application and removal
- Dust-free sanding environment

**Best choice for stripping paint and rust, as well as blending welds.**



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>8" x 8 Hole Individual Vacuum Discs D-3370</b>				
05539521325	40	E 1214 0	25	100
05539521324	80	E 1214 0	25	100

## Back-up Pads for Vacuum Grip-On Discs



20358, 20359

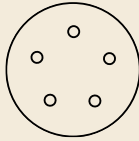
**Unique hook and loop fastening system for use with standard 5" and 6" vacuum hole patterns. These pads have a riveted 5/16"-24 threaded shank.**

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Grip-On Vacuum Discs</b>			
05539599314	5" x 5 Hole Low Profile - Medium	15,000	5*
05539599322	5" x 5 Hole Tapered - Medium	15,000	5*
05539599316	6" x 6 Hole Low Profile - Medium	15,000	5*
05539599324	6" x 6 Hole Tapered - Medium	15,000	5*

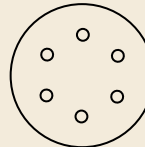
\* Packaged in Individual Clamshells

### Die Patterns

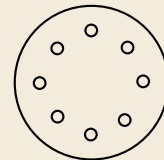
Die pattern numbers showing hole patterns on Vacuum Stick-On Discs.



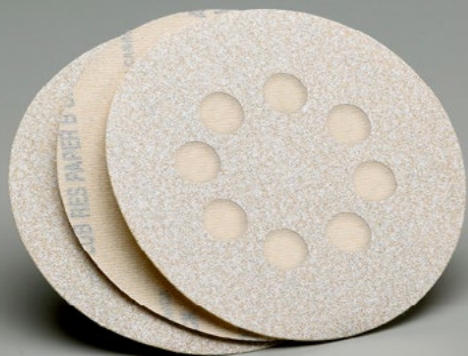
**DIE D-3328  
5" PAD WITH  
5 VACUUM HOLES**



**DIE D-3371  
6" PAD WITH  
6 VACUUM HOLES**



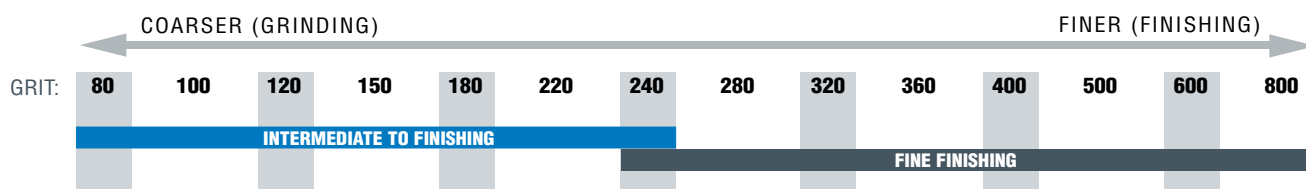
**DIE D-3370  
8" PAD WITH  
8 VACUUM HOLES**



For use on random orbital and rotary sanders.

<b>APPLICATIONS:</b>	Stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass and composites, and bare wood sanding
<b>SIZE RANGE:</b>	5" and 6"
<b>GRIT RANGE:</b>	80 – 400
<b>ABRASIVE GRAIN:</b>	Aluminum Oxide
<b>ATTACHMENT SYSTEMS:</b>	Hook and loop
<b>PAPER WEIGHTS:</b>	Lightweight – B

## APPLICATION/GRIT RECOMMENDATION GUIDE



### MERIT NO-LOAD PB273

GOOD CHOICE FOR SANDING PAINT, PRIMER, PLASTICS, FIBERGLASS, AND WHITEWOOD AT A LOW INITIAL PRICE

#### FEATURES


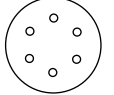
- P-graded, aluminum oxide abrasive
- Flexible latex B-wt. backing, with a full resin bond and open coat
- Water-based stearate, non-pigmented, anti-loading coating

#### BENEFITS

- Fast cutting action and extended life with consistent finish
- Improved resistance to delamination; no delamination to back-up pad
- Can be used moist or wet
- Provides improved load resistance
- No color transfer to work



TIER:	<b>GOOD</b>
BRAND:	Merit
CAP CODE:	<b>PB273 NO-LOAD</b>
ABRASIVE:	Aluminum Oxide
PAPER BACKING WEIGHT:	B-Weight
OTHER:	P-Graded

SIZE	GRIT	MIN./STD. PKG.	PART NO.	
5	80	100/400	 5 IN. X 8 HOLE DIE #3392	
	120			66623366071
	150			66623369778
	180			66623366073
	220			66623366074
	320			66623366075
6	80	100/400	 6 IN. X 6 HOLE DIE #3371	
	150			66623366077
	180			66623367394
	220			66623367397
	320			66623367398
	400			66623367399



# CleanAir Vacuum Grip-On Paper Discs

**NEW!**

## Carbo CleanAir Medalist Ceramic Alumina Dri-Lube Resin Paper Open Vacuum Grip-On

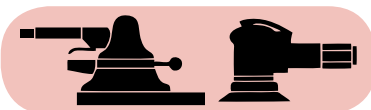
### Features

- Medalist patented ceramic alumina abrasive, P80 - P800
- Full resin bond system
- Unique fiber-reinforced, flexible B- and C-weight latex-saturated backing
- Special undyed stearate oversize
- Unique multi-hole pattern and matching hook and loop back-up pad

### Benefits

- Fastest cut rate even on hard-to-sand surfaces
- Extended life – up to 2:1 over conventional discs
- Broadest ceramic grit range available
- Improved grain adhesion and longest disc life
- 50% - 60% improvement in tear resistance, superior resistance to delamination
- Durable, yet flexible
- Superior load resistance and extended life
- No color transfer to work
- Enhanced dust extraction and reduced clogging
- Cleaner working environment
- Increases productivity by 35%

Combine the revolutionary maximum dust extraction Carbo CleanAir back-up pad with Carbo Medalist Dri-Lube Carbo CleanAir discs to optimize performance, increase productivity and eliminate dust.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 11/16" Individual CleanAir Vacuum Discs</b>				
05539599527	P80	C 2312 DO	50	200
05539599528	P120	C 2312 DO	50	200
05539599529	P150	B 2312 DO	50	200
05539599530	P180	B 2312 DO	50	200
05539599531	P220	B 2312 DO	50	200
05539599532	P240	B 2312 DO	50	200
05539599533	P320	B 2312 DO	50	200
05539599534	P400	B 2312 DO	50	200
05539599535	P500	B 2312 DO	50	200
05539599536	P600	B 2312 DO	50	200
05539599537	P800	B 2312 DO	50	200

**Note:** These discs must be used in conjunction with CleanAir back-up pads.

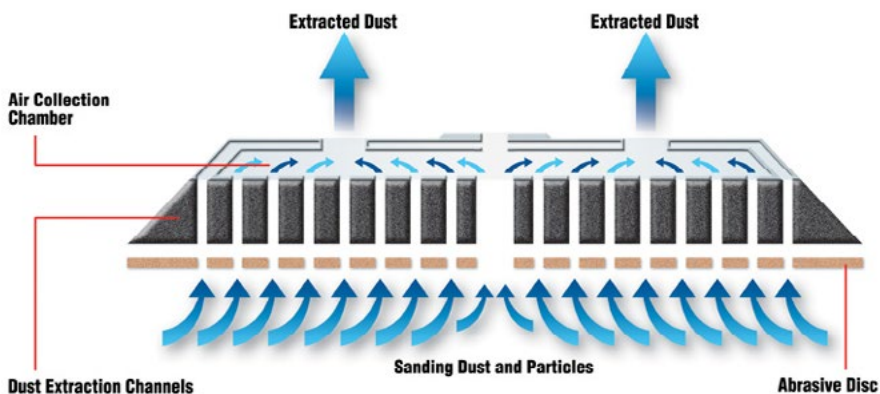
PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>6" x 11/16" Individual CleanAir Vacuum Discs</b>				
05539599538	P80	C 2312 DO	50	200
05539599539	P120	C 2312 DO	50	200
05539599540	P150	B 2312 DO	50	200
05539599541	P180	B 2312 DO	50	200
05539599542	P220	B 2312 DO	50	200
05539599543	P240	B 2312 DO	50	200
05539599544	P320	B 2312 DO	50	200
05539599545	P400	B 2312 DO	50	200
05539599546	P500	B 2312 DO	50	200
05539599547	P600	B 2312 DO	50	200
05539599548	P800	B 2312 DO	50	200

**Note:** These discs must be used in conjunction with CleanAir back-up pads.

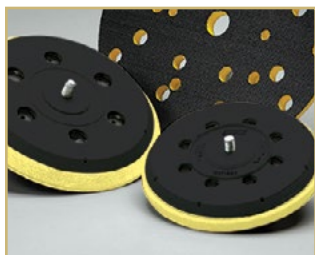
### Less Dust Means More Productivity

#### The Carbo CleanAir System

The overall abrasive area of a Carbo CleanAir disc is similar to that of vacuum discs with traditional 6 hole dust extraction. However, the complete coverage of 181 vacuum assist holes coupled with the Carbo CleanAir back-up pad creates a virtually dust-free sanding surface with no clogging and allows the abrasive grains to continually cut for the life of the disc. Increased productivity means more profit.



### Back-up Pads for Carbo CleanAir Discs



The medium pad is a durable, heat-resistant plastic with a molded-in 5/16"-24 spindle. The soft pad is packed with a Festo adapter, two threaded bolts: M8 and 5/16"-24 and three fiber ring spacers. Use soft pad on extreme contours using 320 grit and finer.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Carbo Clean-Air Discs</b>			
05539599358	6" Medium	12,000	1
05539599338	6" Soft	7,700	5*

\* Non-stock. Ask your Carborundum representative for current lead times.

## Medalist Aluminum Oxide Dri-Lube Finishing Film Open Grip-On

NEW!

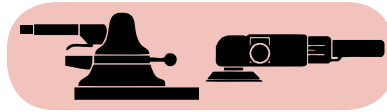
### Features

- Premium aluminum oxide grain
- Anti-loading agent
- Smooth backing

### Benefits

- Fast cut and long life
- Less downtime switching discs
- Eliminate pigtails and costly re-work
- Uniform finish that buffs out faster
- Completes the job faster
- Consistent finish that buffs out quickly and easily

Best choice for quickly removing imperfections from a flawless finish.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>3" x 0" Individual Discs</b>				
05539547310	P1000	P 0536 DO	50	200
05539547311	P1200	P 0536 DO	50	200
05539547312	P1500	P 0536 DO	50	200
<b>5" x 0" Individual Discs</b>				
05539547247*	P1000	P 0536 DO	50	200*
05539547248*	P1200	P 0536 DO	50	200*
05539547249*	P1500	P 0536 DO	50	200*
<b>6" x 0" Individual Discs</b>				
05539547283	P1000	P 0536 DO	50	200
05539547284	P1200	P 0536 DO	50	200
05539547285	P1500	P 0536 DO	50	200

\* Non-stock. Minimum order quantity is 2000.

Ask your Carborundum representative for current lead times.



# Glue-On Paper Discs

## Premier Red Zirconia Alumina Resin Paper Open

### Features

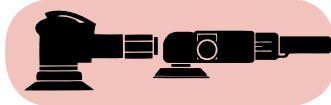
- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing

### Benefits

- Faster removal rates than aluminum oxide discs
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Greater flexibility

*Best choice for stripping paint and rust, as well as blending welds.*

*Use disc cement to apply these discs.*



PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
<b>6" x 0" Individual Discs</b>			
05539521330*	80 E 1214 O	50	200
<b>8" x 0" Individual Discs</b>			
05539521335	36 E 1214 O	25	100
05539521334	40 E 1214 O	25	100
05539521333	80 E 1214 O	25	100

\* Non-stock. Minimum order quantity for these items is 1000.

## Carbo Gold Aluminum Oxide Resin Paper Open

### Features

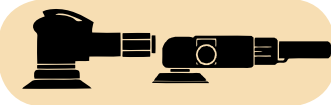
- P-graded, heat-treated aluminum oxide abrasive
- Resin bond and an open coat
- E-weight paper backing

### Benefits

- Fast, aggressive cut and long life
- Increased life, reduced loading and reduced edge wear
- Increased strength and durability

*Ideal for stripping all paints and rust, as well as blending welds.*

*Use disc cement to apply these discs.*



PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
<b>8" x 0" Individual Discs</b>			
05539512420	P40 E 0912 O	50	200
05539512419	P80 E 0912 O	50	200

## Disc Cement



### Disc Cement

*Pressure sensitive adhesive for attaching discs to back-up pads.*

PART NO.	GRADING	CAN/CASE
<b>Disc Cement</b>		
05539512010	16 oz. Can / 500 ml Can	12





## Aluminum Oxide Resin Cloth Stick-On

**NEW!**

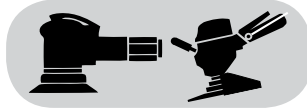
### Features

- Aluminum oxide abrasive
- Full resin bond system
- X-weight cotton backing
- PSA (pressure sensitive adhesive) backing
- NEW! white paper liner

### Benefits

- Tough and durable with aggressive cutting action
- Increased strength and durability
- Cool operating
- Easy application and removal
- Easy removal and disc application
- The Stick-On adhesive is protected from air-borne contaminants

*Designed for intermediate/light pressure, dry sanding. Ideal for dimensioning and finishing of contours on metal and all species of wood.*



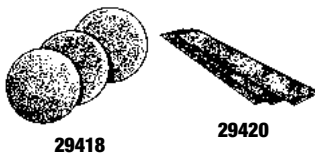
PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>5" x 0" Individual Discs</b>				
05539520765	36	XC 0877	50	50
05539520766	50	XC 0877	50	50
05539520767	80	XC 0877	50	50
<b>6" x 0" Individual Discs</b>				
05539520769	60	XC 0877	50	50
05539520770	80	XC 0877	50	50

## Back-up Pads and PSA Conversion Discs and Strips for Stick-On Discs



### Back-up Pads for Stick-On Discs

*Vinyl-faced pads for use with Stick-On discs or conventional discs using disc adhesive. 5" and 6" pads have a riveted 5/16"-24 threaded shank. 8" pads have a 5/8"-11 threaded female hub.*



### PSA Conversion Discs and Strips

*Permanent adhesive on textile hook backing allows for low cost conversion of Stick-On pads to Grip-On.*

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Stick-On Discs</b>			
05539599304	5" Low Profile - Soft	12,000	5*
05539599309	5" Low Profile - Medium	15,000	5*
05539599317	5" Tapered - Medium	15,000	5*
05539599305	6" Low Profile - Soft	12,000	5*
05539599311	6" Low Profile - Medium	15,000	5*
05539599319	6" Tapered - Medium	15,000	5*
05539512023	8" x 1/2" Tapered - Medium	4,800	1
<b>Stick-On to Grip-On Conversion Discs and Strips</b>			
05539529420	2-3/4" x 16-1/2"		20
05539529418	6"		20

\* Packaged in individual clamshells

## Disc Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	VSM
<b>CLOTH DISCS</b>					
XC 0877	241D, 251D, 261D, 248D	RB346MX	CS310X	-	KK511X

# Stick-On Cloth Discs



Merit ShurStik PSA (pressure sensitive adhesive) individual cloth discs are used on pneumatic die grinders for light to medium pressure grinding, blending, beveling and finishing applications.

- SIZE RANGE:** 1/2" – 4" diameter
- GRIT RANGE:** 24 – 320
- ABRASIVE GRAIN:** Aluminum Oxide
- BACK-UP PADS:** Rubber, with hardness variations for different applications

## Small Diameter Cloth Discs for Pneumatic Die Grinders



TIER:	<b>GOOD</b>						
BRAND:	Merit						
TRADENAME:	<b>SHURSTIK</b>						
ABRASIVE:	Aluminum Oxide						
ATTACHMENT:	PSA						

GRIT	1/2"	3/4"	1"	1-1/2"	2"	3"	4"
24	-	-				08834171173	08834171188
36	08834171100	08834171114	08834171129	08834171144	08834171159	08834171174	08834171189
40	08834171101	08834171115	08834171130	08834171145	08834171160	08834171175	08834171190
50	08834171102	08834171116	08834171131	08834171146	08834171161	08834171176	08834171191
60	08834171103	08834171117	08834171132	08834171147	08834171162	08834171177	08834171192
80	08834171104	08834171118	08834171133	08834171148	08834171163	08834171178	08834171193
100	08834171105	08834171119	08834171134	08834171149	08834171164	08834171179	08834171194
120	08834171106	08834171120	08834171135	08834171150	08834171165	08834171180	08834171195
150	08834171107	08834171121	08834171136	08834171151	08834171166	08834171181	08834171196
180	08834171108	08834171122	08834171137	08834171152	08834171167	08834171182	08834171197
240	08834171109	08834171123	08834171138	08834171153	08834171168	08834171183	08834171198
320	08834171110	08834171124	08834171139	08834171154	08834171169	08834171184	08834171199
<b>QTY./ BOX</b>	100	100	100	100	100	100	100
<b>BACK-UP PADS</b>	1/4" Shank	1/4" Shank	1/4" Shank	1/4" Shank	1/4" Shank	1/4" Shank	1/4" Shank
	15,000 RPM	15,000 RPM	15,000 RPM	15,000 RPM	12,000 RPM	10,000 RPM	6,000 RPM
	08834174096	08834174097	08834174098	08834174099	08834174100	08834174101	08834174102

COATED ABRASIVES



Tool-free, twist-on and -off fastening systems make fast work of disc changes to maximize productivity by minimizing downtime.

- APPLICATIONS:** Mini flap, fiber, and trimmable hard plastic discs: welding grinding and blending; heavy metal removal; light deburring and finishing  
Cloth discs: light- to medium-pressure grinding; blending, leveling and finishing applications; for use on contours or flat surfaces
- SIZE RANGE:** 9/16" – 4" diameter
- GRIT RANGE:** 24 – 320
- ABRASIVE GRAIN:** Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide
- BACKING:** Fiber or cloth
- CLOTH FLEX:** 3-ply (more aggressive), 2-ply (standard), or fx (more flexible) lamination
- ATTACHMENT:** Type TS (II), Type TR (III), and Type TP (I)
- BACK-UP PADS:** Rubber with hardness variations for different applications

## COATED ABRASIVE QUICK-CHANGE DISC AVAILABILITY



### Fiber

- The most heavy-duty discs with resin over resin construction on heavy-duty vulcanized fiber backing. Premium grain for applications from heavy stock removal to surface blending



### Mini Flap

- Layered flaps wear away evenly, producing an aggressive cutting action while also providing blending capabilities



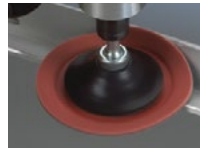
### Cloth 2-Ply

- Our standard 2-ply laminate construction creates an aggressive and durable cloth disc for flat surfaces



### Cloth Flexible (fx)

- A flexible, 2-ply cotton laminate construction for added conformability on contoured surfaces or any application where added flexibility is needed



### Cloth FlexEdge

- Manufactured with an abrasive cloth where the outer 3/8" is more flexible than the rest of the disc; designed to avoid gouging on contoured surfaces or soft materials

## QUICK-CHANGE ATTACHMENT SYSTEMS AND CROSS REFERENCE GUIDE

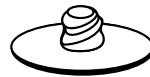
### Type TS (Type II)

- Features a turn-on/turn-off style fastener
- Fastener is made of metal
- Equivalent to Standard Abrasives' SocAtt® locking system



### Type TR (Type III)

- Features a roll-on/roll-off style fastener
- Fastener is made of plastic
- Equivalent to 3M™ Roloc™ fastening system



### Type TP (Type I)

- Snap-on/snap-off system which enables you to change discs quickly and safely, reducing downtime and operating expenses
- Fastener is made of nylon



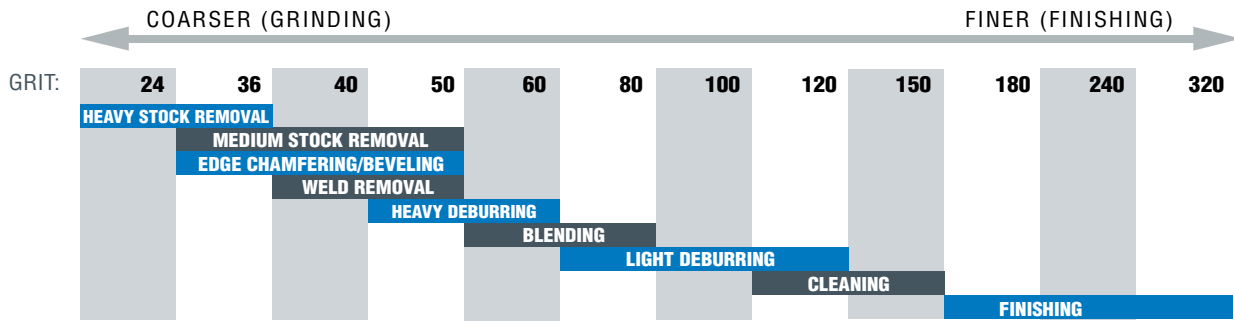
### MERIT

	Type II	Type III	Type I
<b>3M</b>	Roloc TS/TSM	Roloc TR	Roloc TP
<b>Standard</b>	TS (SocAtt)	TR (Lockit)	TP (ClickOn)
<b>Superior</b>	Type S	Type R	–
<b>Arc</b>	Type S	Type R	Type P
<b>Pferd</b>	Type CD	Type CDR	–
<b>Sait</b>	SAIT-LOK	SAIT-LOK-R	–
<b>Camel</b>	Turn On	Roll On	–
<b>Klingspor</b>	QMC	QRC	–
<b>Garryson</b>	Type S	Type R	–



# Quick-Change Discs

## APPLICATION/GRIT RECOMMENDATION GUIDE



## CROSS REFERENCE GUIDE

TOTAL PERFORMANCE ← → INITIAL PRICE

Abrasive	BEST		BETTER				GOOD		
	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide	Aluminum Oxide	Silicon Carbide
Backing	Full Ratio	Full Ratio	Fiber	Flap	Cloth	Cloth	Cloth	Cloth	Cloth
<b>MERIT</b>	Ceramic Plus	Ceramic Plus	Zirconia	Zirc	Zirc Plus	Zirc	ALO Plus	ALO	Silicon Carbide
<b>3M</b>	983C, 988C	963G, 977F, 785C, 777F	501C	-	-	-	-	361F	461F
<b>Standard</b>	-	Ceramic Pro, Ceramic	-	-	Zirconia Pro	Zirconia	A/O Extra, A/O Pro	A/O	Silicon Carbide
<b>Superior</b>	-	Ceramic G.A.	Zirc	-	Zirc w/ Grinding Aid	Premium Zirc	A/O w/ Grinding Aid	Premium A/O, Rigid Kut A/O	-
<b>Arc</b>	-	-	-	-	Zirconia/Y Plus	Zirconia/Y Standard	A/O/X Plus Coolant	A/O/Y Premium	-
<b>Pferd</b>	Ceramic Oxide CO	Ceramic Oxide CO	-	Zirconia Alumina Z	-	ZA Z	Aluminum Oxide A-Plus, Aluminum Oxide A-INOX-FORTE	Aluminum Oxide A, A/O A-FORTE	Silicon Carbide SiC
<b>Sait</b>	-	-	-	-	3Z, Z-H	Z	3A	2A-H, 2A	-
<b>Camel</b>	-	-	-	-	Zirconia AO w/ Grinding Aid	Zirconia AO	-	Aluminum Oxide	-
<b>Klingspor</b>	-	Ceramic	-	-	Alumina Zirconia-Lubricated	Alumina Zirconia	-	Aluminum Oxide	-
<b>Garryson</b>	-	Ceramic	-	-	Zirconia AO w/ Grinding Aid	-	-	Aluminum Oxide	-



## Merit Ceramic Plus Fiber Discs

- Ceramic alumina grain with self-lubricating supersize treatment, resin fiber discs resist heat build-up, cut aggressively, and are perfect for those applications that require a firm aggressive disc
- Heaviest fiber backing, greater durability, longest life, and edge-fray resistance on tough applications and stainless steel



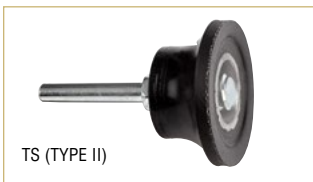
## Merit Zirconia Fiber Discs

- New, improved zirconia alumina provides a constant supply of sharp cutting edges for a fast, aggressive cutting action
- Heaviest fiber backing, greater durability, longer life, and edge fray resistance on tough applications and stainless steel

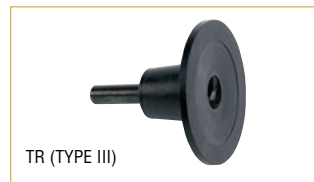


## Merit Mini Zirconia Flap Discs

- High performance zirconia alumina abrasive provides maximum cut rate and life
- Layered flaps wear away evenly, producing a high-quality and consistent finish



TS (TYPE II)



TR (TYPE III)

TIER:	<b>BEST</b>	<b>BEST</b>
BRAND:	Merit	Merit
ABRASIVE:	Ceramic Alumina	Ceramic Alumina
BACKING:	Fiber – Heavy Duty	Fiber – Heavy Duty
OTHER:	Supersized	Supersized
ATTACHMENT:	TS (Type II)	TR (Type III)



SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.
2	36	100	08834165611	08834166041
	50		08834165613	08834166043
	60		08834166226	08834166044
	80		08834166227	08834166045
	120		08834165616	08834166046
3	36	50	08834166035	08834166219
	50		08834166037	08834166220
	60		08834166038	08834166221
	80		08834166039	08834166222
	120		08834166040	08834166223

TIER:	<b>BETTER</b>	<b>BETTER</b>
BRAND:	Merit	Merit
ABRASIVE:	Zirconia Alumina	Zirconia Alumina
BACKING:	Fiber – Heavy Duty	Fiber – Heavy Duty
OTHER:	Supersized	Supersized
ATTACHMENT:	TS (Type II)	TR (Type III)



SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.
2	50	100	08834167802	08834167812
	60		08834167803	
3	50	50	08834167807	
	80		08834167809	

TIER:	<b>BEST</b>	<b>BEST</b>
BRAND:	Merit	Merit
ABRASIVE:	Zirconia Alumina	Zirconia Alumina
FLAP:	Cotton	Cotton
BACKING MATERIAL:	X-Heavy Duty Plastic	X-Heavy Duty Plastic
ATTACHMENT:	TS (Type II)	TR (Type III)



SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.
2	36	10	08834195020	08834194550
	40		08834195021	08834194551
	60		08834195022	08834194552
	80		08834195023	08834194553
	120		08834195024	08834194554
3	36	10	08834195035	08834194563
	40		08834195036	08834194564
	60		08834195037	08834194565
	80		08834195038	08834194566
	120		08834195039	08834194567

DESCRIPTION	STD. PKG.	PART NO.
Mini Flap Disc 2" & 3" TS (Type II) Back-up Pad	1	08834168539
Mini Flap Disc 2" & 3" TR (Type III) Back-up Pad	1	08834160172



## Merit Ceramic Plus Cloth Discs

- Ceramic alumina grain provides exceptional life and value, especially on hard-to-grind alloys
- The supersize grinding aid produces longer life and cooler cut
- Strong, Y-wt. 2-ply polyester backing provides excellent durability and grain adhesion

TIER:	<b>BEST</b>	<b>BEST</b>	<b>BEST</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
BACKING:	Polyester Standard	Polyester Standard	Polyester Standard
OTHER:	Supersized	Supersized	Supersized
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)



SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
9/16	36	100	08834163315		08834163000
	40		08834163316		
	50		08834163317		
	60		08834163318		08834163005
	80		08834163319		08834163014
	100		08834163434		08834163433
	120		08834163320		08834163017
3/4	36	100	08834163321	08834163392	08834163020
	40			08834163393	08834163021
	50		08834163324	08834163394	08834163022
	60		08834162239	08834163395	08834163023
	80		08834163339	08834163396	08834163024
	100		66254410755	08834163438	
	120		08834163362	08834163397	08834163027
1	36	100	08834163374	08834163398	08834163028
	40		08834163375	08834163400	08834163030
	50		08834163376	08834163401	
	60		08834162240	08834163402	08834163042
	80		08834163378	08834163403	08834163043
	100		08834163440	08834163441	08834163439
	120		08834163379	08834163404	08834163112
1-1/2	36	100	08834163421	08834163405	08834163113
	40			08834163406	08834163114
	50		08834163252	08834162620	08834163115
	60		08834160463	08834163407	08834163116
	80		08834163273	08834163408	08834163117
	100		08834163443	08834163444	08834163442
	120		08834168653	08834163409	08834168650
2	36	100	08834163118	08834160449	08834163119
	40				08834163120
	50		08834163259	08834163411	08834163121
	60		08834163551	08834163412	08834163231
	80		08834163381	08834165615	08834163219
	100			08834163447	
	120		08834163382	08834168657	08834168651
3	36	50	08834163383	08834160458	08834163238
	40	100		08834163413	08834163245
	50		08834163385	08834163414	08834168275
	60		08834163386	08834163415	08834163266
	80		08834163387	08834168178	08834169701
	100				08834163448
	120	08834168655	08834168658	08834168652	
4	36	50	08834162742	08834163416	08834163280
	40		08834163388	08834163417	
	50		08834162743	08834163418	
	60		08834163389	08834162992	08834163301
	80		08834163390	08834163419	
	100		08834163452	08834163453	08834163451
	120		08834163391	08834163420	08834163314





- Ideal product for demanding grinding applications
- Grinding aid results in cooler cut on stainless steel, titanium and other exotic alloys
- Strong, Y-wt., 2-ply polyester backing provides excellent durability and grain adhesion
- Lubricated supersize coat runs cooler

## Merit Zirconia Plus Cloth Discs

TIER:	<b>BETTER</b>	<b>BETTER</b>	<b>BETTER</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING:	Polyester Standard	Polyester Standard	Polyester Standard
OTHER:	Supersized	Supersized	Supersized
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
1	36	100		08834167093	08834167009
	40		08834167052	08834167094	08834167010
	50		08834167053	08834167095	08834167011
	60		08834167054	08834167096	08834167012
	80		08834167055	08834167097	08834167013
	120		08834167057	08834167099	08834167015
1-1/2	36	100	08834167058	08834167100	08834167016
	40		08834167059	08834167101	08834167017
	50		08834167060	08834167102	08834167018
	60		08834167061	08834167103	08834167019
	80		08834167062	08834167104	08834167020
	120		08834167064	08834167106	
2	36	100	08834167065	08834167107	08834167023
	40		08834167066	08834167108	
	50		08834165583	08834167109	08834167025
	60		08834167068	08834167110	08834167026
	80		08834167069	08834167111	08834167027
	120		08834167071	08834167113	08834167029
3	36	50	08834167072	08834167114	08834167030
	40		08834167073	08834167115	
	50		08834167074	08834167116	
	60		08834167075	08834167117	08834167033
	80		08834167076	08834167118	08834167034
	120		08834167078	08834167120	08834167036
4	36	50	08834167079		
	40		08834167080		
	50		08834167081		
	60		08834167082		08834167040
	80		08834167083		
	120		08834167085		08834167043



- Self-sharpening, zirconia alumina abrasive provides cooler cut, longer life
- Strong, Y-wt., 2-ply cotton backing construction for extended durability and reduced edge-wear

## Merit Zirconia Cloth Discs

TIER:	<b>BETTER</b>	<b>BETTER</b>	<b>BETTER</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING:	Cotton Standard	Cotton Standard	Cotton Standard
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
1	40	100	08834165327	08834164591	
	60		08834165329	08834164597	
	80		08834165330	08834164304	08834166132
1-1/2	36	100	08834165341	08834166263	08834161366
	40		08834165342	08834164598	
	50		08834165343		
	60		08834165344	08834164599	
	80		08834165345	08834161688	
2	36	100	08834165356	08834164208	08834166134
	40		08834165357	08834164600	
	50		08834165358	08834161534	
	60		08834165359	08834161116	08834166137
	80		08834165360	08834166198	08834166138
3	36	50	08834165371	08834166264	
	40		08834165372		08834166141
	50		08834165373	08834161535	08834166142
	60		08834165374	08834166259	08834166143
	80		08834165375	08834166269	08834166144



- Aluminum Oxide Plus discs feature a grinding aid
- They run cooler and more efficiently for grinding exotic alloys
- Strong, Y-wt., 2-ply polyester backing construction for extended durability and reduced edge-wear

## Merit Aluminum Oxide Plus Cloth Discs

TIER:	<b>GOOD</b>	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
BACKING:	Polyester Standard	Polyester Standard	Polyester Standard
OTHER:	Supersized	Supersized	Supersized
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
3/4	36	100	08834167462	08834164467	08834164345
	50		08834167464	08834164469	
	60		08834167465	08834164470	08834164349
	80		08834167466	08834164471	08834164350
	120		08834167468	08834164473	08834164361
1	36	100	08834167477	08834164475	08834164363
	40			08834164364	
	50		08834167479	08834164477	08834164365
	60		08834167480	08834164478	08834164366
	80		08834167481	08834164479	08834164368
	120		08834167483	08834164481	08834164370
1-1/2	36	100	08834166881	08834164483	08834164392
	40		08834166882	08834164484	08834164393
	50		08834166883		08834164394
	60		08834166884	08834164486	08834164395
	80		08834166885	08834164487	08834164396
	120		08834166887	08834164489	08834164398
2	36	100	08834166896	08834164491	08834164400
	40		08834166897	08834164492	08834164401
	50		08834166898	08834164493	08834164402
	60		08834166899	08834164494	08834164403
	80		08834166900	08834164495	08834164404
	120		08834166902	08834164496	08834164428
3	36	50	08834166911	08834164498	08834164430
	40		08834166912	08834164499	08834164431
	50		08834166913	08834164500	08834164432
	60		08834166914	08834164501	08834164433
	80		08834166915	08834164502	08834164434
	120		08834166917	08834164509	08834164436
4	36	50	08834163959	08834164511	08834164459
	40		08834163960	08834164525	08834164460
	50		08834163961		
	60		08834163962	08834164527	08834164462
	80		08834163963	08834164536	
	120		08834163965		

## Merit Metal Aluminum Oxide Cloth Discs



- Versatile aluminum oxide abrasive is tough and durable with aggressive cutting action
- Heavyweight, but smooth, cotton backing for roughing and blending
- Available in coarse grits for light to medium grinding, medium grits for blending, and fine finishing grits
- Competitive initial price point makes this product the best starting specification for end-users unable to measure performance




TIER:	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
BACKING:	Cotton Standard	Cotton Standard
ATTACHMENT:	TS (Type II)	TR (Type III)

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.
2	36	100	66254468890	66254469256
	40		66254468891	66254469257
	50		66254469251	66254469258
	60		66254469252	66254469259
	80		66254469253	66254469260
	100		66254469254	66254469261
3	120		66254469255	66254469262
	36	50	66254469263	66254469270
	40		66254469264	66254469271
	50		66254469265	66254469272
	60		66254469266	66254469273
	80		66254469267	66254469274
100	66254469268		66254469275	
120	66254469269	66254469276		



## Merit Silicon Carbide Cloth Discs

- Sharp, silicon carbide abrasive on X-wt. backing provides high initial cut and penetration for nonferrous materials

TIER:	<b>GOOD</b>	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Silicon Carbide	Silicon Carbide	Silicon Carbide
BACKING:	Cotton Standard	Cotton Standard	Cotton Standard
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)
			

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
2	40	100	08834165252	08834164275	08834162166
	60		08834165254	08834164163	08834162168
	80		08834165255	08834166155	08834162169
	120		08834165257	08834164837	08834162171
	180		08834165259	08834167313	08834162173
3	40	50	08834165267	08834164277	
	60		08834165269	08834164850	
	80		08834165270	08834166159	08834162188
	120		08834165272	08834166160	08834162190
	180		08834165274	08834168177	08834164971






## Merit Quick-Change Test Kit "D"

- Part No. 08834165001
- Includes 150 discs, assorted grits, in 1", 2", and 3" diameters and 3" back-up pads
- Primarily aluminum oxide cloth quick-change discs
- Several zirconia alumina and FlexEdge discs are included

# Quick-Change Discs



## Merit Aluminum Oxide Cloth Discs

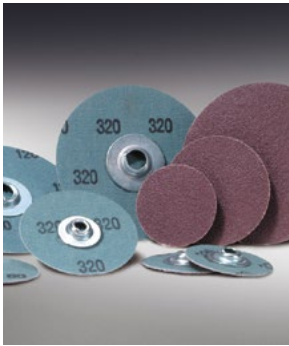
TIER:	<b>GOOD</b>	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
BACKING:	Polyester Standard	Polyester Standard	Polyester Standard
ATTACHMENT:	TS (Type II) 	TR (Type III) 	TP (Type I) 

- Premium abrasive and aluminum oxide blend for aggressive cut and longer life than competitive aluminum oxide discs
- Durable Y-wt. 2-ply polyester backing and new grain coating for longer life and faster cut rate on moderately-demanding applications
- Great for difficult-to-grind materials (aluminum, brass, bronze, stainless, carbon steel, and titanium) and applications requiring an economical option

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
3/4	24	100	69957399601	69957399669	69957399737
	36		69957399602	69957399670	69957399738
	40		69957399603	69957399671	69957399739
	50		69957399604	69957399672	69957399740
	60		69957399605	69957399673	69957399741
	80		69957399606	69957399674	69957399742
	100		69957399607	69957399675	69957399743
	120		69957399608	69957399676	69957399744
	150		69957399609	69957399677	69957399745
	180		69957399610	69957399678	69957399746
	240		69957399611	69957399679	69957399747
	320		69957399612	69957399680	69957399748
1	24	100	69957399613	69957399681	69957399749
	36		69957399614	69957399682	69957399750
	40		69957399615	69957399683	69957399751
	50		69957399616	69957399684	69957399752
	60		69957399617	69957399685	69957399753
	80		69957399618	69957399686	69957399754
	100		69957399619	69957399687	69957399755
	120		69957399620	69957399688	69957399756
	150		69957399621	69957399689	69957399757
	180		69957399622	69957399690	69957399758
	240		69957399623	69957399691	69957399759
	320		69957399624	69957399692	69957399760
1-1/2	24	100	69957399625	69957399693	69957399761
	36		69957399626	69957399694	69957399762
	40		69957399627	69957399695	69957399763
	50		69957399628	69957399696	69957399764
	60		69957399629	69957399697	69957399765
	80		69957399630	69957399698	69957399766
	100		69957399631	69957399699	69957399767
	120		69957399632	69957399700	69957399768
	150		69957399633	69957399701	69957399769
	180		69957399634	69957399702	69957399770
	240		69957399635	69957399703	69957399771
	320		69957399636	69957399704	69957399772
2	24	100	69957399637	69957399705	69957399773
	36		69957399638	69957399706	69957399774
	40		69957399639	69957399707	69957399775
	50		69957399640	69957399708	69957399776
	60		69957399641	69957399709	69957399777
	80		69957399642	69957399710	69957399778
	100		69957399643	69957399711	69957399779
	120		69957399644	69957399712	69957399780
	150		69957399645	69957399713	69957399781
	180		69957399646	69957399714	69957399782
	240		69957399647	69957399715	69957399783
	320		69957399648	69957399716	69957399784
3	24	50	69957399649	69957399717	69957399785
	36		69957399650	69957399718	69957399786
	40		69957399651	69957399719	69957399787
	50		69957399652	69957399720	69957399788
	60		69957399653	69957399721	69957399789
	80		69957399654	69957399722	69957399790
	100		69957399655	69957399723	69957399791
	120		69957399656	69957399724	69957399792
	150		69957399657	69957399725	69957399793
	180		69957399658	69957399726	69957399794
	240		69957399659	69957399727	69957399795
	320		69957399660	69957399728	69957399796
4	36	50	69957399661	69957399729	69957399797
	40		69957399662	69957399730	69957399798
	50		69957399663	69957399731	69957399799
	60		69957399664	69957399732	69957399800
	80		69957399665	69957399733	69957399801
	100		69957399666	69957399734	69957399802
	120		69957399667	69957399735	69957399803
	180		69957399668	69957399736	69957399804



## Merit Aluminum Oxide fx and FlexEdge Cloth Discs



### fx (conformable)

- These (flexible) aluminum oxide discs are designed for general purpose deburring and blending on contoured surfaces

### FlexEdge

- Manufactured with special flexible aluminum oxide abrasive cloth where the outer 3/8" is more flexible than the rest of the disc
- Designed for softer metals where standard (fx) discs can gouge and for contour grinding of structural pieces
- Used in aircraft and aerospace manufacturing for structural hand polishing
- When using back-up pads for FlexEdge discs, order (use) one size smaller than the disc

TIER:	<b>GOOD</b>	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit	Merit
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
BACKING:	Cotton Flexible (fx)	Cotton FlexEdge	Cotton FlexEdge
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)



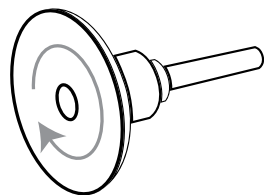
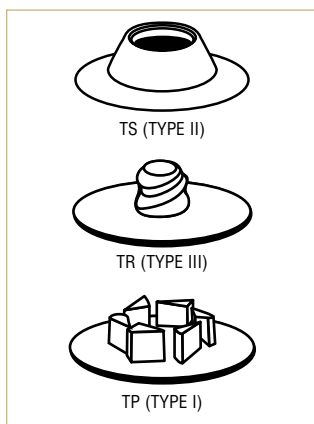
SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
1	24	100	08834168881		
	36		08834168479		
	40		08834168480		
	50		08834168481		
	60		08834168431	08834160394	08834164309
	80		08834168432	08834160395	08834164296
	100		08834168482	08834160396	08834164215
	120		08834168434	08834160397	
	150		08834168483		
	180		08834168484		
	240		08834168485		
	320		08834168486		
	1-1/2		24	100	08834168882
36		08834168487			
40		08834168488			
50		08834168489	08834163713		08834166375
60		08834168435	08834167333		
80		08834168436	08834160399		
100		08834168490	08834163714		
120		08834168437	08834160401		
150		08834168491			
180		08834168492	08834160402		08834164320
240		08834168493			
320		08834168494			
2		24	100		08834168883
	36	08834168495			
	40	08834168496			
	50	08834168497		08834163721	08834164333
	60	08834168438		08834160403	08834164334
	80	08834168439		08834160404	08834164335
	100	08834168498		08834166959	
	120	08834168440		08834167363	08834164337
	150	08834168499			
	180	08834168500		08834160405	08834164339
	240	08834168501			
	320	08834168502			
	3	24		50	08834168884
36		08834168503			
40		08834168504			
50		08834168505	08834163728		08834164352
60		08834168441	08834160406		08834164353
80		08834168442	08834161282		08834164354
100		08834168506	08834166974		08834164355
120		08834168443	08834163729		08834164356
150		08834168507			
180		08834168508	08834160407		08834164358
240		08834168509			
320		08834168510			
Back-up Pad for 3" FlexEdge Discs Max. RPM 30,000			1		08834168539

## TECHtip

Avoid gouging on contours by using a smaller size back-up pad than the diameter of the discs, such as 1-1/2" back-up pad for 2" discs. For 3" discs and larger, order the special FlexEdge back-up pad that is 2" in diameter but contains the cam lock fastener for 3" and larger discs.

# Quick-Change Discs

## Quick-Change Back-up Pads



- Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications
- Soft density pads are used for contours and fine finishing work

DIAMETER/RPM	DENSITY	TS (TYPE II)	TR (TYPE III)	TP (TYPE I)
<b>Quick-Change Back-up Pads</b>				
9/16 40,000 RPM		66261054014		66261054013
3/4 40,000 RPM	Medium	08834164206	08834164038	08834164001
1 40,000 RPM	Medium	08834164651	08834164037	08834164002
1-1/2 30,000 RPM	Hard	08834164622	08834164640	08834163996
	Medium	08834164146	08834161174	08834164003
2 30,000 RPM	Hard	08834164624	08834164643	08834163997
	Medium	08834164198	08834164922	08834164004
	Soft	08834161625	08834164641	08834163949
3 20,000 RPM	Hard	08834161626	08834164036	08834163998
	Medium	08834164113	08834164949	08834164005
	Soft	08834164626	08834164644	08834163948
4 15,000 RPM	Medium	08834164135	08834164655	08834164006

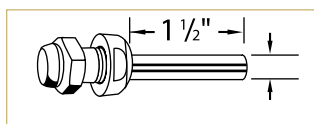
ALL QUICK-CHANGE BACK-UP PADS HAVE A 1/4" SOLID STEEL SHANK. STD. PKG. = 1

## Replacement Medium Density Rubber Pads for Quick-Change Back-up Pads

DIAMETER	MODEL NO.	TP (TYPE I)
<b>Quick-Change Replacement Rubber Back-up Pads</b>		
3/4	RR75	08834164008
1	RR10	08834164009
2	RR20	08834164011
3	RR30	08834164012
4	RR40	08834164013

WHEN THE RUBBER PAD HAS WORN AWAY, BUT THE STEEL COMPONENTS OF YOUR QUICK-CHANGE BACK-UP ARE STILL SERVICEABLE, ORDER THESE REPLACEMENT RUBBER PADS. STD. PKG. = 1

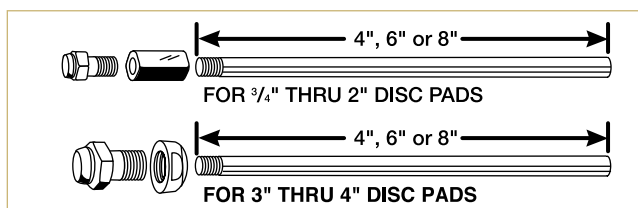
## Replacement Assemblies and Shanks for Quick-Change Back-up Pad



DESCRIPTION	STD. PKG.	PART NO.
<b>Replacement Mandrels and Nut Assembly</b>		
TP (Type I) Assembly RMN1 for 3/4 - 2	1	08834164015
TP (Type I) Assembly RMN3 for 3 - 4	1	08834164016
TS (Type II) & TR (Type III) Replacement 1/4" Shank	1	08834164303

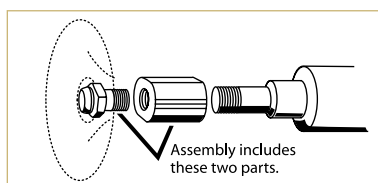
ASSEMBLIES REPLACE ALL THE STEEL COMPONENTS OF A QUICK-CHANGE BACK-UP PAD. THIS SHANK REPLACES THE SCREW-IN 1/4" SOLID STEEL SHANK ONLY.

## Extension Mandrels and Assembly



DIAMETER	MODEL NO.	LENGTH	STD. PKG.	PART NO.
<b>Extension Mandrels and Assembly – TP (Type I)</b>				
3/4 - 2	EMN-14	4"	1	08834164017
3/4 - 2	EMN-16	6"	1	08834164018
3/4 - 2	EMN-18	8"	1	08834164019
3 - 4	EMN-34	4"	1	08834164020
3 - 4	EMN-36	6"	1	08834164026
3 - 4	EMN-38	8"	1	08834164021

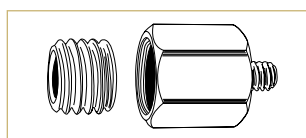
## MNA-1 Pad Adapters



DISC DIAMETER	MODEL NO.	STD. PKG.	PART NO.
<b>MNA-1 Pad Adapters – TP (Type I)</b>			
3/4 - 2	MNA 1/4-20 THD.	1	08834161176
3/4 - 2	MNA 3/8-24	1	08834164055
3/4 - 2	MNA 5/8-11	1	08834163001
3 - 4	MNA 1/4-20	1	08834163002
3 - 4	MNA 3/8-24	1	08834164041
3 - 4	MNA 5/8-11	1	08834164028

CONVERT A TP (TYPE I) BACK-UP PAD 1/4" DIAMETER SOLID SHANK TO A THREADED SHANK

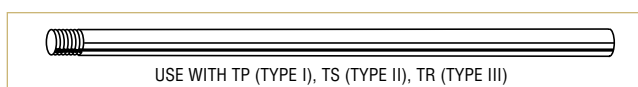
## MNA-23 Pad Adapters



DISC DIAMETER	MODEL NO.	STD. PKG.	PART NO.
<b>MNA-23 Pad Adapters – TS (Type II) and TR (type III)</b>			
3/4 - 4	MNA-23 3/8-24 5/8"-11 THD.	1	08834162764

FOR USE ON A RIGHT ANGLE GRINDER: CONVERT TS (TYPE II) AND TR (TYPE III) BACK-UP PAD 1/4" DIAMETER SOLID SHANKS TO THREADED SHANKS. THE LARGER 5/8-11 ADAPTER (FOR 4-1/2" DISCS) IS USED ALONE TO CONVERT TO A 5/8-11 THREAD. THE 3/8-24 INSERT (FOR 4" DISCS) IS SCREWED INTO THE 5/8-11 ADAPTER TO CREATE A 3/8-24 THREAD ADAPTER.

## 1/4" Diameter Extension Mandrel



MODEL NO.	LENGTH	STD. PKG.	PART NO.
<b>1/4" Diameter Extension Mandrel 1/4-20 Thread</b>			
EM-144	4	1	08834154185
EM-146	6	1	08834154186
EM-148	8	1	08834154187

## Medalist Ceramic Alumina Resin Fiber

**NEW!**

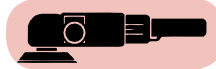
### Features

- Ceramic alumina abrasive
- Resin bond
- Heavy fiber backing

### Benefits

- Sharper, cooler cutting abrasive continually exposing sharp points
- Fast cut rate with long life
- Increased strength, durability and grain adhesion
- Strength and tear resistance

*The choice for all fiber disc grinding applications requiring aggressive cutting action, cool cut and long life. For hardest-to-grind materials.*



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>4-1/2" x 7/8" Individual Discs</b>				
05539549358	24	V 2548	25	25
05539549359	36	V 2548	25	25
05539549360	50	V 2548	25	25
<b>5" x 7/8" Individual Discs</b>				
05539599432	24	V 2548	25	25
05539599433	36	V 2548	25	25
05539599434	50	V 2548	25	25
<b>7" x 7/8" Individual Discs</b>				
05539599435	24	V 2548	25	25
05539599436	36	V 2548	25	25
05539599437	50	V 2548	25	25

## Premier Red Zirconia Alumina Resin Fiber

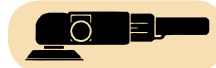
### Features

- Premium ceramic and high-performance zirconia alumina abrasive blend
- Resin bond
- Heavy fiber backing

### Benefits

- Longer life, especially on hard-to-grind materials
- Tough, aggressive yet cool cutting and self sharpening
- Increased strength, durability and grain adhesion
- Strength and tear resistance

*Ideal for heavy-duty grinding of welds, gates, risers and parting lines on castings and carbon steels. The best choice for stainless steel and other hard-to-grind materials.*



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>4-1/2" x 7/8" Individual Discs</b>				
05539520088	24	V 1247	25	25
05539520087	36	V 1247	25	25
05539520086	50	V 1247	25	25
05539520034	60	V 1247	25	25
05539520019	80	V 1247	25	25
<b>5" x 7/8" Individual Discs</b>				
05539510713	24	V 1247	25	25
05539510712	36	V 1247	25	25
05539510711	50	V 1247	25	25
05539520069	60	V 1247	25	25
05539520055	80	V 1247	25	25
<b>7" x 7/8" Individual Discs</b>				
05539510722	24	V 1247	25	25
05539510721	36	V 1247	25	25
05539510720	50	V 1247	25	25
05539520077	60	V 1247	25	25
05539520076	80	V 1247	25	25

See back-up pads for fiber discs on page 44.

## Fiber Disc Competitive Cross Reference

CARBORUNDUM	3M	GEMTEX	HERMES	VSM	KLINGSPOR
V 2548	983C, 984C, 988C	CERAMIX	CB444X, CB444J	ZF713, SF750, SF840	-
V 1247	501C, 785C	-	RB414X, CB444J, CB444X	KF715	CS565, CS566

## Back-up Pads for Resin Fiber Discs

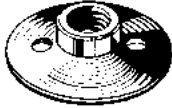


62582, 12032, 12033

For all-purpose fiber disc sanding. Curved ribs on pad face reduce loading and allow for cooler cut. All pads have a threaded 5/8"-11 female hub.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for Resin Fiber Discs</b>			
05539562582	4-1/2" Medium Air-Cooled	11,000	1
05539512033	5" Medium Air-Cooled	10,000	1
05539512032	7" Medium Air-Cooled	8,600	1

## Pad Nut for Resin Fiber Discs



12568

Used to secure resin fiber discs to back-up pad.

PART NO.	DESCRIPTION	PAD NUTS/CASE
<b>Pad Nut for Resin Fiber Discs</b>		
05539512568	5/8"-11	1



## Spec Check

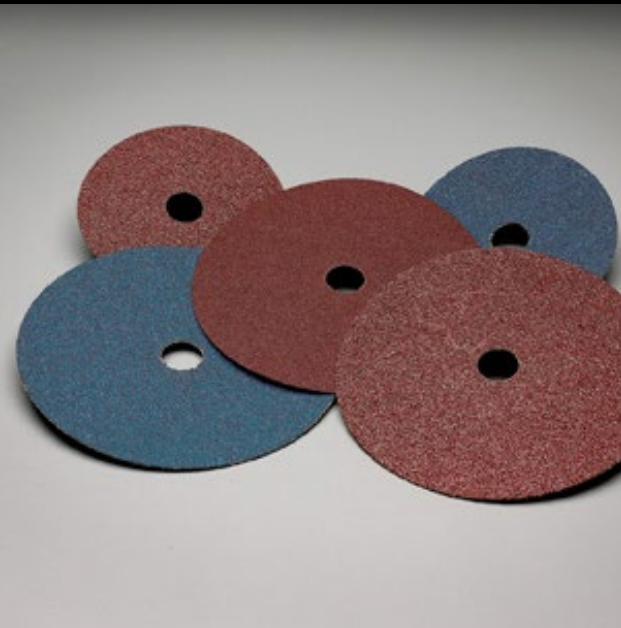
### STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	HEAVY-DUTY	
	BEST PERFORMANCE	GENERAL-DUTY
CARBON STEEL	V 2548	V 1247
STAINLESS STEEL/ALLOYS	V 2548, V 1247	-
CAST IRON	V 2548	V 1247
BRASS/BRONZE	V 1247	
ALUMINUM	V 1247	
FIBERGLASS	V 2548	V 1247
PAINT REMOVAL AND CLEAN-UP	V 1247	

### RECOMMENDED GRIT SELECTION

ROUGH/HEAVY-DUTY	INTERMEDIATE	FINISHING
16-50	50-80	80-120





The most heavy-duty of coated abrasive discs with resin over resin construction on heavy-duty vulcanized fiber backing. Designed for applications ranging from heavy stock removal to surface blending. Used with back-up pads on portable right angle grinders.

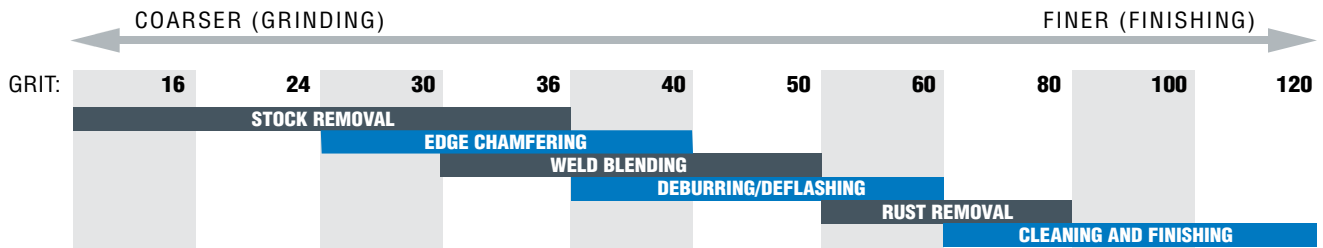
- APPLICATIONS:** Stock removal, edge chamfering, weld blending, deburring/deflashing, rust removal, cleaning and finishing
- SIZE RANGE:** 4" x 5/8" hole, 4-1/2" – 9-1/8" x 7/8" hole
- GRIT RANGE:** 16 – 120
- ABRASIVE GRAIN:** Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

## MATERIAL-TO-PRODUCT RECOMMENDATION GUIDE

	<b>BEST</b> Highest Productivity – Lowest Total Cost	<b>BETTER</b> Excellent Blend of Performance & Price	<b>GOOD</b> Consistent Performance – Low Initial Price
Stainless Steel / Titanium / Super Alloys*	Merit Ceramic Alumina	Merit Zirconia Alumina	Merit Metal A/O
Mild Carbon Steel / Welds	Merit Ceramic Alumina	Merit Zirconia Alumina	Merit Metal A/O
Ferrous Metals / Cast Iron	Merit Ceramic Alumina	Merit Zirconia Alumina	Merit Metal A/O
Brass / Bronze / Aluminum	–	Merit Zirconia Alumina	Merit Metal A/O

\*NICKEL/COBALT BASED – HASTELLOY, INCONEL, WASSPALLOY

## APPLICATION/GRIT RECOMMENDATION GUIDE



# Resin Fiber Discs

## Merit Fiber Discs



TIER:

BRAND:

TRADENAME:

ABRASIVE:

**BETTER**

Merit

**CERAMIC**

Ceramic Alumina

**BETTER**

Merit

**ZA**

Zirconia Alumina

**GOOD**

Merit

**METAL**

Aluminum Oxide

SIZE (D x H)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.
4 x 5/8	24	25			05539510595
	36				05539510594
	50				05539510593
	60				05539510592
	80				05539510591
4-1/2 x 7/8	24	25	66623355601	66623353315	66623353309
	36		66623355602	66623353316	66623353306
	50		66623355603	66623353318	66623353310
	60		66623355604	66623353319	66623353311
	80		66623365598	66623353320	66623353312
	100				66623353313
	120				66623353314
5 x 7/8	16	25			05539510684
	24		66623355597	66623357290	66623357276
	36		66623355598	66623357291	66623357277
	50		66623355599	66623357292	66623357278
	60		66623355600	66623357293	66623357279
	80		66623366015	66623357294	66623357280
	100				66623357281
120			66623357282		
7 x 7/8	16	25			05539510693
	24		66623355578	66623357295	66623357283
	36		66623355594	66623357296	66623357284
	50		66623355595	66623357297	66623357285
	60		66623355596	66623357298	66623357286
	80		66623365600	66623357299	66623357287
	100				66623357288
120			66623357289		
9-1/8 x 7/8	24	25	05539510782		05539510702
	36		05539510749		05539510701
	50		05539510748		
	60				05539510699
	120				05539510695

NOTE: FIBER DISCS MUST ALWAYS BE USED WITH BACK-UP PADS.

### Fiber Disc Back-up Pads

DESCRIPTION	MAX. RPM	STD. PKG.	PART NO.
<b>Back-up Pads for Fiber Discs</b>			
4-1/2" Carbo Medium	11,000	1	05539562582
4-1/2" Merit Spiral Cool	11,000	1	08834195006
5" Carbo Medium	10,000	1	05539512033
5" Merit Spiral Cool	10,000	1	08834195002
7" Carbo Medium	7,000	1	05539512032
7" Merit Spiral Cool	8,500	1	08834195003

# E-ZView Edger Flex-Loc Fiber Discs

## Premier Red Zirconia Alumina Resin Fiber

### Features

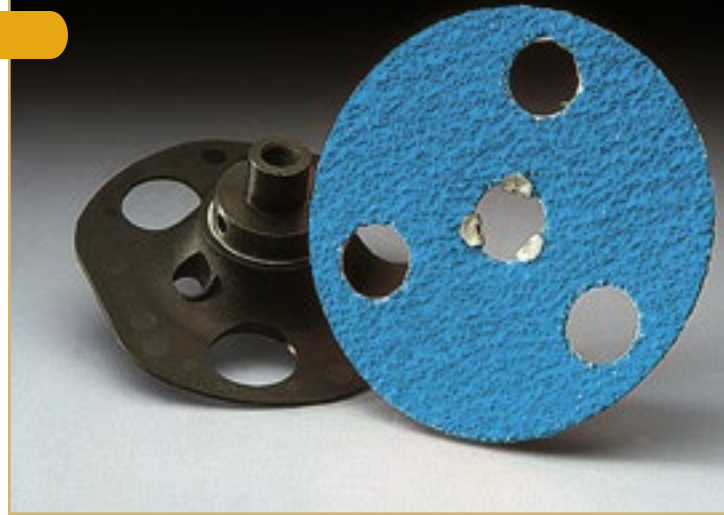
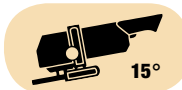
- High performance zirconia alumina abrasive blend
- Resin bond
- Heavy fiber backing
- Round edge shape
- Scooped holes
- Flex-Loc mount

### Benefits

- Long life, especially on hard-to-grind materials
- Ultra tough, aggressive, yet cool cutting, and self sharpening
- Increased strength, durability and grain adhesion
- Strength and tear resistance
- Ideal for reaching into grooves, sharp edges, and hard-to-grind corners where work is done at a steeper angle
- Create air flow to remove swarf – preventing loading – and a 30% cooler cutting action than conventional discs
- Quick, tool-free changing of discs

*Ideal for heavy duty grinding of welds, gates, risers and parting lines on castings and carbon steels. The best choice for stainless steel.*

*Strategically placed holes allow the operator to see the surface area being ground while the disc is spinning, enabling faster and more accurate work, and a superior finish.*



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
<b>4-1/2" E-ZView Edger Flex-Loc Fiber Individual Discs</b>				
05539563969	24	V 1247	10	40
05539563970	36	V 1247	10	40
05539563971	50	V 1247	10	40
<b>5" E-ZView Edger Flex-Loc Fiber Individual Discs</b>				
05539562966	24	V 1247	10	40
05539562967	36	V 1247	10	40
05539562968	50	V 1247	10	40
05539562969	60	V 1247	10	40
05539562970	80	V 1247	10	40
<b>7" E-ZView Edger Flex-Loc Fiber Individual Discs</b>				
05539563828	36	V 1247	10	40

## Back-up Pads for E-ZView Edger Flex-Loc Discs



63975, 63019, 63395



63836

*Designed exclusively for use with E-ZView Edger Flex-Loc Discs. These back-up pads allow easy, tool-free mounting. The mounting hole and recessed lock-nut automatically line disc up with back-up pad and allow more disc to contact work surface.*

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for E-ZView Edger Flex-Loc Discs</b>			
05539563975	4-1/2 x 5/8"-11 Sawtooth	13,000	5
05539563019	5 x 5/8"-11 Sawtooth	13,000	5
05539563395	5 x 7/16"-20 Pistol Grip Sawtooth	20,000	5
05539563836	7 x 5/8"-11 Round Medium, Thicker	8,600	5

## Say Goodbye to Guesswork. Put Your Surface in Easy View.

E-ZView is our patented abrasive product for portable right angle grinders. Strategically positioned holes allow the operator to see the surface area being ground, while the disc is spinning. Being able to see the surface while grinding enables an operator to reduce gouging, work faster and more accurately, and produce a superior finish.



# Flap Discs

## Premier Red Zirconia Alumina Resin Cloth

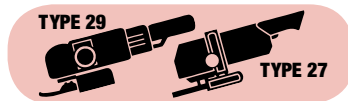
### Features

- Grind and finish at the same time
- Fit same type grinder as resin fiber disc and depressed center wheel
- Type 29 – angled flaps, conical, slightly concaved design
- Increased area of contact
- Type 27 – flat face
- Type 27 Plastic – flat face, plastic back
- High performance blend of ceramic and zirconia abrasives
- Type 27, 27FB, Type 29, and 29FB
- Quality, zirconia alumina abrasive on durable cloth
- Phenolic resin back plate
- Fat Boy – thicker with more flaps
- Fat Boy Type 27
- Fat Boy Type 29
- Available with 5-8"-11 nut

### Benefits

- No switching from depressed center wheel to resin fiber disc
- Eliminates need for special tools
- Built-in angle for grinding minimizes workpiece gouging
- Aggressive action, high stock removal rates; durable
- Ideal for flat surfaces
- Excellent on soft metals; increased versatility
- Best choice when speed is the main consideration
- More forgiving than Type 29
- Ideal for finishing intricate parts
- Plastic back wears away with abrasives for longer life
- Requires less pressure to work at maximum performance
- More forgiving than Type 29 – producing smooth finishes
- High rate of stock removal
- As cloth wears, new sharp grains are exposed
- Will not smear the work piece
- Wears uniformly with flaps
- Up to 40% longer life than standard flap discs
- Produces a smooth finish on shapes and irregular surfaces
- Aggressive action, high stock removal rates
- Ideal when added performance and longer life are required
- Less down time for disc changes

*Ideal for metal grinding and polishing, especially for weld bead grinding on fine carbon and stainless steel.*



PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
<b>4-1/2" x 5/8"-11 Nut – Type 27</b>				
05539564060	36 XC 1176	13,000	5	5
05539564061	40 XC 1176	13,000	5	5
05539564062	60 XC 1176	13,000	5	5
05539564063	80 XC 1176	13,000	5	5

*continued*



PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
<b>4-1/2" x 7/8" – Type 27</b>				
05539563741	36 XC 1176	13,000	5	5
05539563742	40 XC 1176	13,000	5	5
05539563743	60 XC 1176	13,000	5	5
05539563744	80 XC 1176	13,000	5	5
05539563745	120 XC 1176	13,000	5	5
<b>7" x 5/8"-11 Nut – Type 27</b>				
05539564056	36 XC 1176	8,600	5	5
05539564057	40 XC 1176	8,600	5	5
05539564058	60 XC 1176	8,600	5	5
<b>7" x 7/8" – Type 27</b>				
05539563746	36 XC 1176	8,600	5	5
05539563747	40 XC 1176	8,600	5	5
05539563748	60 XC 1176	8,600	5	5
<b>4-1/2" x 5/8"-11 – Type 27 Plastic <span style="float: right;">NEW!</span></b>				
66623326212	40 XC 1176	13,000	10	10
66623326217	60 XC 1176	13,000	10	10
66623326218	80 XC 1176	13,000	10	10
<b>4-1/2" x 7/8" – Type 27 Plastic</b>				
05539567811	40 XC 1176	13,000	10	10
05539567812	60 XC 1176	13,000	10	10
05539567813	80 XC 1176	13,000	10	10
<b>5" x 5/8"-11 – Type 27 Plastic <span style="float: right;">NEW!</span></b>				
66623326219	40 XC 1176	12,000	10	10
66623326220	60 XC 1176	12,000	10	10
66623326221	80 XC 1176	12,000	10	10

*continued*

## Two Basic Flap Discs Designs

### TYPE 27 FLAT – THE CHOICE FOR THE BEST FINISH

- The Type 27 flap discs have a flat design and are used primarily on flat surfaces
- The best choice for smooth finishing
- Also available in Fat Boy sizes with extra large flaps lasting up to 40% longer than standard flap discs



### TYPE 29 CONICAL – THE MOST AGGRESSIVE CHOICE

- Conical flap discs have flaps angled at 10° and may be used on both conical and flat surfaces
- The angle provides greater surface contact and, as a result, tends to be the most aggressive choice
- Also available in Fat Boy sizes with extra large flaps lasting up to 40% longer than standard flap discs
- The best choice when speed and stock removal are primary considerations





## Premier Red Zirconia Alumina Resin Cloth (cont'd)

PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
<b>5" x 7/8" – Type 27 Plastic</b>				
05539570054	40 XC 1176	12,000	10	10
05539570055	60 XC 1176	12,000	10	10
05539570056	80 XC 1176	12,000	10	10
<b>7" x 5/8"-11 – Type 27 Plastic</b>				
66623326222	40 XC 1176	8,600	10	10
66623326223	60 XC 1176	8,600	10	10
66623326233	80 XC 1176	8,600	10	10
<b>7" x 7/8" – Type 27 Plastic</b>				
05539570057	40 XC 1176	8,600	10	10
05539570058	60 XC 1176	8,600	10	10
05539570059	80 XC 1176	8,600	10	10
<b>4-1/2 x 5/8"-11 Nut – Type 27 Fat Boy</b>				
66261068838	40 XC 1176	12,000	5	5
66261068846	60 XC 1176	12,000	5	5
66261068848	80 XC 1176	12,000	5	5
<b>4-1/2" x 7/8" – Type 27 Fat Boy</b>				
05539563929	40 XC 1176	12,000	5	5
05539563930	60 XC 1176	12,000	5	5
05539563931	80 XC 1176	12,000	5	5
<b>7" x 5/8"-11 Nut – Type 27 Fat Boy</b>				
05539570542	40 XC 1176	8,600	5	5
05539570544	80 XC 1176	8,600	5	5
<b>4" x 5/8" – Type 29</b>				
05539518617	36 XC 1176	15,000	5	5
05539518616	40 XC 1176	15,000	5	5
05539518615	60 XC 1176	15,000	5	5
05539518613	80 XC 1176	15,000	5	5
05539518610	120 XC 1176	15,000	5	5
<b>4-1/2" x 5/8"-11 Nut – Type 29</b>				
05539520348	36 XC 1176	13,000	5	5
05539520347	40 XC 1176	13,000	5	5
05539520346	60 XC 1176	13,000	5	5
05539520345	80 XC 1176	13,000	5	5
<b>4-1/2" x 7/8" – Type 29</b>				
05539518624	24 XC 1176	13,000	5	5
05539518623	36 XC 1176	13,000	5	5
05539518622	40 XC 1176	13,000	5	5
05539518621	60 XC 1176	13,000	5	5
05539518620	80 XC 1176	13,000	5	5
05539518619	120 XC 1176	13,000	5	5

**NEW!**

PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
<b>5" x 7/8" – Type 29</b>				
05539518629	36 XC 1176	12,000	5	5
05539518628	40 XC 1176	12,000	5	5
05539518627	60 XC 1176	12,000	5	5
05539518626	80 XC 1176	12,000	5	5
<b>7" x 5/8"-11 Nut – Type 29</b>				
05539518642	24 XC 1176	8,600	5	5
05539518641	36 XC 1176	8,600	5	5
05539518640	40 XC 1176	8,600	5	5
05539518639	60 XC 1176	8,600	5	5
05539518638	80 XC 1176	8,600	5	5
<b>7" x 7/8" – Type 29</b>				
05539518635	36 XC 1176	8,600	5	5
05539518634	40 XC 1176	8,600	5	5
05539518633	60 XC 1176	8,600	5	5
05539518632	80 XC 1176	8,600	5	5
05539518631	120 XC 1176	8,600	5	5
<b>4-1/2" x 5/8"-11 Nut – Type 29 Fat Boy</b>				
05539570539	40 XC 1176	12,000	5	5
05539570540	60 XC 1176	12,000	5	5
05539570541	80 XC 1176	12,000	5	5



### TechTip

- Use one grit size coarser than fiber discs, except in 36 grit.
- Operate Type 29 (regular and Fat Boy) flap discs at a 15° – 25° angle; operate Type 27 (Regular, Plastic and Fat Boy) flap discs at an angle less than 15°; more severe angles will weaken flap edges.



It is the user's responsibility to refer to and comply with ANSI B7.7

COATED ABRASIVES

## Spec Check

### STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	HEAVY DUTY	FINE FINISHES
CARBON AND STAINLESS STEEL AND OTHER TOUGH APPLICATIONS	XC 1176 – TYPE 29	XC 1176 – TYPE 27 PLASTIC
OTHER FERROUS AND NON-FERROUS MATERIALS	XC 1176 – TYPE 29	XC 1176 – TYPE 27

## Flap Disc Competitive Cross Reference

CARBORUNDUM	DEWALT	GARRYSON	GEMTEX	KLINGSPOR	PFERD	SAIT	3M	WALTER	WEILER
XC 1176 PLASTIC	–	ZIRC+	–	–	–	–	747D REGALITE	ENDUROFLEX	–
XC 1176	ZIRC	ZIRC	ZIRC	SMT626	POLIFAN	SAITLAM F ZH	563D	QUICK STEP	TIGER, BIG CAT

# Flap Discs



Flap discs are versatile grinding and finishing tools, consisting of three main components: a backing plate, adhesive, and abrasive cloth flaps. The rectangular flaps are overlapped and glued to the backing plate. Flap discs are designed for right angle grinder applications ranging from heavy stock removal to surface blending.

<b>APPLICATIONS:</b>	Grinding, stock removal, edge chamfering/beveling, weld blending, deburring/deflashing, rust removal, blending, cleaning and finishing 4-1/2" - 7": 5/8"-11 discard mount and 7/8" hole
<b>GRIT RANGE:</b>	24 - 120
<b>ABRASIVE GRAIN:</b>	Zirconia Alumina, Silicon Carbide
<b>ABRASIVE FLAPS:</b>	Polyester or cotton
<b>FLAP DISC SHAPE:</b>	Type 27 Flat and Type 29 Conical
<b>ABRASIVE FLAP DENSITY:</b>	Standard or high
<b>BACKING PLATE MATERIAL:</b>	Fiberglass

## FLAP DISC SHAPES



GRIND AT FLATTER ANGLES:  
0° - 15°

### Type 27 Flat – The Best Choice for Finishing

- Used primarily on flat surfaces
- The best choice for blending and smooth finishing



GRIND AT STEEPER ANGLES:  
15° - 25°

### Type 29 Conical – The Best Choice for Aggressive Stock Removal

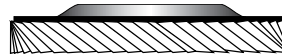
- Conical flap discs have angled flaps and may be used on both contoured and edge work
- The angle provides greater surface contact for stock removal on flat surfaces
- The best choice when speed and stock removal are primary considerations

## ABRASIVE FLAP DENSITIES



### Standard Density

- Excellent for heavy-duty applications and rapid stock removal

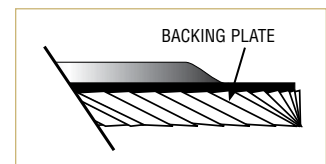


### High Density

- Ideal when working on uneven or curved surfaces, as well as finer grit blending

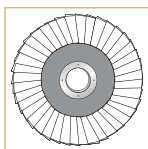
## BACKING PLATE MATERIALS

All flap discs are a combination of abrasive flaps adhered to a rigid backing plate. It is the backing plate that provides stability during operation. There are two main materials used: fiberglass and plastic. The fiberglass backing plate, along with the flap shape, helps to absorb vibration and is consumed during use with no smearing. Fiberglass is the most popular material because of its high strength and light weight.



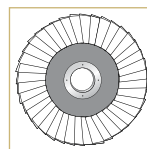
## WHY CHOOSE FLAP DISCS?

Flap discs replace both grinding wheels and fiber discs. The same flap disc can be used for applications ranging from stock removal to blending.



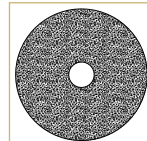
### Flap Discs vs. Grinding Wheels

- Faster stock removal
- Smoother finish, no gouging
- Cooler cutting, less glazing
- Lightweight, easier to control
- Less vibration, less operator fatigue
- Reduced noise

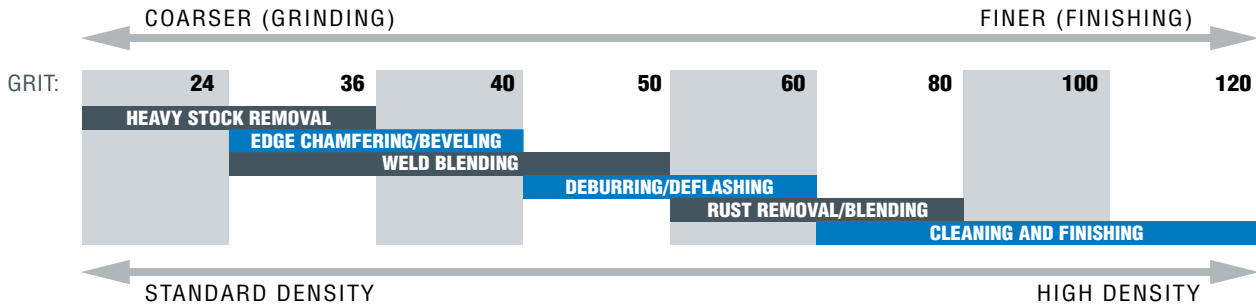


### Flap Discs vs. Fiber Discs

- 20X longer life, reduced abrasive cost
- Fewer disc changes, reduced labor cost
- More consistent finish
- No back-up pad required
- Easier storage, no curling
- Reduced loading
- Use flap discs one grit size coarser than fiber discs, except in 36 grit.



## APPLICATION/GRIT RECOMMENDATION GUIDE



TIER:	GOOD	GOOD	GOOD	GOOD
BRAND:	Merit	Merit	Merit	Merit
TRADENAME:	METAL	METAL	ZIRCONIA	SILICON CARBIDE
SHAPE:	Type 27 Flat	Type 29 Conical	Type 29 Conical	Type 29 Conical
FLAP DENSITY:	Standard	Standard	High	Standard
ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Silicon Carbide
BACKING PLATE:	Fiberglass	Fiberglass	Fiberglass	Fiberglass

SIZE (D x H)	GRIT	MAX. RPM*	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
4-1/2 x 5/8-11	36	13,300	10	66254472655	66254419991	08834194447*	
	40			66254437013	66254419994	08834193906*	
	60			66254472656	66254419996	66261044504*	66254460664
	80			66254472657	66254419997	66261044505*	08834196277
	120					66261044506*	08834196275
4-1/2 x 7/8	24	13,300	10			08834194833*	
	36			66254472653	66254419963	08834191427*	
	40			66254437004	66254419978	08834190726*	
	60			66254448989	66254419984	08834190175*	66254460663
	80			66254448990	66254419987	08834190924*	08834195676
5 x 7/8	36	12,000	10	66254472659	66254419998		
	40			66254472660	66254420001		
	60			66254472661	66254420002	08834190876	66254460694
	80			66254472662	66254420003	08834190405	66254460463
	120					08834192209	66254460464
6 x 5/8-11	40	10,200	10	66254491773	66254491779		
	60			66254491774	66254491780		
	80			66254491775	66254491781		
6 x 7/8	40	10,200	10	66254491770	66254491776		
	60			66254491771	66254491777		
	80			66254491772	66254491778		
7 x 5/8-11	36	8,600	10	66254472669	66254420009	08834193830	
	40			66254472670	66254420010	66261044540	
	60			66254472671	66254420012	08834199751	66254460666
	80			66254472672	66254420013	08834192896	08834197186
7 x 7/8	120					66261044541	08834197187
	24	8,600	10			08834190877	
	36			66254472664	66254420004	08834190878	
	40			66254472665	66254420006	08834192059	
	60			66254472666	66254420007	08834196985	66254460665
	80			66254472667	66254420008	08834196986	08834195705
120					08834196988	66254460462	

\* MAX RPM FOR MERIT ZIRCONIA HIGH DENSITY FLAP DISCS IS 13,000

# Cloth Rolls

## Aluminum Oxide Resin Cloth

### Features

- P-graded, brown aluminum oxide abrasive
- Advanced full resin bond system
- JCF 0852: orange J-weight backing with increased flexibility
- Dispenser boxed

### Benefits

- Tough and durable
- Exceptional grain adhesion for longer life
- Superior conformability to complex surfaces and better finishes
- Convenience; cut or tear to length

**Ideal for cleaning and deburring metal surfaces. May be used dry or with oil.**



PART NO.	GRADING	ROLLS/PKG.	ROLLS/CASE
<b>1" x 10 Yards – Handy Rolls</b>			
05539529317	P80 JCF 0852	1	5
05539529316	P100 JCF 0852	1	5
05539529315	P120 JCF 0852	1	5
05539529314	P150 JCF 0852	1	5
05539529313	P180 JCF 0852	1	5
05539529312	P240 JCF 0852	1	5
05539529311	P320 JCF 0852	1	5
<b>1" x 50 Yards – Economy Rolls</b>			
05539510141	P60 XC 0851	1	5
05539529328	P80 JCF 0852	1	5
05539529327	P100 JCF 0852	1	5
05539529326	P120 JCF 0852	1	5
05539529325	P150 JCF 0852	1	5
05539529324	P180 JCF 0852	1	5
05539529323	P220 JCF 0852	1	5
05539529322	P240 JCF 0852	1	5
05539529321	P280 JCF 0852	1	5
05539529320	P320 JCF 0852	1	5
05539529319	P400 JCF 0852	1	5
05539529318	P600 JCF 0852	1	5
<b>1-1/2" x 50 Yards – Economy Rolls</b>			
05539510945	P50 XC 0851	1	5
05539510947	P60 XC 0851	1	5
05539529339	P80 JCF 0852	1	5
05539529338	P100 JCF 0852	1	5
05539529337	P120 JCF 0852	1	5
05539529336	P150 JCF 0852	1	5
05539529335	P180 JCF 0852	1	5
05539529334	P220 JCF 0852	1	5
05539529333	P240 JCF 0852	1	5
05539529332	P280 JCF 0852	1	5
05539529331	P320 JCF 0852	1	5
05539529330	P400 JCF 0852	1	5
05539529329	P600 JCF 0852	1	5



PART NO.	GRADING	ROLLS/PKG.	ROLLS/CASE
<b>2" x 50 Yards – Economy Rolls</b>			
05539510585	P40 XC 0851	1	5
05539511102	P50 XC 0851	1	5
05539510340	P60 XC 0851	1	5
05539529350	P80 JCF 0852	1	5
05539529349	P100 JCF 0852	1	5
05539529348	P120 JCF 0852	1	5
05539529347	P150 JCF 0852	1	5
05539529346	P180 JCF 0852	1	5
05539529345	P220 JCF 0852	1	5
05539529344	P240 JCF 0852	1	5
05539529343	P280 JCF 0852	1	5
05539529342	P320 JCF 0852	1	5
05539529341	P400 JCF 0852	1	5
05539529340	P600 JCF 0852	1	5



### TechTip

Use light machine oil with cloth rolls as a lubricant for finer finishes and quicker cut.



It is the user's responsibility to refer to and comply with ANSI B7.7

## FastTrack Roll Service

### Product Availability

- XC 0877 Aluminum Oxide Resin Cloth, 36-240, 320
- JCF 0852 Aluminum Oxide Resin Cloth P80-P320, P400, P600

### Quantity Availability

WIDTH	MINIMUM QUANTITY	MAXIMUM QUANTITY
2" to 9"	5 rolls	10 rolls
9" to 11"	4 rolls	8 rolls
11" to 12"	3 rolls	6 rolls

Length = 50 yards for all FastTrack Rolls

### Conversion Time

- 5 days

### Size Availability

- Widths: 2" – 12"
- Lengths: 50 yards

### Ordering is Easy!

- Call your distributor for FastTrack roll guidelines.
- Include a full description of roll required, including: size, specification, grit size and quantity





**NEW!**

## Medalist Ceramic Alumina Dri-Lube Resin Paper Open Grip-On

### Features

- Medalist patented ceramic alumina abrasive, P80 - P600
- Full resin bond system
- Unique fiber-reinforced, flexible B- and C-weight latex-saturated backing
- Special undyed stearate oversize
- Hook and loop fastening system

### Benefits

- Fastest cut rate even on hard-to-sand surfaces
- Extended life – up to 2:1 over conventional discs
- Broadest ceramic grit range available
- Improved grain adhesion and longest disc life
- 50% - 60% improvement in tear resistance, superior resistance to delamination
- Durable, yet flexible
- Superior load resistance
- No color transfer to work
- Neat, clean application and removal
- Can be re-used

*Best choice for paints, primers, plastics, fiberglass, wood and sealer sanding.*



PART NO.	GRADING		ROLLS/PKG.	ROLLS/CASE
<b>2-3/4" x 13 Yards</b>				
05539599570	P80	C 2312 DO	1	4
05539599568	P120	C 2312 DO	1	4
05539599567	P150	B 2312 DO	1	4
05539599566	P180	B 2312 DO	1	4
05539599565	P220	B 2312 DO	1	4
05539599564	P320	B 2312 DO	1	4
05539599590	P400	B 2312 DO	1	4
05539599591	P500	B 2312 DO	1	4
05539599592	P600	B 2312 DO	1	4

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Stick-On

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- PSA (pressure sensitive adhesive) backing
- Special, undyed stearate oversize and an open coat

### Benefits

- Consistent scratch pattern and finish
- Improved grain adhesion and longest life
- 50% - 60% improvement in tear strength, superior resistance to delamination
- Easy application and removal
- Superior load resistance
- No color transfer to work

*Best choice for paints, primers, plastics, fiberglass, wood and sealer sanding.*



PART NO.	GRADING		ROLLS/PKG.	ROLLS/CASE
<b>2-3/4" x 45 Yards</b>				
05539520337	P150	B 0912 DO	1	5
05539520336	P180	B 0912 DO	1	5
05539520335	P220	B 0912 DO	1	5
05539520334	P240	B 0912 DO	1	5
05539520333	P320	B 0912 DO	1	5
05539520332	P400	B 0912 DO	1	5
77696043558*	P600	B 0912 DO	1	5*

\* Non-stock. Minimum order quantity is 15 rolls. Ask your Carborundum representative for current lead times.

### 4-1/2" x 10 Yards

05539561116	P80	B 0912 DO	1	5
05539561115*	P100	B 0912 DO	1	5*
05539561114	P120	B 0912 DO	1	5
05539561113	P150	B 0912 DO	1	5
05539561112	P180	B 0912 DO	1	5
05539561111	P220	B 0912 DO	1	5

\* Non-stock. Minimum order quantity is 10 rolls. Ask your Carborundum representative for current lead times.

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Stick-On

### Features

- Premium, P-graded, light brown aluminum oxide abrasive
- Durable, C-weight backing
- PSA (pressure sensitive adhesive) backing
- Special, water-based stearate oversize and an open coat

### Benefits

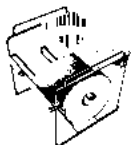
- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance

*Ideal for sanding paints, primers, plastics and fiberglass as well as whitewood sanding, clean-up and repair.*



PART NO.	GRADING		ROLLS/PKG.	ROLLS/CASE
<b>2-3/4" x 20 Yards</b>				
05539570528	P80	C 0712 DO	1	5
<b>2-3/4" x 25 Yards</b>				
05539570527	P150	C 0712 DO	1	5
05539570526	P180	C 0712 DO	1	5
05539570525	P220	C 0712 DO	1	5
05539570524	P320	C 0712 DO	1	5
05539570523	P400	C 0712 DO	1	5

## Dispenser for Stick-On Rolls



*This portable Stick-On roll dispenser is a convenient way to unwind the rolls and tear to the desired length. It can be used with all 2-3/4" PSA Stick-On rolls.*

PART NO.	DESCRIPTION	PRODUCT/CASE
05539520523	Stick-On Roll Dispenser	1

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Ultra fine grit P1000, P1200, and P1500
- Full resin bond system
- Unique fiber-reinforced, B-weight, latex-saturated backing
- Special, undyed stearate oversize and an open coat

### Benefits

- Consistent finish without a deep scratch
- Excellent cut rate and total cut, while minimizing loading = maximum life
- Creates fine finishes
- Improved grain adhesion and longest life
- 50% – 60% improvement in tear strength, superior resistance to delamination
- Flexible; can be used wet
- Superior load resistance and extended life
- No color transfer to work

*Ultimate choice for machine and hand sanding of paints, primers, light metals and basecoat/clearcoat paints.*



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>			
05539520538	P80 B 0912 DO	50	250
05539520537	P100 B 0912 DO	100	500
05539520536	P120 B 0912 DO	100	500
05539520535	P150 B 0912 DO	100	500
05539520534	P180 B 0912 DO	100	500
05539520533	P220 B 0912 DO	100	500

*continued*

PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
<b>9" x 11" (continued)</b>			
05539520532	P240 B 0912 DO	100	500
05539520531	P280 B 0912 DO	100	500
05539520530	P320 B 0912 DO	100	500
05539520529	P400 B 0912 DO	100	500
05539563785	P500 B 0912 DO	100	500
05539520528	P600 B 0912 DO	100	500
05539514148	P800 B 0712 DO	100	500
05539520527	P1000 B 0712 DO	100	500
05539520526	P1200 B 0712 DO	100	500

## Silicon Carbide Dri-Lube Paper Open

**NEW!**

### Features

- Silicon carbide abrasive
- Heavy B-weight latex-saturated paper
- Stearate oversize

### Benefits

- Sharp cut, excellent finish
- Increased flexibility and tear strength
- Improved load resistance

*For hand and machine sanding paint and primer, as well as whitewood clean-up and sealer sanding.*



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>			
05539510819	80 B 0412 DO	50	250
05539510818	100 B 0412 DO	100	500
05539510817	120 B 0412 DO	100	500
05539510816	150 B 0412 DO	100	500
05539510815	180 B 0412 DO	100	500
05539510814	220 B 0412 DO	100	500
05539510813	240 B 0412 DO	100	500
05539510812	280 B 0412 DO	100	500
05539510810	320 B 0412 DO	100	500
05539510808	400 B 0412 DO	100	500

## Paper Sheet Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	SIA	VSM
A 0311 O	110N	-	-	-	-	-
A 0811 O	210N, 210U	HFB	PL31	-	-	-
BF 0415 W	401Q	WSFLEX18B	PS11	WATERPROOF (A)	-	CP918A
BF 0416 W	413Q	WSFLEX18B	PS11	WATERPROOF (A)	-	CP918A
B 0412 DO	414N, 415N, 415U, 426U	PSF-LL, SA168	PL35	CARATFLEX, FINEFLEX	1748	CP131A
B 0912 DO, B 0712 DO	214U, 216U, 334U, 734U	HC133, HCAB	PS33	ROYAL, ROYAL MICRO	1950 SIASPEED	-
BF 0916 W, BF 0716 W	213Q	-	PS12	-	-	-
C 0210	041N	-	-	-	-	-
C 0311 O	130N	GCAB	-	-	-	-
C 0414 W	438Q, 431Q	WSFLEX18C	PS11	-	-	CP918C
C 0811 O	230N	HFB	PL31	-	-	KP31B
D 0311 O	140N	GCAB	-	-	-	-
D 0811 O	230U, 240N, 346U	-	-	-	-	KP31C

## Premier Red Mirror Finish Aluminum Oxide Waterproof Paper

### Features

- Premium, P-graded, heat-treated aluminum oxide abrasive
- Strong, resin bond system
- B-weight, high-latex, waterproof paper backing

### Benefits

- Ultimate cut and life in wet applications
- Long life in wet applications
- Ultimate flexibility
- Wet-curl resistance
- Environmentally stable; resists humidity-caused curling

*Ideal for removing surface imperfections in acrylic lacquers, enamels, urethanes and clearcoats. Use wet for best results.*



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539563888	P220	BF 0916 W	5	250
05539563887	P240	BF 0916 W	5	250
05539563885	P320	BF 0916 W	5	250
05539563884	P400	BF 0916 W	5	250
05539563883	P500	BF 0916 W	5	250
05539563882	P600	BF 0916 W	5	250
05539563881	P800	BF 0716 W	5	250

## Premier Red Mirror Finish Silicon Carbide Waterproof Paper

**NEW!**

### Features

- Premium, ultra fine (1000-2000 grits), silicon carbide abrasive
- Full resin bond
- B-weight waterproof paper backing

### Benefits

- Ultimate finish in wet applications
- Higher cut rate and improved life
- Longer life in wet applications
- Ultimate flexibility
- Much improved wet-curl resistance
- Environmentally stable; resists humidity-caused curling

*Ideal for producing very fine finishes in wet applications.*



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539563880	1000	BF 0415 W	50	250
05539563879	1200	BF 0415 W	50	250
05539563878	1500	BF 0415 W	50	250
05539563877	2000	BF 0415 W	50	250

## Silicon Carbide Waterproof Paper

### Features

- Sharp, strong silicon carbide abrasive
- Full resin bond
- B-weight waterproof paper backing

### Benefits

- Exceptional finishes in wet applications
- Longer life in wet applications
- Extremely flexible
- Improved wet-curl resistance
- Environmentally stable; resists humidity-caused curling

*Exceptional finishing in wet applications.*



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539563866	220	BF 0416 W	50	250
05539563865	240	BF 0416 W	50	250
05539563864	280	BF 0416 W	50	250
05539563863	320	BF 0416 W	50	250
05539563862	360	BF 0416 W	50	250
05539563861	400	BF 0416 W	50	250
05539563860	500	BF 0416 W	50	250
05539563859	600	BF 0416 W	50	250

## Silicon Carbide Waterproof Paper

### Features

- Silicon carbide abrasive
- Resin bond
- Waterproof paper backing

### Benefits

- Ideal for finish sanding
- Excellent grain adhesion
- Strength and resistance to deterioration when used wet

*May be used wet or dry on plastic or painted surfaces. Best results are obtained when used wet. Excellent for machine and hand rubbing of lacquer, urethane and varathane between coats. Ideal for obtaining fine finishes and feather-edging painted surfaces.*



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539510798	60	C 0414 W	50	250
05539510797	80	C 0414 W	50	250
05539510796	100	C 0414 W	50	250
05539510795	120	C 0414 W	50	250
05539510794	150	C 0414 W	50	250
05539510793	180	C 0414 W	50	250

## Aluminum Oxide Paper Open

### Features

- P-graded, aluminum oxide abrasive

*Ideal for general-duty dry sanding of paint, primers, light metals and woods.*

### Benefits

- Tough and durable



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>3-2/3" x 9"</b>				
05539510881	P80	D 0811 O	100	1000
05539510880	P100	C 0811 O	100	1000
05539510879*	P120	C 0811 O	100	1000
05539510878*	P150	C 0811 O	100	1000*
05539510412*	P220	A 0811 O	100	1000*

PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539510876	P36	D 0811 O	25	125
05539510874	P50	D 0811 O	50	250
05539510873	P60	D 0811 O	50	250
05539510872	P80	D 0811 O	50	250
05539510871	P100	C 0811 O	100	500
05539510870	P120	C 0811 O	100	500
05539510868	P150	C 0811 O	100	500
05539510862	P180	A 0811 O	100	500
05539510861	P220	A 0811 O	100	500
05539510859*	P320	A 0811 O	100	500*

*\*Non-stock. Minimum order quantity is 2000.*

*Ask your Carborundum representative for current lead times.*

## Garnet Paper Open

### Features

- Natural garnet abrasive
- Unique bond system

*For hand and machine sanding of whitewood.*

### Benefits

- Sharp and consistent cutting action
- Durable



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539510854*	50	D 0311 O	50	250*
05539510853	60	C 0311 O	50	250
05539510852	80	C 0311 O	50	250
05539510851	100	C 0311 O	100	500
05539510850	120	C 0311 O	100	500
05539510849	150	C 0311 O	100	500
05539510848	80	A 0311 O	50	250
05539510847	100	A 0311 O	100	500
05539510846	120	A 0311 O	100	500
05539510845	150	A 0311 O	100	500
05539510844	180	A 0311 O	100	500
05539510843	220	A 0311 O	100	500
05539510842	240	A 0311 O	100	500
05539510841*	280	A 0311 O	100	500*

*\*Non-stock. Minimum order quantity is 1000.*

*Ask your Carborundum representative for current lead times.*

## Spec Check

### PAPER SHEET STARTING RECOMMENDATIONS BY MATERIAL/APPLICATION

MATERIAL	BEST PERFORMANCE	GENERAL DUTY
UNFINISHED METAL	B 0912 DO / B 0712 DO	D 0811 O, C 0811 O, A 0811 O
PRIMED AND PAINTED SURFACES	B 0912 DO / B 0712 DO	D 0811 O, C 0811 O, A 0811 O
FIBERGLASS / COMPOSITES	B 0912 DO / B 0712 DO	
BARE WOOD	B 0912 DO / B 0712 DO,	A 0311 O, C 0311 O, D 0311 O, D 0811 O, C 0811 O, A 0811 O
CLEAR AND COAT SANDING	BF 0415 W	
SEALER SANDING	B 0912 DO / B 0712 DO,	B 0412 DO
LACQUER SANDING	BF 0415 W, BF 0416 W	C 0414 W, B 0912 DO / B 0712 DO, BF 0916 W
WET SANDING	BF 0415 W, BF 0416 W	C 0414 W, B 0912 DO / B 0712 DO, BF 0916 W
PAINT STRIPPING	B 0912 DO / B 0712 DO	-
DRYWALL SANDING	M 0405 W	-
FINE METAL POLISHING	C 0210	-





## Emery Cloth

### Features

- Natural emery abrasive
- Flexible, cotton backing

### Benefits

- Soft by nature, for light abrading and sanding
- Follows shapes and contours

Used for removing light burrs and cleaning and polishing metals. May be used dry or with oil.



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539510887	Coarse	JC 0250	25	125
05539510886	Medium	JC 0250	50	250
05539510885	Fine	JC 0250	50	250

## Aluminum Oxide Resin Cloth

### Features

- P-graded, aluminum oxide abrasive
- Advanced full resin bond system
- JCF 0852: orange, J-weight backing with increased flexibility

### Benefits

- Tough and durable
- Exceptional grain adhesion for long life
- Superior conformability to complex surfaces and better finishes

Ideal for hand sanding, deburring, polishing and removing cutting tool marks on all metal parts.



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539510988	P40	XC 0851	25	125
05539511103	P50	XC 0851	25	125
05539511143	P60	XC 0851	25	125
05539529361	P80	JCF 0852	25	125
05539529360	P100	JCF 0852	50	250
05539529359	P120	JCF 0852	50	250
05539529358	P150	JCF 0852	50	250
05539529357	P180	JCF 0852	50	250
05539529356	P220	JCF 0852	50	250
05539529355	P240	JCF 0852	50	250
05539529354	P280	JCF 0852	50	250
05539529353	P320	JCF 0852	50	250
05539529352	P400	JCF 0852	50	250
05539563813	P500	JCF 0851	50	250
05539529351	P600	JCF 0852	50	250

## Silicon Carbide Waterproof Sandscreen

### Features

- Black, silicon carbide abrasive
- P-graded in 220 and coarser grits
- Full resin bond system
- Screen backing

### Benefits

- Very sharp and hard, but brittle
- Provides consistent finishes
- Maximum grain adhesion
- Load resistant
- Both sides are usable

Ideally suited for floorsanding, drywall, ceramics and wet deck sanding. May be used wet or dry.



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
<b>9" x 11"</b>				
05539512316	P80	M 0405 W	25	125
05539512315	P100	M 0405 W	25	125
05539512314	P120	M 0405 W	25	125
05539512313	P150	M 0405 W	25	125
05539512312	P180	M 0405 W	25	125
05539512310	P220	M 0405 W	25	125
05539512308	320	M 0405 W	25	125
05539512307	400	M 0405 W	25	125



## Spec Check

### CLOTH SHEET STARTING RECOMMENDATIONS

CUT RATE	FINISH	SPEC
WATERPROOF	LOAD RESISTANT	M 0405 W
FAST CUT	GENERAL FINISH	JCF 0852
SLOW CUT	FINE FINISH	JC 0250

## TechTip

Use light machine oil with cloth sheets as a lubricant for finer finishes and quicker cut.



It is the user's responsibility to refer to and comply with ANSI B7.7

## Cloth Sheet Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	SIA	VSM
JC 0250	011K CRYSTAL BAY		KL371	C680J	-
XC 0851	311T THREE-M-ITE BG, 211K ELECTROCUT	RB317LX	CS310X	-	KK504X
JCF 0852	211K THREE-M-ITE, 311K THREE-M-ITE	RB232J	KL361	2947J	KK504J KK504X
M 0405 W	481W	-	-	-	-

# Stick-On Marine File Strips

## Premier Red Zirconia Alumina Resin Paper Open Stick-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing
- PSA (pressure sensitive adhesive) backing

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Flexible
- Easy application and removal

**Best choice for blending and shaping all types of marine fillers.**



PART NO.	GRADING	STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16-1/2"</b>			
05539521338	36 E 1214 O	50	250
05539521337	40 E 1214 O	50	250
05539521336	80 E 1214 O	50	250

For use with File Board #05539512013 on page 62.



## Carbo Gold Aluminum Oxide Resin Paper Open Stick-On

### Features

- P-graded, heat-treated aluminum oxide abrasive
- Resin bond
- E-weight paper backing
- PSA backing

### Benefits

- Fast, aggressive cut with extended life
- Long life
- Resists loading and edge wear
- Strength and durability
- Easy application and removal

**Ideal for blending and shaping all types of marine fillers.**



PART NO.	GRADING	STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16-1/2"</b>			
05539512431	P36 E 0912 O	50	500
05539512430	P40 E 0912 O	50	500
05539512429	P80 E 0912 O	50	500

For use with File Board #05539512013 on page 61.

## Premier Red Zirconia Alumina Resin Paper Open Vacuum Stick-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing
- PSA backing
- Vacuum holes

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Flexible
- Easy application and removal
- Dust-free sanding environment

**Best choice for blending and shaping all types of marine fillers.**



PART NO.	GRADING	STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16" Vacuum D-3364</b>			
05539521339	80 E 1214 O	50	250

## Premier Red Zirconia Alumina Resin Paper Open Grip-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing
- Hook and loop fastening system

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Flexible
- Easy application and removal
- Can be re-used

**Best choice for blending and shaping all types of marine fillers.**



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16-1/2"</b>				
05539521344	36	E 1214 O	25	125
05539521343	40	E 1214 O	25	125
05539521342	80	E 1214 O	25	125

**For use with File Board 05539512014 and File Shoe 05539512015 on page 61.**

## Carbo Gold Aluminum Oxide Resin Paper Open Grip-On

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Resin bond
- E-weight paper backing
- Hook and loop fastening system

### Benefits

- Fast, aggressive cut with extended life
- Long life
- Resists loading and edge wear
- Durable
- Neat, clean application and removal
- Can be re-used

**Ideal for blending and shaping all types of marine fillers.**



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16-1/2"</b>				
05539520243	P40	E 0912 O	50	250
05539520242	P80	E 0912 O	50	250

**For use with File Board 05539512014 and File Shoe 05539512015 on page 61.**

## Premier Red Aluminum Oxide Dri-Lube Resin Paper Open Grip-On

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Full resin bond system
- Unique, fiber-reinforced, B-weight paper backing
- Hook and loop fastening system
- Special, undyed stearate oversize and an open coat

### Benefits

- 30% to 50% faster cut rate than other strips
- Consistent scratch pattern and finish
- Improved grain adhesion; longest life
- 50% – 60% improvement in tear strength
- Superior resistance to delamination
- Neat, clean application and removal
- Can be re-used
- Superior load resistance
- No color transfer to work

**Blending all paints, primers, plastics and fiberglass.**



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16-1/2"</b>				
05539520475	P80	B 0912 D0	50	500
05539520474	P100	B 0912 D0	50	500
05539520473	P120	B 0912 D0	50	500
05539520472	P150	B 0912 D0	50	500
05539520471	P180	B 0912 D0	50	500
05539520470	P220	B 0912 D0	50	500

**For use with File Board 05539512014 and File Shoe 05539512015 on page 61.**

## Premier Red Zirconia Alumina Resin Paper Open Vacuum Grip-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing
- Hook and loop fastening system
- Vacuum holes

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Flexible
- Easy application and removal
- Can be re-used
- Dust-free sanding environment

**Best choice for blending and shaping all types of marine fillers.**



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 16" Vacuum D-3364</b>				
05539521345	80	E 1214 O	25	125

# Clip-On Marine File Strips

## Premier Red Zirconia Alumina Resin Paper Open Clip-On

### Features

- Premium zirconia alumina abrasive
- Full phenolic resin bond system plus latex
- E-weight, latex paper backing

### Benefits

- Fast removal rates
- Extended life
- Maximum durability plus flexibility
- Excellent grain adhesion
- Reduced edge shed
- Flexible

Best choice for blending and shaping all types of marine fillers.



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 17-1/2"</b>				
05539521350	36	E 1214 O	50	250
05539521349	40	E 1214 O	50	250
05539521348	80	E 1214 O	50	250

For use with File Board #05539512013 on page 61.

## Carbo Gold Aluminum Oxide Resin Paper Open Clip-On

### Features

- P-graded, heat-treated, aluminum oxide abrasive
- Resin bond
- E-weight paper backing

### Benefits

- Fast, aggressive cut with extended life
- Long life, resists loading and edge wear
- Durable

Ideal for blending and shaping all types of marine fillers.



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 17-1/2"</b>				
05539512457	P36	E 0912 O	50	500
05539512456	P40	E 0912 O	50	500
05539512454	P80	E 0912 O	50	500

For use with File Board #05539512013 on page 61.

## Aluminum Oxide Paper Open Clip-On

### Features

- P-graded, brown aluminum oxide abrasive

### Benefits

- Tough and durable

For blending and shaping of marine filler.



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 17-1/2"</b>				
05539510908	P36	D 0811 O	50	500
05539510907	P40	D 0811 O	50	500
05539510906	P60	D 0811 O	50	500
05539510905	P80	D 0811 O	50	500
05539510904	P100	C 0811 O	50	500

For use with File Board #05539512013 on page 61.

## Carbo Gold Aluminum Oxide Dri-Lube Resin Paper Open Clip-On

### Features

- P-graded, light brown aluminum oxide abrasive
- C-weight paper backing
- Special, undyed stearate oversize and an open coat

### Benefits

- Fast, aggressive cut and long life
- Durability plus tear resistance
- Excellent load resistance

Ideal for blending and shaping all types of marine fillers.



PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
<b>2-3/4" x 17-1/2"</b>				
05539510903	P80	C 0712 DO	50	500
05539510902	P100	C 0712 DO	50	500
05539510900	P120	C 0712 DO	50	500
05539510899	P150	C 0712 DO	50	500
05539510898	P180	C 0712 DO	50	500

For use with File Board #05539512013 on page 61.



## Marine Files



### Hand Marine File Board

Sturdy tool for hand sanding and blending marine filler. Can be used with both Clip-On and Stick-On marine file strips.



### Grip-On Marine File Board

Sturdy tool for hand sanding and blending marine filler. Incorporates a unique hook and loop fastening system. For use with Grip-On marine file strips.



### Grip-On Marine Air File Shoe

For use on orbital air sanders. Grip-On feature eliminates the need for clips, making mounting and removal quick and easy.

PART NO.	DESCRIPTION	FILE BOARDS/PKG.
<b>Hand Marine File Board</b>		
05539512013	Hand File Board	1
<b>Grip-On Marine File Board</b>		
05539512014	2-3/4" x 16-1/2"	1
<b>Grip-On Marine Air File Shoe</b>		
05539512015	2-3/4" x 16-1/2"	1



# Abrasive Sponges

## EZ Touch Contour Sponges

### Features

- Thin, coated on one side with aluminum oxide or silicon carbide abrasive
- Designed with superior flexibility

### Benefits

- Can be used wet or dry; washable
- Ideal for flat, curved, contoured and hard-to-reach areas

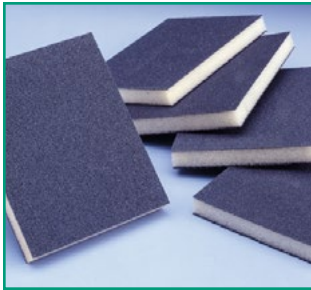
*For hand sanding and uniform finishing of wood, metal, fiberglass, composites, plastics and solid surfaces, and primed, stained, sealed or painted surfaces.*



PART NO.	GRADING	SPONGES/CASE
<b>4-1/2" x 5-1/2" x 3/16" – One Sided</b>		
05539570121	60 Medium Aluminum Oxide	80
05539570122	100 Fine Aluminum Oxide	80
05539570123	180 Super Fine Aluminum Oxide	80
05539570124	220 Ultra Fine Silicon Carbide	80
05539570125	280 Micro Fine Silicon Carbide	80



## Flexible Silicon Carbide Sanding Sponges



*Ideal for sanding sealer and wash coats in wood, and touching-up or repairing of primer.*



PART NO.	GRADING	SPONGES/CASE
<b>4-3/4" x 3-3/4" x 1/2" – Two Sided</b>		
05539513710	100 Coarse Silicon Carbide	250
05539513711	150 Medium Silicon Carbide	250
05539513712	220 Fine Silicon Carbide	250

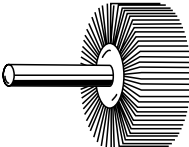






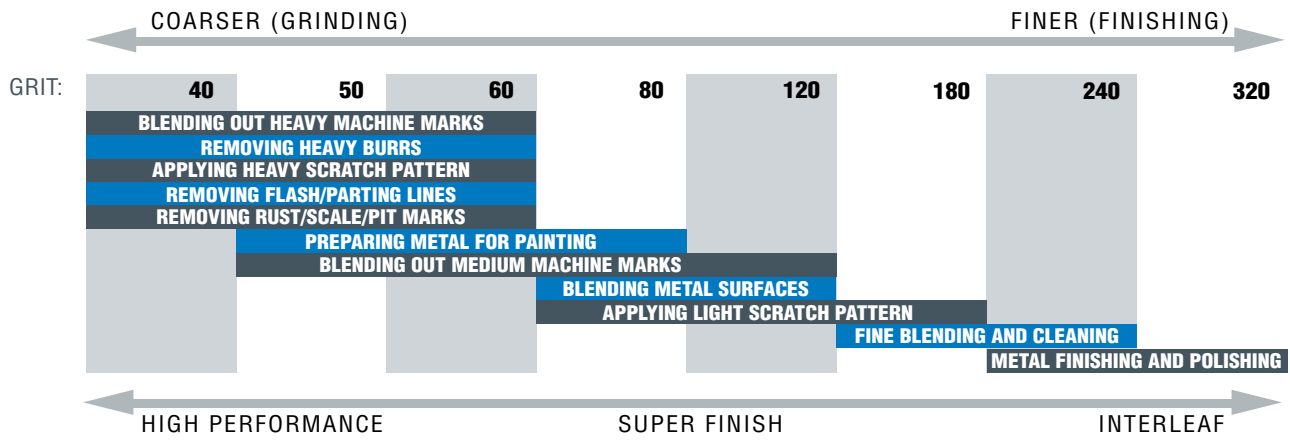
Flap wheels are an ideal choice for a wide variety of blending, deburring and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away, continually exposing fresh abrasives.

- APPLICATIONS:** Used for a wide range of metal fabrication and welding applications including stock removal, blending, deburring, cleaning, finishing, and polishing
- SIZE RANGE:** Flap Wheels with mounted steel shanks: 3/8" - 3" diameter  
Flap Wheels with mounted 1/4-20 thread: 1" - 3" diameter  
Flap Wheels with arbor holes: 3" - 16" diameter
- GRIT RANGE:** 40 - 320
- ABRASIVE GRAIN:** Ceramic Alumina/Aluminum Oxide, Aluminum Oxide

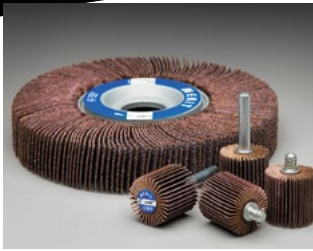
## SHAPE RECOMMENDATION GUIDE

SHAPE	DESCRIPTION/APPLICATION
	<p><b>Flap Wheels with Mounted Steel Shanks</b></p> <p>Wheels are designed with a 1/8" or 1/4" steel shank as an integral part of each wheel. These shanks run through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on air tools when using other abrasive products.</p>
	<p><b>Flap Wheels with Mounted 1/4-20 Thread</b></p> <p>Wheels are designed with a 1/4"-20 thread and flange as an integral part of the wheel. These threads facilitate the quickest changes on air tools using flap wheels exclusively, as there are no special tools needed to change the flap wheel. Also allow extended reach with accessory mandrels.</p>
	<p><b>Flap Wheels with Arbor Holes</b></p> <p>For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.</p>

## APPLICATION/GRIT RECOMMENDATION GUIDE



# Flap Wheels



## MERIT HIGH PERFORMANCE

GOOD CHOICE FOR MORE DURABLE FLAP WHEEL APPLICATIONS WHERE AGGRESSIVE CUT AND SUPERIOR LIFE ARE REQUIRED

### FEATURES

- Long-lasting ceramic alumina/aluminum oxide abrasive grain blend
- Heavy cotton backing

### BENEFITS

- Aggressive cut and 2 to 3 times longer life
- Extended durability for added life and reduced edge wear



## MERIT METAL

GOOD CHOICE WHEN INITIAL PRICE IS THE MAIN CONSIDERATION

### FEATURES

- Quality aluminum oxide abrasive
- Engineered, low-cost cotton backing
- Competitive initial price point

### BENEFITS

- Good cut rate and life
- Longer life and wear resistance
- Best starting specification for end-user unable to measure total performance

## Micro-Mini Flap Wheels with 1/8" Mounted Steel Shanks

- The smallest flap wheels, ranging from 3/8" to 1-3/16" diameter, mounted on a 1/8" diameter steel shank
- Provide fast polishing and light deburring of internal workpieces with holes or grooves as small as 1/2"



TIER: **GOOD**

BRAND: Merit

TRADENAME: **MICRO-MINI**

ABRASIVE: Aluminum Oxide



TIER: **GOOD**

BRAND: Merit

TRADENAME: **MICRO-MINI**

ABRASIVE: Aluminum Oxide

D x W x SK.	MAX. RPM	GRIT	STD. PKG.	PART NO.
3/8 x 3/8 x 1/8	40,000	60	10	08834137470
		80		08834137471
		120		08834137472
		180		08834137473
		240		08834137474
		320		08834137475
5/8 x 5/8 x 1/8	37,000	60	10	08834137480
		80		08834137481
		120		08834137482
		180		08834137483
		240		08834137484
		320		08834137485
5/8 x 3/4 x 1/8	37,000	80	10	08834137541
		120		08834137542
		180		08834137543
		240		08834137544
		320		08834137545
		3/4 x 3/16 x 1/8		35,000
80	08834137551			
120	08834137552			
180	08834137553			
240	08834137554			
320	08834137555			
3/4 x 3/8 x 1/8	35,000	60	10	08834137560
		80		08834137561
		120		08834137562
		180		08834137563
		240		08834137564
		320		08834137565
3/4 x 1/2 x 1/8	35,000	60	10	08834137570
		80		08834137571
		120		08834137572
		180		08834137573
		240		08834137574
		320		08834137575

D x W x SK.	MAX. RPM	GRIT	STD. PKG.	PART NO.
3/4 x 5/8 x 1/8	35,000	60	10	08834137580
		80		08834137581
		120		08834137582
		180		08834137583
		240		08834137584
		320		08834137585
3/4 x 3/4 x 1/8	35,000	60	10	08834137590
		80		08834137591
		120		08834137592
		180		08834137593
		240		08834137594
		320		08834137595
1-3/16 x 1/8 x 1/8	30,000	80	10	08834137491
		120		08834137492
		180		08834137493
		240		08834137494
		320		08834137495
		1-3/16 x 3/16 x 1/8		30,000
80	08834137501			
120	08834137502			
180	08834137503			
240	08834137504			
320	08834137505			
1-3/16 x 3/8 x 1/8	30,000	80	10	08834137511
		120		08834137512
		180		08834137513
		240		08834137514
		320		08834137515



## Micro-Mini Test Kit "MMC"

- Part No. 08834131493
- Includes five wheels, 3/8" to 1-3/16" diameter in various grits, mounted on 1/8" diameter hardened steel shanks





## Mini Flap Wheels with 1/4" Mounted Steel Shanks



TIER:	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit
TRADENAME:	<b>HIGH PERFORMANCE</b>	<b>METAL</b>
ABRASIVE:	Ceramic Alumina/ALO	Aluminum Oxide

D x W x SK.	MAX. RPM	GRIT	STD. PKG.	PART NO.	PART NO.
1 x 1/2 x 1/4	30,000	60	10		08834149800
		80		08834149801	
		120		08834149802	
1 x 5/8 x 1/4	30,000	40	10	08834137105	
		60		08834137100	
		80		08834137101	
		120		08834137102	
		180		08834131536	
		240		08834137104	
		320		08834137357	
1 x 1 x 1/4	30,000	40	10	08834131259	08834149803
		50		08834137309	
		60		08834137310	08834149804
		80		08834137311	08834149805
		120		08834137312	08834149806
		180		08834137313	08834149807
		240		08834137114	08834149808
		320		08834137315	08834149809
1-3/8 x 5/8 x 1/4	30,000	60	10	08834137320	
		80		08834137321	
		120		08834137322	
		180		08834137323	
		240		08834137324	
1-1/2 x 1/2 x 1/4	25,000	60	10		08834149810
		80		08834149811	
		120		08834149812	
1-1/2 x 1 x 1/4	25,000	40	10	08834135140	
		60		08834137340	08834149816
		80		08834137141	08834149817
		120		08834137142	08834149818
		180		08834137343	08834149819
		240		08834132101	
		320		08834137145	
1-1/2 x 1-1/2 x 1/4	25,000	40	10	08834130642	
		60		08834130643	
		80		08834130644	
		120		08834130641	
		180		08834130695	
2 x 1/2 x 1/4	25,000	40	10		08834149820
		60		08834149821	
		80		08834149822	
		120		08834149823	
2 x 3/4 x 1/4	25,000	40	10	08834137158	
		60		08834137160	
		80		08834137161	
		120		08834137162	
		180		08834137163	

CONTINUED

# Flap Wheels

## Mini Flap Wheels with 1/4" Mounted Steel Shanks *CONTINUED*



TIER:

BRAND:

TRADENAME:

ABRASIVE:

**HIGH PERFORMANCE**

**METAL**

Ceramic Alumina/ALO

Aluminum Oxide

D x W x SK.	MAX. RPM	GRIT	STD. PKG.	PART NO.	PART NO.
2 x 1 x 1/4	25,000	40	10	08834137377	08834149824
		50		08834137169	
		60		08834137370	08834149825
		80		08834137371	08834149826
		120		08834137372	08834149827
		180		08834137373	08834149828
		240		08834137374	
320	08834137375				
2 x 1-1/2 x 1/4	25,000	40	10	08834137183	
		60		08834137380	
		80		08834137381	
		120		08834137382	
		180		08834137383	
		240		08834137384	
		320		08834137319	
2-1/2 x 1 x 1/4	20,000	40	10	08834137408	
		60		08834137410	
		80		08834137411	
		120		08834137412	
		180		08834137413	
		240		08834137633	
		320		08834137415	
2-1/2 x 1-1/2 x 1/4	20,000	60	10	08834137420	
		80		08834137421	
		120		08834137422	
3 x 1/2 x 1/4	20,000	40	10		08834149833
		60			08834149834
		80			08834149835
3 x 3/4 x 1/4	20,000	60	10	08834137440	
		80		08834137441	
3 x 1 x 1/4	20,000	40	10	08834137456	08834149836
		60		08834137450	08834149837
		80		08834137451	08834149838
		120		08834137252	08834149839
		180		08834137253	08834149840
		240		08834135339	
		320		08834135341	
3 x 2 x 1/4	12,000	40	10	08834137460	
		60		08834137260	
		80		08834137261	
		120		08834137262	
		180		08834137263	
3 x 2 x 3/8	12,000	60	10	08834135050	
		80		08834135051	
		120		08834135052	

COATED ABRASIVES

## Mini Flap Wheels with 1/4"-20 Thread



TIER: **GOOD**  
 BRAND: Merit  
 TRADENAME: **HIGH PERFORMANCE**  
 ABRASIVE: Ceramic Alumina/ALO

D x W x THD.	MAX. RPM	GRIT	STD. PKG.	PART NO.
1 x 5/8 x 1/4-20	30,000	60	10	08834131001
		80		08834131002
		120		08834131003
1 x 1 x 1/4-20	30,000	40	10	08834131027
		60		08834131008
		80		08834131009
		120		08834131010
		180		08834131011
		240		08834131012
1-3/8 x 5/8 x 1/4-20	30,000	60	10	08834132001
		80		08834132002
		120		08834132003
1-5/8 x 1 x 1/4-20	25,000	40	10	08834132051
		60		08834132015
		80		08834132016
		120		08834132017
		180		08834132018
2 x 3/4 x 1/4-20	25,000	60	10	08834133008
		80		08834133009
		120		08834133010
		180		08834133011



TIER: **GOOD**  
 BRAND: Merit  
 TRADENAME: **HIGH PERFORMANCE**  
 ABRASIVE: Ceramic Alumina/ALO

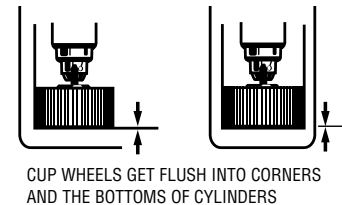
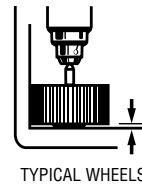
D x W x THD.	MAX. RPM	GRIT	STD. PKG.	PART NO.
2 x 1 x 1/4-20	25,000	40	10	08834133044
		60		08834133015
		80		08834133016
		120		08834133017
		180		08834133018
		240		08834133019
2 x 1-1/2 x 1/4-20	25,000	60	10	08834133020
		80		08834135201
		120		08834135202
		180		08834135203
		180		08834135204
2-1/2 x 1 x 1/4-20	20,000	40	10	08834134061
		60		08834134022
		80		08834134023
		120		08834134024
3 x 3/4 x 1/4-20	20,000	60	10	08834134025
		80		08834135008
		80		08834135009
		120		08834135010
3 x 1 x 1/4-20	20,000	40	10	08834135011
		60		08834135230
		80		08834135015
		80		08834135016
		120		08834135017
		180		08834135018
		240		08834135019

FOR ADAPTERS FOR FLAP WHEELS WITH 1/4"-20 THREAD, SEE THE END OF THIS SECTION



## Cup-Type Mini Flap Wheels with 1/4" Mounted Steel Shanks

- Primarily used for bottom or side-wall type sanding where conventional tools do not reach
- Cup-type mini flap wheels will not mar your workpiece while reaching flush into areas where other wheels cannot



TIER: **GOOD**  
 BRAND: Merit  
 ABRASIVE: Aluminum Oxide

D x W x SK.	MAX. RPM	GRIT	STD. PKG.	PART NO.
2-1/2 x 1-1/2 x 1/4	20,000	60	10	08834144463



## Flap Wheel Test Kits

### Merit Micro Mini GOF Test Kit "MMC"

- Part No. 08834131493
- Includes 5 wheels, 3/8" to 1-3/16" in diameter
- The flap wheels are mounted on 1/8" diameter hardened steel shanks
- Ideal for fast polishing and light deburring of holes or grooves

### Merit Mini Grind-O-Flex Test Kit "CMM"

- Part No. 08834138004
- Includes ten wheels, 1" to 3" diameter in various grits
- Each wheel comes with a 1/4" steel mandrel permanently mounted

### Merit Mini 1/4"-20 Thread Test Kit "CQ"

- Part No. 08834138001
- Includes ten, 1" to 3" diameter, 1/4"-20 thread mini flap wheels
- Each kit includes a 1/4"-20 QC-4 quick-change adapter

## 3-1/2" - 8" Flap Wheels with Arbor Holes



TIER: **GOOD**

BRAND: Merit

TRADENAME: **HIGH PERFORMANCE**

ABRASIVE: Ceramic Alumina/ALO



TIER: **GOOD**

BRAND: Merit

TRADENAME: **HIGH PERFORMANCE**

ABRASIVE: Ceramic Alumina/ALO

D x W x H	MAX. RPM	GRIT	STD. PKG.	PART NO.
3-1/2 x 1 x 5/8	12,000	40	10	08834122001
		50		08834122002
		60		08834122003
		80		08834122004
		120		08834122006
		180		08834122007
		240		08834122008
		320		08834122009
3-1/2 x 1-1/2 x 5/8	12,000	40	10	08834122011
		50		08834122012
		60		08834122013
		80		08834122014
		120		08834122016
		150		08834122017
		180		08834122018
		320		08834122020
3-1/2 x 2 x 5/8	12,000	40	10	08834122022
		60		08834122024
		80		08834122025
		120		08834122027
		180		08834122028
		320		08834122032
4 x 1 x 5/8	12,000	40	10	08834122032
		50		08834122033
		60		08834122034
		80		08834122035
		120		08834122037
		180		08834122038
		240		08834122039
		320		08834122040

D x W x H	MAX. RPM	GRIT	STD. PKG.	PART NO.
4 x 1-1/2 x 5/8	12,000	40	10	08834122042
		50		08834122043
		60		08834122044
		80		08834122045
		120		08834122047
		240		08834122050
4 x 2 x 5/8	12,000	40	10	08834122053
		50		08834122054
		60		08834122055
		80		08834122056
		120		08834122058
		180		08834122059
5 x 1-1/2 x 5/8	12,000	40	10	08834122063
		50		08834122064
		60		08834122065
		80		08834122066
		120		08834122068
		180		08834122070
6 x 1/2 x 1	6,000	40	10	08834122071
		50		08834122072
		60		08834123003
		80		08834123004
		120		08834123005
		150		08834122198
		180		08834123006
		240		08834123007
		320		08834122137

FOR FLAP WHEEL WITH ARBOR HOLE ADAPTERS AND BUSHINGS, SEE THE END OF THIS SECTION



## 3-1/2" - 8" Flap Wheels with Arbor Holes *CONTINUED*



TIER:

BRAND:

TRADENAME:

ABRASIVE:

**HIGH PERFORMANCE**

**METAL**

Ceramic Alumina/ALO

Aluminum Oxide

D x W x H	MAX. RPM	GRIT	STD. PKG.	PART NO.	PART NO.			
6 x 1 x 1	6,000	40	5	08834123009	08834120167			
		50		08834123010	08834120168			
		60		08834123011	08834120169			
		80		08834123012	08834120170			
		100			08834120171			
		120		08834123014	08834120172			
		150		08834123015				
		180		08834123016	08834120174			
		240		08834123017	08834120176			
		320		08834123018	08834120177			
6 x 1-1/2 x 1	6,000	40	5	08834123020				
		50		08834123021				
		60		08834123022				
		80		08834123023				
		120		08834123025				
		150		08834123026				
		180		08834123027				
		240		08834123028				
		320		08834123029				
		6 x 2 x 1		6,000	40	5	08834123031	08834120189
50	08834123032							
60	08834123033		08834120191					
80	08834123034		08834120192					
100			08834120198					
120	08834123036		08834120194					
180	08834123038		08834120197					
240	08834123039		08834120199					
320	08834123040		08834120493					
6 x 3 x 1	6,000		40		3		08834123053	
		50	08834123054					
		60	08834123055					
		80	08834123056					
		120	08834123058					
		150	08834122544					
		180	08834123060					
		240	08834123061					
		320	08834122329					
		8 x 1 x 1	4,500	40		3	08834123070	
50	08834123071							
60	08834123072							
80	08834123073							
120	08834123075							
180	08834123077							
240	08834123078							
320	08834123079							
8 x 2 x 1	4,500			40	3		08834123092	
				50			08834123093	
		60	08834123094					
		80	08834123095					
		120	08834123097					
		180	08834123099					
		240	08834123100					
		320	08834123101					

FOR FLAP WHEEL WITH ARBOR HOLE ADAPTERS AND BUSHINGS, SEE THE END OF THIS SECTION

# Flap Wheels

## Adapter and Bushings for Flap Wheels with Arbor Holes

WHEEL DIAMETER	ADAPTERS	PART NO.
<b>Shank Adapters</b>		
3-1/2	1/4 Shank	08834125001
3-1/2	3/8 Shank	08834125007
4-8	1/4 Shank	08834125003
<b>Threaded Mounting Adapters</b>		
4-8	5/8-11 Thread	08834125027
<b>Reducing Bushings</b>		
6-8	1 to 3/8	08834125016
	1 to 1/2	08834125017
	1 to 5/8	08834125018
	1 to 3/4	08834125019
	1 to 7/8	08834125020
10-16	1 to 5/8	08834122069

STANDARD PACKAGES = 1 ADAPTER, 1 PAIR OF BUSHINGS



08834125001



08834125007



08834125003



08834125009



08834125027

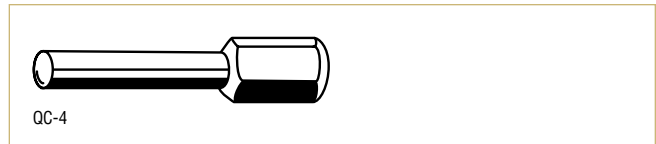


08834125016

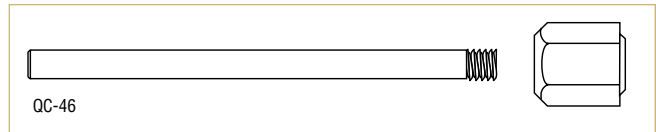
## Adapters for 1/4"-20 Thread Mini and Arbor Hole Flap Wheels

MODEL	DESCRIPTION	PART NO.
<b>Adapters</b>		
ADAPT C	Fits 3 x 2 x 3/8 arbor flap wheel	08834137009
MA-100	Fits A.H. Mini Wheel	08834137007
QC-8	1/8 x 5/8	08834137002
QC-4	1/4 SK. Dia. x 5/8 SK. L.	08834137001
QC-44	1/4 x 4	08834137003
QC-46	1/4 x 6	08834137004
QC-48	1/4 x 8	08834137005
QC-T	1/4-20 Thread	08834137012
QC-T	3/8-24 Thread	08834137010

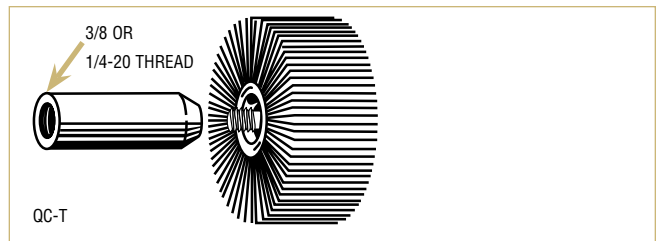
STANDARD PACKAGE = 1 ADAPTER  
OTHER THREAD SIZES AVAILABLE FOR QUOTATION



QC-4



QC-46



QC-T



## Sand-O-Flex Wheels

With their firm cushioning brushes, Sand-O-Flex's abrasive strips are forced into, around and over corners, hollow and fluted surfaces, and small openings. Pressure is distributed evenly over the surface to prevent loss of detail and the flattening of rounded areas; for sanding metals, woods, plastics, rubber and ceramic.

Sand-O-Flex wheels are designed to fit most standard equipment. They load quickly and easily by turning the index knob as needed, allowing you to change grit size in minutes. Sand-O-Flex refills are available both scored (for finer, less aggressive work) and unscored. And, with the use of Merit adapters, Sand-O-Flex wheels will fit most electric bench grinders.



### Sand-O-Flex Wheels – Model 350-RP

- Diameter: 6-1/2" overall, 4" diameter high-impact plastic body
- 1" wide abrasive strips backed by 8 cushioning brushes
- 1/4" diameter steel shank
- Weight: 9-1/2 oz.
- Maximum operating speed: 2,400 RPM
- Special adapter required for bench grinder use
- Some assembly required



TIER:	<b>GOOD</b>
BRAND:	Merit
TRADENAME:	<b>SAND-O-FLEX</b>
ABRASIVE:	Aluminum Oxide

MODEL NO.	GRIT	PART NO.	
<b>Sand-O-Flex Wheel</b>			
350-RP		08834111051	
Comes assembled with 80 grit A/O Resin Bond Scored refill and brushes			
<b>Sand-O-Flex Accessories</b>			
Bench Grinder Adapter 350-RP		08834111055	
1/4 Shank to 1/2 Shank		08834111054	
Replacement Brushes for 350-RP; 8 per set		08834113003	
<b>Resin Bond Refills</b>			
350-RP SCORED 10/box	60	08834111052	
	80	08834111053	
	100	08834112114	
	120	08834111054	
	180	08834111057	
350-RP UNSCORED 10/box	60	08834112031	
	80	08834111059	
	100	08834112021	
	120	08834112032	
	180	08834112033	
<b>Glue Bond Refills</b>			
350-RP SCORED 10/box	60	08834112053	
	80	08834112054	
	100	08834112055	
	120	08834112056	
	150	08834112057	
	180	08834112058	
	240	08834112059	
	320	08834112060	
	350-RP UNSCORED 10/box	60	08834112043
		80	08834112044
100		08834112045	
120		08834112046	
150		08834112047	
180		08834112048	
240		08834112049	
320	08834112050		

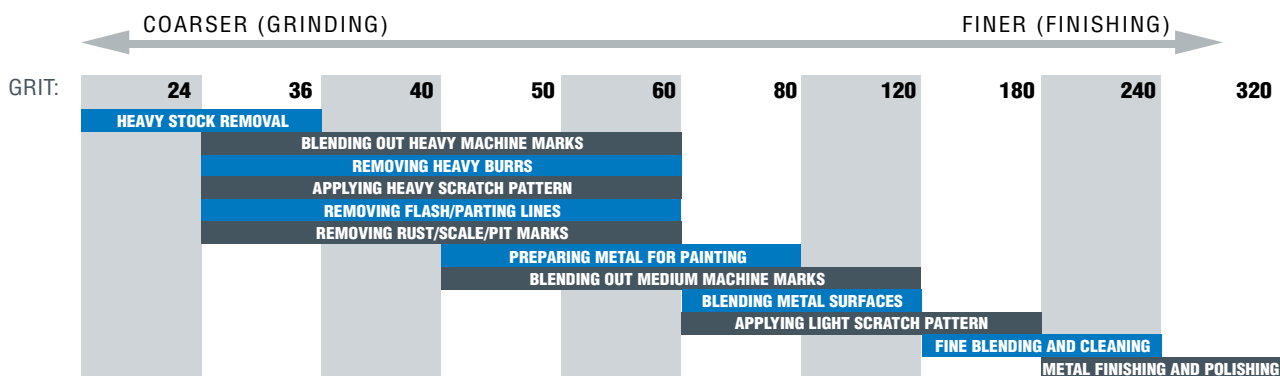
# Specialties – Spiral Bands




Best product for blending and polishing contours when smooth running is a primary concern. Used for finishing hard-to-reach areas, removing parting lines, imperfections, and burrs on all surfaces.

- BENEFITS:**
- Spiral construction avoids shadow marks and provides smooth, chatter-free cutting action
  - Achieves close tolerances when finishing curved, contoured, and hard-to-reach areas
  - Fast cutting and removes toughest metal
  - Bands are easily removed and replaced
- GRIT RANGE:** 24 - 320
- ABRASIVE GRAIN:** Aluminum Oxide
- OTHER:** Use with rubber expanding drum

## APPLICATION/GRIT RECOMMENDATION GUIDE




### GOOD

GRIT	1/4 x 1/2	1/4 x 1	3/8 x 1/2	3/8 x 1	1/2 x 1/2	1/2 x 1	1/2 x 1-1/2	1/2 x 2
24	-	-	-	-	-	08834196712	-	-
36	-	-	-	08834197674	08834196619	08834196591	08834196237	08834196758
40	08834196614	-	-	-	08834196234	08834196174	-	08834196825
50	08834196292	08834196785	08834196386	-	08834196228	08834196214	08834197111	08834196548
60	08834196342	08834196886	08834196829	08834196999	08834196068	08834196212	08834196053	08834196549
80	08834196269	08834196733	08834196512	08834196645	08834196179	08834196215	08834196646	08834196669
100	08834196511	08834196734	08834196513	-	08834196189	08834196534	08834196540	08834196735
120	08834196217	08834197004	08834196747	08834196218	08834196069	08834196210	08834196324	08834196736
150	08834196327	-	-	-	08834196211	08834196772	-	-
180	08834196490	-	08834196504	-	08834196209	08834196713	-	-
240	-	-	08834196481	-	08834196564	08834196814	-	-
320	08834196865	-	08834196830	-	08834196505	08834196487	-	-
<b>PKG. QTY. STOCK</b>	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
<b>MOQ NON-STOCK</b>	400	400	300	300	300	300	300	200
<b>Expanding Rubber Drums</b>								
	1/8 Shank 30,000 RPM 08834196030	1/8" shank 30,000 8834196008	1/8 Shank 30,000 RPM 08834196944	1/8 Shank 18,000 RPM 08834196011	1/4 Shank 30,000 RPM 08834196904	1/4 Shank 15,000 RPM 08834196906	1/4 Shank 12,000 RPM 08834196907	1/4 Shank 10,000 RPM 08834196908


MOQ = MINIMUM ORDER QUANTITY




## GOOD

GRIT	3/4 x 1/2	3/4 x 3/4	3/4 x 1	3/4 x 1-1/2	3/4 x 2	1 x 1/2	1 x 1	1 x 1-1/2
24	-	08834196613	08834196776	08834196596	-	-	08834196563	08834196708
36	08834196769	08834196609	08834196261	08834196238	08834196953	08834196058	08834196072	08834196525
40	08834196605	08834196236	08834196517	08834196227	08834196826	-	08834196073	08834196546
50	08834196608	08834196183	08834196515	08834196500	08834196757	-	08834196184	08834196078
60	08834196578	08834196168	08834196070	08834196554	08834196745	08834196580	08834196075	08834196060
80	08834196255	08834196161	08834196071	08834196249	08834196756	08834196647	08834196074	08834196162
100	08834196567	08834196230	08834196502	08834196501	08834196766	08834196157	08834196167	08834196257
120	08834196579	08834196226	08834196219	08834196057	08834196746	08834197592	08834196177	08834196677
150	08834196631	08834196231	08834196822	-	08834197283	-	08834196686	08834197639
180	08834197116	08834196056	08834196565	08834196851	-	-	08834196059	08834196790
240	08834196603	08834196859	08834196668	-	66254410751	08834197287	08834196178	08834196526
320	08834196806	-	08834196624	08834199664	-	-	08834196789	08834197700
<b>PKG. QTY. STOCK</b>	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
<b>MOQ NON-STOCK</b>	300	300	300	300	200	200	300	200
<b>Expanding Rubber Drums</b>								
	1/4 Shank 27,000 RPM 08834196909	1/4 Shank 24,000 RPM 08834196910	1/4 Shank 17,000 RPM 08834196911	1/4 Shank 10,000 RPM 08834196912	1/4 Shank 10,000 RPM 08834196913	1/4 Shank 20,000 RPM 08834196914	1/4 Shank 18,000 RPM 08834196916	1/4 Shank 10,000 RPM 08834196917

## GOOD

GRIT	1 x 2	1 x 3	1-1/2 x 1	1-1/2 x 1-1/2	1-1/2 x 2	1-1/2 x 3	2 x 1	2 x 1-1/2
24	08834196709	08834197806	08834196684	08834196220	08834196539	-	08834196841	08834196700
36	08834196267	08834196665	08834196222	08834196164	08834196657	08834197063	08834196233	08834196509
40	08834196689	-	08834196223	08834196171	08834196598	-	08834196109	08834196514
50	08834196588	08834197688	08834196185	08834196176	08834196252	-	08834196186	08834196527
60	08834196506	08834196676	08834196503	08834196091	08834196067	08834196703	08834196232	08834196978
80	08834196268	08834196195	08834196254	08834196165	08834196533	08834196809	08834196166	08834196259
100	08834196750	08834196445	08834196216	08834196182	08834196543	08834196522	08834196508	08834196521
120	08834196507	08834196197	08834196707	08834196066	08834196079	08834196343	08834196595	08834196586
150	08834197664	-	08834196989	08834197750	08834197376	-	-	-
180	08834196987	08834196356	-	08834196535	-	08834197869	08834196661	08834196536
240	-	-	08834196491	08834196260	08834197709	-	08834197983	-
320	-	-	08834196063	08834197647	-	-	-	-
<b>PKG. QTY. STOCK</b>	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
<b>MOQ NON-STOCK</b>	200	100	300	200	200	100	200	200
<b>Expanding Rubber Drums</b>								
	1/4 Shank 8,000 RPM 08834196918	NA	1/4 Shank 12,000 RPM 08834196921	1/4 Shank 10,000 RPM 08834196922	1/4 Shank 8,000 RPM 08834196923	NA	1/4 Shank 11,000 RPM 08834196926	1/4 Shank 8,000 RPM 08834196927

## GOOD

GRIT	2 x 2	2 x 3	2-1/4 x 3	3 x 1	3 x 1-1/2	3 x 2	3 x 3
24	08834196516	08834197903	-	08834196795	08834197056	08834196263	08834196256
36	08834196110	08834196827	08834197140	08834196717	08834196802	08834196545	08834196262
40	08834196172	08834196151	08834197158	08834196755	-	08834196090	08834196555
50	08834196187	08834196152	08834196620	-	-	08834196264	08834196253
60	08834196173	08834196175	-	08834196150	08834196719	08834196530	08834196188
80	08834196181	08834196198	08834196270	08834196524	08834196633	08834196265	08834196159
100	08834196193	08834196199	-	08834196831	-	-	08834196250
120	08834196585	08834196200	08834196729	08834196089	-	08834196531	08834196572
150	08834196629	-	08834195857	-	-	-	08834196452
180	08834196306	-	-	-	-	-	08834196131
240	08834196375	-	-	-	-	-	08834196574
320	08834196628	-	08834195825	-	-	-	08834197968
<b>PKG. QTY. STOCK</b>	100/box	100/box	100/box	100/box	100/box	100/box	100/box
<b>MOQ NON-STOCK</b>	200	100	100	200	200	100	100
<b>Expanding Rubber Drums</b>							
	1/4 Shank 6,000 RPM 08834196928	1/4" shank 6,000 RPM 8834196010	NA	3/8 Shank 3,000 RPM 08834196929	NA	3/8 Shank 3,000 RPM 08834196930	3/8 Shank 3,000 RPM 08834196931

MOQ = MINIMUM ORDER QUANTITY

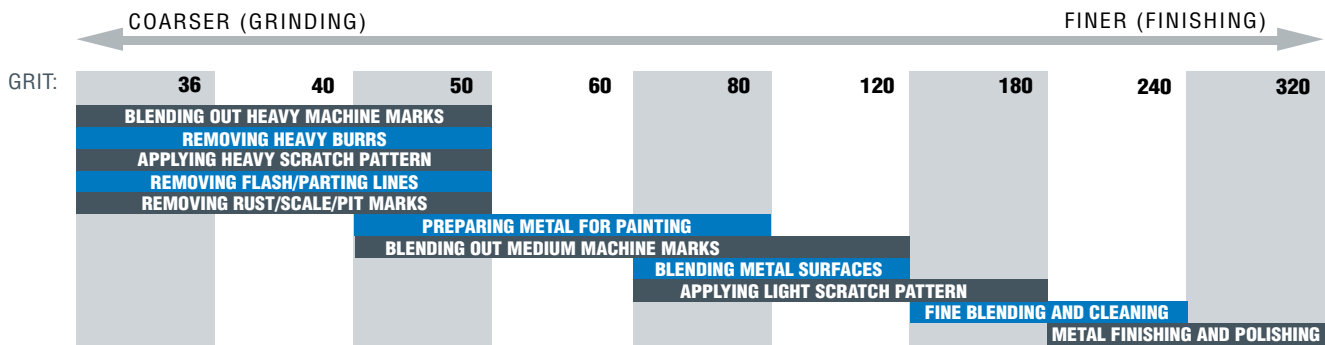
# Specialties – Cartridge Rolls, Spiral Rolls, Cone Points



Cartridge, spiral rolls and cone points are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive.

- APPLICATIONS:** Used on inside surfaces and inside corners where other forms of abrasive cannot reach. Typically these are used on high speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking.
- SHAPES:** Cartridge Rolls, Spiral Rolls (Full Taper, Half Taper, and Sidewall Taper), Tapered Cone Points
- GRIT RANGE:** 36 - 320
- ABRASIVE GRAIN:** Ceramic Alumina, Aluminum Oxide, Silicon Carbide
- BACKING:** Cotton Cloth
- MAXIMUM RPM:** 1/8" to 1/2" – 23,000  
5/8" to 1" – 18,000  
1" to 1-1/2" – 15,000

## APPLICATION/GRIT RECOMMENDATION GUIDE



## FEATURED PRODUCTS



### MERIT BLAZE

FOR HARD-TO-GRIND MATERIALS – STAINLESS STEEL, COBALT, INCONEL, AND TITANIUM

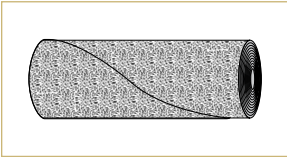
#### FEATURES

- Next-generation ceramic alumina abrasive grain
- Advanced grinding aid
- Improved resin bond system

#### BENEFITS

- Significantly faster cut rates
- Resists wear, resulting in 50% – 300% longer life
- Greatest productivity
- Cooler cutting, longer life
- Exceptional grain retention and longer life

## Cartridge Rolls



- Effective for flash removal
- Polishing or removing machine tool marks
- Edge breaking
- Valuable abrasive tool for reaching into corners, where larger diameter tools cannot work
- All cartridge roll part numbers shown are resin bond, half-glued
- Quarter and full glue are also available for quotation



### Merit Blaze Cartridge Rolls

- With their exclusive ceramic grain technology, grinding aid, and X-weight cotton backing, Merit Blaze products outperform all competitive ceramic, zirconia, and aluminum oxide specialty products in today's markets
- Merit Blaze specialties cut cooler and last longer on stainless steel, cobalt, Inconel, titanium and other hard-to-grind materials

TIER:	<b>BEST</b>
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

D x L x H	GRIT	STD. PKG.	PART NO.
1/4 x 1-1/2 x 1/8	60	100	66261194384
Use M-9 Mandrel	80		66261194394
	120		66261194397
3/8 x 1-1/2 x 1/8	60		66261194392
Use M-9 Mandrel	80	100	66261194395
	120		66261194398
1/2 x 1-1/2 x 1/8	60		66261194393
Use M-9 Mandrel	80	100	66261194396
	120		66261194399



### Merit Silicon Carbide Cartridge Rolls

- Sharp silicon carbide grain penetrates tough, difficult-to-grind materials, as well as soft, loading materials:
  - titanium
  - masonry
  - composites
  - plastic
  - rubber

TIER:	<b>GOOD</b>
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

D x L x H	GRIT	STD. PKG.	PART NO.
1/4 x 1-1/2 x 1/8	60	100	08834183274
Use M-9 Mandrel	80		08834182359
	120		08834189131
3/8 x 1-1/2 x 1/8	60	100	08834181309
Use M-9 Mandrel	80		08834180710
	120		66261042229
1/2 x 1-1/2 x 1/8	60	100	08834189233
Use M-9 Mandrel	80		08834180712
	120		66261086969



### Merit Aluminum Oxide Cartridge Rolls

- Most effective starting specification for flash removal, polishing or removing machine tool marks and edge breaking on all types of metal

TIER:	<b>GOOD</b>
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

D x L x H	GRIT	STD. PKG.	PART NO.
1/4 x 3/4 x 1/8	60	100	08834180042
Use M-3 or M-7 Mandrel	80		08834180043
	120		08834180045
1/4 x 1 x 1/8	50	100	08834180060
Use M-4 or M-8 Mandrel	60		08834180061
	80		08834180062
	100		08834180063
	120		08834180064
	150		08834180065
	180		08834180066
	240		08834180068
	320		08834180070
1/4 x 1-1/2 x 1/8	50	100	08834180079
Use M-9 Mandrel	60		08834180080
	80		08834180081
	100		08834180082
	120		08834180083
	150		08834180084
	180		08834180085
	320		08834180089
1/4 x 2 x 1/8	80	100	08834180100
Use M-10 Mandrel	100		08834180101
	120		08834180102

TIER:	<b>GOOD</b>
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton Cloth

DIA. x L. x A.H.	GRIT	STD. PKG.	PART NO.
3/16 x 3/4 x 3/32	80	100	08834180005
3/16 x 1 x 3/32	60	100	08834180023
Use M-2E Mandrel	80		08834180024
	100		08834180025
	120		08834180026
	150		08834180027
	180		08834180028
	240		08834180030
	320		08834180032

CONTINUED

# Specialties – Cartridge Rolls, Spiral Rolls, Cone Points

## Merit Aluminum Oxide Cartridge Rolls *CONTINUED*

D x L x H	GRIT	STD. PKG.	TIER:	GOOD
			ABRASIVE:	Aluminum Oxide
			BACKING:	Cotton
D x L x H	GRIT	STD. PKG.	PART NO.	
5/16 x 1 x 1/8 use M-4 or M-8 Mandrel	60	100		08834180137
	80			08834180138
	120			08834180140
5/16 x 1-1/2 x 1/8 use M-9 Mandrel	60	100		08834180156
	80			08834180157
	120			08834180159
3/8 x 3/4 x 1/8 use M-7 Mandrel	60	100		08834180194
	80			08834180195
	120			08834180197
				08834180211
3/8 x 1 x 1/8 use M-8 Mandrel	40	100		08834180211
	50			08834180212
	60			08834180213
	80			08834180214
	100			08834180215
	120			08834180216
	150			08834180217
	180			08834180218
240			08834180220	
3/8 x 1-1/2 x 1/8 use M-9 Mandrel	36	100		08834180228
	40			08834180229
	50			08834180230
	60			08834180231
	80			08834180232
	100			08834180233
	120			08834180234
	150			08834180235
	180			08834180236
	240			08834180238
	320			08834180240
3/8 x 2 x 1/8 use M-10 Mandrel	60	100		08834180250
	80			08834180251
	100			08834180252
	120			08834180253
1/2 x 3/4 x 1/8 use M-7 Mandrel	80	100		08834180270
1/2 x 1 x 1/8 use M-8 Mandrel	40	100		08834180286
	50			08834180287
	60			08834180288
	80			08834180289
	100			08834180290
	120			08834180291
	150			08834180292
	180			08834180293
	240			08834180295
	320			08834180297
	1/2 x 1-1/2 x 1/8 use M-9 Mandrel	36	100	
40				08834180305
50				08834180306
60				08834180307
80				08834180308
100				08834180309
120				08834180310
150				08834180311
180				08834180312
240				08834180314
320				08834180316
1/2 x 1-1/2 x 3/16 use M-16 Mandrel	120	100		08834180919
1/2 x 2 x 1/8 use M-10 Mandrel	60	100		08834180326
	80			08834180327
	100			08834180328
	120			08834180329
	180			08834180331
	240			08834180333
	320			08834180335
1/2 x 2 x 3/16 use M-17 Mandrel	60	100		08834180350
	80			08834180653
	120			08834180338

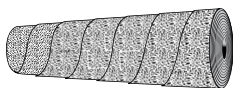
D x L x H	GRIT	STD. PKG.	TIER:	GOOD
			ABRASIVE:	Aluminum Oxide
			BACKING:	Cotton
D x L x H	GRIT	STD. PKG.	PART NO.	
1/2 x 2 x 1/4 use M-22 Mandrel	40	100		08834183168
	80			08834180351
	120			08834180364
5/8 x 1 x 3/16 use M-15 Mandrel	80	100		08834180364
5/8 x 1-1/2 x 1/8 use M-9 Mandrel	36	100		08834180395
	40			08834180392
	50			08834180393
	60			08834180275
	80			08834180789
	120			08834180394
5/8 x 1-1/2 x 3/16 use M-16 Mandrel	50	100		08834180381
	60			08834180382
	80			08834180383
5/8 x 2 x 1/8 use M-10 Mandrel	60	100		08834182505
	80			08834181080
5/8 x 2 x 3/16 use M-10 Mandrel	50	100		08834180400
	60			08834180401
	80			08834180402
	100			08834180403
3/4 x 1 x 1/8 use M-8 Mandrel	80	100		08834180469
	120			08834181543
3/4 x 1 x 3/16 use M-15 Mandrel	40			08834180456
	80	100		08834180459
	120			08834180461
3/4 x 1-1/2 x 1/8 use M-9 Mandrel	40	100		08834180069
	60			08834180490
	80			08834180527
	120			08834180487
	180			08834180474
3/4 x 1-1/2 x 3/16 use M-16 Mandrel	36	100		08834180474
	40			08834180475
	50			08834180476
	60			08834180477
	80			08834180478
	100			08834180479
	120			08834180480
	180			08834180482
3/4 x 1-1/2 x 1/4 100/box 400/case use M-21 Mandrel	36	100		08834180907
	60			08834180489
	80			08834180358
	100			08834180523
	120			08834180488
	150			08834182807
3/4 x 2 x 1/8 use M-10 Mandrel	60	100		08834180791
3/4 x 2 x 3/16 use M-17 Mandrel	40	100		08834180494
	60			08834180496
	80			08834180497
	100			08834180498
3/4 x 2 x 1/4 use M-22 Mandrel	120			08834180499
	60	100		08834180506
	80			08834181297
	100			08834180509
1 x 1-1/2 x 1/8 use M-9 Mandrel	120			08834180507
	60	100		08834180580
	80			08834180584
1 x 1-1/2 x 1/4 use M-21 Mandrel	36	100		08834181195
	60			08834180587
1 x 2 x 3/16 use M-17 Mandrel	80			08834180583
	40	100		08834180589
	60			08834180591
1 x 2 x 1/4 use M-22 Mandrel	80			08834180592
	60	100		08834180603
	80			08834180606
	120			08834180585

Refer to the back of this section for mandrels.



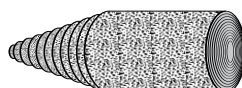
## Spiral Rolls

- All spiral roll part numbers shown are full tapered, resin bond, and half glued
- Half-tapered and sidewall-tapered are available for quotation
- Quarter and full glue are also available for quotation



### Full Taper

- Especially useful for grinding/polishing of channels, fillets and radii, and deburring small holes
- Full taper used when the area to finished is hard to reach with a full cartridge roll
- The tapered roll conforms to smaller areas
- Fits into irregular concaves, contours, channels



### Half Taper

- Used when the area to be finished is not narrow but a beginning point on the roll is needed
- The portion of the roll that is not tapered is then used to finish off the sides



### Sidewall Taper

- The portion of the roll that is tapered guides the roll down to the area to be finished
- The sidewall then finishes off the sides



### Merit Blaze Spiral Rolls Full Taper

- With their exclusive ceramic grain technology, grinding aid and X-weight cotton backing, these products outperform all competitive ceramic, zirconia, and aluminum oxide specialty products in today's markets
- Merit Blaze specialties cut cooler and last longer on stainless steel, cobalt, Inconel, titanium, and other hard-to-grind materials

TIER:	<b>BEST</b>
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

D x L x H	GRIT	STD. PKG.	PART NO.
3/8 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	66261194481
	80		66261194490
	120		66261194491
1/2 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	66261194484
	80		66261194492
	120		66261194495



### Merit Silicon Carbide Spiral Rolls Full Taper

- Sharp silicon carbide grain penetrates tough, difficult-to-grind materials as well as soft, loading materials:
  - titanium
  - masonry
  - composites
  - plastic
  - rubber

TIER:	<b>GOOD</b>
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

D x L x H	GRIT	STD. PKG.	PART NO.
3/8 x 1-1/2 x 1/8 use M-9 Mandrel	60	100	08834189901
	80		08834189904
	120		66261046936
1/2 x 1-1/2 x 1/8 use M-9 Mandrel	60	100	66261185977
	80		08834183460
	120		08834183448

# Specialties – Cartridge Rolls, Spiral Rolls, Cone Points



## Merit Aluminum Oxide Spiral Rolls Full Taper

- Especially useful for grinding/polishing of channels, fillets and radii, and deburring small holes
- All spiral roll part number shown are full tapered, resin bond, and half glued
- Half-tapered and sidewall tapered are available for quotation
- Quarter and full glue are also available for quotation

		TIER: <b>GOOD</b>	
		ABRASIVE: Aluminum Oxide	
		BACKING: Cotton	
D x L x H	GRIT	STD. PKG.	PART NO.
3/8 x 1 x 1/8 use M-8 Mandrel	60	100	08834181714
	80		08834181715
	120		08834181717
	180		08834181719
3/8 x 1-1/2 x 1/8 use M-9 Mandrel	50	100	08834181723
	60		08834181724
	80		08834181708
	120		08834181727
	150		08834181728
	180		08834181709
1/2 x 1 x 1/8 use M-8 Mandrel	60	100	08834181734
	80		08834181735
	120		08834181737
	180		08834181739
1/2 x 1-1/2 x 1/8 use M-9 Mandrel	36	100	08834181230
	40		08834181742
	50		08834181743
	60		08834181744
	80		08834181745
	100		08834181746
	120		08834181747
	180		08834181749
240	08834181750		

		TIER: <b>GOOD</b>	
		ABRASIVE: Aluminum Oxide	
		BACKING: Cotton	
D x L x H	GRIT	STD. PKG.	PART NO.
1/2 x 2 x 1/8 use M-10 Mandrel	60	100	08834181754
	80		08834181755
	120		08834181757
5/8 x 1-1/2 x 1/8 use M-9 Mandrel	100	100	08834181776
	120		08834181777
	240		08834183313
	320		08834181781
5/8 x 1-1/2 x 3/16 use M-16 Mandrel	80	100	08834181444
3/4 x 1-1/2 x 1/8 use M-9 Mandrel	60	100	08834181286
	80		08834180886
3/4 x 1-1/2 x 3/16 use M-16 Mandrel	50	100	08834181807
	60		08834181808
	80		08834181809
	120		08834181811
3/4 x 2 x 3/16 use M-17 Mandrel	60	100	08834181820
1 x 1-1/2 x 1/8 use M-9 Mandrel	60	100	08834181240
1 x 2 x 3/16 use M-17 Mandrel	36	100	08834181875
	60		08834181878
	80		08834181879

CONTINUED

COATED ABRASIVES

## Merit Aluminum Oxide Tapered Cone Points



- Tapered cone points are similar to cartridge rolls but their shape lends greater accessibility to many difficult-to-reach work areas
- They are used for deburring holes and in close tolerance work areas
- Popular sizes and mandrels are listed, with additional sizes available upon request



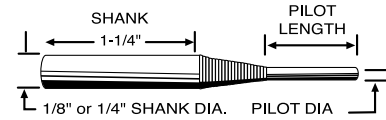
		TIER: <b>GOOD</b>	
		ABRASIVE: Aluminum Oxide	
		BACKING: Cotton	
D x L x H	GRIT	STD. PKG.	PART NO.
5/16 x 1-1/2 x 5° Use B-20 Mandrel	80	500	08834180873
	100		08834182043
	120		08834182717
	150		08834186890
	180		08834182535
	240		08834182044
3/16 x 1 x 2-1/2° Use K-110 Mandrel	320	500	08834182537
	50		08834186892
	60		08834186893
	80		08834180918
	100		08834182197
	120		08834182199
	150		08834182200
	180		08834186894
	240		08834186895

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## Cartridge and Spiral Roll Mandrels

MODEL NO.	PILOT DIA.	PILOT LENGTH	SHANK DIA.	SHANK LENGTH	OVERALL LENGTH	PART NO.
<b>Cartridge and Spiral Roll Mandrels</b>						
M-2E	3/32	3/4	1/4	1	3	08834183799
M-2	3/32	1	1/8	1	3	08834181202
M-3	1/8	1/2	1/8	1	2-1/2	08834181203
M-4	1/8	3/4	1/8	1	2-1/2	08834181204
M-5	1/8	1	1/8	1	2-3/4	08834181205
M-6	1/8	1-1/2	1/8	1	2-1/2	08834181206
M-7	1/8	1/2	1/4	1-1/4	2-1/4	08834181207
M-8	1/8	3/4	1/4	1-1/4	2-1/2	08834181208
M-9	1/8	1	1/4	1-1/4	2-3/4	08834181209
M-10	1/8	1-1/2	1/4	1-1/4	3-1/4	08834181210
M-11	1/8	2	1/4	1-1/4	4	08834181211
M-12	3/16	1/2	1/8	1-1/4	2-1/4	08834181212
M-13	3/16	3/4	1/8	1-1/4	2-1/2	08834181213
M-14	3/16	1/2	1/4	1-1/4	2-1/2	08834181214
M-15	3/16	3/4	1/4	1-1/4	2-3/4	08834181215
M-16	3/16	1	1/4	1-1/4	3	08834181216
M-17	3/16	1-1/2	1/4	1-1/4	3-1/2	08834181217
M-18	3/16	2	1/4	1-1/4	4	08834181218
M-19	1/4	1/2	1/4	1-1/4	2-1/2	08834181219
M-20	1/4	3/4	1/4	1-1/4	2-3/4	08834181220
M-21	1/4	1	1/4	1-1/4	3	08834181221
M-22	1/4	1-1/2	1/4	1-1/4	3-1/2	08834181222
M-23	1/4	2	1/4	1-1/4	4	08834181223
M-24	5/16	3/4	1/4	1-1/4	2-3/4	08834181224
M-25	5/16	1	1/4	1-1/4	3	08834181225
M-26	5/16	1-1/2	1/4	1-1/4	3-1/2	08834181226
M-27	5/16	2	1/4	1-1/4	4	08834181227

STANDARD PACKAGE = 1



### Recommended Pilot Length for Mandrels

3/4 Roll Length	use 1/2 Pilot
1 Roll Length	use 3/4 Pilot
1-1/2 Roll Length	use 1 Pilot
2 Roll Length	use 1-1/2 Pilot

### Extra Shank Length Mandrels

MODEL NO.	SHANK LENGTH	OVERALL LENGTH	PART NO.
<b>Extras Shank Length Mandrels</b>			
M-8-4	4	5-1/4	08834180116
M-8-6	6	7-1/4	08834180122
M-9-2.5	2-1/2	4	08834180096
M-9-3	3	4-1/2	08834180129
M-9-4	4	5-1/2	08834180074
M-9-6	6	7-1/2	08834180131
M-9-8	8	9-1/2	08834180133
M-10-4	4	6	08834180092
M-10-6	6	8	08834180145

ALL EXTRA LENGTH SHANKS ARE 1/4" DIAMETER  
STANDARD PACKAGE = 1



### Tapered Cone Point Mandrels

DESCRIPTION	SHANK	PART NO.
<b>Cone Point Mandrels</b>		
A-10	1/4	08834181300
B-20	1/4	08834181301
C-30	1/4	08834181302
D-40	1/4	08834181303
E-50	A1/4	08834181304
F-60	1/4	08834181305
G-70	1/4	08834181306
H-80	1/4	08834181307
I-90	1/4	08834181308
K-110	1/8	08834181310

STANDARD PACKAGE = 1

## Test Kits

### Merit Blaze Cartridge Roll Test Kit

- Part No. 66261066726
- Kit includes a variety of our new Merit Blaze cartridge rolls, spiral rolls and mandrels in popular sizes and grits.

### Merit Aluminum Oxide Cartridge Roll Test Kit "CR"

- Part No. 08834181061
- Includes over 120 pieces of our most popular sizes, grits and shapes with their appropriate mandrels.

### Merit General Purpose Test Kit "GP"

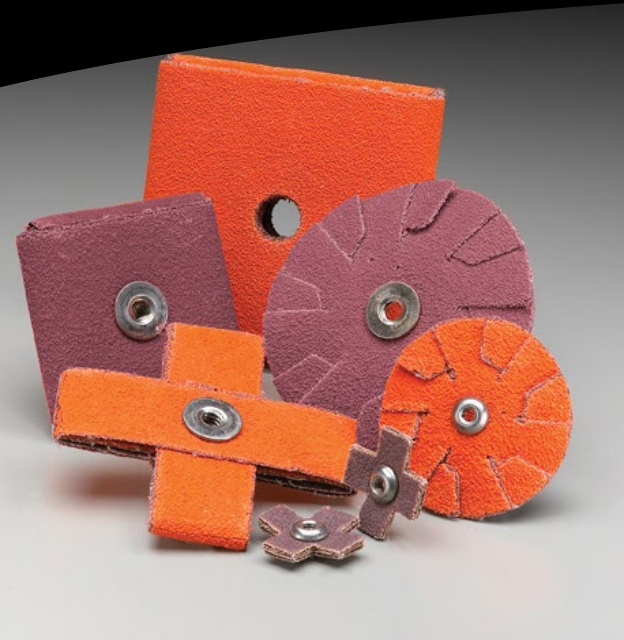
- Part No. 08834169025
- Includes samples of various Merit abrasive specialties. One of these kits could be worth the cost of the entire kit by solving your problems in deburring, polishing and grinding.

### Merit Porting Test Kit "APK-MO"

- Part No. 08834169032
- The samples in this kit highlight Merit for general metal and wood working polishing and finishing applications.



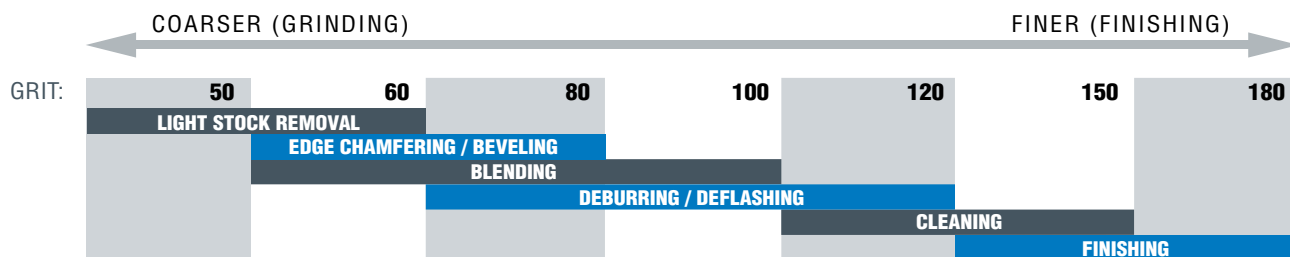
# Specialties – Square Pads, Cross Pads, Overlap Slotted Discs



Square pads, cross pads and overlap slotted discs are all used on high speed pneumatic tools for deburring, blending, cleaning, and polishing applications. All of these abrasive specialties are designed for applications in small, tight, hard-to-access locations on parts that are being finished.

- BENEFITS:** Variety of shapes and sizes to fit application and part geometry  
Shapes provide flexibility for the application, while eliminating aggressiveness of the sanding action  
Cross Pads allow visibility of the surface while sanding, to ensure correct amount of material is removed
- GRIT RANGE:** 50 – 180
- ABRASIVE GRAIN:** Ceramic Alumina, Aluminum Oxide
- BACKING:** Cotton
- MAXIMUM RPM:** 1" Diameter – 25,000  
1-1/2" Diameter – 18,000 to 23,000  
2-1/2" Diameter – 14,000 to 18,000  
3" Diameter – 12,000 to 14,000  
4" Diameter – 8,000 to 12,000  
5" to 6" Diameter – 5,500 to 7,500

## APPLICATION/GRIT RECOMMENDATION GUIDE



COATED ABRASIVES

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### MERIT BLAZE

BEST FOR HARD-TO-GRIND MATERIALS – STAINLESS STEEL, COBALT, INCONEL, AND TITANIUM

#### FEATURES

- Next-generation ceramic alumina abrasive grain
- Advanced grinding aid
- Improved resin bond system

#### BENEFITS

- Significantly faster cut rates
- Resists wear, resulting in 50%-300% longer life
- Greatest productivity
- Cooler cutting, longer life
- Improved grain retention and longer life



### MERIT ALUMINUM OXIDE

GOOD FOR MOST ID DEBURRING AND POLISHING APPLICATIONS

#### FEATURES

- Quality aluminum oxide abrasive grain
- Resin bond system
- Standard quick-change eyelet for easy mounting to quick-change mandrel

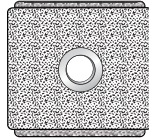
#### BENEFITS

- Versatile; ideal for deburring, chamfering, and polishing most radii, holes, recesses, and cylinder walls
- Good grain retention and life
- Fast, easy mounting and removal; minimal downtime
- Mandrel use increases range and versatility





## Square Pads



**BEST**

TIER: ABRASIVE: Merit Blaze Ceramic Alumina  
OTHER: Supersized



**GOOD**

Merit Aluminum Oxide

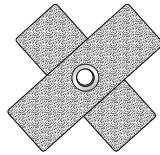
### Merit Square Pads

- With Merit square pads, corners wear down consistently exposing fresh abrasive; the pad becomes round for less aggressive stock removal
- Grind almost as fast as hard wheels, but are much smoother and easier to control
- For quick blending of channels, fillets, corners, or spotting flat surfaces

L x W x T	EYELET	GRIT	STD. PKG.	PART NO.	PART NO.
1 x 1 x 6 ply	8-32	80	100		08834184826
1 x 1 x 8 ply	8-32	60	100		08834184828
		80			08834184124
		120			08834184994
1-1/2 x 1-1/2 x 1/2	1/4-20	60	100		08834184463
		80			08834184125
2 x 2 x 1/2	1/4-20	60	100	66261194520	08834184334
		80		66261194552	08834184397
		120		66261194554	
2 x 2 x 3/4	1/4-20	50	100		08834184487
		80			08834184394
3 x 3 x 1/4	1/4-20	60	100	66261194531	
		80		66261194555	08834184882
		120		66261194556	
3 x 3 x 1/2	1/4-20	50	100	66261194528	08834182152
		60		66261194557	08834182057
		80		66261194558	08834184336
		120			

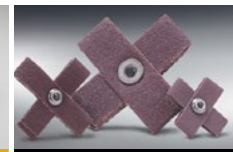


## Cross Pads



**BEST**

TIER: ABRASIVE: Merit Blaze Ceramic Alumina  
OTHER: Supersized



**GOOD**

Merit Aluminum Oxide

### Merit Cross Pads

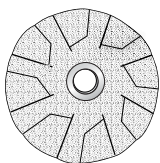
- The shape of Merit's cross pads enables you to see through to the contact area, and provides greater flexibility than square pads to conform to variable internal diameters
- Used for close-tolerance polishing of small radii and channels, deburring, and finishing of bell-mouth configurations
- All pads are furnished with standard quick-change eyelet, as listed
- Plain hole sizes must be specified

L x W x T	PLY	EYELET	GRIT	STD. PKG.	PART NO.	PART NO.
3/4 x 3/4 x 3/8	8	3-48	80	100		08834185578
1 x 1 x 3/8	8	3-48	60	100		08834184943
			80			08834185519
			100			08834184195
			120			08834185164
1-1/2 x 1-1/2 x 1/2	8	8-32	60	100	66261194496	08834184258
			80		66261194508	08834184465
			100			08834182196
			120		66261194511	08834182148
2 x 2 x 1/2	8	8-32	60	100		08834182156
			80			08834182157
			120			08834182132
2 x 2 x 3/4	8	8-32	60	100	66261194502	08834184128
			80		66261194513	08834184194
			120		66261194516	08834184285
2 x 2 x 1	8	8-32	120	100		08834184805
2-1/4 x 2-1/4 x 1/2	8	8-32	80	100		08834184402
2-1/2 x 2-1/2 x 3/4	8	8-32	80	100		08834184206
			120			08834184074
3 x 3 x 1	8	1/4-20	60	100	66261194504	08834182135
			80		66261194549	08834184119
			120		66261194551	08834184116
3 x 3 x 1	10	1/4-20	80	100		08834182140
3 x 3 x 1-1/2	10	1/4-20	80	100		08834182184
4 x 4 x 1	8	1/4-20	60	100		08834184142
			80			08834184135
			120			08834184377
4 x 4 x 1-1/2	8	1/4-20	80	100		08834184129
			120			08834184370

# Specialties – Square Pads, Cross Pads, Overlap Slotted Discs



## Overlap Slotted Discs



TIER:

**BEST**

**GOOD**

**GOOD**

ABRASIVE:

Merit Blaze  
Ceramic Alumina

Merit Aluminum Oxide

Merit Aluminum Oxide

OTHER:

Supersized, 2-Ply

2 Per Set

4 Per Set

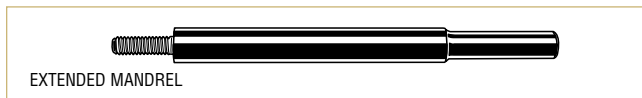
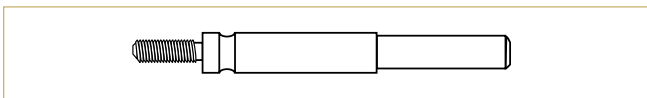
DIA.	EYELET	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.	
1	8-32	60	100		08834184346		
		80			08834184019	08834184085	
		100			08834184224		
		120			08834184151	08834184236	
		180			08834185078		
1-1/4	8-32	60	100		08834184270		
		80			08834184065		
		100			08834184291		
		120			08834184084		
1-1/2	8-32	60	100	66261195051	08834184066		
		80		66261195368	08834184079		
		100			08834184279	08834184023	
		120		66261195367	08834186035		
		180			08834184498		
1-3/4	8-32	60	100		08834184655		
		80			08834184042		
2	8-32	60	100	66261195054	08834184076		
		80		66261195055	08834184145		
		100			08834184055		
		120		66261195056	08834184444		
2-1/2	8-32	80	100		08834184444		
3	1/4-20	50	100		08834184818		
		60			66261195057	08834184041	
		80			66261195058	08834184077	
		100				08834184082	
		120			66261195059	08834184344	
4	1/4-20	60	100		08834184000		
		100			08834184159		
		120			08834185155		
4-1/2	1/4-20	100	100		66261029934		
		120			08834184431		
5	1/4-20	100	100		08834184302		

ALL OVERLAP SLOTTED DISCS ARE AVAILABLE (MADE-TO-ORDER) REINFORCED WITH A FIBER WASHER

## Quick-Change Mandrels for Overlap Slotted Discs, Square and Cross Pads

CROSS PAD SIZE DIA.	SQUARE PAD SIZE DIA.	OAL	MODEL NO.	THD. SIZE	PART NO.
1/4, 3/8, and 1/2 wide		2-1/2	MM48-4	3-48	08834183162
3/4, 1 wide	Up thru 1-1/2 sq. x 1/2 thick 2 sq. x 1/4 or 3/8 thick	3	MM32-4	8-32	08834183163
		4	MM-32-4-4	8-32	08834121680
		6	MM-32-4-6	8-32	08834121681
All pads 2-1/2 x 1-1/2 and larger	2 sq. x 1/4 or 1/2 thick and larger	3	MM20-4	1/4-20	08834183164

FOR OVERLAP SLOTTED DISCS, CHOOSE A MANDREL WITH THE SAME THREAD SIZE AS THE DISC



EXTENDED MANDREL



Flaps of abrasive cloth are stacked, inserted into a holder, and then attached to a mandrel. The flaps are designed to break down during use and reveal the next layer of abrasive.

Cloth flaps are mixed with non-woven flaps to create an interleaf bore polisher.

**APPLICATIONS:** For deburring, sizing, cleaning and polishing the interior diameters of cylinders, tubes and hydraulic fittings. Flaps adjust automatically to inside diameter, polishing the entire surface area with each pass.

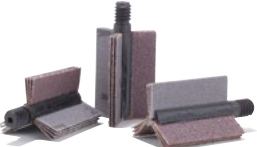




Bore polishers are self-centering, so they apply equal pressure to full wall of inside diameter. Spring action design gives faster inside diameter cleaning, deburring and polishing to cylinders, deep bores and tubes.

Interleafed bore polishers are designed to polish and finish in one easy application. The abrasive flaps cut, while the non-woven flaps apply a fine finish.

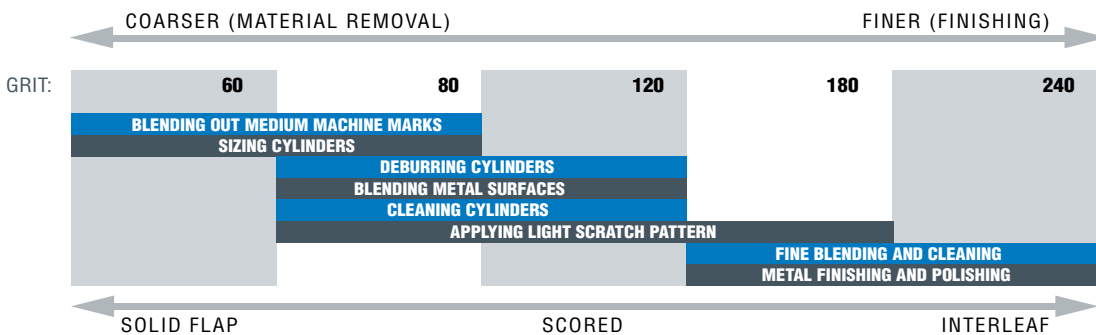
**GRIT RANGE:** 60 - 240

**ABRASIVE GRAIN:** Aluminum Oxide

## APPLICATION-TO-PRODUCT SHAPE RECOMMENDATION GUIDE

SHAPE	APPLICATION
 <p><b>Bore Polisher</b> <b>Solid Flaps</b> <b>B-3 Series</b></p>	<ul style="list-style-type: none"> <li>For 5/8" to 1" interior diameter bores</li> <li>3 abrasive packs 1-1/2" wide, bonded to hub</li> <li>Use with QC-5 mandrel Part No. 08834154182</li> </ul>
 <p><b>Bore Polisher</b> <b>Solid Flaps</b> <b>B-4 Series</b></p>	<ul style="list-style-type: none"> <li>For 1" to 4" interior diameter bores</li> <li>4 abrasive packs 1-1/2" wide, bonded to hub</li> <li>Use with BPM-4 mandrel Part No. 08834154183</li> </ul>
 <p><b>Bore Polisher</b> <b>Solid Flaps</b> <b>B-8 Series</b></p>	<ul style="list-style-type: none"> <li>For 2" to 5-7/8" interior diameter bores</li> <li>8 abrasive packs 1-1/2" wide, bonded to hub</li> <li>Use with BPM-8 mandrel Part No. 08834154184</li> </ul>
 <p><b>Bore Polisher</b> <b>Scored Flaps</b></p>	Available upon request
 <p><b>Bore Polisher</b> <b>Interleaf</b></p>	Merit interleaf bore polishers do double duty. Designed to polish and finish in one easy application, they are the ideal choice when close tolerances must be maintained while giving an interior a polished finish.

## APPLICATION/GRIT RECOMMENDATION GUIDE



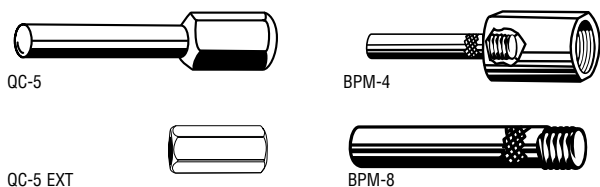
# Specialties – Bore Polishers

## Merit Aluminum Oxide Bore Polishers

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART NO.	TIER:
					<b>GOOD</b>
					ABRASIVE:
					Aluminum Oxide
					BACKING:
					X-wt. Cotton/Poly
<b>Bore Polishers – Solid Flap B-3 and B-4 Series</b>					
B-305	60	25,000	10	08834154190	
Fits I.D. 5/8 to 1	80			08834154191	
	120			08834154193	
	180			08834154195	
	240			08834154197	
B-405	60	22,000	10	08834154091	
Fits I.D. 1 to 1-1/2	80			08834154092	
	120			08834154093	
	180			08834154094	
B-410	60	20,000	10	08834154100	
Fits I.D. 1-1/2 to 2	80			08834154101	
	120			08834154102	
	180			08834154103	
	240			08834154104	
B-415	60	16,000	10	08834154109	
Fits I.D. 2-1/8 to 2-1/2	80			08834154110	
	120			08834154111	
	180			08834154112	
	240			08834154113	
B-420	60	15,000	10	08834154118	
Fits I.D. 2-1/2 to 3	80			08834154119	
	120			08834154120	
	180			08834154121	
	240			08834154122	
B-425	60	10,000	10	08834154127	
Fits I.D. 3-1/8 to 4	80			08834154128	
	120			08834154129	
	180			08834154130	
	240			08834154131	

STANDARD PACKAGE = 1

## Mandrels for Bore Polishers



DESCRIPTION	MODEL NO.	THREAD	PART NO.
For B-3 Series	QC-5	5/16-18	08834154182
For B-4 Series	BPM-4	1/2-20	08834154183
For B-8 Series	BPM-8	1/4-20	08834154184
QC-5 Ext.	QC-5 Ext.	5/16-18	08834150573

STANDARD PACKAGE = 1

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART NO.	TIER:
					<b>GOOD</b>
					ABRASIVE:
					Aluminum Oxide
					BACKING:
					X-wt. Cotton/Poly
<b>Bore Polishers – Solid Flap B-8 Series</b>					
B-810	60	16,000	10	08834154136	
Fits I.D. 2 to 2-1/2	80			08834154137	
	120			08834154138	
	180			08834154139	
	240			08834154140	
B-815	60	15,000	10	08834154145	
Fits I.D. 2-5/8 to 3	80			08834154146	
	120			08834154147	
	180			08834154148	
	240			08834154149	
B-820	60	10,000	10	08834154154	
Fits I.D. 3-1/8 to 4	80			08834154155	
	120			08834154156	
	180			08834154157	
	240			08834154158	
B-825	60	8,000	10	08834154163	
Fits I.D. 4-1/4 to 5-1/4	80			08834154164	
	120			08834154165	
	180			08834154166	
	240			08834154167	
B-830	60	8,000	10	08834154172	
Fits I.D. 5-1/4 to 5-7/8	80			08834154173	
	120			08834154174	
	180			08834154175	
	240			08834154176	

### Bore Polishers – Scored Flaps

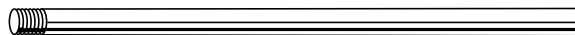
Available on request

### Bore Polishers – Interleaf

B-405 Interleaf	80	22,000	10	08834150271
Fits ID 1 to 1-1/2	180			08834150273
B-410 Interleaf	80	20,000	10	08834150275
Fits ID 1-1/2 to 2				

STANDARD PACKAGE = 1

## Extension Mandrels for Bore Polishers



DIAMETER X LENGTH	MODEL NO.	PART NO.
1/4 x 4 x 1/4-20 Thread	EM-144	08834154185
1/4 x 6 x 1/4-20 Thread	EM-146	08834154186
1/4 x 8 x 1/4-20 Thread	EM-148	08834154187

To extend a B-3 series bore polisher, attach the QC-5 Ext. to the bore polisher, then attach the desired length extension mandrel above to the QC-5 Ext. To extend a B-4 series bore polisher, attach the adapter piece of the BPM-4 mandrel to the bore polisher, then attach the desired length extension mandrel above to the BPM-4 adapter piece. To extend a B-8 series bore polisher, attach the desired length extension mandrel above directly to the bore polisher. Standard package = 1.

## Test Kit

### Merit Bore Polisher Test Kit “BP”

- Part No. 08834154181
- Contains ten bore polishers and two mini 1/4"-20 thread flap wheels in assorted sizes and grits for finishing 1" to 5" interior diameters, and mandrel for 1/4" chuck.







FlexDrum's abrasive cloth sweeps away flaws. Its extreme longevity and perfect balance make it well-suited for automatic as well as offhand use. Hubs and abrasive segments can be combined to fit your job perfectly.

APPLICATIONS	Blending out parting lines on castings, smoothing out pre-ground welded areas, removing burrs and work flaws, graining stainless, brush-finishing and satin-finishing aluminum, removing rust, deflashing molded plastic and rubber parts, and preparing surfaces for painting or plating.
SIZE RANGE:	Diameter of loaded FlexDrum: 8" – 18" Width of FlexDrum: 1-1/2" – 12" Custom die-cut segments as well as extra wide segments, in widths up to 144" are also available
GRIT RANGE:	50 – 240
BOND:	Resin or glue
BACKING:	Heavyweight cotton
ABRASIVE GRAIN:	Premium Aluminum Oxide

## SHAPE/APPLICATION RECOMMENDATION GUIDE



### Plain Segment

- For flat or mildly contoured surfaces



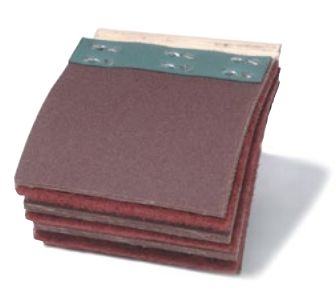
### 1/4 Scored (SC) Segment

- Great for complex parts
- Provides a fine finish



### 1/2 Slash (SL) Segment

- Great for mild and moderate contours



### Interleaf Segment

- Available upon request

## LOADING FLEX DRUM HUBS



FlexDrum hub end plate removes for easy loading of abrasive segments.



Custom profiled segments eliminate break-in resulting in maximum productivity. Contact your sales representative for more information.

# Specialties – FlexDrum

## Plain Segments – for flat or mildly curved surfaces

### AVAILABILITY

		GOOD							
TIER:									
BRAND:		Merit	Merit	Merit	Merit	Merit	Merit	Merit	
ABRASIVE:		A/O	A/O	A/O	A/O	A/O	A/O	A/O	
GRIT:		50	60	80	100	120	180	240	
WIDTH	TRIM LENGTH*	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	
1-1/2	2-3/4	12	08834155002	08834155003	08834155004		08834155006	08834155008	08834155010
2	2-3/4	12	08834155013	08834155014	08834155015	08834155016	08834155017	08834155019	
2	4	20	08834155312	08834155313	08834155314	08834155315	08834155316	08834155318	
2	5	20		08834155568	08834155569		08834155571	08834155573	08834155575
3	2-3/4	12	08834155025	08834155026	08834155027	08834155028	08834155029	08834155031	
3	4	20	08834155324	08834155325	08834155326		08834155328	08834155330	
3	5	20		08834155579			08834155582	08834155584	
4	2-3/4	12	08834155036	08834155037	08834155038	08834155039	08834155040	08834155042	08834155044
4	4	20	08834155336	08834155337	08834155338	08834155339	08834155340	08834155342	08834155344
4	5	20		08834155590			08834155593	08834150390	08834155953

## 1/4 Scored Segments – for complex parts and provide a fine finish

### AVAILABILITY

		GOOD								
TIER:										
BRAND:		Merit	Merit	Merit	Merit	Merit	Merit	Merit		
ABRASIVE:		A/O	A/O	A/O	A/O	A/O	A/O	A/O		
GRIT:		50	60	80	100	120	180	240		
WIDTH	TRIM LTH.*	SCORE	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	
1-1/2	2-3/4	1/4	12	08834155082	08834155083	08834155084	08834155085	08834155086	08834155088	08834155090
2	2-3/4	1/4	12	08834155094	08834155095	08834155096	08834155097	08834155098	08834155100	08834155102
3	2-3/4	1/4	12	08834155106	08834155107	08834155108	08834155109	08834155110	08834155112	
4	2-3/4	1/4	12	08834155117	08834155118	08834155119	08834155120	08834155121	08834155123	

## 1/2 Slashed Segments – for mild and moderate contours

### AVAILABILITY

		GOOD								
TIER:										
BRAND:		Merit	Merit	Merit	Merit	Merit	Merit	Merit		
ABRASIVE:		A/O	A/O	A/O	A/O	A/O	A/O	A/O		
GRIT:		50	60	80	100	120	180	240		
WIDTH	TRIM LTH.*	SLASH	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	
2	4	1/2	20		08834155420	08834155421	08834155422	08834155423	08834155425	08834155427
2	5	1/2	20			08834155637		08834155639		
3	4	1/2	20	08834155430	08834155431	08834155432	08834155433	08834155434	08834155436	08834155438
3	5	1/2	20			08834155648				
4	4	1/2	20	08834155443	08834155444	08834155445	08834155446	08834155447	08834155449	08834155451
4	5	1/2	20		08834155658	08834155659		08834155661	08834150383	

\*TRIM LENGTH IS THE ACTUAL USABLE LENGTH OF SEGMENT WHEN LOADED

COATED ABRASIVES

## TECHtip

FlexDrums can be used for polishing large IDs. Just load half the segments with a wheel diameter 1/2" to 1" larger than the ID of your workpiece.

## Hub Units

- FlexDrum hubs are perfectly balanced, last indefinitely and are available in widths from 1-1/2" to 12"
- Extra wide widths available up to 144"

MODEL NO.	D x W	ARBOR HOLE/THREAD	SEGMENTS PER HUB	PART NO.
<b>FlexDrum Hub Units</b>				
81.5-B	2-3/8 x 1-1/2	1 AH	12	08834140065
82-B	2-3/8 x 2	1 AH	12	08834141049
		5/8-11 THD		08834140048
83-B	2-3/8 x 3	1 AH	12	08834141018
		5/8-11 THD		08834140034
84-B	2-3/8 x 4	1 AH	12	08834140066
		5/8-11 THD		08834140049
122-B	4 x 2	1-1/4 AH	20	08834140050
123-B	4 x 3	1-1/4 AH	20	08834140051
124-B	4 x 4	1-1/4 AH	20	08834140061
142-B	6 x 2	1-1/4 AH	30	08834140062
143-B	6 x 3	1-1/4 AH	30	69957399208
144-B	6 x 4	1-1/4 AH	30	08834141060
840-B2	8 x 2	1-1/4 AH	40	63642592550
840-B4	8 x 4	1-1/4 AH	40	63642592548



**2-3/8" DIAMETER HUB  
WITH 1" ARBOR HOLE**  
8" WHEEL WHEN LOADED



**2-3/8" DIAMETER HUB ALSO  
AVAILABLE WITH 5/8"-11 ARBOR**  
8" WHEEL WHEN LOADED



**4" DIAMETER HUB**  
12" WHEEL WHEN LOADED



**8" DIAMETER HUB**  
16" OR 18" WHEEL WHEN LOADED



**6" DIAMETER HUB**  
14" OR 16" WHEEL WHEN LOADED

# Specialties – FlexDrum

## FlexDrum Reference Charts

FlexDrum can be mounted on any type of arbor.

### Weights

DIAMETER	WEIGHT
<b>Weight of Hubs*</b>	
4 diameter hub	1.5 lbs./inch of width
6 diameter hub	2 lbs./inch of width
8 diameter hub	2.5 lbs./inch of width
<b>Weight of Hubs with Segments*</b>	
4 diameter hub	3.4 - 4 lbs./inch of width
6 diameter hub	5 - 5.5 lbs./inch of width
8 diameter hub	6.75 - 7 lbs./inch of width

\*APPROXIMATE VALUES. ACTUAL WEIGHT WILL DEPEND ON ABRASIVE TYPE AND OVERALL WIDTH OF HUB.

### FlexDrum Maximum RPM

WHEEL DIAMETER	MAXIMUM RPM
8	4,500
12	3,000
14	2,500
16	2,200
18	2,000

### Recommended H.P. Required

HUB	H.P.
4 diameter hub	1/2 H.P./inch of width
6 diameter hub	3/4 H.P./inch of width
8 diameter hub	1 H.P./inch of width

### Recommended Surface Feet per Minute for using FlexDrum Wheels on Various Materials

MATERIAL	SFPM
Mild Steel	5,000
Stainless Steel	6,500
Alloy Steel	5,000
Titanium	3,500
Hard Aluminum	5,500
Nonferrous	5,000
Rubber	4,500
Hardwood (edge breaking)	4,000
Softwood	3,500
Thermoplastic	3,000



### FlexDrum Hub Specification Chart

	82-B	121-B	141-B	840-B
Diameter of Finished Wheel	8	12	14 or 16	16 or 18
Diameter of Hub Alone	2-3/8	4	6	8
Arbor Hole	1 or 5/8-11 thd	3/4 to 1-3/4	1 to 3-1/2	1-1/4 to 5
Segments Per Hub	12	20	30	40

### How to determine Diameter of Finished FlexDrum

HUB DIAMETER	+	TRIM LENGTH (X2)	=	FINISHED WHEEL
2-3/8		2-3/4		8
4		4		12
4		5		14
6		4		14
6		5		16
8		4		16
8		5		18

## TECHtip

For surface feet per minute, use the following calculation: SFPM=.262 x DIA (in inches) x RPM.



## How to Read a Coated Abrasive Specification

A coated abrasive product is made up of three basic raw materials: an *abrasive mineral*, the *backing* onto which the abrasive is applied, and an *adhesive bond*. The Carborundum Abrasives coated abrasive marking system includes both a generic and a technical marking.

The generic markings identify the abrasive type, bond, backing, and any special features and/or tradenames. An example would be: *Premier Red Aluminum Oxide Dri-Lube Resin Paper Open*.

The technical markings identify the actual components which make up the product. Technical markings consists of up to 10 parts. An example would be: *P400 B 0912 DO*. The following terminology explains the technical marking system.

## Coated Abrasive Terminology Key

GRADING		GRIT SIZE	BACKING	CLOTH TYPE	BACKING FLEXIBILITY	MINERAL	BACKING	BOND	PERFORMANCE	COATING
P	FEPA	12	Paper:	B Poly/ Cotton	F Flexible	00 Cork	0 Mesh	0 Glue	A Anti-Static	O Open Coat
	ANSI		A			01 Crocus	1 Paper	1 U/G		
		2000	B	Blend	Standard	02 Emery	2 Comb.	2 U/U	D Dri-Lube	Closed Coat
			C	C Cotton	S Stiff	03 Garnet	3 Film	3 R/G	Oversizee	
			D			04 S/C (Silicon Carbide)	4 Fiber	or U		
			E			05 WA (White A/O)			R Reactive	
			F	G Glass		06 PA (Pink A/O)	Cloth:	Full Resin:	Oversize	
						07 LBA (Light Brown A/O)	5 Most	4 Least		
						08 A/O (Aluminum Oxide)	Flexible	Durable	W Washable	or
			Cloth:	N Poly/ Nylon		09 HT A/O (Heat-Treated)			Waterproof	
			J			10 Open				
		9.5	X			11 ZA (Zirconia Alumina)				
		Micron	Y	P Polyester		12 ZA (Premium)	9 Least	9 Most		
						23 SG (Reduced Ratio)	Flexible	Durable		
		1/0	T Comb.	R Rayon		24 Open (SG-Ceramic Alumina)	Performance Rating			
		2/0	M Mesh			25 SG (Full Ratio)				
		3/0	V Fiber			40 S/C-Cork Super Finishing				
		4/0	P Film			80 A/O-Cork Super Finishing				

## Abrasive Types

### EMERY (02)

Emery is a dark gray, round-shaped grain which tends to polish rather than abrade a work surface.

- for polishing and cleaning metal only

### GARNET (03)

Garnet is reddish brown in color. This natural abrasive is medium hard and relatively sharp, but not as durable as synthetic abrasives.

- for use on wood only
- particularly good for soft woods such as pine
- produces an excellent finish

### SILICON CARBIDE (04)

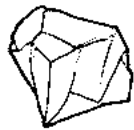
Silicon carbide is the hardest and sharpest of the manufactured abrasives. Because of its extreme sharpness, this bluish-black abrasive grain permits fast stock removal and cool cut.

- cast iron
- non-ferrous metals, i.e. brass, aluminum and bronze
- non-metallics, i.e. glass, rubber, plastic and stone
- final finish on wood and stainless steel
- abrasive planing particleboard

### LIGHT BROWN ALUMINUM OXIDE (07)

Light brown aluminum oxide is a tough, yet sharp, synthetic abrasive characterized by cool cut, long life and the ability to break down under pressure, producing new cutting edges.

- production wood sanding
- non-ferrous metal finishing



### BROWN ALUMINUM OXIDE (08)

Brown aluminum oxide is a tough, durable, synthetic abrasive characterized by the long life and wear resistance of its cutting edges. It offers enormous penetrating strength, even at high speeds.

- ferrous metals
- aluminum
- hardwood

### HEAT-TREATED ALUMINUM OXIDE (09)

Heat-treated aluminum oxide is a tough but cool cutting abrasive which gives both long life and freeness of cut on a wide range of materials.

- ferrous metals
- wood sanding

### ZIRCONIA ALUMINA (11, 12)

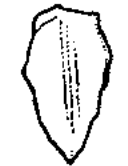
Zirconia alumina is an ultra-tough, synthetic abrasive which provides a free, cool cut for high stock removal applications. It is tougher and sharper than aluminum oxide. It has a micro-crystalline structure which allows for controlled breakdown and self-sharpening.

- heavy-duty snagging and grinding of all ferrous and non-ferrous metals
- abrasive planing of wood, plywood and particleboard
- grinding fiberglass, rubber and plastics

### CERAMIC ALUMINA (25)

The sub-micron structure of ceramic alumina allows each grain to continually expose sharp cutting points, resulting in a cooler cutting action and an extended life.

- all ferrous/non-ferrous metals, carbon steel and exotic alloys



## Grit Comparison Chart

AVERAGE PARTICLE SIZE IN MICRONS	GRADING SYSTEMS (OTHER THAN EMERY)			EMERY PRODUCTS
	CAMI	FEPA	JIS	
5.0	-	-	-	-
6.0	-	-	3000	-
6.5	1200	-	2500	4/0
8.4	-	P2500	-	-
8.5	-	-	2000	-
9.2	1000	-	-	3/0
10.3	-	P2000	-	-
10.5	-	-	1500	-
12.2	800	-	1200	-
12.6	-	P1500	-	-
15.0	-	-	-	-
15.3	-	P1200	1000	-
16.0	600	-	-	2/0
18.3	-	P1000	800	-
19.7	500	-	-	0
20.0	-	-	-	-
21.8	-	P800	-	-
23.6	400	-	600	-
25.0	-	-	-	-
25.75	-	P600	-	-
28.8	360	-	500	-
30.0	-	P500	-	-
35.0	-	P400	400	-
36.0	320	-	-	-
40.0	-	-	360	-
40.5	-	P360	-	-
44.0	280	-	-	1
45.0	-	-	-	-
46.2	-	P320	320	-
50.0	-	-	-	-
52.5	-	P280	280	-
53.5	240	-	-	-
55.0	-	-	-	-
58.5	-	P240	-	-
60.0	-	-	240	-
64.0	-	-	-	2
65.0	-	P220	220	-
66.0	220	-	-	-
78.0	180	P180	180	-
79.0	-	-	-	3
93.0	150	-	150	-
95.0	-	-	-	FINE
97.0	-	P150	-	-
116.0	120	-	120	-
127.0	-	P120	100	-
136.0	-	-	-	MEDIUM
141.0	100	-	-	-
156.0	-	P100	-	-
189.0	-	-	-	COARSE
192.0	80	-	80	-
197.0	-	P80	-	-
260.0	-	P60	-	-
268.0	60	-	60	-
326.0	-	P50	50	-
341.0	-	-	-	EX. COARSE
351.0	50	-	-	-
412.0	-	P40	40	-
428.0	40	-	-	-
524.0	-	P36	-	-
535.0	36	-	36	-
622.0	-	P30	-	-
638.0	30	-	30	-
715.0	24	-	-	-
740.0	-	P24	24	-
905.0	20	-	-	-
984.0	-	P20	20	-
1320.0	16	-	16	-
1324.0	-	P16	-	-
1764.0	-	P12	-	-
1842.0	12	-	-	-

## Backing Types

Backings are the base for the abrasive minerals and, combined with the adhesive bond, support and anchor the abrasive mineral. The backings used in the manufacture of coated abrasives are:

### PAPER

Paper is used for a variety of operations from hand sanding to mechanical sanding. It is the least expensive backing. Due to the fine surface of paper, a consistent finish is produced. Paper weights include *A, B, C, D, E* and *F* weights with *A* being the lightest and most flexible and *F* being the heaviest and least flexible. *A, B, C* and *D* weight papers are used for hand sanding and light mechanical operations in the form of sheets, *Grip-On* and *Stick-On* discs and *Stick-On* rolls. *E* and *F* weight papers are primarily used for more aggressive mechanical operations in the form of belts and discs.

### CLOTH

Cloth backings used for coated abrasives are identified by weight. Cloth backings are filled or "finished" with a variety of materials, glues or resins, to create various backing characteristics, most notably flexibility.

There are three basic weights of cloth: *J-weight* or "jeans" is the lightest and most flexible. *X-weight* or "drills" is a heavier cloth that ranges in flexibility, strength and durability and is used on the broadest range of applications. *Y-weight* is a heavyweight drills cloth used on heavy-duty, high stock removal operations. Several cloth types are used: cotton, polyester, and polyester/cotton blends.

### FIBER

Vulcanized fiber (cotton fibers which are chemically treated and then pressed under temperature and pressure to form a very durable backing) is used exclusively as the backing for resin fiber discs.

## Bond Types

An adhesive bond system is required to secure the abrasive mineral to the backing. All coated abrasive products are made with a two-stage bonding process. The first layer of bond applied to the backing is called the *make coat*. The make coat provides the adhesive base between the abrasive mineral and the backing.

The second coat is the *size coat*, which is applied over the abrasive mineral and make coat to anchor the abrasive mineral and provide the desired physical strength of the finished product.

*Glue, urea resin, and phenolic resin* are the three basic bonding agents most commonly used. There are many size coat and make coat combinations, such as *glue over glue, urea over glue, and resin over resin*. *Glue over glue* is the most flexible bond while *resin over resin bond* is moisture-resistant, harder, less flexible, heat-resistant and has superior grain retention.

## Coating Types

There are two types of abrasive coatings used in the manufacturing of coated abrasives: *open coat* and *closed coat*.

### OPEN COAT

With an open coat, 50% to 75% of the coated abrasive surface is covered by abrasive grain. There are evenly spaced voids between the particles of grain, helping reduce the effect of loading caused by wood dust or metal particles.

### CLOSED COAT

With a closed coat, the entire coated abrasive surface is covered with abrasive grain, with no voids between the particles. This is the most typical coating, permitting the greatest degree of stock removal and longest product life.



**OPEN COAT**  
(1/3 LESS GRAIN THAN  
CLOSED COAT)



**CLOSED COAT**

## Non-Woven Silicon Carbide Surface Strip Depressed Center Wheels

### Features

- Open web construction
- Extra coarse grit
- Thick and durable

### Benefits

- Smear resistant formula
- Resist loading
- Quick cleaning and conditioning of surfaces

An open web construction quickly and easily cleans and conditions a multitude of materials, with very little loading. Excellent for removal of surface rust and residue, corrosion, light weld splatter, dirt, mill scale and other similar surface contaminants.



### Major applications include:

- preparing surfaces before welding
- cleaning and conditioning after welding
- surface preparation before coatings are applied
- paint and epoxy coating removal



PART NO.	GRIT/ABRASIVE	COLOR	MAX. RPM	WHLs/CASE
<b>4-1/2" x 5/8-11"</b>				
05539562616	Extra Coarse S/C	Black	12,000	10
<b>4-1/2" x 7/8"</b>				
05539562615	Extra Coarse S/C	Black	12,000	10
<b>7" x 5/8-11"</b>				
05539562618	Extra Coarse S/C	Black	8,000	10
<b>7" x 7/8"</b>				
05539562617	Extra Coarse S/C	Black	8,000	10

## Non-Woven Surface Finish Depressed Center Wheels

### Features

- Fine grain particle concentration cleans and polishes while imparting final finishes on a variety of materials
- Advanced resin system
- Low density
- Undersized backing
- CFX-2MA
- CFX-2FA
- CFX-2FS
- Medium A/O High Strength

### Benefits

- Increases productivity and reduces total abrasive costs by eliminating a grinding step
- Resists loading: smear-free, clean, fine finishes
- Conformable and flexible
- Maximizes grinding area and usage for longer life
- Most aggressive
- Multi-purpose
- Polishing
- Less aggressive, most conformable

Can be used in place of, or in sequence with, fiber and flap discs, to clean, polish and impart great finishes in one or two operations.



Surface Finish depressed center wheels will work anywhere our Surface Strip products work.

Use Surface Finish when a less aggressive product is needed.

### Major applications include:

- prepping surfaces
- removing light scale on electrical power generation components (beryllium, copper, brass and bronze), composite and fiberglass resins, surface impurities from aluminum tubing, weld discoloration, over-spray from powder coating and painting operations
- cleaning and polishing injection molds, paper mill rolls, stainless steel, and ferrous and nonferrous metal surfaces

PART NO.	GRIT/ABRASIVE	MAX. RPM	WHLs/CASE
<b>4-1/2" x 5/8"-11</b>			
66261023940	CFX-2MA	12,000	10
66261023910	CFX-2FA	12,000	10
66261023909	CFX-2FS	12,000	10
66261023942	Medium A/O High Strength	12,000	10
<b>4-1/2" x 7/8"</b>			
66261021754	CFX-2MA	12,000	10
66261021758	CFX-2FA	12,000	10
66261021750	CFX-2FS	12,000	10
66261021761	Medium A/O High Strength	12,000	10

# Non-Woven E-ZView Edger Flex-Loc Discs

## Non-Woven A/O Resin E-ZView Edger Flex-Loc Discs

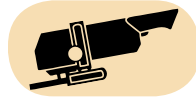
### Features

- Non-woven web design
- Advanced resin system
- Round edge shape
- Scooped holes
- Flex-Loc mount
- Redesigned center-hole locking mechanism

### Benefits

- Conformable, controlled cutting action
- Minimizes undercutting and gouging
- Resists loading
- Ideal for reaching into grooves, sharp edges, and hard-to-grind corners where work is done at a steeper angle
- Allow operator to see the surface area being ground
- Create air flow to remove swarf – preventing loading – and a 30% cooler cutting action than conventional discs
- Quick, tool-free changing of discs
- Elimination of hole slippage or spinning
- Discs are easily mounted and stay securely in place at all times.

Deliver a consistent finish when used to clean, deburr, blend or finish all types of metal and plastic. Ideal for the removal of rust, oxidation and coatings.

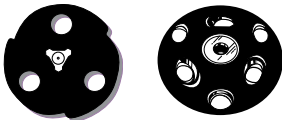


**Allows operator to see surface being ground!**

PART NO.	GRIT/ABRASIVE	COLOR	DISCS/CASE
<b>4-1/2" Non-Woven E-ZView Edger Flex-Loc Discs</b>			
05539563955	Coarse A/O	Brown	40
05539563956	Medium A/O	Maroon	40
05539563957	Very Fine A/O	Blue	40

PART NO.	GRIT/ABRASIVE	COLOR	DISCS/CASE
<b>7" Non-Woven E-ZView Edger Flex-Loc Discs</b>			
05539563960	Coarse A/O	Brown	40
05539563959	Medium A/O	Maroon	40
05539563958	Very Fine A/O	Blue	40

## Back-up Pads for E-ZView Edger Flex-Loc Discs



63975, 63019,  
63395

63835, 63836

Designed exclusively for use with E-ZView Edger Flex-Loc Discs. These back-up pads allow easy, tool-free mounting. The mounting hole and recessed lock-nut automatically line disc up with back-up pad and allow more disc to contact work surface.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-up Pads for E-ZView Edger Flex-Loc Discs</b>			
05539563975	4-1/2 x 5/8"-11 Sawtooth	13,000	5
05539563019	5 x 5/8"-11 Sawtooth	13,000	5
05539563395	5 x 7/16"-20 Pistol Grip Sawtooth	20,000	5
05539563835	7 x 5/8"-11 Round Hard, Thicker	8,600	5
05539563836	7 x 5/8"-11 Round Medium, Thicker	8,600	5





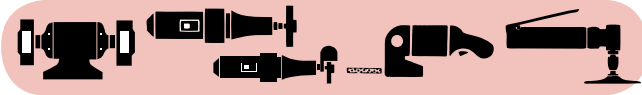
## Non-Woven Silicon Carbide Surface Strip Discs

### Features

- Open web construction
- Extra coarse grit
- Thick and durable
- 2" and 3" discs with Flex-Loc TR fastener
- Thick, durable 4" Flex-Loc TR+ disc with a more open web construction and longer TR shank

### Benefits

- Smear resistant formula
- Resist loading
- Quick cleaning and conditioning of surfaces
- Quick, tool-free disc changes allow more grinding time
- Resists loading; extended life
- Can be used on face and edge
- Quick-change replacement



An open web construction quickly and easily cleans and conditions a multitude of materials, with very little loading. Excellent for removal of surface rust and residue, corrosion, light weld splatter, dirt, mill scale and other similar surface contaminants.

### Major applications include:

- preparing surfaces before welding
- cleaning and conditioning after welding
- surface preparation before coatings are applied
- paint and epoxy coating removal

PART NO.	GRIT/ABRASIVE	COLOR	MAX. RPM	DISCS/CASE
<b>2" Flex-Loc TR</b>				
05539564097	Extra Coarse S/C	Black	15,500	10
<b>3" Flex-Loc TR</b>				
05539564098	Extra Coarse S/C	Black	12,000	10
<b>4" Flex-Loc TR+</b>				
05539573903	Extra Coarse S/C	Black	8,000	5



PART NO.	GRIT/ABRASIVE	COLOR	MAX. RPM	DISCS/CASE
<b>4" x 1/4"</b>				
05539563438	Extra Coarse S/C	Black	8,000	25
<b>4" x 3/8"</b>				
05539562614	Extra Coarse S/C	Black	8,000	25
<b>4" x 1/2"</b>				
05539527164	Extra Coarse S/C	Black	8,000	25
<b>6" x 1/4"</b>				
05539563439	Extra Coarse S/C	Black	5,500	15
<b>6" x 1/2"</b>				
05539527163	Extra Coarse S/C	Black	5,500	15

## Back-up Pads for Flex-Loc TR Discs



### For Flex-Loc TR Discs

Molded rubber pad with a 1/4" steel shank for quick mounting. Unique locking device on face provides convenience and quick change.

PART NO.	DIAMETER/DESCRIPTION	MAX. RPM	PADS/CASE
<b>Back-Up Pads for Flex-Loc TR Discs</b>			
77696061650	4" Flex-Loc TR+ Medium	8,000	10

# Non-Woven Discs



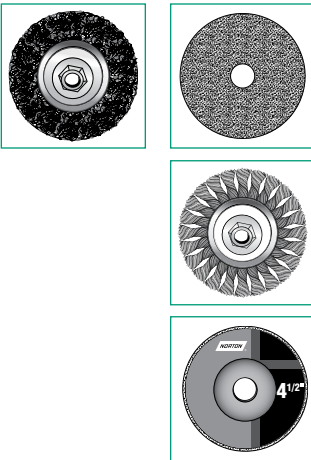
Non-woven right angle discs have three components: strong synthetic fiber mesh and quality abrasives, bonded together by a smear-resistant adhesive. Power Strip discs have an open web construction that enables aggressive cutting action while inherently maintaining a cool, non-loading surface. Surface Preparation discs have a more open weave that excels in preparation and cleaning of a surface. Each product provides excellent cutting action while improving surface finish.

The non-woven web is attached to a fiberglass backing plate (Power Strip depressed center wheels) for direct mounting or onto a woven substrate backing (Surface Prep discs) for mounting on a rubber back-up pad.

- APPLICATIONS:** Medium-to-light material removal, deburring, blending, cleaning, finishing, and polishing
- SIZE RANGE:** 4-1/2" - 7" / 7/8" plain hole or 5/8"-11 mount
- GRIT RANGE:** X-Coarse, Coarse, Medium, Fine, Very Fine
- ABRASIVE GRAIN:** Silicon Carbide, Aluminum Oxide
- BACKING PLATE:** Fiberglass
- BACK-UP PAD:** Rubber

## Right Angle Discs

### WHY CHOOSE NON-WOVEN RIGHT ANGLE DISCS?



### Non-Woven Right Angle Discs vs. Fiber Discs, Wire Wheels, and Depressed Center Wheels

- Deburring, blending and finishing done with one product to reduce the number of steps
- To provide a controlled, sustained finish
- To prevent undercutting and gouging
- To provide a cooler grinding action to lessen the chance of warping or discoloration
- When loading is an issue with fiberglass, adhesives and soft metals
- For stripping coatings and paint off of hard materials like concrete, cement and stone
- Less vibration and quieter for high operator acceptance
- To provide a safe alternative to wire brushes



### Merit Power Strip Discs

TIER:	<b>GOOD</b>
BRAND:	Merit
TRADENAME:	<b>POWER STRIP</b>
ABRASIVE:	Silicon Carbide
GRIT SIZE:	36-50
GRADE:	X-Coarse
TYPE/BACKING:	Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART NO.
4-1/2 x 5/8-11	12,000	10	08834197038
4-1/2 x 7/8	12,000	10	08834192122
7 x 5/8-11	8,000	10	08834197040
7 x 7/8	8,000	10	08834196415

## Surface Preparation Discs



### MERIT SURFACE PREP NON-WOVEN DISCS

GOOD CHOICE FOR LIGHT DEBURRING AND BLENDING OPERATION

FEATURES	BENEFITS
<ul style="list-style-type: none"> <li>• New resin system, aerospace-tailored</li> <li>• Proprietary new coating method</li> </ul>	<ul style="list-style-type: none"> <li>• Smear-free, even on high nickel content alloys</li> <li>• Will not load on aluminum and soft metals, as competitive products may</li> </ul>
<ul style="list-style-type: none"> <li>• Extended form holding</li> </ul>	<ul style="list-style-type: none"> <li>• Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as other competitive products may</li> <li>• Lowest total cost of consumable tooling per workpiece</li> </ul>
<ul style="list-style-type: none"> <li>• Improved backing on hook and loop discs</li> </ul>	<ul style="list-style-type: none"> <li>• Will not fly off rotary sanders</li> <li>• Discs sit flatter on back-up pads, resulting in a more consistent finish on DA applications</li> </ul>
<ul style="list-style-type: none"> <li>• Good choice for light deburring and blending operations</li> </ul>	<ul style="list-style-type: none"> <li>• Provide better grain utility while remaining flexible</li> </ul>



### MERIT AVOS SURFACE PREP SPEED-LOK DISCS

BETTER CHOICE FOR LIGHT DEBURRING, CLEANING AND FINISHING

FEATURES	BENEFITS
<ul style="list-style-type: none"> <li>■ Patented hole design</li> </ul>	<ul style="list-style-type: none"> <li>■ Allows interrupted cut, reducing heat up to 30% over standard surface preparation discs</li> <li>■ Cool cutting results in longer disc life</li> <li>■ Provides complete vision into the grinding zone</li> <li>■ Operators can grind more accurately with less re-work</li> </ul>
<ul style="list-style-type: none"> <li>■ Scooped holes</li> </ul>	<ul style="list-style-type: none"> <li>■ Create air flow to pull loose abrasive and swarf away from work surface grinding zone – resulting in extended disc life</li> </ul>
<ul style="list-style-type: none"> <li>■ 15 degree angle back-up pad</li> </ul>	<ul style="list-style-type: none"> <li>■ Grinding at 5°-15° angle allows greater utilization of disc surface</li> <li>■ Eliminates gouging of workpiece</li> </ul>

#### Merit Surface Prep Discs

DIA.	7/8"	AVOS SPEED-LOK	SPEED CHANGE 5/8"-11
<b>EXTRA COARSE</b>			
4-1/2"	66261096871	66623374826	66623373701
5"	66261069521	66623374827	08834164631
6"	66623326083		
7"	66623326086	66623374828	66623373702
<b>COARSE</b>			
4-1/2"	66623325131	66623374829	66261199421
5"	66261070755	66623374830	08834166411
6"	66623325162		
7"	66623325139	66623374831	08834166414
<b>MEDIUM</b>			
4-1/2"	66254491135	66623374832	66623373703
5"	66261070750	66623374833	08834168802
6"	66623325954		
7"	66623325921	66623374834	66261069674
<b>FINE</b>			
4-1/2"	66623325152	66623374835	66623373704
5"	66623325157	66623374836	66623373705
6"	66623325895		
7"	66623325901	66623374837	66623373706
<b>VERY FINE</b>			
4-1/2"	66623325939	66623374838	66254460716
5"	66623325947	66623374839	08834166413
6"	66623326078		
7"	66623325961	66623374840	08834166416

#### Merit Surface Prep Back-up Pads

DESCRIPTION	MAX. RPM	STD. PKG.	PART NO.
<b>Surface Prep Disc Back-up Pads for 7/8" Discs</b>			
4-1/2" Medium	11,000	5	05539562582
5" Medium	10,000	5	05539512033
7" Medium	8,600	5	05539512032
<b>AVOS Speed-Lok Disc Back-up Pads</b>			
4-1/2" x 5/8"-11 Sawtooth	13,000	5	05539563975
5" x 5/8"-11 Sawtooth	13,000	5	05539563019
5" x 7/16"-20 Pistol Grip Sawtooth	20,000	5	05539563395
7" x 5/8"-11 Round, Medium, Thicker	8,600	5	05539563836

# Non-Woven Discs

## Non-Woven Hook and Loop Discs



### Merit Surface Prep Discs

DIA.	HOOK & LOOP
<b>EXTRA COARSE</b>	
1-1/2"	66623340094
2"	66623325974
3"	66623326060
4"	66623326062
4-1/2"	66623326067
5"	66623326072
6"	66623326084
7"	08834167644
8"	08834163834
<b>COARSE</b>	
1-1/2"	66623340095
2"	05539562621
3"	66623325128
4"	05539512515
4-1/2"	05539520420
5"	05539512519
6"	05539512522
7"	05539512525
8"	05539562627

DIA.	HOOK & LOOP
<b>MEDIUM</b>	
1-1/2"	08834168008
2"	05539562620
3"	05539562623
4"	05539512514
4-1/2"	05539520419
5"	05539512518
6"	05539512521
7"	05539512524
8"	05539562626
<b>FINE</b>	
1-1/2"	66623340097
2"	66623325142
3"	66623325144
4"	66623325146
4-1/2"	66623325148
5"	66623325155
6"	66623325896
7"	66623325898
8"	66623325911

DIA.	HOOK & LOOP
<b>VERY FINE</b>	
1-1/2"	66623340096
2"	66623325929
3"	08834162565
4"	66623325935
4-1/2"	08834162550
5"	08834162584
6"	08834162587
7"	08834162588
8"	66623325973
<b>SUPER FINE</b>	
4-1/2"	66261191633
7"	66261191673



### Back-Up Pads for Surface Prep Discs

**GOOD**  
Merit  
**SURFACE PREP**

PAD DIAMETER	SPINDLE OR HOLE SIZE	MAX. RPM	STD. PKG.	PART NO.
<b>Back-Up Pads for Hook And Loop Discs</b>				
1-1/2	1/4" Steel Shank	23,000	1	08834168024*
2	1/4" Steel Shank	23,000	1	08834168025
3	1/4" Steel Shank	20,000	1	08834168026*
4	1/4" Steel Shank	18,000	1	08834168027*
4	1/2"-13 Thread	13,000	5	05539562714*
4	5/8"-11 Thread	13,000	1	08834168984
4-1/2	5/8"-11 Thread	10,000	5	05539562718
5	1/4" Steel Shank	10,000	2	08834168993*
5	1/2"-13 Thread	10,000	1	08834168028*
5	5/8"-11 Thread	10,000	1	08834168967
6	5/8"-11 Thread	8,000	5	05539562723
7	5/8"-11 Thread	6,000	1	08834168032

\* NON-STOCK





Merit non-woven quick-change discs are a combination of strong synthetic mesh and quality abrasives, bonded together by a smear-resistant adhesive. They are ideal for use on portable tools to clean and remove imperfections on metal surfaces, clean, deburr or finish a variety of surfaces, blend weld seams, or create decorative finishes. The open construction of the non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

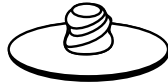
- APPLICATIONS:** Medium-light stock removal, beveling, deburring/deflashing, rust removal, blending, cleaning and finishing, polishing
- SURFACE FINISHING MATERIALS:** Surface Stripping, Surface Deburring & Blending, Surface Preparation, Buffing
- SIZE RANGE:** 3/4" – 4" diameter
- GRIT RANGE:** X-Coarse, Coarse, Medium, Fine, Very Fine, Super Fine
- ABRASIVE GRAIN:** Aluminum Oxide, Silicon Carbide
- ATTACHMENT:** Quick-Change Type TR (Type III), Type TS (Type II), and Type TP (Type I)
- BACK-UP PADS:** Rubber with hardness variations for different applications

## Non-Woven Quick-Change Discs

### QUICK-CHANGE ATTACHMENT SYSTEMS AND CROSS REFERENCE GUIDE

#### Type TR (Type III)

- Features a roll-on/roll-off style fastener
- Fastener is made of plastic
- Equivalent to 3M™ Roloc™ fastening system



#### Type TS (Type II)

- Features a turn-on/turn-off style fastener
- Fastener is made of metal
- Equivalent to Standard Abrasives' SocAtt® locking system



#### Type TP (Type I)

- Snap-on/snap-off system which enables you to change discs quickly and safely, reducing downtime and operating expenses
- Fastener is made of nylon



#### MERIT

	Type III	Type II	Type I
<b>3M</b>	Roloc TR	Roloc TS/TSM	Roloc TP
<b>Standard</b>	TR (Lockit)	TS (SocAtt)	TP (ClickOn)
<b>Superior</b>	Type R	Type S	–
<b>Arc</b>	Type R	Type S	Type P
<b>Pferd</b>	Type CDR	Type CD	–
<b>Sait</b>	SAIT-LOK-R	SAIT-LOK	–
<b>Camel</b>	Roll On	Turn On	–
<b>Klingspor</b>	QRC	QMC	–
<b>Garryson</b>	Type R	Type S	–

### APPLICATION/GRIT RECOMMENDATION GUIDE

	MOST AGGRESSIVE		LEAST AGGRESSIVE		
	POWER STRIP	DEBURRING & BLENDING	SURFACE PREP	SURFACE PREP	HS BUFFING, BUFFING
<b>SCALE REMOVAL</b>	BEST CHOICE				
<b>STOCK REMOVAL</b>	BEST CHOICE	SECOND CHOICE			
<b>HEAVY DEBURRING</b>	SECOND CHOICE	BEST CHOICE			
<b>LIGHT DEBURRING</b>		BEST CHOICE	SECOND CHOICE		
<b>LIGHT FINISHING</b>			BEST CHOICE	SECOND CHOICE	
<b>BLENDING</b>			BEST CHOICE	SECOND CHOICE	
<b>CLEANING</b>			SECOND CHOICE	BEST CHOICE	
<b>FINISHING</b>				BEST CHOICE	SECOND CHOICE

## CROSS REFERENCE GUIDE

	STRIPPING	HEAVY/LIGHT DEBURRING	LIGHT DEBURRING/BLENDING/CLEANING/FINISHING	
<b>MERIT</b>	<b>GOOD</b> Power Strip	<b>GOOD</b> Deburring & Blending	<b>GOOD</b> Surface Prep	<b>GOOD</b> HS Buffing, Buffing
<b>3M</b>	Clean & Strip Clean Strip XT	EXL Unitized	Surf Cond, SL, SE	–
<b>Standard</b>	Cleaning Disc	500-900 Series Unitized	FE, GP, RC	Buff & Blend - HS, Buff & Blend
<b>Fiberal/SIA</b>	–	–	Meteor, Type B & C	–
<b>Superior</b>	Type R	XL Unitized	FD, GD, CC	HS, HD A/O
<b>Arc</b>	Arcstrip	–	Surface Cond	Blend & Finish
<b>Pferd</b>	Policlean	–	Finishing Disc - Hard & Soft	–
<b>Sait</b>	SAIT-Strip	–	HD, GP	Sand-Light Blending
<b>Camel</b>	EZ Strip - Black	–	–	–
<b>Klingspor</b>	Strip-It Black	–	–	–
<b>Garryson</b>	–	–	Surface Cond	–
<b>Bibielle</b>	–	BUR Unitized	DCR	–

## ABRASIVE/GRIT/DENSITY KEY

<b>ABRASIVE</b>	<b>S/C</b>					<b>A/O</b>
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN					MORE DURABLE, LONGER LASTING, POLISHED FINISH
<b>GRIT SIZE</b>	<b>XC (24-36)</b>	<b>C (50-80)</b>	<b>M (100-150)</b>	<b>F (180-220)</b>	<b>VF (240-360)</b>	<b>SF (400-600)</b>
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH			REDUCED CUT RATE, FINER FINISH		
<b>DENSITY</b>	<b>2</b>					<b>9</b>
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING			HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH		



### Merit Quick-Change Power Strip Discs

- Power Strip material provides a unique combination of aggressive performance, long life and improved finish. It is ideal for removing coatings on a variety of substrates, such as wood, metal and plastics.
- Incorporated with extruded nylon fibers, flexible resin technology, and extra-coarse abrasive grains, these discs outperform traditional coated abrasive products, leaving a thoroughly cleaned surface, which ensures excellent adhesion in subsequent processes such as coating, painting and soldering.

<b>TIER:</b>	<b>GOOD</b>	<b>GOOD</b>
<b>BRAND:</b>	Merit	Merit
<b>TRADENAME:</b>	<b>POWER STRIP</b>	<b>POWER STRIP</b>
<b>ABRASIVE:</b>	Silicon Carbide	Silicon Carbide
<b>GRADE:</b>	XC	XC
<b>ATTACHMENT:</b>	TR (Type III)	TS (Type II)



DIAMETER	MAX. RPM	STD. PKG.	PART NO.	PART NO.
2 x 1/2	15,500	10	08834163514	08834167724
3 x 1/2	12,000	10	08834163513	08834167725
4 x 1/2	8,000	10	08834167722	08834167726

## Merit Deburring & Blending Discs



TIER: **GOOD**  
 BRAND: Merit  
 TRADENAME: **DEBURR/BLEND**  
 ATTACHMENT: TR (Type III)



SIZE (D x T)	ABR.	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART NO.
2 x 1/4	A/O	C	7-9	22,000	60	66261054187
	A/O	M	2-3	22,000	60	66261054183
	A/O	M	4-6	22,000	60	66261054185
	A/O	M	7-9	22,000	60	66261054186
	S/C	F	2-3	22,000	60	66261054182
3 x 1/8	A/O	M	4-6	15,000	40	66261054191
	A/O	F	2-3	15,000	40	66261054188
	A/O	F	4	15,000	40	66261054189
3 x 1/4	A/O	F	6	15,000	40	66261054190
	A/O	C	7-9	15,000	20	66261054198
	A/O	M	2-3	15,000	20	66261054193
	A/O	M	4-6	15,000	20	66261054196
	A/O	M	7-9	15,000	20	66261054197
	A/O	F	2-3	15,000	20	66261054192
	A/O	F	4-6	15,000	20	66261054194
	S/C	F	4-6	15,000	20	66261054195

## Merit Surface Preparation Discs



### MERIT SURFACE PREP GOOD CHOICE FOR FINISHING AND BLENDING APPLICATIONS

#### FEATURES

- New resin system, aerospace-tailored
- Proprietary new coating method

#### BENEFITS

- Smear-free, even on high nickel content alloys
- Will not load on aluminum and soft metals, as competitive products may
- Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as other competitive products may

### Merit Surface Prep

DIA.	TR (TYPE III)	TS (TYPE II)	TP (TYPE I)
<b>EXTRA COARSE</b>			
3/4"	66623340003	66254449283	66623340001
1"	08834168190	66254449284	66623340005
1-1/2"	08834168156	66261090621	66623340009
2"	08834167825	08834167821	08834168276
3"	08834167827	08834167823	08834162425
4"	08834168289	08834168804	66623340019
<b>COARSE</b>			
3/4"	08834166242	66261026669	08834163845
1"	08834166248	08834166474	08834161710
1-1/2"	08834163540	08834166407	66623340025
2"	66623340028	08834166287	08834163039
3"	08834166322	08834166319	08834166275
4"	08834166327	08834166388	08834166442
<b>MEDIUM</b>			
3/4"	08834166241	66261022000	08834166235
1"	69957351584	66254449282	08834164818
1-1/2"	66623340036	66623340035	08834163049
2"	08834166290	66623340037	08834168277
3"	08834166291	08834162910	08834161024
4"	08834166328	66623340040	08834166299

### Merit Surface Prep

DIA.	TR (TYPE III)	TS (TYPE II)	TP (TYPE I)
<b>FINE</b>			
3/4"	66623340059	66623340057	66623340055
1"	66623340065	66623340063	66623340061
1-1/2"	66623340071	66623340069	66623340067
2"	66623340079	66623340075	66623340073
3"	66623340086	66623340083	66623340081
4"	66623340093	66623340091	66623340089
<b>VERY FINE</b>			
3/4"	08834166240	66623340043	08834166234
1"	08834160754	08834166476	08834166243
1-1/2"	08834166367	66623340047	08834166336
2"	66623340049	08834166317	08834166273
3"	66254441300	08834166321	08834166277
4"	08834162686	08834166390	08834166300
<b>SUPER FINE</b>			
2"	66254441623	66623374000	66261092243
3"	66261193683	66623373998	66623303836

Refer to the end of this section for a list of quick-change back-up pads.



## Merit Surface Preparation Stars

- The perfect item for I.D. work
- Their shape penetrates the I.D. and polishes or cleans the surface without disturbing any tolerances
- Attach their 1/4-20 eyelets to Merit's MM20-4 mandrel. Part No. 08834183164 (See description at end of Overlap Slotted Disc Section.)

TIER:	<b>GOOD</b>
BRAND:	Merit
TRADENAME:	<b>SURFACE PREP</b>
ABRASIVE:	A/O
ATTACHMENT:	1/4-20

SIZE (D x EYELET)	GRIT	STD. PKG.	PART NO.
1-1/2" x 1/4-20	C	100	08834185923
	M		08834185924
	VF		08834185925
2" x 1/4-20	C	100	08834185926
	M		08834185927
	VF		08834485928
3" x 1/4-20	C	100	08834185929
	M		08834185678
	VF		08834185931
4" x 1/4-20	C	100	08834185932
	M		08834185933
	VF		08834185934



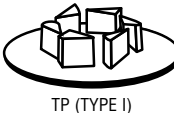
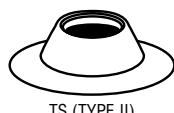
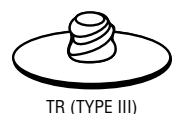
## Merit Buffing/Polishing Discs

- Tough, yet conformable, high-strength discs are smear-proof and resist tearing on burrs and sharp edges
- Designed for light removal of paint or rust without affecting the base product

TIER:	<b>BETTER</b>	<b>BETTER</b>	<b>GOOD</b>	<b>GOOD</b>	<b>GOOD</b>
BRAND:	Merit	Merit	Merit	Merit	Merit
TRADENAME:	<b>HIGH-STRENGTH</b>	<b>HIGH-STRENGTH</b>	<b>BUFFING</b>	<b>BUFFING</b>	<b>BUFFING</b>
ABRASIVE:	A/O	A/O	A/O	A/O	A/O
ATTACHMENT:	TR (Type III)	TS (Type II)	TR (Type III)	TS (Type II)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.
1-1/2"	C	100			08834161647	08834166391	08834166294
	M				08834166368	08834166392	08834166292
	F				08834166369	08834166393	08834166332
	VF				08834166417	08834166406	08834166333
2"	C	50			08834161649	08834166394	08834161627
	M		08834164064	08834164244	08834166303	08834166395	08834166280
	F				08834166304	08834166396	08834166281
	VF		08834163987	08834164245	08834166305	08834166405	08834166282
3"	C	25			08834161651	08834166397	08834166293
	M		08834164065	08834164252	08834166308	08834166398	08834166284
	F				08834166309	08834166399	08834166285
	VF		08834163559	08834164255	08834166310	08834166403	08834166286
4"	C	25			08834161654	08834166400	
	M				08834166314	08834166401	08834166295
	F				08834166315	08834166402	08834166296
	VF				08834166316	08834166404	08834166297

## Quick-Change Back-up Pads



- Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications
- Soft density pads are used for contours and fine finishing work

Refer to the end of the Coated Abrasive Quick-Change Discs section for a complete list of back-up pads and mandrels.

DIAMETER	MAX. RPM	DENSITY	TR (TYPE III)	TS (TYPE II)	TP (TYPE I)
<b>Quick-Change Back-up Pads</b>					
3/4"	40,000	Medium	08834164038	08834164206	08834164001
1"	40,000	Medium	08834164037	08834164651	08834164002
1-1/2"	30,000	Hard	08834164640	08834164622	08834163996
		Medium	08834161174	08834164146	08834164003
2"	30,000	Hard	08834164643	08834164624	08834163997
		Medium	08834164922	08834164198	08834164004
		Soft	08834164641	08834161625	08834163949
3"	20,000	Hard	08834164036	08834161626	08834163998
		Medium	08834164949	08834164113	08834164005
		Soft	08834164644	08834164626	08834163948
4"	15,000	Medium	08834164655	08834164135	08834164006

ALL QUICK-CHANGE BACK-UP PADS HAVE A 1/4" DIAMETER SHANK. STD. PKG. = 1



## Fibratex Hand Pads

### Features

- Non-woven nylon, low density pads impregnated with abrasive grain
- Numerous specifications
- Excellent conformability and flexibility
- Easy to fold
- Replacement for steel wool and wire brushes

### Benefits

COARSER  
ACTING FOR  
GENERAL  
CLEANING



FINER  
ACTING FOR  
LIGHT  
SCUFFING &  
BLENDING

#### **Brown - 05539574000**

A heavy-duty, medium grit aluminum oxide pad for aggressive action where a stiffer, coarser pad is required.

#### **Gray - 05539574600**

A medium grit, silicon carbide pad, with an open web structure primarily used for all types of blending applications, especially on stainless steel.

#### **Green - 05539579600**

A very fine grit aluminum oxide pad for general clean-up as well as finishing stainless steel.

#### **Maroon - 05539577700**

A very fine grit, aluminum oxide pad with a fast initial cut rate for cleaning, deburring, corrosion and oxidation removal.

#### **Maroon - 05539574700 / 05539584700**

Very fine, aluminum oxide pads for general cleaning and finishing, removal of rust and oxidation from metals, and lightly sanding old paint or new primers. No color bleeding when working with solvents. 84700 is perforated to create two smaller 4-1/2" x 6" pads.

#### **Light Green - 05539569600**

A very fine grit, aluminum oxide pad for general purpose cleaning in food processing plants and sanitary preparations.

#### **Gray - 05539563500**

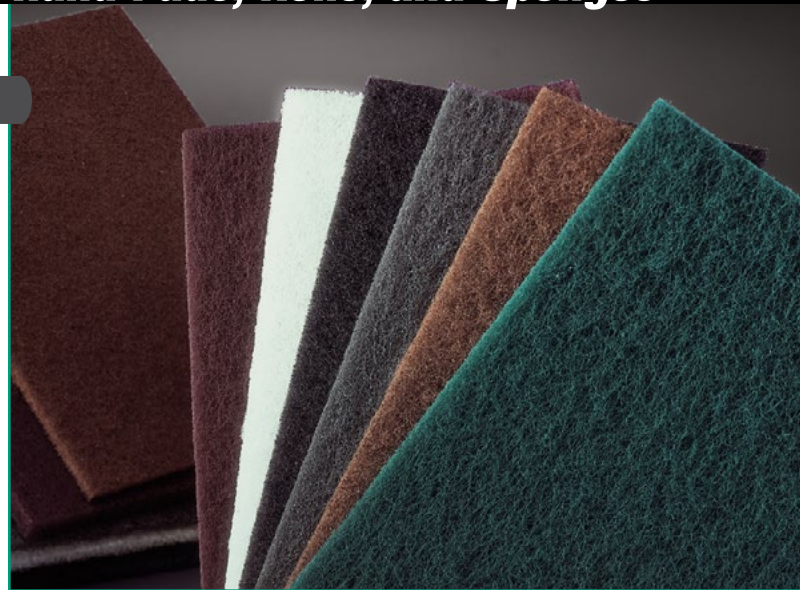
An ultra fine grit, silicon carbide pad for denubbing between finish coats, as well as lacquer rubbing.

#### **Gray - 05539574800**

A micro fine grit, silicon carbide pad for light cleaning steel and non-steel, defuzzing wood and final rubbing. Softer acting, more flexible. Consistent, finer finishes.

#### **White - 05539545600**

For general clean-up, light primer rub down and paint overspray removal. Softer acting, more flexible. Non-abrasive.



PART NO.	GRIT/ABRASIVE	COLOR	PADS/CASE
<b>6" x 9"</b>			
05539574000	Medium A/O	Brown	40
05539574600	Medium S/C	Gray	40
05539579600	VF A/O Scouring	Green	60
05539577700	Very Fine A/O Long Life	Maroon	60
05539574700	Very Fine A/O Gen. Purp.	Maroon	<b>BEST</b> 60
05539584700	VF A/O G/P Perforated	Maroon	<b>BEST</b> 60
05539569600	VF A/O Food Pro	Lt. Green	2,880*
05539563500	Ultra Fine S/C	Gray	60
05539574800	Micro Fine S/C	Gray	60
05539545600	Non-Abrasive	White	60

\*Supplied in pallet quantity only.

PART NO.	DESCRIPTION	HOLDERS/CASE
<b>Hand Pad Holder</b>		
05539562709	Hand Pad Holder	10



### TechTip

Fibratex products are non-metallic, won't rust, and are ideal as replacements for steel wool.



It is the user's responsibility to refer to and comply with all safety regulations.

## Fibratex Sponge Pads

### Features

- Durable hand pad material on one side, top quality sponge on the other

### Benefits

- Allows user to carry fluids to the scrubbing area or pick up liquid after use



Ideal for general clean-up. Mild acting green, or non-abrasive white Fibratex hand pad material is laminated to a top quality sponge, which allows for the convenience of 2 pads in one.



PART NO.	GRIT/ABRASIVE	DESCRIPTION	PADS/CASE
<b>3-1/4" x 6-1/4" x 1"</b>			
05539563538	Non-Abrasive	White Clean-N-Sponge Pad	40
05539563537	Very Fine A/O	Green Scour-N-Sponge Pad	40

# Non-Woven Hand Pads, Rolls, and Sponges



Merit surface finishing hand pads and rolls are made of a non-woven nylon web impregnated with abrasive grain and resin bond.

- APPLICATIONS:** Light- to heavy-duty cleaning, deburring, blending, polishing, and finishing of metal, wood, composite, plastics, stone, solid surface and painted surfaces.
- ABRASIVE GRAIN:** Aluminum Oxide, Silicon Carbide
- GRIT RANGE:** Medium (M), Fine (F), Very Fine (VF), Ultra Fine (UF), Micro Fine (MF), Non-Abrasive (-)
- HAND PAD FEATURES:**
- Flexible; conform to work surface
  - Gentle action easily removes flashing or burrs without affecting dimension of workpiece
  - Non-loading; constant supply of new cutting edges
  - Non-rusting; no workpiece contamination
  - Resilient construction; long life, increased productivity; solvent resistant; waterproof
- ROLL FEATURES:**
- Economical alternative to cut pads
  - Can be cut to specific sizes

MORE AGGRESSIVE, ROUGHER FINISH

LESS AGGRESSIVE, FINER FINISH

PRODUCT #:  
COLOR:  
DESCRIPTION:

ABRASIVE:  
GRIT SIZE:  
STEEL WOOL EQUIVALENT:  
APPLICATIONS:

	#740 (DARK TAN) HEAVY DUTY	#644 (MAROON) GP - FINE	#747 (MAROON) GP PLUS - VERY FINE	#796 (GREEN) SCOURING	#635 (GRAY) CLEAN & FINISH	#748 (GRAY) FINAL SHINE	#456 (WHITE) CLEANING
ABRASIVE:	AO	AO	AO	AO	SC	SC	Non-Abrasive
GRIT SIZE:	Medium 100 - 150	Fine 180 - 220	Very Fine 240 - 360	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro Fine 800 - 1200	Non-Abrasive ----
STEEL WOOL EQUIVALENT:	4 Extra Coarse	2 Medium Coarse	1 Medium	0 Fine	00 Very Fine	00 Very Fine	0000 Super Fine
APPLICATIONS:	<ul style="list-style-type: none"> <li>• Most durable and aggressive cutting pad</li> <li>• Heavy-duty removal                             <ul style="list-style-type: none"> <li>- rust</li> <li>- oxidation</li> </ul> </li> <li>• Deburring</li> </ul>	<ul style="list-style-type: none"> <li>• Cleaning and deburring                             <ul style="list-style-type: none"> <li>- machinery</li> <li>- metal parts</li> <li>- plastic</li> <li>- solid surface</li> <li>- stone</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>• Light cleaning, deburring and finishing                             <ul style="list-style-type: none"> <li>- machinery</li> <li>- metal parts</li> <li>- plastic</li> <li>- solid surface</li> <li>- stone</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>• Removing stains, marks, rust, corrosion or oxidation from stainless equipment</li> <li>• Light cleaning of metal surfaces</li> </ul>	<ul style="list-style-type: none"> <li>• Light cleaning and finishing of most surfaces                             <ul style="list-style-type: none"> <li>- steel, aluminum</li> <li>- denibbing plastic</li> <li>- scuffing acrylics</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>• Final finishing                             <ul style="list-style-type: none"> <li>- final rub on wood</li> <li>- final blend metal</li> <li>- final finish plastics and acrylics</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>• Scratch-free cleaning                             <ul style="list-style-type: none"> <li>- metal</li> <li>- fiberglass</li> <li>- stone</li> <li>- solid surface</li> <li>- ceramic</li> </ul> </li> <li>• Wood                             <ul style="list-style-type: none"> <li>- highlighting</li> <li>- rubbing</li> </ul> </li> </ul>

TIER: **GOOD**  
BRAND: Merit

## Merit Hand Pads and Rolls

SIZE (W x L)	COLOR	DESCRIPTION	ABRASIVE	GRIT SIZE	STD. PKG.	PART NO.
<b>Hand Pads</b>						
6 x 9	Dark Tan	740 Heavy-Duty Pad	A/O	Med	20	08834193462
	Maroon	777 General Purpose Very Fine Pad	A/O	VF	20	08834193463
	Maroon	747 General Purpose Plus Pad	A/O	VF	20	08834196204
	Green	796 Scouring Pad	A/O	VF	20	08834193497
	Gray	748 Final Shine Pad	S/C	MF	20	08834196196
	White	456 Cleaning Pad	None	-	20	08834193270
<b>Hand Pad Holder</b>						
3-1/4 x 5-1/2	N/A	Hand Pad Holder			10	08834190748
<b>Rolls</b>						
4" x 30 Ft.	Maroon	644 General Purpose Fine Roll	A/O	F	4	05539511952
	Maroon	777 General Purpose Very Fine Roll	A/O	VF	4	05539526809
	Maroon	747 General Purpose Plus Roll	A/O	VF	4	05539562608
	Green	796 Scouring Roll	A/O	VF	5	05539562607
	Gray	851 General Cleaning Roll	S/C	VF	3	05539515708
	Gray	635 Clean & Finish Roll	S/C	UF	5	05539512500
	White	456 Cleaning Roll	None	-	3	05539512839
6" x 30 Ft.	Maroon	High Strength Roll	A/O	M	2	05539527176
	Maroon	747 General Purpose Plus Roll	A/O	VF	3	05539512505
	Maroon	777 General Purpose Very Fine Roll	A/O	VF	3	05539526424
	Gray	851 General Cleaning Roll	S/C	VF	3	05539562610
	Gray	635 Clean & Finish Roll	S/C	UF	3	05539512503

# Non-Woven Flap Wheels

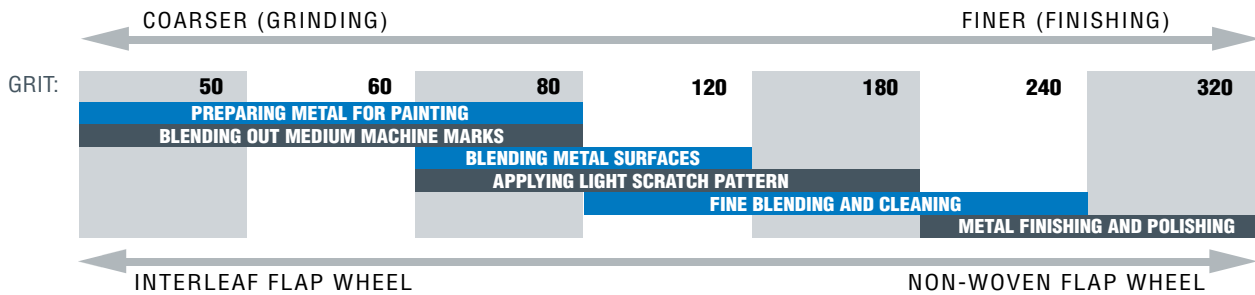


Non-woven surface finishing flap wheels are an ideal choice for a wide variety of blending and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away continually exposing fresh abrasives.

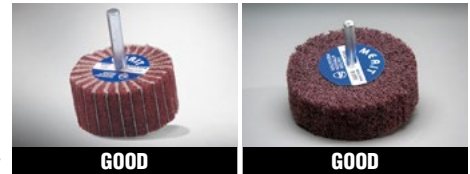
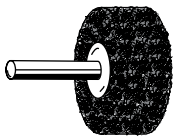
There are two types of non woven flap wheels: non-woven only abrasive flaps where finishing is the primary application, and interleaf with alternating cloth and non-woven abrasive flaps (less conformable, more aggressive) for stock removal and finishing. Interleaf flap wheels must always be run in the direction indicated by the arrow.

- APPLICATIONS:** Used for a wide range of metal fabrication and welding applications including blending, deburring, cleaning, finishing, and polishing
- SIZE RANGE:** Flap wheels with mounted steel shanks: 2" – 4" diameter  
Flap wheels with arbor holes: 3" – 12" diameter
- GRIT RANGE:** 50 – 320
- ABRASIVE GRAIN:** Aluminum Oxide, Silicon Carbide

## APPLICATION/GRIT RECOMMENDATION GUIDE



## 1/4" Mounted Steel Shanks



SIZE (D x W x SK.)	MAX. RPM	ABRASIVE	CA GRIT	NON-WOVEN GRIT	STD. PKG.	INTERLEAF PART NO.	NON-WOVEN PART NO.
2 x 1 x 1/4	12,000	A/O	60	Coarse	10	08834138122	
		A/O	80	Medium		08834138123	
		A/O	120	Medium		08834144457	66261189992*
		A/O	180	Fine		08834144458	
		A/O	320	Very Fine		08834144459	69957399202*
2 x 1-1/2 x 1/4	12,000	A/O	60	Coarse	10	08834138124	
		A/O	80	Medium		08834138125	
		A/O	120	Medium		08834138126	
		A/O	180	Fine		08834138127	
		A/O	320	Very Fine		08834138128	
3 x 1 x 1/4	12,000	A/O	60	Coarse	10	08834138129	
		A/O	80	Medium		08834138130	
		A/O	120	Medium		08834138118	08834131921
		A/O	180	Fine		08834138120	
		A/O	–	Very Fine			66261189993
3 x 1-3/4 x 1/4	12,000	A/O	–	Medium	10		66261026075
		A/O	–	Very Fine			66261189994
3 x 2 x 1/4	8,000	A/O	60	Grit	10	08834131338	
		A/O	80	Coarse		08834138116	
		A/O	120	Medium		08834144460	
		A/O	180	Medium		08834144461	
4 x 2 x 1/4	12,000	A/O	80	Coarse	10	08834121115	
		A/O	120	Medium		08834120458	

\*STANDARD PACKAGE QUANTITY = 20



# Non-Woven Flap Wheels

## Arbor Hole Mounts



**GOOD**

Merit



**GOOD**

Merit

TIER:  
BRAND:  
TRADENAME:

**INTERLEAF**

**NON-WOVEN**

SIZE (D x W x SK.)	MAX. RPM	ABRASIVE	CA GRIT	NON-WOVEN GRIT	STD. PKG.	PART NO.	PART NO.
3 x 2 x 3/8	12,000	A/O	50	Coarse	10	08834139022	
		A/O	60	Coarse		08834139000	
		A/O	80	Medium		08834139002	
		A/O	120	Medium		08834139001	
		A/O	180	Fine		08834139023	
		A/O	240	Very Fine		08834139028	
		A/O	320	Very Fine		08834139024	
4 x 2 x 5/8	12,000	A/O	50	Coarse	10	08834126024	
		A/O	60	Coarse		08834126025	
		A/O	80	Medium		08834126026	
		A/O	120	Medium		08834126016	
		A/O	180	Fine		08834126015	
		A/O	240	Very Fine		08834126014	
		A/O	320	Very Fine		08834126027	
6 x 1 x 1	6,000	A/O	50	Coarse	10	08834126028	
		A/O	60	Coarse		08834126029	
		A/O	80	Medium		08834126000	
		A/O	120	Medium		08834126006	
		A/O	150	Medium		08834126046	
		A/O	180	Fine		08834126068	
		A/O	240	Very Fine		08834126030	
6 x 1 x 2	3,000	A/O	120	Medium	4		05539512667
		A/O	180	Fine			05539562635
		S/C	–	Fine			05539512660
		S/C	–	Very Fine			05539512658
6 x 2 x 1	6,000	A/O	50	Coarse	10	08834126032	
		A/O	60	Coarse		08834126008	
		A/O	80	Medium		08834126009	
		A/O	120	Medium		08834126010	
		A/O	150	Medium		08834126069	
		A/O	180	Fine		08834126018	
		A/O	240	Very Fine		08834126017	
A/O	320	Very Fine	08834126033				
6 x 3 x 1	6,000	A/O	50	Coarse	6	08834126053	
		A/O	60	Coarse		08834126054	
		A/O	80	Medium		08834126055	
		A/O	120	Medium		08834126056	
		A/O	180	Fine		08834126048	
		A/O	240	Very Fine		08834126047	
		A/O	320	Very Fine		08834126057	
8 x 1 x 3	2,500	A/O	–	Fine	3		05539527460
8 x 2 x 1	4,500	A/O	60	Coarse	6	08834126041	
		A/O	80	Medium		08834126042	
		A/O	120	Medium		08834126043	
		A/O	180	Fine		08834126044	
8 x 2 x 3	2,500	A/O	–	Medium	2		05539512677
		A/O	–	Fine			05539526627
8 x 3 x 1	4,500	A/O	50	Coarse	3	08834126060	
		A/O	60	Coarse		08834126066	
		A/O	80	Medium		08834126061	
		A/O	120	Medium		08834122398	
		A/O	180	Fine		08834126062	
		A/O	320	Very Fine		08834126064	
12 x 2 x 5	1,900	A/O	–	Medium	1		05539528945
		A/O	–	High Strength			05539562637

NON-WOVEN ABRASIVES





Merit non-woven belts are a combination of strong synthetic mesh and quality abrasive, bonded together by a smear-resistant adhesive. The open construction of non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

**APPLICATIONS:** Removing surface defects, light edge burrs, parting lines, flashing, rust, oxides, corrosion, paints, and scale; blending mill marks, tool marks, uneven edges, and applying decorative finishes.

**ABRASIVE GRAIN:** Aluminum Oxide

**GRIT RANGE:** Extra Coarse (Black), Coarse (Brown), Medium (Maroon), Fine (Green), Very Fine (Blue)



## MERIT SURFACE PREP

GOOD CHOICE FOR FINISHING AND BLENDING APPLICATIONS

FEATURES	BENEFITS
<ul style="list-style-type: none"> <li>■ New resin system, aerospace-tailored</li> <li>■ Proprietary new coating method</li> <li>■ Extended form holding</li> </ul>	<ul style="list-style-type: none"> <li>■ Smear-free, even on high nickel content alloys</li> <li>■ Will not load on aluminum and soft metals, as competitive products may</li> <li>■ Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as other competitive products may</li> <li>■ Lowest total cost of consumable tooling per workpiece</li> </ul>

## APPLICATION/GRIT RECOMMENDATION GUIDE

	EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
	<b>GOOD CHOICE - MERIT SURFACE PREP</b>				
Scale Removal	X				
Stock Removal		X			
Heavy Deburring		X			
Light Deburring			X		
Light Finishing			X		
Blending				X	
Finishing					X

## Merit Surface Prep Belts

WIDTH	LENGTH	EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
1/4"	18"	08834190391	08834190961	77696064544	66623333469	08834190960
1/4"	24"	66623311055	08834190963	08834194060	66623333470	08834190962
1/2"	12"	63642582266	66254441799	66261019760	66623333471	66261096581
1/2"	18"	08834199002	66623333393	66261071010	66623333472	08834194002
1/2"	24"	66261041203	05539570453	66623333498	66623301573	66623333513
3/4"	18"	08834199776	66623333394	66261192907	66623333473	66623333514
3/4"	20-1/2"	66623333552	66254499800	08834194010	66623333474	08834194011
3/4"	80"	66623333553	66623333395	66623333499	66623333475	66623333517
1"	18"	08834199003	08834190970	08834198035	66623333476	08834190968
1"	21"	66623333557	66623333396	66254482190	66623333477	66623333520
1"	30"	66623333559	08834199508	08834194072	66623333478	08834199509
1"	42"	66623333561	08834194012	08834194013	66623333479	08834194014
1"	60"	66623333563	66623333397	66623333500	66623333480	66623333522
1"	64"	66623333565	66623333398	66623333501	66623333481	66623333523
1"	72"	66623333567	66623333399	66623328846	66623333482	66261030821
1"	132"	66623333568	66261046477	66254491234	66623333483	66623333524
1-1/2"	60"	66623333569	66623333400	69957396806	66623333484	66623333526
2"	18-15/16"	66623333570	66623333401	08834190146	66623333485	66623333527
2"	34"	66623333571	66623333402	66623312395	66623333486	66623333530
2"	48"	66623329040	08834194015	05539568393	66623333487	08834194017

CONTINUED

WIDTH	LENGTH	EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
2"	60"	08834199006	08834194018	08834194019	66623333488	08834194020
2"	72"	08834199007	08834194021	08834194022	66623333489	08834194023
2"	132"	66623333575	08834194024	08834194025	66623333490	08834194026
2-1/2"	60"	66623333577	08834194030	08834194031	66623333491	08834194032
2-3/4"	15-1/2"	66623333579	66623333403	08834194034	66623333493	08834194035
3"	10-11/16"	66623333581	05539568397	08834190976	66623333494	08834190975
3"	18"	66623333582	08834190979	66623333502	66623333495	08834190977
3"	21"	66623333583	08834190959	08834194103	66623333496	08834194129
3"	24"	66623333585	66254402501	08834194037	66623333497	08834194038
3"	72"	66623333587	66623333404	66623327858	66623333498	66623333538
3"	80"	66623333589	66623333405	66254469978	66623333499	66623333539
3"	90"	66623333591	66623333406	05539527159	66623333496	66623333540
3"	118"	66623333593	66623333407	66623333503	66623333495	66623333544
3"	132"	66623333594	08834194039	63642596252	66623333494	08834194041
3-1/2"	15-1/2"	08834199009	66623333408	08834198044	66623333493	08834194044
4"	24"	08834199010	08834194045	08834194046	66623333492	08834194047
4"	36"	66623333598	08834194048	08834194049	66623333491	08834194050
4"	132"	08834199011	66623333409	08834198044	66623333490	08834194056
4"	168"	66623333601	66623333410	66623333504	66623333495	66623333549
6"	48"	66623333603	08834194057	05539570433	66623333498	08834194059

# Non-Woven Abrasive Basics

## Introduction

Most non-woven products consist of a non-woven web of nylon fibers, impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting.

The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Non-woven products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic, non-rusting and easily pre-formed to conform to special-shaped workpieces.

Since non-woven products are designed for use where stock removal is not required, they begin where other abrasives leave off. The relatively non-aggressive nature of nylon and grit inherent in the non-woven material makes it ideal as a finishing tool. While 60 to 80 grit are considered intermediate sizes in other products, they are considered coarse for non-woven items.

Used wet or dry, non-woven products offer the following advantages:

- Controlled cut without stock removal
- Consistent, uniform finish
- Minimized smearing and discoloration of the workpiece (heat is dissipated through the open mesh of the product)
- Increased production; time savings
- Ability to automate operations
- Reduced operator training
- Less maintenance required
- Greater safety than other methods
- Conformability to irregular surfaces

These advantages make non-woven products excellent alternatives to bristle brushes, set-up wheels, greaseless compounds, and steel wool.

## Abrasives

Silicon carbide or aluminum oxide abrasives are available. Silicon carbide is sharper, cuts faster, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer, produces less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Non-woven hand pads and rolls are available in a non-abrasive material.

## Grits

Grit refers to the size of the abrasive grain impregnated into the nylon web. Use of large particles results in more aggressive cut and a coarser finish. Small size particles produce fine surface finishes, if all other conditions are equal.

GRIT DESIGNATIONS	COMPARABLE GRIT SIZE
Coarse (C)	50 - 80
Medium (M)	100 - 150
Fine (F)	180 - 220
Very Fine (VF)	240 - 360
Ultra Fine (UF)	600
Micro Fine (MF)	800 - 1200

## Densities

The product "density" refers to the number of fibers which have been compressed into the nylon web material. Under identical conditions, harder (closed) density wheels cut faster, last longer, and produce finer finishes than softer (more open) density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the workpiece.

## Fiber Sizing

Several nylon fiber sizes (the denier) are used in the manufacture of non-woven web material because the fiber size is a significant factor in the coating process, as each produces distinct cutting characteristics.

As the intended applications for the specific item determines the fiber size used, the denier is not an optional ingredient and, therefore, is not included in the product offering specifications.

## Bonding Agents

Waterproof resins are used in the manufacture of non-woven web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web. A variety of resins are utilized in order to obtain the required softness, hardness, toughness, flexibility and other characteristics required of the finished product.

As the intended applications for the specific non-woven item determine the resin type, the resin is not an optional ingredient and, therefore, is not included in the product offering specifications.

## Conventional Finishing Methods Versus Non-Woven Products

The following chart outlines the advantages achievable when using non-woven products as alternatives to other cleaning, blending, deburring, and finishing methods. Non-woven products are listed in the sequence of normal preference for the application stated. However, because of the numerous variables, only testing can ensure selection of the most cost-effective product.

CONVENTIONAL FINISHING METHOD	KEY APPLICATION	NON-WOVEN PRODUCT AS AN ALTERNATIVE	ADVANTAGES OF FIBRATEx PRODUCT VERSUS ALTERNATE FINISHING METHODS
Bristle Brushes	Cleaning	Flap Wheel	Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminates compound dust and flying bristles
Greaseless Compounds	Finishing	Flap Wheel	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters

## Getting the Most Out of Non-Woven Products

Maximum life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

### 1) Direction

Flap wheels and unified wheels can be run in either direction.

### 2) Speed

Speed is an important factor in that it affects product finish, rate of cut and wheel life. In general, fast wheel speeds give harder action and a finer finish; whereas, slower speeds give a softer action and a coarser finish for the same wheel density.

The following are recommended operating speeds for the most common applications.

APPLICATION	RECOMMENDED SPEED
Cleaning and upgrading of surface conditions	2200 to 6000 SFPM
Cut-buffing on metal surfaces	6500 to 8000 SFPM
Deburring	5500 to 8000 SFPM
Decorative finishing	500 to 3000 SFPM
Imparting decorative finishes	900 to 3000 SFPM
Oxide removal	3500 to 6500 SFPM

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

### 3) Pressure

Light to medium pressure is recommended for most operations. Flap wheels require much lighter pressure to perform properly than other non-woven wheels. Unified wheels can withstand much higher pressures in order to perform deburring jobs. In all cases, avoid excessive pressure which may result in wheel deformation and damage to the work surface.

### 4) Feed Speed

Feed speeds directly affect the number of pieces completed over a given period of time. Slow feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.

### 5) Oscillation

Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut may be experienced. A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

### 6) Lubricants

Lubricants, such as water, water soluble oil and straight oil, will decrease the heat generated while running, improve the luster and reduce the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

## Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

VARIABLE FACTOR	ROUGH FINISH	SMOOTH SURFACE
	High RMS Reading	Lower RMS Reading
1. Grit Size	COARSE ←	→ VERY FINE
2. Wheel Grade	SOFT ←	→ HARD
3. Wheel Speed	SLOW ←	→ FAST
4. Feed Speed	FASTER (LONG SCRATCH) ←	→ SLOWER (SHORT SCRATCH)
5. Oscillation	NO OSCILLATION ←	→ OSCILLATION
6. Lubricants and Compounds	DRY ←	→ WATER → SOLUBLE OIL → STRAIGHT OIL
		← COMPOUNDS →





# Depressed Center Wheels for Grinding

## Premier Red Zirconia Alumina Abrasive

### Features

- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Best performing wheel

### Benefits

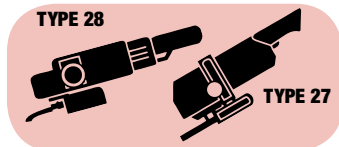
- 60% faster stock removal and a minimum of 3X the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Highest productivity; lowest total grinding cost

### Z24

Outstanding results grinding stainless steel, high alloy steel, and all ferrous metals.

### Z24 Long Life

Extended life when grinding stainless steel, high alloy steel and all ferrous metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539502864	3 x 1/4 x 3/8	Z24	18,000	20
05539502867	4 x 1/4 x 3/8	Z24	15,280	20
05539502868	4 x 1/4 x 5/8	Z24	15,280	20
05539502873	4-1/2 x 1/4 x 5/8-11	Z24	13,580	20
05539502872	4-1/2 x 1/4 x 7/8	Z24	13,580	20
05539502877	5 x 1/4 x 5/8-11	Z24	12,225	20
05539502876	5 x 1/4 x 7/8	Z24	12,225	20

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders (continued)</b>				
05539502883	7 x 1/4 x 5/8-11	Z24	8,600	10
05539502884	7 x 1/4 x 5/8-11	Z24 Long Life	8,600	10
05539502881	7 x 1/4 x 7/8	Z24	8,600	20
05539502882	7 x 1/4 x 7/8	Z24 Long Life	8,600	20
05539502889	9 x 1/4 x 5/8-11	Z24	6,600	10
05539502890	9 x 1/4 x 5/8-11	Z24 Long Life	6,600	10
<b>Type 28 - For Right Angle Grinders</b>				
05539502892	7 x 1/4 x 5/8-11	Z24	8,600	10

## Gold MaXX Zirconia Alumina/Aluminum Oxide Abrasive Blend

### Features

- Premium zirconia alumina and aluminum oxide abrasive blend in a free-cutting bond

### Benefits

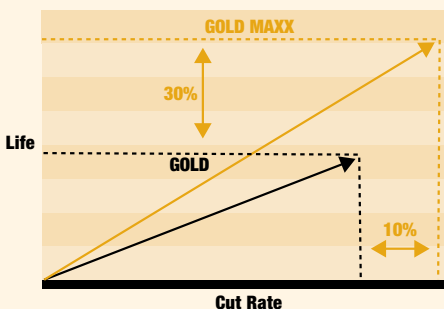
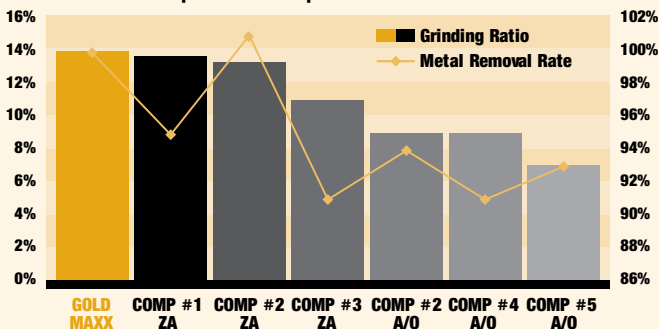
- Excellent cut rate and long life 10% faster cut rate and 30% longer life than standard aluminum oxide wheels
- Smooth grinding action that maximizes productivity and minimizes operator fatigue

Grinds efficiently on a variety of ferrous metals: from carbon steel to stainless steels and some exotic metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539570192	4-1/2 x 1/4 x 5/8-11	ZA24-R	13,580	20
05539570191	4-1/2 x 1/4 x 7/8	ZA24-R	13,580	20
05539570193	5 x 1/4 x 7/8	ZA24-R	12,225	20
66252830562	6 x 1/4 x 7/8	ZA24-R	10,185	20
05539570195	7 x 1/4 x 5/8-11	ZA24-R	8,600	10
05539570194	7 x 1/4 x 7/8	ZA24-R	8,600	20
05539570197	9 x 1/4 x 5/8-11	ZA24-R	6,600	10
05539570196	9 x 1/4 x 7/8	ZA24-R	6,600	20

### GOLD MaXX Competitive Comparison



**GOLD MaXX outperforms standard GOLD with 10% faster cut and 30% longer life.**



## Gold Aluminum Oxide Abrasive

Features	Benefits
• Quality aluminum oxide abrasive	• Fast stock removal
• Advanced resin bond	• Free cutting without a reduction in wheel life
• Exceptional balance	• No vibration
	• No burning of workpiece
	• Less grinder maintenance
	• Less operator fatigue
• Unique glass cloth reinforcement design	• No fraying or spalling of abrasive grit

### A24 Aluminum Oxide Abrasive – For Steel/Metal

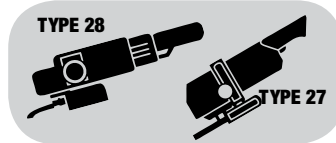
The choice for grinding all types of ferrous metals and various alloy steels.

### A30 Aluminum Oxide Abrasive – For Stainless Steel

Ideal for grinding all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.

### A46 Aluminum Oxide Abrasive – For Aluminum

Engineered for grinding aluminum weld beads and fabricated parts.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 27 – For Right Angle Grinders</b>				
05539502836	4 x 1/4 x 3/8	A24	15,280	20
05539502837	4 x 1/4 x 5/8	A24	15,280	20
05539502843	4-1/2 x 1/4 x 5/8-11	A24	13,580	20
05539502842	4-1/2 x 1/4 x 7/8	A24	13,580	20
05539502847	5 x 1/4 x 5/8-11	A24	12,225	20
05539502846	5 x 1/4 x 7/8	A24	12,225	20
05539502849	6 x 1/4 x 7/8	A24	10,185	20
05539502854	7 x 1/4 x 5/8-11	A24	8,600	10
05539502853	7 x 1/4 x 7/8	A24	8,600	20
05539502858	9 x 1/4 x 5/8-11	A24	6,600	10
05539502857	9 x 1/4 x 7/8	A24	6,600	20

### Type 28 – For Right Angle Grinders

05539502860	7 x 1/4 x 5/8-11	A24	8,600	10
05539502859	7 x 1/4 x 7/8	A24	8,600	20
05539502862	9 x 1/4 x 5/8-11	A24	6,600	10
05539502861	9 x 1/4 x 7/8	A24	6,600	20

### For Stainless Steel

### Type 27 – For Right Angle Grinders

05539561560	4-1/2 x 1/4 x 5/8-11	A30	13,580	20
05539503511	4-1/2 x 1/4 x 7/8	A30	13,580	20

### For Aluminum

### Type 27 – For Right Angle Grinders

05539508158	4-1/2 x 1/4 x 5/8-11	A46	13,580	20
05539503588	4-1/2 x 1/4 x 7/8	A46	13,580	20
05539503589	5 x 1/4 x 7/8	A46	12,225	20
05539503594	7 x 1/4 x 5/8-11	A46	8,600	10

## Carbo Metal Aluminum Oxide Abrasive

Features	Benefits
• Quality aluminum oxide abrasive	• Quick stock removal on hard metals
• Low initial cost per wheel	• Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 27 – For Right Angle Grinders</b>				
05539561568	4-1/2 x 1/4 x 5/8-11	A24	13,580	20
05539561567	4-1/2 x 1/4 x 7/8	A24	13,580	20
05539561571	5 x 1/4 x 7/8	A24	12,225	20
05539561576	7 x 1/4 x 5/8-11	A24	8,600	10
05539561575	7 x 1/4 x 7/8	A24	8,600	20



### TechTip

Unique, patented mini-mount hub used on 4-1/2" and 5" depressed center wheels provides up to 30% more wheel life because the hub covers just a small surface area, providing maximum grinding area exposure and usage.

# Depressed Center Wheels for Light Grinding and Cutting

## Premier Red Zirconia Alumina Abrasive

### Features

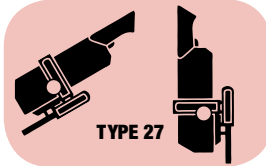
- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Best performing wheel

### Benefits

- 60% faster stock removal and a minimum of 3X the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Highest productivity, lowest total grinding cost

Outstanding results cutting and light grinding stainless steel, high alloy steel and all ferrous metals.

These wheels can be used for both cutting and light grinding.



### TechTip

For maximum performance, run the grinder at the "Maximum Operating Speed", which is marked on the wheel.

**!** It is the user's responsibility to refer to and comply with ANSI B7.1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539507349	4 x 1/8 x 3/8	Z24	15,280	20
05539504702	4-1/2 x 1/8 x 5/8-11	Z24	13,580	20
05539504701	4-1/2 x 1/8 x 7/8	Z24	13,580	20
05539504703	5 x 1/8 x 7/8	Z24	12,225	20
05539504706	7 x 1/8 x 5/8-11	Z24	8,600	10
05539504708	9 x 1/8 x 5/8-11	Z24	6,600	10

## Gold MaXX Zirconia Alumina/Aluminum Oxide Abrasive Blend

### Features

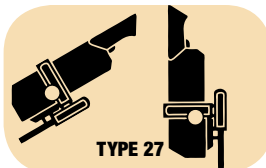
- Premium zirconia alumina and aluminum oxide abrasive blend in a free-cutting bond

### Benefits

- Excellent cut rate and long life 10% faster cut rate and 30% longer life than standard aluminum oxide wheels
- Smooth grinding action that maximizes productivity and minimizes operator fatigue

Grinds efficiently on a variety of ferrous metals: from carbon steel to stainless steels and some exotic metals.

These wheels can be used for both cutting and light grinding.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
66252832395	4-1/2 x 1/8 x 5/8-11	ZA24-R	13,580	20
66252832507	4-1/2 x 1/8 x 7/8	ZA24-R	13,580	20
66252832508	5 x 1/8 x 7/8	ZA24-R	12,225	20
66252830561	6 x 1/8 x 7/8	ZA24-R	10,185	20
66252832396	7 x 1/8 x 5/8-11	ZA24-R	8,600	10
66252832509	7 x 1/8 x 7/8	ZA24-R	8,600	20
66252830879	9 x 1/8 x 5/8-11	ZA24-R	6,600	10



### Spec Check

WHEEL TYPE	APPLICATIONS
.045", 1/16" & 3/32" THICK TYPE 27	CUTTING ONLY, WHERE FAST CUTTING AND LOW KERF LOSS ARE DESIRED IDEAL FOR PIPE CUTTING
.125" THICK TYPE 27	CUTTING AND CLEANING ROOT PASS WELDS
1/8" THICK TYPE 27	CUTTING-OFF, NOTCHING AND LIGHT SIDE GRINDING
1/4" THICK TYPE 27	GRINDING WITH LOW HORSEPOWER AIR AND ELECTRIC GRINDERS OR WHERE LOW PRESSURE IS USED
Z24 LONG LIFE, 1/4" THICK TYPE 27	GRINDING WITH HIGH HORSEPOWER MACHINES (3 HP OR HIGHER) AND HEAVY PRESSURE; FLAME CUT AND OTHER SEVERE APPLICATIONS
SAUCERS TYPE 28	SMOOTH, GOUGE-FREE GRINDING AT SHALLOW ANGLES
GOLD FLEXIBLE TYPE 29	POLISHING AND BLENDING APPLICATIONS

# Depressed Center Wheels for Light Grinding and Cutting

## Gold Aluminum Oxide Abrasive

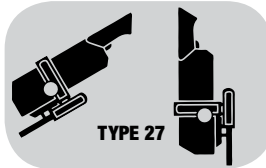
### Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Value priced

### Benefits

- Fast stock removal
- Free cutting without a reduction in wheel life
- No vibration
- No burning of workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Good performance/price ratio

The economical choice for cutting and light grinding all types of ferrous metals and various alloy steels.



These wheels can be used for both cutting and light grinding.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539504709	4 x 1/8 x 5/8	A24	15,280	20
05539504711	4-1/2 x 1/8 x 5/8-11	A24	13,580	20
05539504710	4-1/2 x 1/8 x 7/8	A24	13,580	20
05539504712	5 x 1/8 x 7/8	A24	12,225	20
05539504714	6 x 1/8 x 7/8	A24	10,185	20
05539504716	7 x 1/8 x 5/8-11	A24	8,600	10
05539504718	9 x 1/8 x 5/8-11	A24	6,600	10
05539504717	9 x 1/8 x 7/8	A24	6,600	10

## Carbo Metal Aluminum Oxide Abrasive

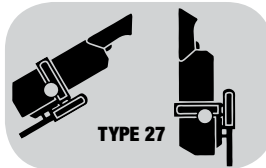
### Features

- Quality aluminum oxide abrasive
- Low initial cost per wheel

### Benefits

- Quick stock removal on hard metals
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose applications.



These wheels can be used for both cutting and light grinding.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539561566	4-1/2 x 1/8 x 5/8-11	A24	13,580	20
05539561574	7 x 1/8 x 5/8-11	A24	8,600	10
05539561573	7 x 1/8 x 7/8	A24	8,600	10

# Depressed Center Cutting-off Wheels

## Premier Red Zirconia Alumina Abrasive

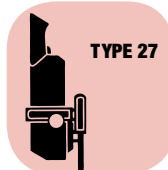
### Features

- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Best performing wheel

### Benefits

- 60% faster stock removal and a minimum of 3X the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- Highest productivity; lowest total grinding cost

Outstanding results cutting stainless steel, high alloy steel and all ferrous metals.



These wheels should be used for cutting only.



BONDED ABRASIVES

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539502863	3 x .125 x 3/8	Z24	18,000	20
05539502865	4 x .125 x 3/8	Z24	15,280	20
05539502871	4-1/2 x .125 x 5/8-11	Z24	13,580	20
05539502870	4-1/2 x .125 x 7/8	Z24	13,580	20

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal (cont'd)</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539502874	5 x .125 x 7/8	Z24	12,225	20
05539502879	7 x .125 x 5/8-11	Z24	8,600	10
05539502878	7 x .125 x 7/8	Z24	8,600	20



# Depressed Center Cutting-off Wheels

## Gold Aluminum Oxide Abrasive

### Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Exceptional balance
- Value priced

### Benefits

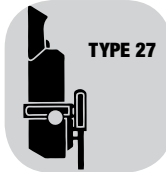
- Fast stock removal
- Free cutting
- No vibration
- No burning of workpiece
- Less grinder maintenance
- Less operator fatigue
- Good performance/price ratio

### A24 Aluminum Oxide Abrasive - For Steel/Metal

Ideal choice for cutting all types of ferrous metals and various alloy steels.

### A30 Aluminum Oxide Abrasive - For SS

Engineered to cut all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.



These wheels should be used for cutting only.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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### For Steel/Metal

#### Type 27 - For Right Angle Grinders

05539502833	4 x .125 x 3/8	A24	15,280	20
05539502834	4 x .125 x 5/8	A24	15,280	20
05539502839	4-1/2 x .125 x 5/8-11	A24	13,580	20
05539502838	4-1/2 x .125 x 7/8	A24	13,580	20
05539502844	5 x .125 x 7/8	A24	12,225	20
05539502848	6 x .125 x 7/8	A24	10,185	20
05539502851	7 x .125 x 5/8-11	A24	8,600	10
05539502850	7 x .125 x 7/8	A24	8,600	20
05539502856	9 x .125 x 5/8-11	A24	6,600	10
05539502855	9 x .125 x 7/8	A24	6,600	20

### For Stainless Steel

#### Type 27 - For Right Angle Grinders

05539561559	4-1/2 x .125 x 5/8-11	A30	13,580	20
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## Gold Aluminum Oxide Abrasive

### Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Extra thin
- Specially reinforced

### Benefits

- Burn-free cutting
- Long life
- Meets nuclear industry standards
- Quick cutting action
- Minimal kerf loss
- Added safety, strength and straight cuts

Engineered for cutting pipe and all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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### For Steel/Stainless Steel/Metal

#### Type 27 - For Right Angle Grinders

05539563817	4-1/2 x 3/32 x 7/8	A30	13,580	20
05539563819	5 x 3/32 x 7/8	A30	12,225	20
05539563821	7 x 3/32 x 7/8	A30	8,600	20

These wheels should be used for cutting only.

## GoldCut Aluminum Oxide Abrasive

### Features

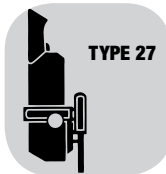
- Quality aluminum oxide abrasive
- Clean bond
- Extra thin depressed center cutting-off wheels
- Specially reinforced
- Hubbed wheels

### Benefits

- Burn-free cutting
- Works particularly well on stainless
- No sulphur, iron or chlorine in bond means no contamination of workpiece
- Quick cutting action
- Minimal kerf loss
- Added safety, strength and straight cuts
- Quick, tool-free changes increase productivity

Excellent choice for cutting all types of metals and various alloy steels.

These wheels should be used for cutting only.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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### For Steel/Metal

#### Type 27/42 - For Right Angle Grinders

66252830584	4-1/2 x .045 x 5/8-11	A30	13,580	20
05539561551	4-1/2 x .045 x 7/8	A30	13,580	20
05539561553	5 x .045 x 7/8	A30	12,225	20
05539561554	6 x .045 x 7/8	A30	10,185	20
05539561555	7 x 1/16 x 7/8	A30	8,600	20
66252830585	9 x 1/16 x 5/8-11	A30	6,600	10



**NEW!**

## Carbo Metal Aluminum Oxide Abrasive

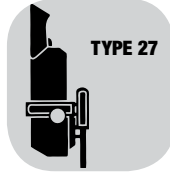
### Features

- Aluminum oxide abrasive
- Competitive initial price point

### Benefits

- Engineered for all steel/ferrous metals
- Best starting specification for end-user unable to measure performance

Good choice for steel/metal applications with low initial price



These wheels should be used for cutting only.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Stainless /Metal</b>				
<b>Type 27/42 - For Right Angle Grinders - Reinforced</b>				
66252836280	4-1/2 x .045 x 7/8	A60	13,580	20
66252836281	5 x .045 x 7/8	A60	12,225	20
66252836282	6 x .045 x 7/8	A60	10,185	20

## Spec Check

### DEPRESSED CENTER WHEEL STARTING RECOMMENDATIONS BY MATERIAL

MATERIALS:	HEAVY-DUTY GRINDING BEST PERFORMANCE	GENERAL-DUTY GRINDING	BLENDING AND FINISHING	CUTTING	SURFACE PREPARATION
ANGLE / CHANNEL IRON BAR STOCK / I-BEAMS CARBON / HIGH TENSILE STEEL METAL STUDS / TUBING	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD TYPE 27	FIBRATEx SURFACE STRIP FIBRATEx SURFACE FINISH
CAST IRON / PIPE	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD TYPE 27	FIBRATEx SURFACE STRIP FIBRATEx SURFACE FINISH
STAINLESS / ALLOYS	PREMIER RED TYPE 27	GOLD MAXX TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD SS TYPE 27	FIBRATEx SURFACE STRIP FIBRATEx SURFACE FINISH
ALUMINUM / BRASS / BRONZE	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD ALU TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD ALU TYPE 27	FIBRATEx SURFACE STRIP FIBRATEx SURFACE FINISH
FIBERGLASS / PLASTIC	-	GOLD FLEXIBLE TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD TYPE 27	FIBRATEx SURFACE STRIP FIBRATEx SURFACE FINISH
PAINT / RUST	-	GOLD TYPE 27	-	-	-

## Depressed Center Wheel Competitive Cross Reference

CARBORUNDUM	FLEXOVIT	METABO	PFERD	SAIT	TYROLIT	WALTER
PREMIER RED LONG LIFE Z24LL	FLEXON ZA-24P	-	ZA-SG	ATTACKER	-	A-20-XX
PREMIER RED Z24	FLEXON ZA-20Q	ZA24	ZA-SG	Z-TECH	1ZA30QBFX	A-20-XX
GOLD MAXX ZA24-R	FLEXON	ZA24	ZA-SG	Z-TECH	1ZA30QBFX	A-20-XX
GOLD A24	A24/A30T	A24R/T	A-SG	A24R, A24T	A30RBF	A-24-HPS
GOLD ALUMINUM A46	A24ALU	A36M	A-W-ALU	A46N	A36NBFX	A-24-ALU
GOLD FLEXIBLE	FLEXCEL	-	-	CHALLENGER	RONDELLER	ROTELLER
CARBO METAL A24	A30S	A24N	-	A24N	-	-

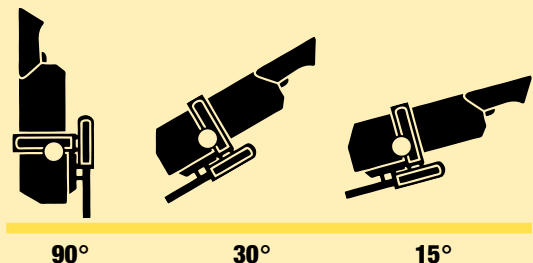


### TechTip

- For best results, hold your right angle grinder at a:
- 30° angle with 1/4" and 1/8" thick Type 27 wheels
  - 90° angle with .045", 1/16", 3/32", .125" and 1/8" thick Type 27 wheels
  - 15° angle with saucers (Type 28) and Gold Flexible (Type 29) Wheels



It is the user's responsibility to refer to and comply with ANSI B7.1



90°

30°

15°

# Depressed Center Wheels for Blending and Polishing

## Gold Flexible Aluminum Oxide Abrasive

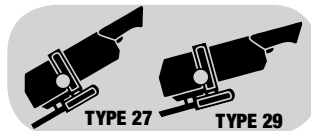
### Features

- Aluminum oxide grain
- Special formulation
- Flexible
- Type 29 conical has nubs on the face; (Use at a 15° angle)
- Type 27 has concentric grooves

### Benefits

- Cool cutting; leaves no burn marks
- Prevents loading
- No offensive odors generated while grinding
- Type 27 meets nuclear industry standards; no contamination of workpiece
- Excellent control of finish quality and removal rate in light stock removal applications
- Shallow grinding angle permits larger contact area with less gouging of workpiece
- Nubs/grooves allow more air to circulate in grinding zone, promoting cooler cutting (reducing heat and loading) and better swarf removal
- Ideal for getting into tight spaces, smoothing corners and curves, and polishing and blending welds on flat surfaces

*Blending, finishing and polishing of stainless steel, aluminum, structural steel, carbon steel, cast iron welds and burrs.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Stainless Steel/Metal</b>				
<b>Type 27 - For Right Angle Grinders</b>				
05539567289	4-1/2 x 1/8 x 7/8	A60-Medium	13,580	20
05539567287	7 x 1/8 x 5/8-11	A60-Medium	8,600	10
<b>For Steel/Metal</b>				
<b>Type 29 - For Right Angle Grinders</b>				
66252833457	4-1/2 x 1/8 x 7/8	A36	13,580	20
66252833458	5 x 1/8 x 7/8	A36	12,225	20

## Metal Adapter Kit



*This adapter kit contains the items necessary to mount depressed center wheels with 7/8" center holes on to standard portable right angle or vertical shaft grinders. Adapter hubs are threaded for mounting on to standard 5/8"-11 NCRH spindles. This adapter kit may be used with wheel thicknesses of 1/8" or 1/4". All depressed center wheels must use the proper adapters to securely mount to the spindle.*

PART NO.	DESCRIPTION	KITS/BOX
<b>For Depressed Center Wheels</b>		
07660789275	Adapter Kit	1

# Cut-off Wheels for Precision Toolroom Applications

## Reinforced Aluminum Oxide Abrasive

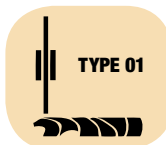
### Features

- Aluminum oxide abrasive
- Resin bond
- High strength, reinforced construction
- BFTK - side reinforced, rough sides
- Decimal thickness
- BFW - side reinforced, rough sides

### Benefits

- Fast cut rate and long life
- Free cutting action
- Burn-free cutting
- Resists breakage and provides straight cuts
- Maximum cut rate
- Very narrow cuts; minimum kerf loss
- Versatile; durable free cutting

Used primarily for cutting off high speed steel drill bits and end mills, as well as slotting dies.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For High-Speed Steel and Tool Steels</b>				
05539518986	6 x .060 x 1-1/4	A60-OBFTK	10,190	10
05539509197	7 x .035 x 5/8	A60-OBFTK	8,730	10
05539509196	7 x .035 x 1-1/4	BA60-OBFTK	8,730	10
05539509195	7 x .060 x 5/8	A60-OBFTK	8,730	10
05539509194	7 x .060 x 1-1/4	BA60-OBFTK	8,730	10
05539562844	7 x 1/16 x 1-1/4	A36-TBFW	8,730	10

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For High-Speed Steel and Tool Steels</b>				
05539501911	8 x .035 x 5/8	A60-OBFTK	7,640	10
05539501912	8 x .060 x 5/8	A60-OBFTK	7,640	10
05539509192	8 x .060 x 1-1/4	A60-OBFTK	7,640	10

## Non-Reinforced Aluminum Oxide Abrasive

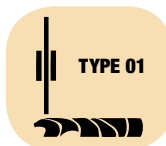
### Features

- Aluminum oxide abrasive
- Resin bond

### Benefits

- Fast cut rate and long life
- Free cutting action
- Burn-free cutting
- Long life

For use on machines where the work is rigidly clamped and the wheel operates on a controlled cutting plane with no twisting or lateral stresses. Ideal for slotting dies or cutting off high-speed steel drills and end mills.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For High-Speed Steel and Tool Steels</b>				
05539509188	6 x 1/16 x 1-1/4	A60-OB5SW	7,640	10
05539501923	7 x 1/32 x 1-1/4	A60-MB5SW	5,460	10
05539509187	7 x 1/32 x 1-1/4	A60-OB5SW	5,460	10
05539509186	7 x 1/32 x 1-1/4	A70-QB5SW	5,460	10
05539509185	7 x 1/16 x 1-1/4	A46-OB5SW	6,550	10
05539509184	7 x 1/16 x 1-1/4	A60-OB5SW	6,550	10
05539509183	8 x 1/16 x 1-1/4	A46-OB5SW	5,730	10
05539501926	8 x 1/16 x 1-1/4	A60-MB5SW	5,730	10
05539562839	10 x 1/16 x 5/8	A46-QB5RW	4,585	10
05539509181	10 x 1/16 x 5/8	A60-OB5SW	4,585	10



### TechTip

- Reinforced cut-off wheels are designed to resist breakage caused by severe cross-bending and are required on any operation where the work is not securely clamped.
- Non-reinforced cut-off wheels are designed for use on "fixed-base" types of machines where the work is securely clamped, guarded, and where the wheel operates on a controlled cutting plane.



It is the user's responsibility to refer to and comply with ANSI B7.1

# Non-Reinforced Cut-off Wheels for MetLab Applications

## Non-Reinforced Aluminum Oxide and Silicon Carbide Abrasives

### Features

- Developed specifically for microscopic metal analysis
- Available in silicon carbide abrasive
- Available in aluminum oxide abrasive
- Superior bond system
- Used wet

### Benefits

- Burr-free cutting and minimal distortion of metallurgical samples
- Ideal for titanium and other non-ferrous metals
- Engineered for hard, medium and soft metals, ferrous alloys and tool steels
- Generates pure cuts while minimizing wheel wear and odor
- More cuts/wheel and minimal downtime to change wheels
- Minimal burn

Developed specifically for sectioning and sample preparation for metallurgical lab analysis.



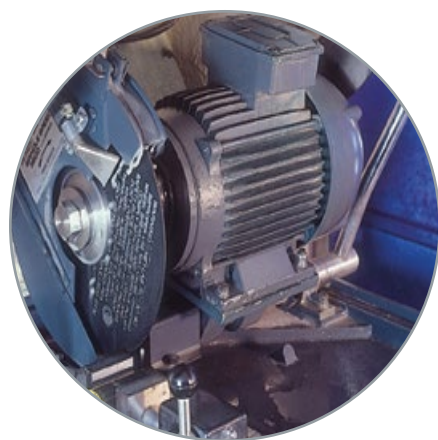
PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Rc 55-68 Steel</b>				
66253060544*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 901	4,025	10
66253060553*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 101	3,500	10
66253060560*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 121	3,820	10
66253060690*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 141	2,770	10
<b>For Rc 40-55 Steel</b>				
66253060546*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 902	4,025	10
66253060554*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 102	3,500	10
66253060562*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 122	3,820	10
66253060691*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 142	2,770	10

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Rc 30-40 Steel</b>				
66253060547*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 903	4,025	10
66253060555*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 103	3,500	10
66253060563*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 123	3,820	10
66253060692*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 143	2,770	10
<b>For Rc 20-30 Steel</b>				
66253060548*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 904	5,085	10
66253060556*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 104	4,585	10
66253060681*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 124	3,820	10
66253060712*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 144	3,330	10

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Non-ferrous Materials</b>				
66253060550*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 905	5,085	10
66253060557*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 105	4,585	10
66253060683*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 125	3,820	10
66253060713*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 145	3,330	10

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Titanium</b>				
66253060552*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 906	5,085	10
66253060558*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 106	4,585	10
66253060684*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 126	3,820	10
66253060714*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 146	3,330	10

\*All MetLab wheels are non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.



BONDED ABRASIVES



# Reinforced Cut-off Wheels for Portable Machines

## Premier Red Reinforced Ceramic Alumina/Zirconia Alumina Abrasive Blend

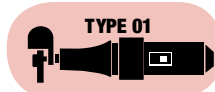
### Features

- An exclusive blend of high-performance ceramic alumina and zirconia alumina abrasives
- Advanced grain and bond technology
- 1/32" & .035 thick – fastest initial cut rate
- 1/16" thick
- 1/8" & 3/16" thick – exceptional control
- Smaller blotters

### Benefits

- Up to 50% added wheel life
- Up to 5X the life versus A/O wheels on carbon steel, cast iron, stainless steel and exotic metals
- Substantially longer wheel life
- Fastest cut rate
- Minimum kerf loss
- For demanding applications
- Longest lasting
- Faster, freer cutting

Ideal for cutting all types of stainless steel and steel alloys.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal</b>				
05539503861	3 x 1/32 x 3/8	MZ60-T	25,465	50
05539503863	3 x 1/16 x 3/8	MZ36-T	25,465	50
05539504270	3 x 3/16 x 3/8	MZ36-T	25,465	50

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Stainless Steel/Metal (continued)</b>				
05539503507	4 x .035 x 3/8	MZ60-T	19,100	25
05539503508	4 x 1/16 x 3/8	MZ36-T	19,100	25
05539503509	4 x 1/8 x 3/8	MZ36-T	19,100	25

## Gold Reinforced Aluminum Oxide Abrasive

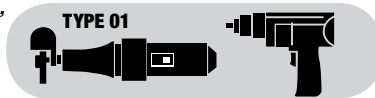
### Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction
- BFTK - side reinforced, rough sides
- BFW - side reinforced, rough sides

### Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cutting
- Maximum cut rate
- Minimum kerf loss
- Versatile, durable free cutting

For cutting off ferrous metals, alloy steels and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
05539509277	2 x .035 x 1/4	A60-OBFTK	30,560	25
05539509276	2 x .035 x 3/8	A60-OBFTK	30,560	25

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal (continued)</b>				
05539509275	2 x 1/16 x 1/4	A36-TBFW	30,560	25
05539509269	3 x .035 x 1/4	A60-OBFTK	25,465	25
05539509268	3 x .035 x 3/8	A60-OBFTK	25,465	25
05539509267	3 x .060 x 1/4	A60-OBFTK	25,465	25
05539509266	3 x .060 x 3/8	A60-OBFTK	25,465	25
05539509265	3 x 1/16 x 1/4	A36-TBFW	25,465	25
05539509264	3 x 1/16 x 1/4	A60-TBFW	25,465	25
05539509263	3 x 1/16 x 3/8	A36-TBFW	25,465	25
05539509262	3 x 1/16 x 3/8	A60-TBFW	25,465	25
05539509261	3 x 1/8 x 1/4	A36-TBFW	25,465	25
05539509260	3 x 1/8 x 3/8	A36-TBFW	25,465	25
05539509258	4 x .035 x 1/4	A60-OBFTK	19,100	25
05539509257	4 x .035 x 3/8	A60-OBFTK	19,100	25
05539509255	4 x 1/16 x 1/4	A36-TBFW	19,100	25
05539509254	4 x 1/16 x 3/8	A36-TBFW	19,100	25
05539509252	4 x 1/8 x 3/8	A36-TBFW	19,100	25



## Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	CORRECTION
NON-SQUARE CUTS	WORK NOT CLAMPED PROPERLY MISALIGNED SPINDLE BEARINGS POOR COOLANT DISTRIBUTION WHEEL IS TOO HARD	CHECK CLAMP AND CLEAN TO REMOVE SWarf CHECK FOR BEARING TRUTH AND ALIGNMENT ENSURE EQUAL VOLUME OF COOLANT TO EACH WHEEL SIDE USE SOFTER ACTING WHEEL - SOFTER GRADE/FINER GRIT
WORKPIECE BURN	INSUFFICIENT FEED RATE POOR COOLANT FLOW WHEEL IS TOO COARSE WHEEL IS TOO HARD WHEEL IS RUNNING OUT WHEEL SPEED IS TOO SLOW	WORK MACHINE TO MAXIMUM POWER AVAILABLE INCREASE VOLUME AND DIRECT AT CUTTING POINT USE FINER WHEEL OR MORE MACHINE POWER USE SOFTER GRADE WHEEL CHECK SPINDLE AND FLANGES ENSURE TIGHT FLANGES AND MAXIMUM SPEED MARKED ON WHEEL BEING USED
POOR FINISH	TOO MUCH BURR WHEEL TOO COARSE	USE FINER GRIT OR SOFTER WHEEL USE FINER GRIT

# Reinforced Cut-off Wheels for Portable Circular Saws

## Reinforced Aluminum Oxide Abrasive

### Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

Used on hand-held portable circular saws to cut steel and all types of metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Fast Cut</b>				
05539509243	7 x 1/16 x 5/8	A36-TBFW	8,730	10
05539509238	8 x 1/16 x 5/8	A36-TBFW	7,640	10
<b>For Stainless Steel</b>				
05539509249	7 x 3/32 x 5/8	A36-XBFW	8,730	10

## Cut-off Wheel Competitive Cross Reference

CARBORUNDUM	FLEXOVIT	METABO	SAIT	3M	WALTER
<b>FOR SMALL STRAIGHT OR IN-LINE PORTABLE GRINDERS (2" - 4")</b>					
PREMIER RED	FLEXON	-	SAITECH	GREEN CORPS	-
GOLD	A46T/A36-R	A 60 TZ	A36T/A24R	-	A24-ZIP, A60-ZIP
<b>FOR RIGHT ANGLE GRINDERS (4" - 9")</b>					
PREMIER REDCUT	-	-	SAITECH .045	-	A30-ZIP
GOLDCUT	RAZORBLADE	SLICER	0.045	-	A30-ZIP
CARBO METAL	-	SLICER	-	-	-
<b>FOR CIRCULAR SAWS (7" - 8")</b>					
METAL	A36TB38	A 30 S	-	-	A30-ZIP
<b>FOR PORTABLE GAS OR ELECTRIC SAWS (12" - 16")</b>					
GOLD METAL	A24TB	A 24 N	BRUTE	-	A24 PORTACUT
GOLD CONCRETE	AC24SB	C 24 N	C24R	-	C24 PORTACUT
GOLD DUCTILE	AC24SB	AC 24 R	DUCTILE	-	-
<b>FOR STATIONARY SAWS (10" - 20")</b>					
PREMIER RED	-	-	-	-	-
GOLD FAST CUT	A30RB	A 30 R	A24N	-	A24-FC RIPCUT
GOLD LONG LIFE	A30SB	A 30 N	A24R	-	A24-RIP
<b>FOR CHOP SAWS (10" - 16")</b>					
PREMIER RED FAST CUT	-	-	SAITECH STEEL WORKER	-	-
PREMIER RED LONG LIFE	-	-	-	-	-
GOLD FAST CUT	A30RB	A 30 R	EZ-CHOP	-	A30 CHOPCUT II
GOLD LONG LIFE	A30SB	A 30 S	IRON WORKER	-	A30-HC CHOPCUT
CARBORUNDUM	DEWALT	CONTINENTAL	MAKITA	PEARL	TYROLIT
<b>FOR CHOP SAWS (14")</b>					
CARBO METAL	COMPARABLE TO COMPETITIVE BRANDS' GENERAL PURPOSE LINES				

# Reinforced Cut-off Wheels for Right Angle Grinders

## Premier RedCut Reinforced Zirconia Alumina/Aluminum Oxide Abrasive Blend

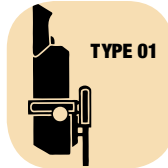
### Features

- Premier performing zirconia alumina/aluminum oxide abrasive blend in a free cutting bond
- Unique, high-strength, reinforced construction
- Extra thin

### Benefits

- 3X the life and 2X the cut rate of standard A/O wheels
- Smooth cutting action that minimizes burn and burrs and operator fatigue
- Maximum productivity; lowest total grinding costs
- Provides strength for use on right angle grinders
- Flexible, resilient; resists breakage
- Less binding; quick cutting action

**Excels on a broad range of materials, from alloys and stainless to gray iron.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Stainless Steel/Metal</b>				
<b>Type 01/41 – For Right Angle Grinders</b>				
05539566206	4-1/2 x 1/16 x 7/8	ZA60-Q	13,580	25
05539566207	5 x 1/16 x 7/8	ZA60-Q	12,225	25
05539566208	6 x 1/16 x 7/8	ZA60-Q	10,185	25

## Safety Tip

- Contact your machine vendor for proper flanges and guards when using Type 01 wheels on right angle grinders.
- Use Type 01 when proper cut-off guard and equal size flanges are available.



It is the user's responsibility to refer to and comply with ANSI B7.1

## GoldCut Reinforced Aluminum Oxide Abrasive

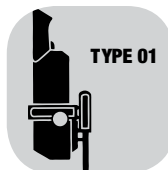
### Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Unique, high-strength, reinforced construction
- Extra thin

### Benefits

- Fast stock removal
- Free cutting action
- Long life, with no bounce
- Provides strength for use on right angle grinders
- Flexible, resilient; resists breakage
- Less binding; quick cutting action

**For general purpose cutting of stainless steel, steel and metal material with a right angle grinder.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 01/41 – For Right Angle Grinders</b>				
05539563951	4 x .045 x 5/8	A46-Q	15,280	25
05539527224	4 x 3/32 x 5/8	A36-Q	15,280	25
05539563952	4-1/2 x .045 x 7/8	A60-Q	13,580	25
05539527225	4-1/2 x 3/32 x 7/8	A60-Q	13,580	25
05539563953	5 x .045 x 7/8	A60-Q	12,225	25
05539527226	5 x 3/32 x 7/8	A60-Q	12,225	25
05539563954	6 x .045 x 7/8	A46-Q	10,185	25
05539527228	6 x 3/32 x 7/8	A60-Q	10,185	25
66252832324	7 x 1/16 x 7/8	A46-Q	8,600	25

## Carbo Metal Reinforced Aluminum Oxide Abrasive

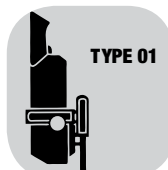
### Features

- Quality aluminum oxide abrasive
- Extra thin
- Low initial cost per wheel

### Benefits

- Quick cutting action
- Low kerf loss
- Ideal for on-site and small-unit jobs

**Economical choice for initial-price-conscious customers with general purpose applications.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Type 01/41 – For Right Angle Grinders</b>				
05539561584	4-1/2 x .040 x 7/8	A60	13,580	25
05539561585	5 x .040 x 7/8	A60	12,225	25
05539561586	6 x .040 x 7/8	A60	10,185	25

# Reinforced Cut-off Wheels for Right Angle Grinders

## Spec Check

### CUT-OFF WHEEL STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	IN-LINE GRINDERS	RIGHT ANGLE GRINDERS	CIRCULAR SAWS	PORTABLE GAS / ELECTRIC SAWS	STATIONARY SAWS	CHOP SAWS
ANGLE / CHANNEL IRON / BAR / SHEET STOCK	PREMIER RED GOLD	PREMIER REDCUT	METAL	GOLD METAL	PREMIER RED GOLD LONG LIFE	PREMIER RED LONG LIFE GOLD LONG LIFE
METAL STUDS / TUBING	-	GOLDCUT	METAL	GOLD METAL	GOLD LONG LIFE	GOLD LONG LIFE
CAST IRON / PIPE	GOLD	GOLDCUT	METAL	GOLD METAL	GOLD FAST CUT	GOLD FAST CUT
STAINLESS / ALLOYS	PREMIER RED	PREMIER REDCUT	STAINLESS	GOLD METAL	PREMIER RED	PREMIER RED FAST CUT
ALUMINUM / BRASS / BRONZE	GOLD	GOLDCUT	METAL	GOLD METAL	GOLD FAST CUT	GOLD FAST CUT
CONCRETE / BRICK / BLOCK / ASPHALT / GREEN CONCRETE	-	-	-	GOLD CONCRETE	-	-
DUCTILE	-	-	-	GOLD DUCTILE	-	-
PAINT / RUST / FIBERGLASS / PLASTIC	GOLD	GOLDCUT	METAL	-	GOLD FAST CUT	GOLD FAST CUT





# Reinforced Cut-off Wheels for Stationary Machines

## Premier Red Reinforced Zirconia Alumina Abrasive

### Features

- Premium, zirconia alumina abrasive
- Resin bond
- High-strength, externally reinforced construction

### Benefits

- Fastest cut rate on steel/metal
- Ideal for cutting stainless and high alloy steels
- Works best on dry cuts
- Most free cutting
- Longest wheel life
- Greatest productivity
- Resists breakage and provides straight cuts

For use on fixed-base machines.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Stainless Steel/Metal</b>				
05539507054	16 x 5/32 x 1	2ZA30-YB35FW	3,820	10
05539507061	20 x 5/32 x 1	2ZA30-TB35FW	2,710	5



## Gold Reinforced Aluminum Oxide Abrasive

### Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, externally reinforced construction

### Benefits

- Fast cut rate on metal or steel
- Burn-free cutting
- For dry cuts
- Long life
- Resists breakage and provides straight cuts

For use on fixed-base machines.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				
<b>Fast Cut</b>				
05539509216	10 x 3/32 x 5/8	A30-RBFW	6,110	10
05539507069	12 x 1/8 x 1	A30-RBFW	5,095	10
05539507070	14 x 1/8 x 1	A30-RBFW	4,365	10
05539507071	16 x 5/32 x 1	A30-RBFW	3,820	10
05539507072	20 x 5/32 x 1	A30-RBFW	2,710	5
05539509204	20 x 3/16 x 1	A30-RBFIW+	2,710	5
<b>Long Life</b>				
05539507063	10 x 3/32 x 5/8	A24-TBFW	6,110	10
05539507065	14 x 1/8 x 1	A24-TBFW	4,365	10
05539507066	16 x 5/32 x 1	A24-TBFW	3,820	10
05539507067	20 x 5/32 x 1	A24-TBFW	2,710	5
05539507068	20 x 3/16 x 1	A24-TBFIW+	2,710	5

+ These wheels are internally reinforced.



## TechTip

- Run the cut-off machine at the "Maximum Operating Speed" marked on the wheel.
- A cut-off machine should have 1 horsepower for every inch of wheel diameter.
- With a less powerful machine, we recommend starting with a Fast Cut specification.
- Use Long Life wheels in high horsepower, aggressive applications.



It is the user's responsibility to refer to and comply with ANSI B7.1

# Reinforced Cut-off Wheels for Chop Saws

## Premier Red Reinforced Zirconia Alumina Abrasive

### Features

- Premium zirconia alumina abrasive
- High performance resin bond
- High-strength, externally reinforced construction

### Benefits

- Fast cut rate
- 3X the life of aluminum oxide wheels
- Ideal for cutting stainless steel
- Works best on dry cuts
- Most free cutting
- Long life; highest productivity
- Resists breakage and provides straight cuts

For use on table-top machines. Best choice for cutting light tubing, angle iron, exhaust pipes, steel extrusions, stainless, alloyed steel and many non-ferrous metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Stainless Steel/Metal</b>				

### Fast Cut

05539507079	12 x 7/64 x 1	2ZA36-NB35FW	5,095	10
05539507080	14 x 7/64 x 1	2ZA36-NB35FW	4,365	10
05539507083	16 x 7/64 x 1	2ZA36-NB35FW	3,820	10

### Long Life

05539507082	14 x 7/64 x 1	2ZA36-PB35FW	4,365	10
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### TechTip

- Use Long Life chop saw wheels on machines rated 15 amps or higher.
- Use Fast Cut chop saw wheels on older, lower-powered machines.

**!** It is the user's responsibility to refer to and comply with ANSI B7.1

## Gold Reinforced Aluminum Oxide Abrasive

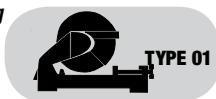
### Features

- Quality aluminum oxide abrasive
- Resin bond
- High-strength, externally reinforced construction

### Benefits

- Fast cut rate
- Burn-free cutting
- Resists breakage and provides straight cuts

For use on table-top machines. Ideal for cutting light tubing, angle iron, exhaust pipes and steel extrusions.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				

### Fast Cut

05539507087	14 x 7/64 x 1	A36-NBFW	4,365	10
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### Long Life

05539507085	12 x 7/64 x 1	A36-PBFW	5,095	10
05539507086	14 x 3/32 x 1	A36-PBFW	4,365	10
05539507088	16 x 7/64 x 1	A36-PBFW	3,820	10

## Carbo Metal Reinforced Aluminum Oxide Abrasive

### Features

- Quality aluminum oxide abrasive
- Low initial cost per wheel

### Benefits

- Designed for cutting alloys, steels and ferrous metals
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose cut-off applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal</b>				

05539561581	12 x 3/32 x 1	A36-P	5,095	10
05539561582	14 x 3/32 x 1	A36-P	4,365	10



# Reinforced Cut-off Wheels for High-Speed Gas/Electric Saws

NEW!

## Gold Reinforced Aluminum Oxide Abrasive

### Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut metal or steel.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Steel/Metal – Universal Arbor</b>				
66252837844	12 x 1/8 x 1"/20mm	A24	6,360	10
66252837845	14 x 1/8 x 1"/20mm	A24	5,400	10



## Gold Reinforced Silicon Carbide/Aluminum Oxide Abrasive Blend

### Features

- Silicon carbide/aluminum oxide abrasive blend
- Resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut ductile iron, ultra-hard metals, hydraulic hose, and PVC pipe.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Ductile Iron</b>				
05539565134	12 x 1/8 x 20mm	CA24	6,360	10
05539565136	14 x 1/8 x 20mm	CA24	5,400	10
05539565138	16 x 1/8 x 1"	CA24	4,700	10

## Gold Reinforced Silicon Carbide Abrasive

### Features

- Sharp, silicon carbide abrasive
- Resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut concrete and masonry.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Concrete/Masonry – Universal Arbor</b>				
66252837846	12 x 1/8 x 1"/20mm	C24	6,360	10
66252837847	14 x 1/8 x 1"/20mm	C24	5,400	10



### Universal Arbor Two Blade Sizes in One

Our patent-pending 1"/20mm knock-out arbor holes fit all gas and electric high speed saws. A 20mm bushing is pre-mounted into the 1" molded arbor hole. The wheel, with the 20mm bushing, can be mounted directly on any 20mm arbor high speed saw. Remove the 20 mm bushing to mount on 1" arbor high speed saw. Plus heavy-duty triple reinforcing results in a higher performing wheel.



BONDED ABRASIVES

# Reinforced Cut-off Wheels for Foundry Applications

## Premier Red Reinforced Zirconia Alumina Abrasive

### Features

- Premium zirconia alumina abrasive
- Resin bond
- Internally reinforced wheels

### Benefits

- Fastest cut rate on high alloy steels, stainless steel, steel/metal
- Works best on dry cuts
- Most free cutting
- Longest wheel life
- Highest productivity
- High strength; less kerf loss and provide straight cuts

Foundry cut-off wheels are used on chop stroke and locked-head push-through applications. Ideal for cutting off casting gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Stainless Steel/Metal</b>				
66253060317*	12 x 1/8 x 1	2ZA30-VB35FW	5,090	10
66253060319*	14 x 1/8 x 1	2ZA30-VB35FW	4,365	10
66253060323*	16 x 5/32 x 1	2ZA30-VB35FW	3,820	10
66253060325*	20 x 5/32 x 1	2ZA24-TB35FW	2,710	10
66253060328*	20 x 5/32 x 1	2ZA24-VB35FW	2,710	10
66253060329*	20 x 5/32 x 1	2ZA24-YB35FW	2,710	10
66253060330*	20 x 5/32 x 1	2ZA24-TB35FIW+	2,710	10
66253060334*	20 x 3/16 x 1	2ZA24-TB35FIW+	2,710	10
66253060335*	20 x 3/16 x 1	2ZA24-VB35FIW+	2,710	10

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Stainless Steel/Metal</b>				
66253060336*	20 x 3/16 x 1	2ZA24-YB35FIW+	2,710	10
66253062169*	24 x 7/32 x 1-3/4	2ZA24-TB35FIW+	2,260	5
05539528045	24 x 7/32 x 1-3/4	2ZA244-VB35FIW+	2,260	5
66253062170*	24 x 7/32 x 1-3/4	2ZA24-YB35FIW+	2,260	5

+Wheels with FIW grading are internally reinforced.

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

## Gold Reinforced Aluminum Oxide Abrasive

### Features

- Quality aluminum oxide abrasive
- Resin bond
- Internally reinforced wheels

### Benefits

- Fast cut rate on ferrous and non-ferrous metals
- Free cutting action
- For dry cuts
- Long life
- High strength; less kerf loss and provide straight cuts

Used on chop stroke and locked-head push-through applications. Ideal for cutting off casting gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
66253060313*	12 x 1/8 x 1	RGA244-TB35FW	5,090	10
66253060318*	14 x 1/8 x 1	RGA244-TB35FW	4,365	10
66253060322*	16 x 5/32 x 1	RGA244-RB35FW	3,820	10
66253060324*	20 x 5/32 x 1	RGA244-TB35FW	2,710	10
66253060331*	20 x 3/16 x 1	RGA244-RB35FIW+	2,710	10
66253060332*	20 x 3/16 x 1	RGA244-TB35FIW+	2,710	10
66253060333*	20 x 3/16 x 1	RGA244-VB35FIW+	2,710	10
05539528046	24 x 3/16 x 1-3/4	RGA244-RBFIW+	2,260	5
66253062165*	24 x 7/32 x 1-3/4	RGA244-RB35FIW+	2,260	5
66253062166*	24 x 7/32 x 1-3/4	RGA244-TB35FIW+	2,260	5
66253062167*	24 x 7/32 x 1-3/4	RGA244-VB35FIW+	2,260	5
05539528047	26 x 7/32 x 1-3/4	RGA244-YB35FIW+	2,090	5

+Wheels with FIW grading are internally reinforced.

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.





## Premier Red Reinforced Zirconia Alumina Abrasive

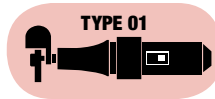
### Features

- Premium zirconia alumina abrasive
- High-performance resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- 3 times the life of aluminum oxide
- Greatest productivity
- Free cutting action
- Long life
- Resists breakage

Use when grinding with a hand-held machine. Best choice for grinding steel, steel alloys and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 01 - For Portable Grinders</b>				
66253060939*	3 x 1/4 x 3/8	2ZA24-RBFF	18,080	10
66253060940*	3 x 3/8 x 3/8	2ZA24-QBFF	18,080	10
66253060953*	6 x 1 x 5/8	2ZA14-QBF64	8,000	5
05539509169	6 x 1 x 5/8	2ZA14-RBF64	8,000	5
66253060957*	8 x 3/4 x 5/8	2ZA14-QBF64	6,000	5
66253060958*	8 x 3/4 x 5/8	2ZA14-RBF64	6,000	5
05539509167	8 x 1 x 5/8	2ZA14-RBF64	6,000	5
66253060960*	8 x 1 x 5/8	2ZA16-QBF64	6,000	5

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

## Gold Reinforced Aluminum Oxide Abrasive

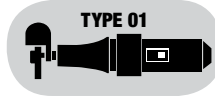
### Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

### Benefits

- Fast cut rate
- Free cutting action
- Long life
- Resists breakage

Use when grinding with a hand-held machine. The economical choice for grinding steel, steel alloys and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 01 - For Portable Grinders</b>				
05539507346*	6 x 1 x 5/8	GA16-P5BF5	6,000	5
05539507347	8 x 1 x 5/8	GA16-P5BF5	4,540	5

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

## Reinforced Aluminum Oxide Abrasive

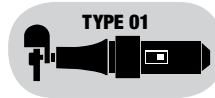
### Features

- Aluminum oxide abrasive
- Reinforced

### Benefits

- Fast cut rate and long life
- Durable, yet cool cutting

Use when grinding with a hand-held machine. Ideal for grinding parting lines, gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 01 - For Portable Grinders</b>				
66253060936*	3 x 1/4 x 3/8	A24-TBFF	18,080	10
05539506618	3 x 1/2 x 3/8	GA24-PBFF	18,080	10

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

# Portable Snagging Wheels

## Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

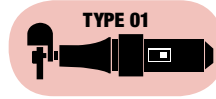
### Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High-performance resin bond

### Benefits

- Fast cut rate
- 3 times the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

**Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Soft Metals</b>				
<b>Type 01 - For Portable Grinders</b>				
66253060956*	6 x 1 x 5/8	2ZC14-QBF64	8,000	5
66253060961*	8 x 1 x 5/8	2ZC16-QBF64	6,000	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Gold Aluminum Oxide/Silicon Carbide Abrasive Blend

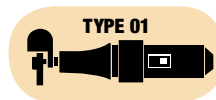
### Features

- Quality aluminum oxide/silicon carbide abrasive blend
- Resin bond

### Benefits

- Fast cut rate
- Free cutting action

**Economical choice for grinding dirty, scale-covered castings, aluminum and other soft metals.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Soft Metals</b>				
<b>Type 01 - For Portable Grinders</b>				
66253061064*	8 x 1 x 5/8	CGA16-P5BF5	4,540	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Premier Red Zirconia Alumina Abrasive

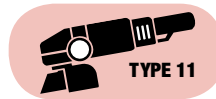
### Features

- Premium zirconia alumina abrasive
- High-performance resin bond

### Benefits

- Fast cut rate
- 3 times the life of aluminum oxide abrasive; greatest productivity
- Free cutting action

**Best choice for grinding steel, steel alloys and cast iron. Used for grinding weld seams, cleaning metal before welding, grinding off fins and parting lines, smoothing surfaces on castings, and smoothing surfaces before painting or plating.**



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 11 - For Portable Cup Grinders</b>				
<b>Full Steel Back Bushing</b>				
66253060844*	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	2ZA16-QB64	9,070	10
66253060847*	5 / 3-13/16 x 2 x 5/8-11 Rim 1, Back 3/4	2ZA16-QB64	7,260	5
66253060852*	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA14-RB64	6,000	5
05539500694	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-QB64	6,000	5
<b>Standard Back Bushing</b>				
05539563938	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	2ZA16-QB64	9,070	10
05539509156	5 / 3-3/4 x 2 x 5/8-11 Rim 1, Back 3/4	2ZA16-QB64	7,260	5
05539508397	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA14-RB64	6,000	5
05539509155	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-PB64	6,000	5
05539507176	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-QB64	6,000	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Aluminum Oxide Abrasive

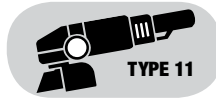
### Features

- Quality aluminum oxide abrasive
- Resin bond

### Benefits

- Fast cut rate
- Free cutting action

*Economical choice for grinding steel, steel alloys and all ferrous metals.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 11 - For Portable Cup Grinders</b>				
<b>Full Steel Back Bushing</b>				
05539563936*	5 / 3-13/16 x 2 x 5/8-11	A24-PB5	7,260	5
	Rim 1, Back 3/4			
05539507182	6 / 4-13/16 x 2 x 5/8-11	A16-PB5	6,000	5
	Rim 1-1/2, Back 3/4			

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 11 - For Portable Cup Grinders</b>				
<b>Standard Back Bushing</b>				
05539509166	4 / 3 x 2 x 5/8-11	A16-PB5	9,070	10
	Rim 3/4, Back 3/4			
66253060855*	5 / 3-3/4 x 2 x 5/8-11	A16-PB5	7,260	5
	Rim 1, Back 3/4			
05539509162	5 / 3-3/4 x 2 x 5/8-11	A24-PB5	7,260	5
	Rim 1, Back 3/4			
05539509160	6 / 4-3/4 x 2 x 5/8-11	A16-PB5	6,000	5
	Rim 1-1/2, Back 3/4			
05539563989	6 / 4-3/4 x 2 x 5/8-11	A16-QB5	6,000	5
	Rim 1-1/2, Back 3/4			
05539509159	6 / 4-3/4 x 2 x 5/8-11	A24-PB5	6,000	5
	Rim 1-1/2, Back 3/4			
05539507180*	6 / 4-3/4 x 2 x 5/8-11	A24-RB5	6,000	5
	Rim 1-1/2, Back 3/4			

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

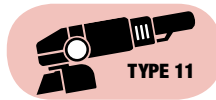
### Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High performance resin bond

### Benefits

- Fast cut rate
- 3 times the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

*Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Soft Metals</b>				
<b>Type 11 - For Portable Cup Grinders</b>				
<b>Full Steel Back Bushing</b>				
05539507178*	6 / 4-13/16 x 2 x 5/8-11	2ZC16-QB64	6,000	5
	Rim 1-1/2, Back 3/4			
<b>Standard Back Bushing</b>				
05539507177	6 / 4-3/4 x 2 x 5/8-11	2ZC16-QB64	6,000	5
	Rim 1-1/2, Back 3/4			

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Aluminum Oxide/Silicon Carbide Abrasive Blend

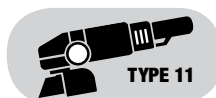
### Features

- Quality aluminum oxide/silicon carbide abrasive blend
- Resin bond

### Benefits

- Fast cut rate
- Free cutting action

*Economical choice for grinding dirty, scale-covered castings, aluminum and other soft metals.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Soft Metals</b>				
<b>Type 11 - For Portable Cup Grinders</b>				
<b>Full Steel Back Bushing</b>				
05539507183	6 / 4-13/16 x 2 x 5/8-11	CGA16-QB5	6,000	5
	Rim 1-1/2, Back 3/4			
<b>Standard Back Bushing</b>				
66253060740*	4 / 3 x 2 x 5/8-11	CGA16-PB5	9,070	10
	Rim 3/4, Back 3/4			
05539507181	6 / 4-3/4 x 2 x 5/8-11	CGA16-QB5	6,000	5
	Rim 1-1/2, Back 3/4			

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

# Portable Snagging Cones and Plugs

## Premier Red Zirconia Alumina Abrasive

### Features

- Premium zirconia alumina abrasive
- High-performance resin bond

### Benefits

- Fastest cut rate
- 3X the life of aluminum oxide abrasive: greatest productivity
- Free cutting action

*The best choice for grinding steel, steel alloys and cast iron, for removing burrs and flash and finishing any type of metal surface in a confined area.*



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Iron/Steel/Metal</b>				

### Type 16 Cones (Round End)

66253060513*	1-1/2 x 3 x 3/8-24	2ZA20-R	24,190	10
66253060541*	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520886	2 x 3 x 5/8-11	2ZA20-R	18,145	10
05539520887	2-3/4 x 3-1/2 x 5/8-11	2ZA20-R	13,195	10

### Type 17R (Round End)

66253060533*	2 / 3/4 x 3 x 5/8-11	2ZA20-R	18,145	10
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### Type 18 Plugs (Square End)

66253060510*	1-1/2 x 2-1/2 x 5/8-11	2ZA20-R	24,190	10
66253060516*	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520889	2 x 3 x 5/8-11	2ZA20-R	18,145	10
66253060540*	2 x 3 x 5/8-11	2ZA24-R	18,145	10

### Type 18R Plugs (Round End)

05539520893	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520891	2 x 3 x 5/8-11	2ZA20-R	18,145	10

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

### Cone and Plug Shapes



## Gold Zirconia Alumina/Aluminum Oxide Abrasive Blend

### Features

- Performance, zirconia alumina/aluminum oxide abrasive blend
- Resin bond

### Benefits

- Fast cut rate
- Easily grinds scale-covered parts
- Long life

*Excellent for grinding steel, steel alloys and cast iron, for removing burrs and flash and finishing any type of metal surface in a confined area.*



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 16 Cones (Round End)</b>				
05539563710	1-1/2 x 3 x 3/8-24	3ZA24-R	24,190	10
05539563711	1-1/2 x 3 x 5/8-11	3ZA20-R	24,190	10
<b>Type 18 Plugs (Square End)</b>				
05539563715	2 x 3 x 5/8-11	3ZA20-R	18,145	10





## Aluminum Oxide Abrasive

### Features

- Quality, aluminum oxide abrasive
- Resin bond

### Benefits

- Fast stock removal
- Free cutting action

The economical choice for grinding steel or iron castings, removing burrs and flash and finishing metal surfaces in confined areas.



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 16 Cones (Round End)</b>				
66253060500*	1 x 3 x 3/8-24	A24-R	36,290	10
05539564069*	1-1/2 x 2 x 3/8-24	A24-R	24,190	10
05539564068*	1-1/2 x 2-1/2 x 3/8-24	A24-R	24,190	10
05539509154	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
66253060517*	1-3/4 x 3 x 3/8-24	A24-R	20,735	10
66253060523*	1-3/4 x 3 x 5/8-11	A24-R	20,735	10
05539564070	2 x 3 x 3/8-24	A24-R	18,145	10
05539509153	2 x 3 x 5/8-11	A24-R	18,145	10
05539509152	2-3/4 x 3-1/2 x 5/8-11	A24-R	13,195	10
05539564073*	3 x 3 x 5/8-11	A24-R	12,100	10
05539564071*	3 x 4 x 5/8-11	A24-R	12,100	10

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
<b>Type 17 Cones (Square End)</b>				
05539509150	1-1/2 / 1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509149	2 / 1/2 x 3 x 5/8-11	A24-R	18,145	10
<b>Type 17R Cones (Round End)</b>				
05539564076*	1-1/2 / 3/4 x 3 x 3/8-24	A24-R	24,190	10
<b>Type 18 Plugs (Square End)</b>				
66253060512*	1-1/2 x 2-1/2 x 3/8-24	A24-R	21,490	10
05539509145	1-1/2 x 2-1/2 x 5/8-11	A24-R	24,190	10
05539509144	1-1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509143	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
66253060524*	2 x 2 x 3/8-24	A24-R	18,145	10
05539509142	2 x 3 x 3/8-24	A24-R	18,145	10
05539509141	2 x 3 x 5/8-11	A24-R	18,145	10
05539509139	3 x 4 x 5/8-11	A24-R	12,095	10
<b>Type 18R Plugs (Round End)</b>				
05539564074*	1-1/2 x 2-1/2 x 3/8-24	A24-R	24,190	10
05539509138	1-1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509137	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
05539509136	2 x 3 x 5/8-11	A24-R	18,145	10
05539509134	3 x 4 x 5/8-11	A24-R	12,095	10

## Foundry Floorstand Snagging Wheels

### Premier Red Zirconia Alumina/Aluminum Oxide Abrasive Blend

#### Features

- Premium zirconia alumina abrasive blend
- High performance resin bond

#### Benefits

- Fast cut rate
- 3X the life of aluminum oxide
- Greatest productivity
- Free cutting action

Castings small enough to be carried to the grinder are ground using a floorstand wheel. Best choice for grinding all types of metals, cast iron and cast steel.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
66253061609*	30 x 2 x 12	AZA14-QBF68	1,595	1
66253061610*	30 x 2 x 12	AZA14-RBF68	1,595	1
66253061590*	30 x 2 x 12	2ZA14-RBF68	1,595	1
66253061589*	30 x 2 x 12	2ZA16-QBF68	1,595	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.



BONDED ABRASIVES

### TechTip

- Always ensure proper mounting of floorstand wheels by mounting with arrow as marked on wheel.
- Always use a safety guard.
- Always run the wheel for 1 minute before grinding.
- For optimum performance, ensure adequate air pressure and air volume when using pneumatic machines.
- Avoid loading or glazing by changing the contact angle.



It is the user's responsibility to refer to and comply with ANSI B7.1

# Foundry Floorstand Snagging Wheels

## Gold Zirconia Alumina/Aluminum Oxide Abrasive Blend

### Features

- Performance zirconia alumina/aluminum oxide abrasive blend
- Resin bond
- High-strength, safety web construction
- Convenient 10 wheels/pallet packaging available

### Benefits

- Fast cut rate
- Easily grinds scale-covered parts
- Extended wheel life
- Resists breakage
- Economical; environmentally-friendly
- Easy storage and handling

*Castings small enough to be carried to the grinder are ground using a floorstand wheel. Ideal for grinding all types of metals, cast iron and cast steel.*

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
66253061451*	24 x 2-1/2 x 12	3AZA14-RBF68	1,990	1
66253061570*	24 x 3 x 12	3AZA14-RBF68	1,990	1
05539562953	30 x 2 x 12	3AZA14-SBF68	1,595	1
05539562952	30 x 2 x 12	3AZA16-QBF68	1,595	1
<b>Special Pallet Pack of 10 Wheels</b>				
05539563986*	30 x 2 x 12	3AZA14-SBF68	1,595	10
05539563987	30 x 2 x 12	3AZA16-QBF68	1,595	10

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Zirconia Alumina/Aluminum Oxide Abrasive Blend

### Features

- Unique zirconia alumina/aluminum oxide abrasive blend
- Resin bond
- High-strength, safety web construction

### Benefits

- Competitive performance/price ratio
- Ideal for medium to low pressure applications
- Long life
- Resists breakage

*Castings small enough to be carried to the grinder are ground using a floorstand wheel. The choice for medium to low pressure cast iron and metal applications - when initial-price is the main purchasing consideration.*

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
05539563988	30 x 2 x 12	AZ All Purpose	1,595	1
<b>Special Pallet Pack of 10 Wheels</b>				
05539563990*	30 x 2 x 12	AZ All Purpose	1,595	10

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

### Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High-performance resin bond

### Benefits

- Fast cut rate
- 3X the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

*Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.*

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Iron/Steel/Metal</b>				
66253061611*	30 x 2 x 12	2ZC14-RBF68	1,595	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.



## Aluminum Oxide Abrasive

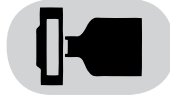
### Features

- Aluminum oxide abrasive
- Resin bond

### Benefits

- Tough and durable, yet cool cutting
- High-strength and long life

*Tool post wheels provide the first step in reconditioning heavily damaged high speed tool steel on post grinders and universal attachments on cylindrical grinders.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
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### For Steel/Metal

#### Type 01 - For Tool Post Grinders

05539509907	2 x 1/2 x 3/8	A36-P5B6	18,145	10
66253060947*	3 x 1/2 x 3/8	GA24-R5B6	12,095	10

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

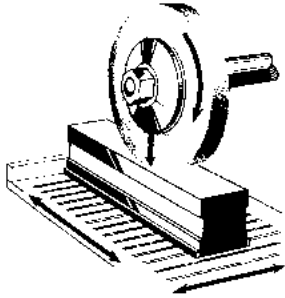
# Toolroom Wheels

## Toolroom Grinding Applications

Toolrooms are found in almost every manufacturing plant throughout the country. They may be called by other names such as machine shops, maintenance shops or repair shops, however the work done is virtually the same. Toolroom grinding involves the production, maintenance and repair of cutting tools and machinery parts used in all types of manufacturing operations.

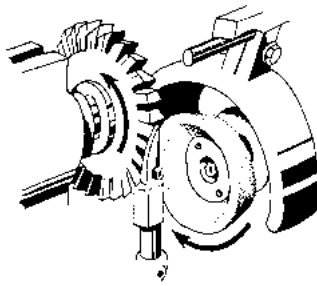
### Surface Grinding

The grinding of flat, contoured or angular surfaces on a workpiece which is passed in a horizontal plane against a revolving grinding wheel. Surface grinding applications range from heavy, rapid stock removal operations to precision contouring.

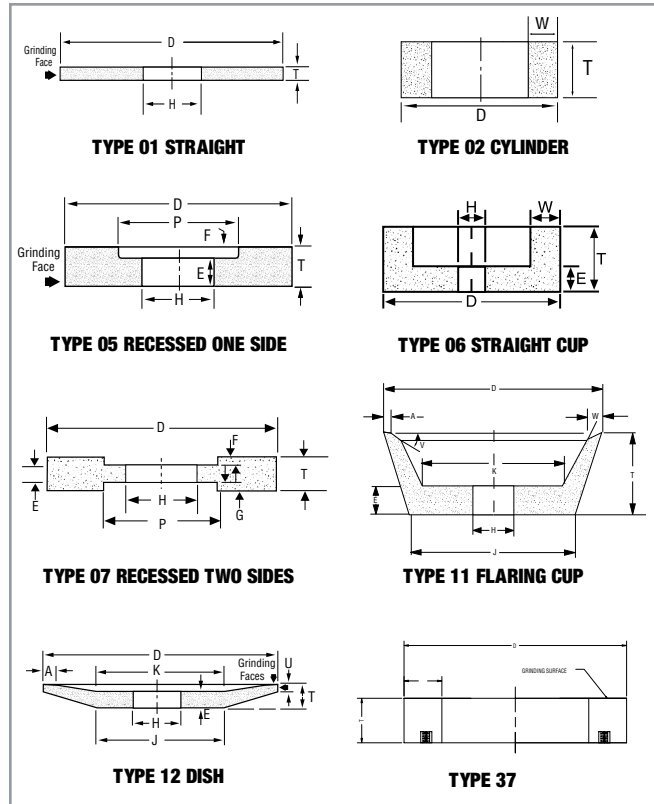


### Tool and Cutter Grinding

The grinding or resharpening of milling cutters, reamers, drills or end mills for the purpose of restoring keen cutting edges or exact cutting angles.



## Wheel Shapes



## Toolroom Basics Selection Guide

PRODUCTIVITY	DURABILITY	ABRASIVE	COLOR	GRIT	GRADE	NARROW CONTACT FORM HOLDING BOND	MEDIUM/WIDE CONTACT AREA POROUS BOND	DRESSING TOOL
Highest	More Durable	Medalist	Blue	46 (Coarse)	F (Soft)	VL	VLP	SG Tool
↕	↕	Medalist R	Purple	↕	↕	-	VPP	SG Tool
		32AR	Gray/Purple			V40	V40P	Conventional Tool
		AR	Ruby			V40	VPP	Conventional Tool
		PA	Pink			V40	VPP	Conventional Tool
Standard	More Friable	AA	White	220 (Fine)	Q (Hard)	V40	V40P, VPP	Conventional Tool

**Abrasive:** Select abrasive type based on required performance, stock removal rate, and material to be ground.

**Grit Size:** Select the grit size depending on finish required, stock removal rate needed, and corner/form holding requirements.

**Grade:** Select the grade based on contact area\*, and heat sensitivity/thickness of material to be ground.

**Bond:** Select the appropriate bond based on the abrasive selected and the contact area.\*

### Grit Selection

TEST GRIT	REQUIREMENTS	FINISH	MINIMUM CORNER RADIUS
6	General purpose	32 Ra and rougher	0.020"
60	Commercial finish	32 Ra and better	0.016"
80, 100	Fine finish	20 Ra and better	0.0105"
120	Very fine finish	10 Ra and better	0.006"
150	Corner/form holding		0.005"
180	Corner/form holding		0.0035"
220	Corner/form holding		0.002"

### Grade/Bond Selection

GENERAL CONDITIONS AND NEEDS	NORMAL GRADE RANGE	STARTING GRADE	BOND
Narrow* contact area or form holding	K - L	K	VL, V40
General surface grinding	H - K	J	VL, V40
Medium/Wide* contact area, cooler grind	F - H	H	VLP, VPP, V40P

### \*Definitions of Contact Area:

**Narrow:** The contact area of the grind is less than 25% of the wheel width, or less than 1/4" wide.

**Medium:** The contact area of the grind is 25% - 50% of the wheel width, or over 1/4" - 1/2" wide.

**Wide:** The contact area of the grind is greater than 50% of the wheel width, or over 1/2" wide.



## Toolroom Wheel Starting Recommendations

APPLICATION/MATERIAL	PERFORMANCE/PRODUCTIVITY								
	BEST	BETTER	GOOD	BEST	BETTER	GOOD	BEST	BETTER	GOOD
	NARROW CONTACT AREA			MEDIUM CONTACT AREA			WIDE CONTACT AREA		
<b>TOOL RESHARPENING</b>									
<b>HEAVY STOCK REMOVAL (&gt; .004)</b>									
- HSS & TOOL STEEL RC 50-68	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	32AR46-GV40P	AA46-HV40
<b>MODERATE STOCK REMOVAL (.002 - .004)</b>									
- HSS & TOOL STEEL RC 50-68	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32A60-HV40P	AA60-HV40
- CARBIDE	-	-	GC60-IVGC	-	-	GC60-IVGC	-	-	GC60-IVGC
<b>SURFACE GRINDING</b>									
<b>HEAVY STOCK REMOVAL (&gt; .004)</b>									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-IVL	32AR46-IV40	AA46-IV40	MEDALIST46-GVLP	32AR46-GV40P	PA46-GVPP
- SOFT STEELS RC 30-45 300 SERIES STAINLESS	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	AR46-HVPP	PA46-HVPP
- CAST IRON: DUCTILE & GRAY	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	32AR46-HV40P	AA466-HV40
- NON-FERROUS ALLOYS	-	-	GC60-IVGC	-	-	GC60-IVGC	-	-	GC60-IVGC
<b>MODERATE STOCK REMOVAL (.002 - .004)</b>									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-IVL	32AR60-IV40	AA60-IV40	MEDALIST60-GVLP	32AR46-GV40P	AA60-HV40
- SOFT STEELS RC 30-45 300 SERIES STAINLESS	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32AR46-HV40P	AA60-HV40
- CAST IRON: DUCTILE & GRAY	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32AR46-HV40P	AA60-IV40
- NON-FERROUS ALLOYS	-	-	GC60-IVGC	-	-	GC60-IVGC	-	-	GC60-IVGC
<b>LIGHT STOCK REMOVAL AND FINISHING (&lt;.001)</b>									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS	-	32AR80-JV40	AA80-JV40	-	32AR80-IV40	AA80-IV40	-	32AR60-HV40	AA80-HV40
- SOFT STEELS RC 30-45 300 SERIES STAINLESS	-	32AR80-KV40	AA80-KV40	-	32AR80-JV40	AA80-JV40	-	32AR80-IV40	AA80-IV40
- CAST IRON: DUCTILE & GRAY	-	32AR80-KV40	AA80-KV40	-	32AR80-JV40	AA80-JV40	-	32AR80-IV40	AA80-IV40
- NON-FERROUS ALLOYS	-	-	GC80-IVGC	-	-	GC80-IVGC	-	-	GC80-IVGC

## Toolroom Competitive Cross Reference

CARBORUNDUM	BAY STATE	CAMEL	CINCINNATI	COLONIAL	RADIAC
32AR	7A, 17A	AZ	4A, 12A, 29A, 32A	-	32A, WRA
AA	9A, 48A	83A, WA, AZ (BLUE)	9A, 10A, 11A, 82A	20A	WA, 9A
AR	-	-	-	25A	RA
C	C	-	6C	C	C
DA	2A, 3A, 6A, 8A	91A, DA	29A, 97A	10TA	43A, 45A, 97A, WPA
GA	TA	94A, CGW, A	A, AK	TA	A
GC	1C	-	5C	GC	GC
MEDALIST, MEDALIST R	3GA	AS3	3MSB	20A/VG3	7BP, 8BP
PA	-	PA	12A	24A	RAA

## Toolroom Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	CORRECTION
WHEEL CORNER BREAKDOWN	POOR WHEEL DRESSING WHEEL TOO COARSE WHEEL TOO SOFT WORN MACHINE BEARINGS WRONG WHEEL STRUCTURE	DRESS WHEEL FINER USE FINER GRIT USE HARDER GRADE CHECK FOR RUN-OUT AND CORRECT USE NON-POROUS WHEEL
BURNING OF WORKPIECE	WORN DRESSING TOOL POOR COOLANT FLOW WHEEL ACTING HARD WORK SPEED TOO SLOW INFEEED TOO FAST	ROTATE OR REPLACE DRESSING TOOL INCREASE/DIRECT COOLANT FLOW TO CONTACT AREA DRESS WHEEL COARSER, USE SOFTER GRADE WHEEL OR USE A POROUS WHEEL INCREASE WORK SPEED REDUCE STOCK REMOVED PER PASS OR UPGRADE TO MEDALIST OR 32AR
POOR SURFACE FINISH	POOR WHEEL DRESSING DIRTY COOLANT WHEEL TOO COARSE WHEEL TOO HARD	REDRESS MORE FREQUENTLY OR DECREASE DRESS TRAVERSE RATE FILTER COOLANT OR REPLACE WITH NEW USE FINER GRIT USE SOFTER GRADE WHEEL

# Toolroom Wheels

## Medalist Ceramic Alumina / Aluminum Oxide Abrasive Blend

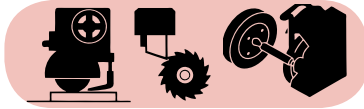
### Features

- High-performance ceramic alumina / aluminum oxide abrasive blend – blue color
- Self-sharpening abrasive
- High-performance vitrified bond
- VLP bond: induced porosity
- Best performance

### Benefits

- Fast stock removal on moderate to very heavy stock removal applications
- Cool cutting
- Less burn on part
- Dressing frequency reduced
- Enhanced wheel life
- Superior form and corner holding
- Load resistant
- Highest productivity, lowest total grinding cost

*The best choice for grinding all high speed tool steels. Medalist has the versatility to grind easy- to difficult-to-grind steels.*



*Use VL bond for general purpose applications or medium contact areas.*

*Use VLP and VPP bonds on wide contact areas where heat is an issue.*



## TechTip

*Key Operating Tips for Maximizing Grinding Performance with Medalist Wheels*

*Change one parameter at a time:*

- 1 Increase infeed 50%
- 2 Increase traverse rate 25%
- 3 Reduce dressing infeed 25%

## Gold 32AR Aluminum Oxide Abrasive

### Features

- High-performance aluminum oxide abrasive - gray/purple color
- Strong, sharp monocrystalline grain blend
- Tough, yet friable grain
- Strong vitrified bond
- V40P bond: induced porosity

### Benefits

- Exceptionally cool, fast cutting on medium to heavy stock removal operations
- Excellent resistance to point wear
- Good penetration on tough alloy steels
- Holds form well
- Requires less dressing
- Long wheel life
- Load resistance

*Ideal for moderate to heavy infeed rates, rapid stock removal and precision contouring – for all types of tool steels.*



*Use V40 bond for general purpose applications or medium contact areas.*

*Use V40P bond on wide contact areas where heat is an issue.*



## AR Aluminum Oxide Abrasive

### Features

- Durable aluminum oxide abrasive – ruby color
- Durable vitrified bond

### Benefits

- Extremely cool cutting
- Good form holding
- Maximum grain retention
- Less dressing; longer wheel life

Engineered for medium to heavy stock removal at moderate to heavy feed rates on a wide variety of tool steels.



Use V40 bond for general purpose applications or medium contact areas.

Use VPP bond on wide contact areas where heat is an issue.



## AA Aluminum Oxide Abrasive

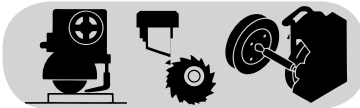
### Features

- Aluminum oxide abrasive – white color
- Excellent friability
- Durable, vitrified bond
- V40P bond: induced porosity

### Benefits

- Fast stock removal for light to medium stock removal operations
- Cool cutting action
- Long wheel life
- Load resistant

AA is ideal for grinding heat-sensitive steels, as well as easy- and medium-to-grind high-speed steels and cast, alloy steels.



Use V40 bond for general purpose applications or medium contact areas.

Use V40P and VPP bonds on wide contact areas where heat is an issue.



## PA Aluminum Oxide Abrasive

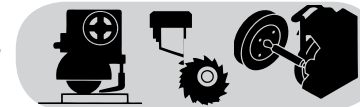
### Features

- Friable, aluminum oxide abrasive – pink color
- Durable vitrified bond

### Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal applications at light to moderate feed rates on tool steels (hardened, forged and stainless) and cast iron.



Use V40 bond for general purpose applications or medium contact areas.

Use VPP bond on wide contact areas where heat is an issue.



See Carbo Cool wheel listings for additional porous specifications on pages 143-145.



# Toolroom Wheels



		BEST – MEDALIST			BETTER – 32AR & AR		GOOD – AA & PA		
WHEEL SIZE	MAX. RPM	WHEELS/ BOX	PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING	
<b>Type 01 – For Internal Grinding</b>									
1/2 x 1/2 x 1/4	64,935	40					66253062129*	PA60-KV40	
3/4 x 1 x 1/4	43,240	40					66253062131*	PA60-KV40	
1 x 1/4 x 1/4	32,470	40					66253062132*	PA60-IV40	
1 x 3/4 x 1/4	32,470	40					66253062133*	PA60-IV40	
1 x 1 x 3/8	32,470	40					66253062138*	PA60-KV40	
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>									
6 x 1/4 x 1-1/4	4,140	10	05539562350	80-KVL	05539527691*	32AR60-KV40			
6 x 1/2 x 1-1/4	4,140	10			66253051313*	32AR46-JV40	05539509882*	AA60-JV40	
	4,140	10			05539527692	32AR60-JV40			
	4,140	10			05539562244*	32AR60-KV40			
	4,140	10			66253051315*	32AR80-KV40			
6 x 3/4 x 1-1/4	4,140	10			66253051675*	32AR46-JV40			
	4,140	10			66253051677*	32AR60-JV40			
6 x 1 x 1-1/4	4,140	10			66253051683*	32AR46-JV40			
	4,140	10			66253051684*	32AR60-JV40			
7 x 1/8 x 1-1/4	3,600	10					05539562175*	AA100-KV40	
7 x 1/4 x 1-1/4	3,600	10	05539562351 B	46-JVL	05539527686	32AR46-HV40	66253051696	AA46-IV40	
	3,600	10	05539527241	60-IVL	66253051861*	32AR46-IV40	05539509875*	AA60-JV40	
	3,600	10	05539527242 B	60-JVL	05539527688	32AR46-JV40	05539509874	AA60-KV40	
	3,600	10	05539527243	60-KVL	66253051862*	32AR60-HV40	66253051698	AA80-JV40	
	3,600	10	05539527244	80-JVL	05539527689	32AR60-IV40	05539509871*	AA80-KV40	
	3,600	10	05539527245	80-KVL	05539527311 B	32AR60-JV40	05539509870*	AA100-IV40	
	3,600	10	05539527247	100-KVL	05539527312	32AR60-KV40	05539509869*	AA100-JV40	
	3,600	10			05539527313*	32AR80-IV40	05539527714	AA100-KV40	
	3,600	10			05539527314	32AR80-JV40	05539562176*	AA120-JV40	
	3,600	10			05539527315 B	32AR80-KV40	05539509866	AA150-KV40	
	3,600	10			66253051867*	32AR100-IV40	05539562177*	AA150-LV40	
	3,600	10			05539562246 B	32AR100-JV40	66253051859*	AA220-KV40	
	3,600	10			05539562249	32AR120-KV40	05539569194*	PA46-JV40	
	3,600	10					05539569199*	PA60-JV40	
	3,600	10					05539569200*	PA120-HV40	
	3,600	10					05539569207*	PA120-JV40	
	7 x 3/8 x 1-1/4	3,600	10			66253051936*	32AR60-HV40		
		3,600	10			66253051937*	32AR60-JV40		
	7 x 1/2 x 1-1/4	3,600	5	05539527248	46-GVLP	05539527316*	32AR46-FV40P	05539509865	AA46-HV40
		3,600	5	05539564478	46-GVPP	05539527317	32AR46-GV40P	05539507039*	AA46-HV40P
3,600		5	66253051963*	46-HVL	05539527319	32AR46-HV40	05539509864	AA46-IV40	
3,600		5	05539527250	46-IVL	05539527318 B	32AR46-HV40P	05539509863	AA46-JV40	
3,600		5	05539527249 B	46-IVLP	05539527321	32AR46-IV40	05539509862*	AA46-KV40	
3,600		5	05539527251	46-JVL	05539527320	32AR46-IV40P	66253051967	AA60-HV40	
3,600		5	05539527252	46-KVL	05539527322	32AR46-JV40	05539564489	AA60-HVPP	
3,600		5	05539527253*	60-GVLP	05539527323	32AR46-KV40	05539509860	AA60-IV40	
3,600		5	66253051965*	60-HVL	05539527326	32AR60-HV40	05539509859	AA60-JV40	
3,600		5	05539527255 B	60-IVL	05539527325*	32AR60-HV40P	05539509858	AA60-KV40	
3,600		5	05539527254*	60-IVLP	05539527327	32AR60-IV40	66253051969	AA80-HV40	
3,600		5	05539527256	60-JVL	05539527328 B	32AR60-JV40	05539509857	AA80-IV40	
3,600		5	05539527257 B	60-KVL	05539527329	32AR60-KV40	05539509856*	AA80-JV40	
3,600		5	05539527259*	80-IVL	05539527330*	32AR80-IV40	05539509854	AA80-KV40	
3,600		5	05539527260	80-JVL	05539562257*	32AR80-JV40	05539509852	AA100-IV40	
3,600		5	05539527261 B	80-KVL	05539527331	32AR80-KV40	05539509850*	AA100-JV40	
3,600		5			05539562253*	32AR100-IV40	05539562180	AA120-KV40	
3,600		5			66253061619*	AR46-HV40	66253054721*	AA150-KV40	
3,600		5			66253061620*	AR46-IV40	66253061613*	PA46-HV40	
3,600		5			66253061621*	AR60-IV40	66253061614*	PA46-IV40	
3,600	5			66253061622*	AR60-JV40	05539566899	PA46-JV40		
3,600	5					05539569213*	PA46-KV40		
3,600	5					66253061615*	PA60-IV40		
3,600	5					05539569217*	PA60-JV40		
3,600	5					05539569218*	PA60-KV40		
3,600	5					05539569222*	PA80-KV40		





WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>								
7 x 3/4 x 1-1/4	3,600	5	05539527262 B	46-KVL	66253054729*	32AR46-HV40	05539562185*	AA46-KV40
	3,600	5	05539527263*	60-KVL	05539527334*	32AR46-IV40	05539509848	AA60-IV40
	3,600	5			05539527335*	32AR46-KV40	05539569233*	PA46-JV40
	3,600	5			05539527336*	32AR60-IV40	05539569234*	PA60-JV40
	3,600	5			05539527337 B	32AR60-KV40		
7 x 1 x 1-1/4	3,600	5	05539527264	46-JVL	05539509861*	32AR60-IV40		
	3,600	5	05539562356*	60-KVL	05539562261*	32AR60-KV40		
8 x 1/4 x 1-1/4	•	5			05539562263*	32AR46-HV40	05539562188*	AA60-IV40
	3,600	5			66253054775*	32AR46-KV40	05539509844 B	AA80-JV40
	3,600	5			66253054776*	32AR60-HV40	66253054773*	AA100-KV40
	3,600	5			66253054778*	32AR60-IV40	66253054774*	AA120-KV40
	3,600	5			05539562264	32AR60-JV40		
	3,600	5			05539527338	32AR60-KV40		
	3,600	5			66253054780*	32AR80-IV40		
	3,600	5			05539527339	32AR80-KV40		
8 x 1/2 x 1-1/4	3,105	5	05539527267	46-GVLP	05539527340 B	32AR46-GV40	05539509841	AA46-HV40
	3,105	5	05539527268 B	46-IVL	05539527342	32AR46-HV40	05539509840	AA46-IV40
	3,600	5	05539527269	46-JVL	05539527341†	32AR46-HV40P	05539509839	AA46-JV40
	•	5	05539527270	46-KVL	05539527343 B	32AR46-IV40	05539509838*	AA46-KV40
	3,600	5	05539527271	60-IVL	05539527344	32AR46-JV40	05539509836	AA60-IV40
	3,600	5	05539527272	60-JVL	05539527345	32AR46-KV40	05539562190	AA60-JV40
	3,600	5	05539527273	60-KVL	05539527347	32AR60-HV40	66253052850	AA60-KV40
	3,600	5	05539562363*	80-JVL	05539527348	32AR60-IV40	05539527716*	AA80-JV40
	3,600	5			05539527349 B	32AR60-JV40	05539509831*	AA80-KV40
	3,600	5			05539562271*	32AR80-IV40	66253052540*	AA100-JV40
	3,105	5			66253061627*	AR46-HV40	66253061623*	PA46-HV40
	3,105	5			66253061628*	AR46-IV40	66253061624*	PA46-IV40
	3,600	5			66253061629*	AR60-IV40	05539569237*	PA46-JV40
	3,600	5			66253061630*	AR60-JV40	05539564569	PA60-GVPP
	3,600	5					66253061625*	PA60-IV40
	3,600	5					66253061626*	PA60-JV40
8 x 3/4 x 1-1/4	•	5	05539527274	46-IVL	66253052537*	32AR46-HV40	05539509827	AA46-JV40
	3,600	5	05539527275	46-JVL	05539527351*†	32AR46-HV40P	66253052539*	AA80-JV40
	•	5	05539527276	46-KVL	05539527353	32AR46-IV40		
	3,600	5	05539527277	60-JVL	05539527354	32AR46-JV40		
	3,600	5			05539527355	32AR60-IV40		
	3,600	5			05539527356	32AR60-JV40		
8 x 1 x 1-1/4	3,105	5	05539562365*	46-IVL	05539527358*	32AR46-IV40	05539562193*	AA46-IV40
	3,600	5	05539562379*	60-KVL	05539562272	32AR60-IV40		
	3,600	5			05539562318*	32AR60-KV40		

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.  
 † See 8" Max. RPM Tech Tip below.  
 B = Best seller



## TechTip

- 8" Type 01 and Type 05 Vitrified Toolroom Wheels' Maximum Operating Speeds:
- 46 grit, J grade and harder = 3,600 RPMs
- 54 grit, I grade and harder = 3,600 RPMs
- 60 grit and finer, H grade and harder = 3,600 RPMs
- † exceptions to the rule: speed-tested to 3,600 RPMs
- all other specifications = 3,105 RPMs



It is the user's responsibility to refer to and comply with ANSI B7.1

Refer to page 159 for truing and dressing products.

See Carbo Cool Wheel listings on pages 143-145 for additional porous specifications.

# Toolroom Wheels



WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>								
10 x 1/2 x 3	2,485	5					66253052916*	AA46-HV40
	2,485	5					05539569344*	AA60-JV40
10 x 3/4 x 3	2,485	2			66253052918*	32AR46-HV40		
	2,485	2			05539562201	32AR46-IV40		
	2,485	2			05539562202*	32AR60-IV40		
	2,485	2			05539527696	32AR60-JV40		
10 x 1 x 2	2,485	2					66253053091*	AA46-HV40
	2,485	2					66253053090*	AA46-IV40
	2,485	2					66253053096*	AA60-KV40
	2,485	2					66253053097*	AA80-JV40
10 x 1 x 3	2,485	2	05539527278	46-GVLP	05539527697*	32AR46 GV40P	05539569070*	AA46-HV40
	2,485	2	05539527279	46-IVL	66253054449*	32AR46-HV40	66253054439*	AA46-KV40
	2,485	2	05539527280	46-JVL	05539569253*	32AR46-HV40P	05539509814	AA46-JV40
	2,485	2	05539527282	60-JVL	05539527359	32AR46-IV40	66253054445*	AA60-HV40
	2,485	2			05539567967*	32AR46-JV40	66253054446*	AA60-IV40
	2,485	2			05539527360	32AR60-IV40	66253054447*	AA60-JV40
	2,485	2			05539562204	32AR60-KV40	66253054448*	AA80-JV40
	2,485	2					05539569240*	PA46-IV40
	2,485	2					05539569242*	PA60-IV40
	12 x 3/4 x 1-1/4	2,070	1	05539562382	46-OVL			
12 x 3/4 x 3	2,070	2			05539562210*	32AR46-HV40P	66253054540*	AA46-HV40
	2,070	2			05539562211*	32AR46-IV40	66253054541*	AA46-IV40
	2,070	2			66253054542*	32AR46-JV40	05539569054*	AA60-IV40
	2,070	2			66253054544*	32AR60-JV40		
12 x 3/4 x 5	2,070	2				66253054552*	AA60-JV40	
12 x 1 x 3	2,070	2	05539562325*	46-HVLP	05539527361	32AR46-HV40	66253054555*	AA46-HV40
	2,070	2	05539527283	46-IVL	05539562216 B	32AR46-IV40	66253054556*	AA46-IV40
	2,070	2	05539527284	46-JVL	05539527362	32AR46-JV40	05539509810*	AA46-JV40
	2,070	2	05539562328*	60-GVLP	05539527363*	32AR60-IV40	66253054557*	AA46-KV40
	2,070	2	05539564511	60-GVPP	05539527364	32AR60-JV40	05539569246*	PA46-KV40
	2,070	2	05539527285*	60-IVL	66253054558*	32AR60-KV40	05539564571	PA60-GVPP
	2,070	2	05539527287*	60-JVL	66253053100*	32AR60-JV40	66253053092*	AA46-JV40
12 x 1 x 5	2,070	2	05539562332*	46-IVL	05539527365	32AR46-IV40	05539524572*	AA46-HV40
	2,070	2	05539527287	46-JVL	66253053098*	32AR60-IV40	05539501900	AA46-IV40
	2,070	2	05539527290	60-JVL	66253053100*	32AR60-JV40	66253053092*	AA46-JV40
	2,070	2			66253053101*	32AR60-KV40	66253053094*	AA46-KV40
	2,070	2					05539562163*	AA60-IV40
	2,070	2					05539509807	AA60-JV40
	2,070	2					69083164147*	AA80-JV40
12 x 1-1/4 x 3	2,070	2			60253053097*	AA80-JV40		
12 x 1-1/2 x 3	2,070	2			05539562221	32AR46-IV40		
12 x 1-1/2 x 5	2,070	2			05539562222*	32AR60-JV40		
	2,070	2	05539562337 B	60-GVLP	05539562223*	32AR46-GV40P		
	2,070	2			05539527368 B	32AR46-HV40		
	2,070	2			05539527369	32AR46-IV40		
	2,070	2			05539562224	32AR46-JV40		
	2,070	2			05539562226	32AR60-HV40		
12 x 2 x 1-1/4	2,070	2			05539562227*	32AR46-KV40		
12 x 2 x 5	2,070	2			05539562316	32AR46-IV40	05539562166*	AA46-HV40
	2,070	2			05539569544*	32AR46-JV40		
14 x 1 x 3	1,800	2	05539562339*	46-IVL	66253054713*	32AR46-HV40		
	1,800	2			66253054716*	32AR60-IV40		
14 x 1 x 5	1,800	2	05539527291*	46-GVLP	05539562230	32AR46-HV40	66253054785*	AA46-IV40
	1,800	2	05539562341*	46-HVLP	05539527370	32AR46-JV40	05539509806	AA46-JV40
	1,800	2	05539562342*	46-IVL	05539527371	32AR60-JV40	66253054786*	AA46-KV40
	1,800	2	05539527292	46-JVL	66253061056*	32AR60-KV40	66253054787*	AA60-IV40
	1,800	2	05539527293	60-JVL			05539562170*	AA80-KV40
	1,800	2	05539562345*	80-JVL			05539569202*	PA46-IV40
	1,800	2					05539569204*	PA60-JV40

See Carbo Cool Wheel listings on pages 143-145 for additional porous specifications. Refer to page 159 for truing and dressing products.





		BEST – MEDALIST			BETTER – 32AR		GOOD – AA & PA	
WHEEL SIZE	MAX. RPM	WHEELS/ BOX	PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>								
14 x 1-1/2 x 5	1,800	1	05539527294	46-GVLP	05539562234*	32AR46-GV40P	05539524608*	AA46-HV40
	1,800	1	05539527295 B	46-IVL	05539527372 B	32AR46-HV40	05539562172	AA46-IV40
	1,800	1	05539527296	46-JVL	05539527673	32AR46-IV40	05539509804 B	AA46-JV40
	1,800	1	05539562346 B	60-IVL	05539527700	32AR46-JV40	66253054791*	AA46-KV40
	1,800	1	05539527298	60-JVL	05539562236*	32AR46-KV40	66253054792*	AA60-HV40
	1,800	1	05539562347*	80-KVL	05539562237	32AR60-HV40	05539509803	AA60-JV40
	1,800	1			05539527674*	32AR60-IV40		
	1,800	1			05539527701*	32AR60-JV40		
14 x 2 x 5	1,800	1	05539562348	46-JVL	05539562240	32AR46-IV40	66253054797*	AA46-HV40
	1,800	1	05539562349	60-JVL	05539562241*	32AR46-KV40	66253054798*	AA46-JV40
	1,800	1			05539562242	32AR60-KV40	66253054799*	AA60-JV40
16 x 1-1/2 x 5	1,550	1					66253059029*	AA46-HV40
	1,550	1					66253059030*	AA46-JV40
	1,550	1					66253059031*	AA60-KV40
16 x 2 x 5	1,550	1					66253059032*	AA46-IV40
	1,550	1					66253059033*	AA46-JV40
	1,550	1					66253059038*	AA60-KV40
<b>Type 02 – For Surface and Tool &amp; Cutter Grinders</b>								
6 x 1 x 4	3,600	5			66253052535*	32AR46-KV40		
Rim 1, Fits Both: Four 9/32 Holes on 3-1/4" Bolt Circle & Four 7/16 Holes on 3-1/4" Bolt Circle								
9 x 2 x 5 Rim 2-1/32, Six 9/32 Holes on 4" Bolt Circle	2,546	2			05539562315	32AR70-JV40P	05539503517	AA70-JV40P
<b>Type 05 – For Internal Grinding</b>								
1/2 x 1/2 x 1/8 Recess 1/8 1/4 x 5/32	14,935	40					66253062125*	PA60-KV40
1 x 1 x 3/8 Recess 1/8 1/2 x 1/2	32,470	40					66253062136*	PA60-KV40
1-1/2 x 1 x 3/8 Recess 1/8 5/8 x 1/2	21,645	40					66253062140*	PA60-KV40
2 x 1 x 3/8 Recess 1/8 3/4 x 1/2	15,980	40					66253062141*	PA60-KV40
<b>Type 05 – For Surface Grinders</b>								
7 x 3/4 x 1-1/4 Recess 1/8 2-3/4 x 1/4	3,600	5			05539527702*	32AR46-IV40		
	3,600	5			05539568013*	32AR60-IV40		
	3,600	5			05539562312*	32AR60-KV40		
7 x 3/4 x 1-1/4 Recess 1/8 3 x 1/4	3,600	5					66253054745*	AA46-HV40
	3,600	5					66253054746	AA46-IV40
	3,600	5					66253054748	AA46-JV40
	3,600	5					66253054755*	AA60-HV40
	3,600	5					66253054756	AA60-JV40
7 x 1 x 1-1/4 Recess 1/8 2-3/4 x 1/2	3,600	5	05539527300	46-JVL	05539527703	32AR46-HV40		
	3,600	5	05539527301	60-JVL	05539527675	32AR46-IV40		
	3,600	5			05539527704	32AR60-IV40		
7 x 1 x 1-1/4 Recess 1/8 3 x 1/2	3,600	5	05539562369*	46-IVL	05539562284*	32AR46-HV40P	66253054764*	AA46-HV40
	3,600	5	05539562370	60-KVL	05539562285*	32AR46-KV40	05539509798	AA46-IV40
	3,600	5					66253054767	AA46-JV40
	3,600	5					66253054768	AA46-KV40
	3,600	5					05539564605	AA60-GVPP
	3,600	5					05539509796*	AA60-IV40
	3,600	5					66253054769	AA60-JV40
	3,600	5					05539505805*	AA60-KV40

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.  
B = Best seller



WHEEL SIZE	MAX. RPM	WHEELS/BOX	BEST – MEDALIST		BETTER – 32AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
<b>Type 05 – For Surface Grinders</b>								
7 x 1-1/4 x 1-1/4 Recess 1/8 2-3/4 x 5/8	3,600	5			05539562286	32AR60-IV40		
7 x 1-1/2 x 1-1/4 Recess 1/8 2-3/4 x 3/4	3,600	5			05539562287*	32AR46-IV40		
8 x 3/4 x 1-1/4 Recess 1/8 3 x 1/4	3,105	5					05539564321*	AA46-HV40
	3,105	5					66253052857*	AA46-HV40P
	3,105	5					05539569071*	AA46-IV40
	3,600	5					66253052856*	AA46-JV40
	3,600	5					66253052859*	AA60-IV40
	3,600	5					66253052858*	AA60-JV40
	3,600	5					66253052860*	AA60-KV40
8 x 1 x 1-1/4 Recess 1/8 3 x 1/2	3,105	5					66253052861*	AA46-HV40P
	3,600	5					66253052862*	AA60-HV40
	3,600	5					66253054864*	AA60-IV40
	3,600	5					66253052866	AA60-JV40
	3,600	5					66253052868*	AA60-KV40
8 x 1 x 1-1/4 Recess 1/8 3-1/4 x 1/2	3,600	5			05539527677	32AR46-IV40	05539564600	AA46-HVPP
	3,600	5			05539527678	32AR46-JV40	05539564563	PA46-HVPP
	3,600	5			05539527676*	32AR60-IV40	05539564577	PA60-HVPP
12 x 1-1/2 x 3 Recess 1/8 7-1/2 x 1/2	2,070	2					66253053107*	AA46-HV40
	2,070	2					66253053108*	AA46-IV40
	2,070	2					66253054575*	AA46-JV40
12 x 1-1/2 x 5 Recess 1/8 7-1/2 x 1/2	2,070	2	05539562366	46-GVLP	05539569121*	32AR46-HV40	66253054583*	AA46-KV40
	2,070	2			05539562277	32AR46-IV40	66253054578*	AA60-IV40
	2,070	2					66253054584*	AA60-JV40
14 x 1-1/2 x 5 Recess 1/8 8 x 1/2	1,800	1	05539562367	46-JVL	05539562279	32AR46-IV40	05539562195*	AA46-HV40
	1,800	1	05539562368*	60-JVL	05539562280*	32AR46-KV40	05539567482*	AA46-IV40
	1,800	1			05539562281	32AR60-IV40	66253054794*	AA46-JV40
	1,800	1			66253061063*	32AR60-JV40	66253054796*	AA60-HV40
	1,800	1			05539562282*	32AR60-KV40	05539569087*	AA60-IV40
14 x 2 x 5 Recess 1/8 8 x 1	1,800	1			05539568664*	32AR46-KV40	66253054800*	AA46-HV40
	1,800	1			05539562283	32AR60-KV40	66253054801*	AA46-IV40
	1,800	1					66253054802*	AA46-JV40
	1,800	1					66253054803*	AA46-KV40
	1,800	1					66253054804*	AA60-IV40
	1,800	1					66253054805*	AA60-JV40
<b>Type 06 – For Tool &amp; Cutter Grinders</b>								
4 x 2 x .787 (20mm) Rim 3/8, Back 3/8	5,730	5					05539509793	AA80-JV40
5 x 1-1/2 x 1-1/4 Rim 3/8, Back 3/8	4,585	5			05539562288	32AR46-KV40		
	4,585	5			05539527705	32AR60-KV40		
6 x 1-1/2 x 1-1/4 Rim 3/8, Back 3/8	3,820	5			66253052239*	32AR46-JV40		
	3,820	5			66253052240*	32AR60-JV40		
6 x 1-1/2 x 1-1/4 Rim 1-1/2, Back 1/2	3,820	5					05539509792*	AA60-JV40
<b>Type 07 – For Surface Grinders</b>								
12 x 2 x 3 Recess 2/8 6-1/2 x 1/2	2,070	1					66253054700*	AA46-IV40
	2,070	1					66253054703*	AA60-JV40
12 x 2 x 3 Recess 2/8 7-1/4 x 1/2	2,070	1			05539562291*	32AR46-JV40		
12 x 2 x 5 Recess 2/8 7-1/2 x 1/2	2,070	1	05539564513	60-GVPP	05539562292	32AR46-HV40	66253054706*	AA46-IV40
	2,070	1			05539562294	32AR46-KV40	66253054708*	AA46-JV40
	2,070	1					66253054709*	AA60-HV40
	2,070	1					66253054711*	AA60-JV40
	2,070	1					66253054712*	AA60-KV40

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.





WHEEL SIZE	MAX. RPM	WHEELS/BOX	BEST – MEDALIST		BETTER – 32AR		GOOD – AA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
<b>Type 07 – For Surface Grinders</b>								
14 x 2 x 5	1,800	1					66253054806*	AA46-IV40
Recess 2/S 8 x 3/8	1,800	1					66253054808*	AA46-JV40
	1,800	1					66253054809*	AA46-KV40
<b>Type 11 – For Tool &amp; Cutter Grinders</b>								
3-1/2 /2-3/4 x	7,640	5			66253051978*	32AR46-JV40		
1-1/2 x 1-1/4	7,640	5			66253051992*	32AR46-KV40		
Rim 3/4, Back 3/8	7,640	5			66253051993*	32AR60-JV40		
	7,640	5			66253041994*	32AR60-KV40		
4 / 3 x 1-1/2 x 1-1/4	5,730	5	05539562371*	46-IVLP	05539527679	32AR46-KV40	05539509790*	AA46-KV40
Rim 1/4, Back 1/2	5,730	5	05539527302*	46-JVL	05539527680	32AR60-JV40	05539509788*	AA60-KV40
	5,730	5	05539569173*	60-HVLP	05539527681	32AR60-KV40		
	5,730	5	05539527303	60-JVL	66253051997*	32AR80-JV40		
	5,730	5	05539562373*	80-KVL	05539569167*	32AR120-KV40		
5 / 3-3/4 x 1-3/4 x 1-1/4	4,585	5	05539527305	46-JVL	05539527682	32AR46-JV40	05539567353*	AA46-HV40
Rim 1/4, Back 1/2	4,585	5	05539569177*	60-IVL	05539527684	32AR46-KV40	05539569412*	AA46-JV40
	4,585	5	05539527306	60-KVL	05539527685	32AR60-JV40	05539569097*	AA46-KV40
	4,585	5			05539527683	32AR60-KV40	05539509783	AA60-JV40
	4,585	5					05539509782	AA60-KV40
6 / 4-1/2 x 2 x 1-1/4	3,820	5			05539562301	32AR46-IV40	05539509781	AA46-KV40
Rim 3/8, Back 1/2	3,820	5			66253052001*	32AR46-JV40		
<b>Type 12 – For Tool &amp; Cutter Grinders</b>								
4 x 1/2 x 3/4	6,210	5			66253051996*	32AR80-JV40		
U = 3/8, E = 5/16								
6 x 1/2 x 1-1/4	4,140	5	05539527308	46-JVL	05539527707	32AR60-JV40	05539509777	AA60-JV40
U = 3/8, E = 5/16 J = 3, K = 3			05539527309*	60-LVL	05539562306*	32AR60-KV40		
6 x 3/4 x 1-1/4	4,140	5	05539527310*	60-KVL	66253051999*	32AR46-JV40	66253051998*	AA60-KV40
U = 3/8, E = 3/8, J = 3, K = 3					66253052000*	32AR60-JV40		
7 x 1/2 x 1-1/4	3,600	5			05539562275*	32AR60-KV40		
U = 7/16, E = 11/32, J = 2-3/4, K = 3-1/4								
7 x 3/4 x 1-1/4	3,600	5			05539562313 *	32AR60-KV40		
U = 1/2, E = 1/2, J = 2-3/4, K = 3-1/4								
8 x 1-9/16 x 1-1/4	3,105	4	05539562380	46-JVL				
U = 7/16, E = 25/32, J = 3, K = 3								
10 x 1 x 1-1/4	2,485	2			05539562303	32AR54-JV40		
U = 2, E = 11/16, J = 6-1/4, K = 3-5/8								
<i>Refer to diagram on page 133 for dimension key.</i>								
<b>Type 37 – For Surface Grinders</b>								
10 x 3-1/2 x 8	2,105	1	05539562383	54-IVL				
Rim 1, Eight 1/4-20 Bolts on 9" Bolt Circle								

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

See Carbo Cool Wheel listings on pages 143-145 for additional porous specifications. Refer to page 159 for truing and dressing products.

## Skate Sharpening Wheels - Gold 32AR Aluminum Oxide Abrasive

### Features

- Premium aluminum oxide abrasive – gray/purple color
- Strong vitrified bond
- Plastic bushing

### Benefits

- Fast, cool cutting action
- No burn
- Consistent form holding
- Long life
- Provides a tighter fit – reducing vibrations and arbor-wear on the skate grinder

Sharpening all types of skate blades.



Refer to page 159 for truing and dressing products.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 - For Skate Sharpening Machines</b>				
05539528044*	8 x 5/16 x 1-1/4	32AR80-KV40	3,600	5
<b>Type 01 Cross Grind - For Skate Sharpening Machines</b>				
05539509972	6 x 1 x 1	60 - Medium	4,140	5

## Saw Gumming Wheels - Premier Red Zirconia Alumina Abrasive - Resin Bond

### Features

- Durable 2ZA zirconia alumina abrasive

### Benefits

- Designed specifically for large, timber-harvesting, circular and band saw steel blades

Saw gumming wheels are used primarily to shape and resharpen various timber and woodworking saws.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 - For Saw Gumming</b>				
66253062023*	10 x 5/8 x 1-1/4	2ZA36-NB67	3,630	5
66253062026*	12 x 5/8 x 1-1/4	2ZA36-NB67	3,025	5
66253062029*	12 x 3/4 x 1-1/4	2ZA36-NB67	3,025	5
66253062030*	12 x 7/8 x 1-1/4	2ZA36-NB67	3,025	5
66253062031*	12 x 1 x 1-1/4	2ZA36-NB67	3,025	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Saw Gumming Wheels - Gold 32AR Aluminum Oxide Abrasive - Vitrified Bond

### Features

- High-performance aluminum oxide abrasive and strong vitrified bond

### Benefits

- Long wheel life on medium to heavy stock removal operations on lower-speed machines

Saw gumming wheels are used primarily to shape and resharpen various timber and woodworking saws.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 - For Saw Gumming</b>				
66253061632*	8 x 3/16 x 1-1/4	32AR46-MV40	4,535	5
66253062014*	10 x 3/8 x 1-1/4	32AR46-MV40	3,630	5
66253062013*	10 x 1/2 x 1-1/4	32AR46-MV40	3,630	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

Refer to page 159 for truing and dressing products.

## Carbo Cool Medalist R Ceramic Alumina Abrasive

### Features

- Ceramic Medalist R abrasive with VPP porous bond – purple color
- Controlled porosity bond
- Durable bond post
- Maximum depth of cut

### Benefits

- Maximum productivity; lowest total grinding costs
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life
- Consistent grinding action at high metal removal rates

High porosity for heavy stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Heavy Stock Removal</b>				
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>				
05539564481*	7 x 1/2 x 1-1/4	46-HVPP	3,600	5
05539564497*	8 x 1/2 x 1-1/4	46-GVPP	3,600	5
05539564503		46-HVPP	3,600	5
05539564505*	12 x 1 x 3	46-HVPP	2,710	2

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Heavy Stock Removal</b>				
<b>Type 05 – For Surface Grinders</b>				
05539564493*	7 x 1 x 1-1/4	46-GVPP	3,600	5
05539564494	Recess 1/S 2-3/4 x 1/2	46-HVPP	3,600	5
05539564495*		60-GVPP	3,600	5
05539564504*	8 x 1 x 1-1/4	46-HVPP	3,600	5
05539564510	Recess 1/S 3-1/4 x 1/2	60-GVPP	3,600	5
05539564516*		60-HVPP	3,600	5
05539564500*	12 x 1-1/2 x 5	46-GVPP	2,710	2
05539564506	Recess 1/S 7-1/2 x 1/2	46-HVPP	2,710	2
05539564518*		60-HVPP	2,710	2
05539564508	14 x 1-1/2 x 5	46-HVPP	2,320	1
05539564520	Recess 1/S 8 x 1/2	60-HVPP	2,320	1

## Carbo Cool AR Aluminum Oxide Abrasive

### Features

- Durable aluminum oxide abrasive with VPP porous bond – ruby color
- Controlled porosity bond
- Durable bond post

### Benefits

- Extremely cool cutting
- Good form holding
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Engineered for medium to heavy stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Medium/Heavy Stock Removal</b>				
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>				
66253051674*	6 x 1/2 x 1-1/4	AR60-HVPP	4,140	5
66253051678*	6 x 3/4 x 1-1/4	AR46-HVPP	4,140	5
66253051679*		AR60-GVPP	4,140	5
66253051680*		AR60-HVPP	4,140	5
05539564480*	7 x 1/2 x 1-1/4	AR46-GVPP	3,600	5
05539564484		AR46-HVPP	3,600	5
66253054724*		AR46-IVPP	3,600	5
05539564486*		AR60-HVPP	3,600	5
66253054725*		AR60-IVPP	3,600	5
66253054728*		AR80-HVPP	3,600	5
66253054734*	7 x 3/4 x 1-1/4	AR46-GVPP	3,600	5
66253054741*		AR60-GVPP	3,600	5

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Medium/Heavy Stock Removal (cont'd)</b>				
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>				
66253052852*	8 x 1/2 x 1-1/4	AR46-GVPP	3,600	5
05539564530		AR46-HVPP	3,600	5
66253052855*		AR60-GVPP	3,600	5
66253053087*	10 x 3/4 x 3	AR46-GVPP	3,250	5
66253054530*	10 x 1 x 3	AR46-GVPP	3,250	5
66253054561*	12 x 1 x 3	AR46-HVPP	2,710	2
66253053102*	12 x 1 x 5	AR46-GVPP	2,710	2
66253053106*		AR46-HVPP	2,710	2
66253061069*	14 x 1 x 5	AR46-GVPP	2,320	2
66253061070*		AR46-HVPP	2,320	2
66253061074*	14 x 1-1/2 x 5	AR46-GVPP	2,320	2

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

# Carbo Cool Toolroom Wheels

## Carbo Cool AR Aluminum Oxide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Medium/Heavy Stock Removal (cont'd)</b>				
<b>Type 05 – For Surface Grinders</b>				
66253054759*	7 x 3/4 x 1-1/4	AR46-GVPP	3,600	5
66253054760*	Recess 1/S 3 x 1/4	AR46-HVPP	3,600	5
66253054761*		AR60-GVPP	3,600	5
05539564529*	7 x 1 x 1-1/4	AR46-HVPP	3,600	5
05539564545*	Recess 1/S 2-3/4 x 1/2	AR60-HVPP	3,600	5
66253054771*	7 x 1 x 1-1/4	AR46-GVPP	3,600	5
66253054772*	Recess 1/S 3 x 1/2	AR60-GVPP	3,600	5
05539564531*	8 x 1 x 1-1/4	AR46-HVPP	3,600	5
05539564538*	Recess 1/S 3-1/4 x 1/2	AR60-GVPP	3,600	5
05539564547*		AR60-HVPP	3,600	5
05539564535*	14 x 1-1/2 x 5	AR46-HVPP	2,320	1
05539564544	Recess 1/S 8 x 1/2	AR60-GVPP	2,320	1
05539564526	12 x 1-1/2 x 5	AR46-GVPP	2,710	1
	Recess 1/S 7-1/2 x 1/2			

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Medium/Heavy Stock Removal (cont'd)</b>				
<b>Type 07 – For Surface Grinders</b>				
05539564527	12 x 2 x 5	AR46-GVPP	2,710	1
05539564534*	Recess 2/S 7-1/2 x 1/2	AR46-HVPP	2,710	1
* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.				

Refer to page 159 for truing and dressing products.

## Carbo Cool PA Aluminum Oxide Abrasive

### Features

- Friable, aluminum oxide abrasive with VPP porous bond – pink color
- Controlled porosity bond
- Durable bond post

### Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Increased chip clearance and maximum coolant flow
- Reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Light/Medium Stock Removal</b>				
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>				
66253051941*	7 x 3/8 x 1-1/4	PA60-IVPP	3,600	5
05539564477	7 x 1/2 x 1-1/4	PA46-GVPP	3,600	5
05539564490		PA46-HVPP	3,600	5
05539564491*		PA60-GVPP	3,600	5
05539564492*		PA60-HVPP	3,600	5
05539564554*	8 x 1/2 x 1-1/4	PA46-GVPP	3,600	5
05539564562*		PA46-HVPP	3,600	5
05539564576*		PA60-HVPP	3,600	5
66253053088*	10 x 3/4 x 3	PA46-HVPP	3,250	5
66253054537*	10 x 1 x 3	PA46-IVPP	3,250	5
66253054538*		PA60-IVPP	3,250	5
66253054545*	12 x 3/4 x 3	PA46-HVPP	2,710	2
66253054551*		PA46-IVPP	2,710	2
66253054567*	12 x 1 x 3	PA46-IVPP	2,710	2
66253053104*	12 x 1 x 5	PA46-IVPP	2,710	2
66253054717*	14 x 1 x 3	PA46-IVPP	2,320	2
66253061075*	14 x 1-1/2 x 5	PA46-IVPP	2,320	2



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>High Porosity – For Light/Medium Stock Removal (cont'd)</b>				
<b>Type 05 – For Surface Grinders</b>				
05539564565*	12 x 1-1/2 x 5	PA46-HVPP	2,710	2
05539564572*	Recess 1/S 7-1/2 x 1/2	PA60-GVPP	2,710	2
05539564579		PA60-HVPP	2,710	2
05539564560*	14 x 1-1/2 x 5	PA46-GVPP	2,320	1
05539564567*	Recess 1/S 8 x 1/2	PA46-HVPP	2,320	1
05539564574*		PA60-GVPP	2,320	1
05539564581*		PA60-HVPP	2,320	1
<b>Type 07 – For Surface Grinders</b>				
05539564566*	12 x 2 x 5	PA46-HVPP	2,710	1
	Recess 2/S 7-1/2 x 1/2			
* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.				



## Carbo Cool AA Aluminum Oxide Abrasive

### Features

- Most friable aluminum oxide abrasive with VPP porous bond – white color
- Versatile
- Controlled porosity bond
- Durable bond post

### Benefits

- Exceptionally cool cutting in light pressure grinding applications, or where burn is a concern
- Ideal for use across a broad variety of tool steels
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excellent for light stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>High Porosity – For Light Stock Removal</b>				
<b>Type 01 – For Surface, Cylindrical and Tool &amp; Cutter Grinders</b>				
05539564479	7 x 1/2 x 1-1/4	AA46-GVPP	3,600	5
05539564487*		AA46-HVPP	3,600	5
05539564488*		AA60-GVPP	3,600	5
05539564592*	8 x 1/2 x 1-1/4	AA46-GVPP	3,600	5
05539564599*		AA46-HVPP	3,600	5
05539564606*		AA60-GVPP	3,600	5
05539564601*	12 x 1 x 3	AA46-HVPP	2,710	2

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>High Porosity – For Light Stock Removal</b>				
<b>Type 05 – For Surface Grinders</b>				
05539564602*	12 x 1-1/2 x 5	AA46-HVPP	2,710	2
05539564609*	Recess 1/S 7-1/2 x 1/2	AA60-GVPP	2,710	2
05539564616		AA60-HVPP	2,710	2
<b>Type 07 – For Surface Grinders</b>				
05539564603*	12 x 2 x 5	AA46-HVPP	2,710	1
	Recess 2/S 7-1/2 x 1/2			

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity.

## GC Silicon Carbide Abrasive

### Features

- High performance, sharp, silicon carbide abrasive – green
- Performance vitrified bond

### Benefits

- Fast stock removal
- Cool, free cut
- Long life

GC abrasive is used for grinding hard, cemented carbide tooling and non-ferrous materials.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Carbide</b>				
<b>Type 01 – For Surface and Tool &amp; Cutter Grinders</b>				
05539509586*	6 x 1/2 x 1-1/4	GC60-IVGC	4,140	5
05539509585 B		GC80-IVGC	4,140	5
05539509582		GC120-IVGC	4,140	5
05539509581	6 x 3/4 x 1-1/4	GC60-IVGC	4,140	5
05539509580		GC80-IVGC	4,140	5
05539509578		GC120-IVGC	4,140	5
66253060303*	7 x 1/4 x 1-1/4	GC60-IVGC	3,600	5
66253060304*		GC80-IVGC	3,600	5
66253060305*		GC100-IVGC	3,600	5
05539569208*		GC120-HVGC	3,600	5
05539509576	7 x 1/2 x 1-1/4	GC60-IVGC	3,600	5
05539509575		GC80-IVGC	3,600	5
05539562390*		GC80-JVGC	3,600	5
05539509574*		GC100-IVGC	3,600	5
05539509573		GC120-IVGC	3,600	5

\* Non-stock. Ask your sales representative for lead-times. Minimum quantity = box quantity. continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>For Carbide</b>				
<b>Type 01 – For Surface and Tool &amp; Cutter Grinders (cont'd)</b>				
05539562392*	7 x 3/4 x 1-1/4	GC80-JVGC	3,600	5
66253060314*	8 x 1/4 x 1-1/4	GC80-IVGC	3,600	5
05539509572	8 x 1/2 x 1-1/4	GC60-IVGC	3,600	5
66253060315*		GC80-IVGC	3,600	5
05539562395 B		GC100-IVGC	3,600	5

B = Best seller continued

# Toolroom Wheels

## GC Silicon Carbide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Carbide</b>				
<b>Type 01 - For Surface and Tool &amp; Cutter Grinders (continued)</b>				
05539509570	8 x 3/4 x 1-1/4	GC60-IVGC	3,600	5
05539562397	8 x 1 x 1-1/4	GC60-JVGC	3,600	5
05539562398		GC80-IVGC	3,600	5
66253061066*	10 x 1 x 3	GC60-JVGC	2,485	2
05539562386	14 x 1 x 5	GC60-IVGC	1,800	2
05539562388	14 x 2 x 5	GC60-JVGC	1,800	1
<b>Type 02 - For Surface and Tool &amp; Cutter Grinders</b>				
05539509566	6 x 1 x 4	GC60-IVGC	3,600	2
05539509565*	Rim 1, Fits Both:	GC100-IVGC		2
05539509564	Four 9/32 Holes on 3-1/4" Bolt Circle Four 7/16 Holes on 3-1/4" Bolt Circle	GC120-IVGC		2
66253059203*	14 x 4 x 1-1/4 Rim 1-1/2", Plate Mounted, Tape Wound	GC60-IVGC	1,640	1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Carbide</b>				
<b>Type 05 - For Surface Grinding</b>				
66253060309*	7 x 3/4 x 1-1/4	GC60-IVGC	3,600	5
66253060310*	Recess 1/S 3 x 1/4	GC80-IVGC	3,600	5
66253060311*		GC100-IVGC	3,600	5
66253060312*	7 x 1 x 1-1/4	GC60-IVGC	3,600	5
05539569224*	Recess 1/S 3 x 1/2	GC80-IVGC	3,600	5
66253060316*	8 x 1 x 1-1/4 Recess 1/S 3 x 1/2	GC60-IVGC	3,600	5

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## Bench and Pedestal Wheels

### Aluminum Oxide Abrasive

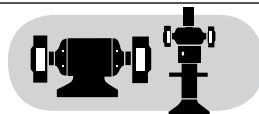
#### Features

- Aluminum oxide abrasive  
– brown color
- Vitrified bond

#### Benefits

- Fast cut rate
- Free cutting action; long life

Ideal for removing burrs on steel parts, as well as sharpening high-speed steel cutting tools. Note: Bushings included.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Steel/Metal</b>				
<b>Type 01 - For Bench and Pedestal Grinders</b>				
66253059518*	6 x 1/2 x 1	46-M	4,140	5
05539509978		60-M	4,140	5
66253059519*		80-M	4,140	5
05539509976*	6 x 3/4 x 1	36-M	4,140	5
66253059522*		46-M	4,140	5
05539509975		60-M	4,140	5
05539509974		100-K	4,140	5
05539509973	6 x 1 x 1	36-M	4,140	5
66253059524*		46-M	4,140	5
05539509972		60-M	4,140	5
05539509971		100-K	4,140	5
66253059529*	7 x 3/4 x 1	36-M	3,600	5
66253059533*		46-M	3,600	5
66253059534*		60-M	3,600	5
05539509966	7 x 1 x 1	36-M	3,600	5
66253059536*		46-M	3,600	5
05539509965		60-M	3,600	5
05539509964		100-K	3,600	5

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Steel/Metal</b>				
<b>Type 01 - For Bench and Pedestal Grinders (continued)</b>				
05539509962	8 x 3/4 x 1	36-M	3,600	5
66253060232*		46-M	3,600	5
05539509961		60-M	3,600	5
05539509960	8 x 1 x 1	24-P	3,600	5
05539509959		36-M	3,600	5
66253060235*		46-M	3,600	5
05539509956		60-M	3,600	5
66253060236		80-M	3,600	5
05539509955	10 x 1 x 1-1/4	24-P	2,485	2
05539509953		36-M	3,250	2
05539509952		60-M	3,250	2

continued

## Aluminum Oxide Abrasive

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Steel/Metal</b>				
<b>Type 01 - For Bench and Pedestal Grinders (continued)</b>				
05539509950	10 x 1-1/4 x 1-1/4	36-M	3,250	2
05539509948	10 x 1-1/2 x 1-1/4	24-P	2,485	2
05539509947		36-M	3,250	2
66253060241*		46-M	3,250	2
66253060246*		60-M	3,250	2
66253060273*	12 x 1 x 1-1/4	24-P	2,070	1
66253060276*		46-M	2,705	1
05539509941	12 x 1-1/2 x 1-1/2	36-M	2,705	1
66253060250*		60-M	2,705	1
05539509939	12 x 2 x 1-1/2	24-P	2,070	1
05539509938		36-M	2,705	1
66253060252*		46-M	2,705	1
05539509937		60-M	2,705	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Steel/Metal</b>				
<b>Type 01 - For Bench and Pedestal Grinders (continued)</b>				
05539509935	14 x 2 x 1-1/2	24-P	1,800	1
05539509934		36-M	1,800	1
66253060264*		60-M	1,800	1
66253060267*	14 x 3 x 1-1/2	36-O	1,800	1
66253060268*		46-M	1,800	1
66253060270*	16 x 2 x 1-1/2	36-O	1,800	1
66253060271*	18 x 3 x 1-1/2	24-O	1,800	1
66253060269*		36-O	1,800	1

\* Non-stock. Ask your sales representative for lead-times.

Minimum quantity = box quantity.

## Silicon Carbide Abrasive

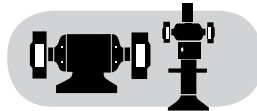
### Features

- Sharp, silicon carbide abrasive – dark green color
- Vitrified bond

### Benefits

- Fast cut rate
- Free cutting action; long life

Ideal for sharpening carbide-tipped cutting tools. Note: Bushings included.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Carbide/Non-Ferrous Metals</b>				
<b>Type 01 - For Bench and Pedestal Grinders</b>				
05539509929	6 x 3/4 x 1	60-I	4,140	5
05539509928		80-I	4,140	5
05539509927		120-I	4,140	5
05539509926	6 x 1 x 1	60-I	4,140	5
05539509925		80-I	4,140	5
05539509924		120-I	4,140	5
66253060286*	7 x 3/4 x 1	60-I	3,600	5
66253060287*		120-I	3,600	5

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>For Carbide/Non-Ferrous Metals</b>				
<b>Type 01 - For Bench and Pedestal Grinders (continued)</b>				
66253060288*	7 x 1 x 1	60-I	3,600	5
05539509922		80-I	3,600	5
05539509920		120-I	3,600	5
05539509916	8 x 1 x 1	60-I	3,600	5
05539509915		80-I	3,600	5
05539509914		120-I	3,600	5
05539509913	10 x 1 x 1-1/4	60-I	3,250	2
05539509912		80-I	3,250	2
05539509911		120-I	3,250	2
66253062192*	12 x 1 x 1-1/4	60-I	2,705	1
66253062195*		80-I	2,705	1
66253060289*	12 x 2 x 1-1/2	60-I	2,705	1
66253060290*		80-I	2,705	1
66253060291*		120-I	2,705	1

\* Non-stock. Ask your sales representative for lead-times.

Minimum quantity = box quantity.

## Reducing Bushings



Reducing bushings can be safely used to reduce the center hole in a grinding wheel. They are designed to fit freely on the spindle and maintain proper clearance. It is important that the bushing diameter does not come in contact with the flange bearing area and does not exceed the width of the wheel.

Reducing bushings are included with Bench and Pedestal Wheels as follows:

WHEEL DIAMETER	BUSHING
6", 7"	7/8, 3/4, 5/8, 1/2
8"	7/8, 3/4, 5/8
10"	1, 7/8, 3/4
12"	1-1/4, 1
14"	1-1/4, 1
16"	1-1/4
18"	1-1/4

# Cylindrical Wheels

## GA Aluminum Oxide Abrasive

### Features

- Strong, blocky-shaped aluminum oxide abrasive – brown color
- Strong vitrified bond system

### Benefits

- Well suited for general purpose applications
- High “G” ratios (metal removed/wheel wear)
- Longer wheel life
- Excellent form holding

*Ideal for general machine shop grinding of various steels and steel alloys.*

*Cylindrical grinding of cylindrical components between centers.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
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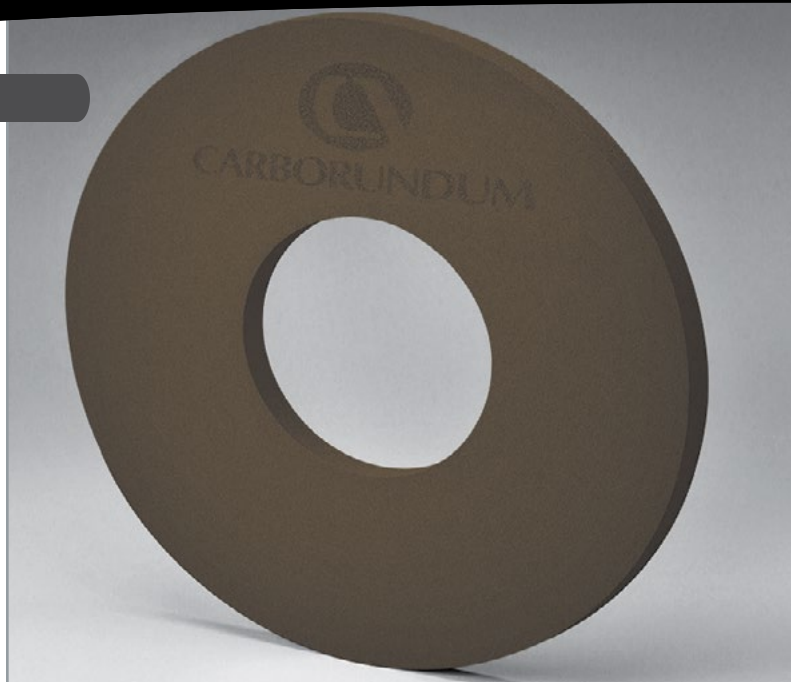
### Type 01 – For Cylindrical Grinders

66253059251*	14 x 1 x 5	GA54-KV40	1,800	1
66253059252*		GA60-LV40	1,800	1
66253059253*		GA80-MV40	1,800	1

### Type 05 – For Cylindrical Grinders

66253059254*	14 x 1-1/2 x 5	GA54-KV40	1,800	1
66253059256*	Recess 1/S 8 x 1/2	GA60-LV40	1,800	1
66253059257*		GA80-MV40	1,800	1
66253059258*	14 x 2 x 5	GA54-KV40	1,800	1
66253059259*	Recess 1/S 8 x 1	GA60-LV40	1,800	1
66253059261*		GA80-MV40	1,800	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.



## GRA Aluminum Oxide Abrasive

### Features

- Blended aluminum oxide GRA abrasive - brown color
- Premium performance vitrified bond

### Benefits

- Cool cutting action
- Fast stock removal
- Long wheel life and excellent form holding

*For general machine shop grinding of various steels and steel alloys.*

*Cylindrical grinding of cylindrical components between centers.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
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### Type 01 – For Cylindrical Grinders

66253059262*	16 x 1 x 5	GRA60-LV14	2,030	1
66253059263*		GRA80-MV14	2,030	1
66253059264*	16 x 1 x 8	GRA54-KV14	2,030	1
66253059265*		GRA60-LV14	2,030	1
66253059266*		GRA80-MV14	2,030	1
66253059267*	16 x 1-1/2 x 5	GRA60-LV14	2,030	1
66253059268*		GRA80-MV14	2,030	1
66253059272*	16 x 1-1/2 x 8	GRA54-KV14	2,030	1
66253059273*		GRA60-LV14	2,030	1
66253059274*		GRA80-MV14	2,030	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
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### Type 01 – For Cylindrical Grinders

66253059277*	16 x 2 x 5	GRA80-LV14	2,030	1
66253059278*	16 x 2 x 8	GRA54-KV14	2,030	1
66253059279*		GRA60-LV14	2,030	1
66253059280*		GRA80-LV14	2,030	1
66253059286*	20 x 1 x 12	GRA60-KV14	1,625	1
66253059287*		GRA60-LV14	1,625	1
66253059288*		GRA60-MV14	1,625	1
66253059291*	20 x 2 x 12	GRA60-KV14	1,625	1
66253059290*		GRA60-LV14	1,625	1
66253059293*	20 x 3 x 12	GRA60-KV14	1,625	1
66253059476*	24 x 1-1/2 x 12	GRA60-KV14	1,350	1
66253059478*	24 x 2 x 12	GRA60-KV14	1,350	1
66253059480*		GRA60-LV14	1,350	1
66253059488*	24 x 3 x 12	GRA60-KV14	1,350	1
66253059509*	30 x 2 x 12	GRA54-JV14	1,355	1
66253059510*		GRA60-KV14	1,080	1
66253059511*	30 x 3 x 12	GRA54-JV14	1,080	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.





## DAC Aluminum Oxide/Silicon Carbide Abrasive Blend

### Features

- Blended aluminum oxide/silicon carbide abrasives for versatility – gray color
- Resinoid bond system

### Benefits

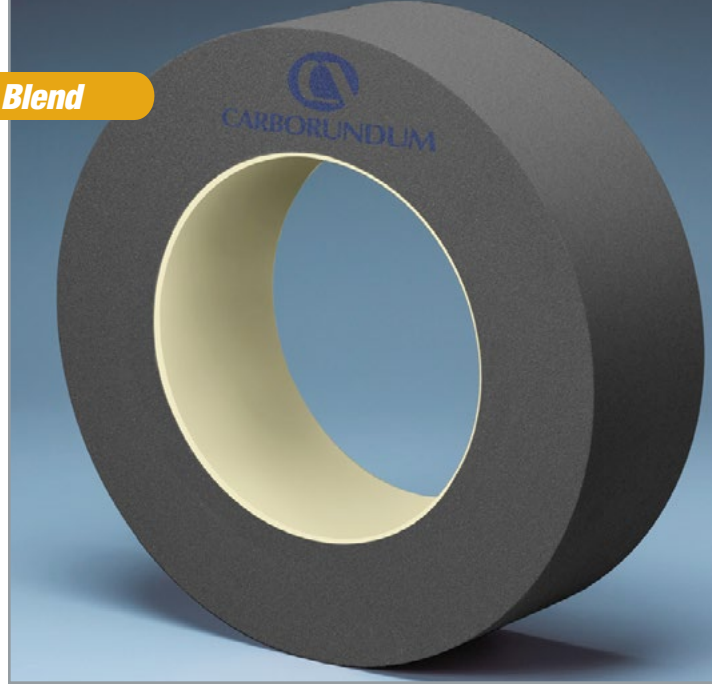
- Ideal when one wheel is used to grind several different materials from high to low tensile strength

Centerless grinding of cylindrical components in a thru-feed or plunge mode.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 – For Centerless Grinders</b>				
66253062178*	20 x 6 x 305mm	DAC54-QB83	1,815	1
66253062180*	20 x 8 x 12	DAC54-QB83	1,815	1
66253062184*	24 x 6 x 12	DAC54-QB83	1,510	1
66253062188*	24 x 8 x 12	DAC54-QB83	1,510	1
66253062190*	24 x 10 x 12	DAC54-QB83	1,510	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.



## GRA Aluminum Oxide Abrasive

### Features

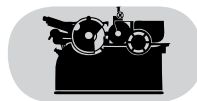
- Blended aluminum oxide GRA abrasive - gray color
- Premium performance vitrified bond

### Benefits

- Cool cutting action
- Fast stock removal
- Long wheel life and excellent form holding

Ideal choice for general machine shop grinding of various steels and steel alloys.

Centerless Grinding cylindrical components in a thru-feed or plunge mode.



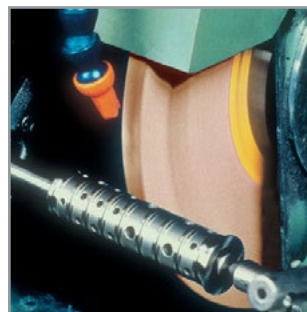
PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 – For Centerless Grinders</b>				
66253059283*	16 x 4 x 10	GRA60-LV14	2,030	1
66253059285*		GRA80-LV14	2,030	1
66253059289*	20 x 2 x 12	GRA60-MV14	1,625	1
66253059292*		GRA80-MV14	1,625	1
66253059295*	20 x 3 x 12	GRA60-LV14	1,625	1
66253059296*	20 x 4 x 12	GRA60-KV14	1,625	1
66253059297*		GRA60-LV14	1,625	1
66253059298*		GRA60-MV14	1,625	1
66253059299*		GRA80-MV14	1,625	1
66253059302*	20 x 6 x 12	GRA60-KV14	1,625	1
66253059303*		GRA60-LV14	1,625	1
66253059305*		GRA60-MV14	1,625	1
66253059306*		GRA80-LV14	1,625	1
66253059309*		GRA80-MV14	1,625	1
66253059468*	20 x 8 x 12	GRA60-MV14	1,625	1
66253059470*		GRA80-LV14	1,625	1
66253059472*		GRA80-MV14	1,625	1
66253059473*	20 x 10 x 12	GRA60-LV14	1,625	1
66253059482*	24 x 2 x 12	GRA60-MV14	1,350	1
66253059485*		GRA80-MV14	1,350	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
<b>Type 01 – For Centerless Grinders (continued)</b>				
66253059489*	24 x 4 x 12	GRA60-KV14	1,350	1
66253059490*		GRA60-MV14	1,350	1
66253059491*		GRA80-MV14	1,350	1
66253059492*	24 x 6 x 12	GRA60-KV14	1,350	1
66253059493*		GRA60-LV14	1,350	1
66253059494*		GRA60-MV14	1,350	1
66253059496*		GRA80-MV14	1,350	1
66253059498*	24 x 8 x 12	GRA60-KV14	1,350	1
66253059499*		GRA60-LV14	1,350	1
66253059500*		GRA60-MV14	1,350	1
66253059501*		GRA80-MV14	1,350	1
66253059507*	24 x 10 x 12	GRA60-KV14	1,350	1
66253059508*		GRA60-LV14	1,350	1
66253062309*	24 x 20 x 12	GRA60-KV14	1,350	1
66253062317*	Composed of Two 24 x 10 x 12 Butted Wheels	GRA60-LV14	1,350	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.



### TechTip

- Use resinoid bond wheels for stock removal, long irregular parts, and faster throughfeed grinding.
- Use vitrified bond wheels for form holding and plunge grinding.



It is the user's responsibility to refer to and comply with ANSI B7.1

# Centerless and Feed Wheels

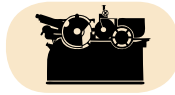
## Rubber Bond Feed Wheels

### Features

- The basic components of centerless grinding are the grinding wheels on the previous page, the rubber feed (regulating) wheels below, and the work rest blade
- The workpiece lies between the two wheels and is supported by the rest blade

### Benefits

*These rubber regulating/feed wheels are the drive mechanism for the workpiece.*



PART NO.	WHEEL SIZE	GRADING	WHEELS/BOX
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#### Type 01 - For Centerless Grinders

66253060229*	8 x 2 x 3	GA80-RR	1
66253060233*	9 x 2 x 4	GA80-RR	1
66253060238*	11 x 6 x 6-1/2	GA80-RR	1
66253060239*	12 x 1 x 5	GA80-RR	1
66253060242*	12 x 1-1/2 x 5	GA80-RR	1
66253060243*	12 x 2 x 5	GA80-RR	1
66253060244*	12 x 2-1/2 x 5	GA80-RR	1
66253060245*	12 x 3 x 5	GA80-RR	1
66253060247*	12 x 4 x 5	GA80-RR	1
66253060251*	12 x 6 x 5	GA80-RR	1

#### Type 05 - For Centerless Grinders

66253060255*	12 x 8 x 5 Recess 1/S 7-1/2 x 1-1/2	GA80-RR	1
66253060262*	14 x 10 x 6 Recess 1/S 8-1/2 x 1-1/2	GA80-RR	1

\*\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

PART NO.	WHEEL SIZE	GRADING	WHEELS/BOX
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#### Type 07 - For Centerless Grinders

66253060298*	8 x 4 x 3 Recess A/S 4-1/4 x 1-1/2 Recess B/S 4-1/4 x 1/2	GA80-RR	1
66253060295*	9 x 4 x 4 Recess 2/S 5-1/2 x 5/8	GA80-RR	1
66253060249*	12 x 4 x 5 Recess 2/S 7-1/2 x 1/2	GA80-RR	1
66253060253*	12 x 6 x 5 Recess A/S 7-1/2 x 1-1/2 Recess B/S 7-1/2 x 1/2	GA80-RR	1
66253060254*	12 x 6 x 5 Recess 2/S 7-1/2 x 1-1/2	GA80-RR	1
66253060256*	12 x 8 x 5 Recess A/S 7-1/2 x 2-1/2 Recess B/S 7-1/2 x 1-1/2	GA80-RR	1
66253060257*	12 x 8 x 5 Recess A/S 7-1/2 x 3-1/2 Recess B/S 7-1/2 x 1-1/2	GA80-RR	1
66253060258*	12 x 10 x 5 Recess A/S 8 x 2 Recess B/S 8 x 1-1/2	GA80-RR	1
66253060259*	14 x 8 x 5 Recess A/S 8 x 2 Recess B/S 8 x 1-1/2	GA80-RR	1
66253060261*	14 x 10 x 5 Recess 2/S 8 x 1-1/2	GA80-RR	1
66253060272*	14 x 20 x 6 Recess 2/S 8-1/2 x 1-1/2 Composed of Two 14 x 10 x 6 Butted Wheels	GA80-RR	1

## Surface Grinding Wheels

### AA Aluminum Oxide Abrasive

#### Features

- Aluminum oxide abrasive  
– white color
- Excellent friability
- Durable, vitrified bond

#### Benefits

- Fast stock removal for light to medium stock removal operations
- Cool cutting action
- Long wheel life

*AA abrasive is ideal for grinding heat sensitive steels, as well as easy- and medium-to-grind high-speed steels and cast, alloy steels.*

*Use V40 bond for general purpose applications or medium contact areas.*



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
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#### Type 01 - For Large Surface Grinders

66253059045*	20 x 1 x 8	AA46-HV40	1,240	1
66253059046*		AA60-JV40	1,240	1
66253059047*	20 x 1 x 10	AA36-HV40	1,240	1
66253059050*	20 x 1-1/2 x 10	AA36-JV40	1,240	1
66253059051*		AA46-HV40	1,240	1
66253059069*		AA60-JV40	1,240	1
66253059052*	20 x 2 x 10	AA36-JV40	1,240	1
66253059054*		AA46-HV40	1,240	1
66253059055*		AA60-JV40	1,240	1

continued



## AA Aluminum Oxide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 05 - For Large Surface Grinders</b>				
66253059048*	20 x 1-1/2 x 8	AA46-HV40	1,240	1
66253059049*	Recess 1/S 11-1/2 x 1/2 AA60-JV40		1,240	1
<b>Type 07 - For Large Surface Grinders</b>				
66253059044*	18 x 2 x 8 Recess 2/S 11-1/2 x 1/2	AA60-HV40	1,380	1
66253059070*	20 x 2 x 8	AA46-HV40	1,240	1
66253059071*	Recess 2/S 11-1/2 x 1/2 AA60-JV40		1,240	1
66253059056*	20 x 3 x 8	AA46-HV40	1,240	1
66253059057*	Recess 2/S 11-1/2 x 1/2 AA46-IV40		1,240	1
66253059059*	20 x 3 x 10	AA46-HV40	1,240	1
66253059060*	Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	AA46-IV40	1,240	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 07 - For Large Surface Grinders (continued)</b>				
66253059062*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	AA46-HV40	1,240	1
66253059065*	20 x 6 x 10 Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	AA46-HV40	1,240	1
66253059067*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	AA46-HV40	1,240	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## PA Aluminum Oxide Abrasive

### Features

- Friable, aluminum oxide abrasive with porous bond – pink color
- Controlled porosity bond
- Durable bond post

### Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Increased chip clearance and maximum coolant flow
- Reduced loading
- Cool cutting - wet or dry - in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal applications.  
Use on wide contact areas where heat is an issue.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 01 - For Large Surface Grinders</b>				
66253059211*	20 x 2 x 10	PA46-G19V40P	1,625	1
<b>Type 02 - For Large Surface Grinders</b>				
66253059206*	18 x 5 - 1-1/2 Rim Tape Wound	PA30-G19V40P	1,060	1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 05 - For Large Surface Grinders</b>				
66253059202*	18 x 1-1/2 x 8 Recess 1/S 11-1/2 x 1/2	PA46-G19V40P	1,805	1
<b>Type 07 - For Large Surface Grinders</b>				
66253059209*	20 x 2 x 8 Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059213*	20 x 3 x 8	PA46-E19V40P	1,625	1
66253059215*	Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059217*	20 x 3 x 10	PA46-E19V40P	1,625	1
66253059219*	Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059222*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059223*	20 x 6 x 10	PA46-E19V40P	1,625	1
66253059224*	Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	PA46-G19V40P	1,625	1
66253060320*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	PA46-G19V40P	1,625	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

## DA Aluminum Oxide Abrasive Blend

### Features

- A tough blend of AA and GA aluminum oxide abrasives

### Benefits

- Fast, cool cutting action and good form holding

The choice for medium to heavy feed rates, less heat-sensitive, precision operations



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 07 - For Large Surface Grinders</b>				
66253059073*	20 x 2 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1
66253059058*	20 x 3 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
<b>Type 07 - For Large Surface Grinders (continued)</b>				
66253059061*	20 x 3 x 10 Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	DA46-IV40	1,240	1
66253059063*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1
66253059066*	20 x 6 x 10 Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	DA46-IV40	1,240	1
66253059068*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	DA46-IV40	1,240	1
66253059226*	20 x 8 x 12 Recess 2/S 14-1/4 x 1	DA46-IV40	1,240	1

\* Non-stock. Ask your sales representative for lead-times.  
Minimum quantity = box quantity.

# Surface Grinding Segments

## Medalist Ceramic Alumina Abrasive

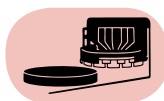
### Features

- High-performance, ceramic alumina abrasive - blue color
- Self-sharpening abrasive
- High-performance bond
- Induced porosity

### Benefits

- Fastest stock removal; maximum productivity
- Cool cutting
- Less burn on part
- Enhanced segment life
- Cool, free cut
- Excellent chip and coolant flow

**Ideal for high stock removal on flat surfaces.  
Best for grinding hard materials.**



PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539507043	5 x 1-1/2 x 6	30-EVLP	NO	8
05539507044		30-GVLP	NO	8
05539507047	11-1/4 x 2-1/4 x 6	30-EVLP	CD	5
05539562907		30-FVLP	CD	5
05539507048		30-GVLP	CD	5
05539505202	11-1/4 x 2-1/4 x 8	30-GVLP	CD	5



## Premier Red Aluminum Oxide Abrasive

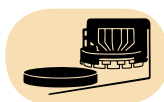
### Features

- Performance, aluminum oxide abrasive - pink color
- Premium vitrified bond
- Induced porosity

### Benefits

- Fast, cool cutting action
- Long life
- Cool, free cut

**Engineered for high stock removal on flat surfaces.  
Very versatile; work well on mild steels.**



PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539562911	5 x 1-1/2 x 6	RA30-GV40P	NO	8
05539562912	11-1/4 x 2-1/4 x 6	RA24-EV40P	CD	5
05539562914		RA30-EV40P	CD	5
05539562915		RA30-GV40P	CD	5

## Gold Aluminum Oxide Abrasive

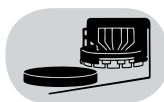
### Features

- Excellent value, aluminum oxide abrasive blend - gray/pink color
- Advanced vitrified bond
- Induced porosity

### Benefits

- Fast, cool cutting action
- Long life
- Cool, free cut

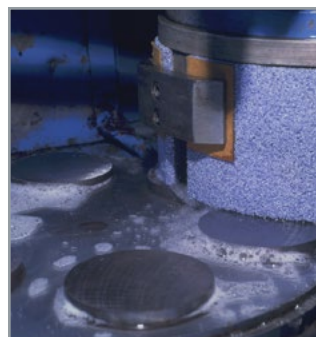
**For high stock removal on flat surfaces.  
Excellent value for general purpose use.**



PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539563010	11-1/4 x 2-1/4 x 6	Gold 30-E	CD	5
05539562922		Gold 30-F	CD	5
05539562924	11-1/4 x 3 x 8	Gold 30-F	CD*	4

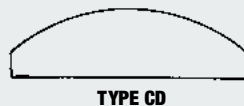
\* Bonus Grind

BONDED ABRASIVES



**Size = width x thickness x height**

SEGMENT NO.	SEGMENTS PER SET
<b>FOR NORTON-MATTISON CHUCKS (NO):</b>	
NO14	6
NO18	8
NO20	9
NO22	10
<b>FOR CORTLAND CHUCKS (CD):</b>	
CD18L	4
CD22L	5
CD36	8





## NorZon Zirconia Alumina Abrasive - Resin Bond

### Features

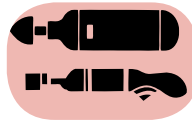
- Self-sharpening zirconia alumina abrasive
- Durable resin bond

### Benefits

- Aggressive, free cut
- 4 times faster stock removal than competitive aluminum oxide products
- Long lasting

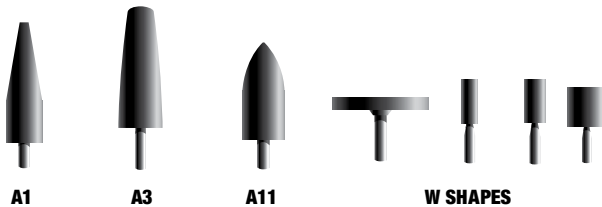
Premium quality mounted points for metal fabricating and foundry applications.

24 grit: snagging castings, smoothing contours, removing fins and parting lines.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>"A" Shapes</b>						
61463616457	A1	3/4 x 2-1/2	1/4	NZ24-UBXR1	19,800	5/25
61463616459	A3	1 x 2-3/4	1/4	NZ24-UBXR1	16,100	5/25
61463616463	A11	7/8 x 2	1/4	NZ24-UBXR1	19,860	5/25
<b>"W" Shape</b>						
61463616465	W189	1/2 x 2	1/4	NZ24-UBXR1	24,000	5/25
61463616467	W197	5/8 x 2	1/4	NZ24-UBXR1	21,000	5/25
61463616471	W208	3/4 x 2	1/4	NZ24-UBXR1	18,750	5/25
61463617520	W220	1 x 1	1/4	NZ24-UBXR1	25,500	5/25
61463616473	W221	1 x 1-1/2	1/4	NZ24-UBXR1	19,120	5/25
61463616475	W222	1 x 2	1/4	NZ24-UBXR1	15,900	5/25

Shank length is 1-1/2". Maximum operating speed based on 1/2" overhang.



### TechTip

- Use "A" shapes for medium- to heavy-duty blending
- Use "W" shapes for offhand and precision grinding of medium to heavy stock



It is the user's responsibility to refer to and comply with ANSI B7.1

## Charger Zirconia Alumina Abrasive - Resin Bond

### Features

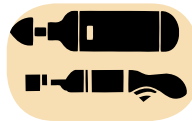
- Self-sharpening 30 grit zirconia alumina abrasive
- Specially formulated organic bond

### Benefits

- 35% faster cut rate than standard aluminum oxide
- An aggressive, free cut
- More parts cleaned in less time to substantially increase productivity
- 5X greater life than ordinary aluminum oxide
- Reduces vibration and wheel chatter

Premium quality mounted points for metal fabricating and foundry applications.

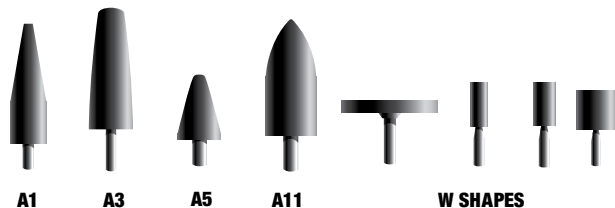
30 grit: deburring, removing weld beads, smoothing and blending welded areas.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>"A" Shapes</b>						
61463616458	A1	3/4 x 2-1/2	1/4	Charger	19,800	5/25
61463616460	A3	1 x 2-3/4	1/4	Charger	16,100	5/25
61463616462	A5	3/4 x 1-1/8	1/4	Charger	45,000	5/25
61463616464	A11	7/8 x 2	1/4	Charger	19,860	5/25
<b>"W" Shape</b>						
61463616466	W189	1/2 x 2	1/4	Charger	24,000	5/25
61463616470	W207	3/4 x 1-1/2	1/4	Charger	24,000	5/25
61463616472	W208	3/4 x 2	1/4	Charger	18,750	5/25
61463617521	W220	1 x 1	1/4	Charger	25,500	5/25
61463616474	W221	1 x 1-1/2	1/4	Charger	19,120	5/25
61463616476	W222	1 x 2	1/4	Charger	15,900	5/25

Shank length is 1-1/2" .

Maximum operating speed based on 1/2" overhang.



# Mounted Points

## Fiber-Reinforced Aluminum Oxide Abrasive - Resin Bond

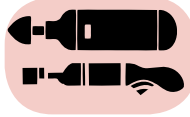
### Features

- Cotton fiber reinforced aluminum oxide
- 80 grit
- 120 grit

### Benefits

- Ideal for blending and finishing parts without changing geometry
- For most materials
- For polishing and stainless steel applications

Engineered for blending, polishing and finishing dies, cavities, etc.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>For Polishing</b>						
61463622664	A11	7/8 x 2	1/4	A80-HBF3	19,860	25/25
61463620242	B52	3/8 x 3/4	1/8	A120-HBF3	45,370	25/25
61463622657	B121	1/2" Ball	1/8	A80-HBF3	45,370	25/25
61463622655	W163	1/4 x 1/2	1/8	A80-HBF3	60,000	25/25
61463622656				A120-HBF3		
61463622654	W176	3/8 x 1/2	1/8	A80-HBF3	45,370	25/25
61463622649	W185	1/2 x 1/2	1/8	A80-HBF3	34,500	25/25
61463622651	W187	1/2 x 1	1/8	A80-HBF3	20,620	25/25
61463622646	W220	1 x 1	1/4	A80-HBF3	25,500	25/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.



A11



B52



B121



W SHAPE

## Center Lap - Aluminum Oxide Abrasive - Vitrified Bond

### Features

- Specially formulated wheel treatment (#5 wood resin)
- Large diameter spindle
- Precise dimensional tolerances

### Benefits

- Adds lubricity to the point, minimizing risk of metallurgical damage
- Minimum deflection, rigid support
- Ensure accurate location of centers

For use on Ex-Cello Center Lap and similar machines to produce accurate centers - precisely angled, truly conical, and free from ridges - for cylindrical grinding

PART NO.	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>For Center Lapping</b>					
61463621421	1/2 x 2**	1/2	A80-VVM	65,000	5/25
61463622926	1 x 2**	1/2	A80-VVM	15,900	5/25

\*\* Pointed 60°

Shank length is 1-1/4". Maximum operating speed based on 1/2" overhang.



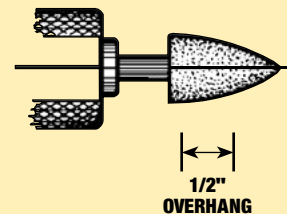
### TechTip

#### Description of Overhang

- Overhang is the distance between the grinder chuck and the abrasive on the spindle. The larger the overhang, the lower the maximum safe operating speed.
- Maximum operating speed is based on 1/2" overhang.
- The standard shank length is 1-1/2".



It is the user's responsibility to refer to and comply with ANSI B7.1



1/2" OVERHANG



## Gemini Aluminum Oxide Abrasive – Vitrified Bond

### Features

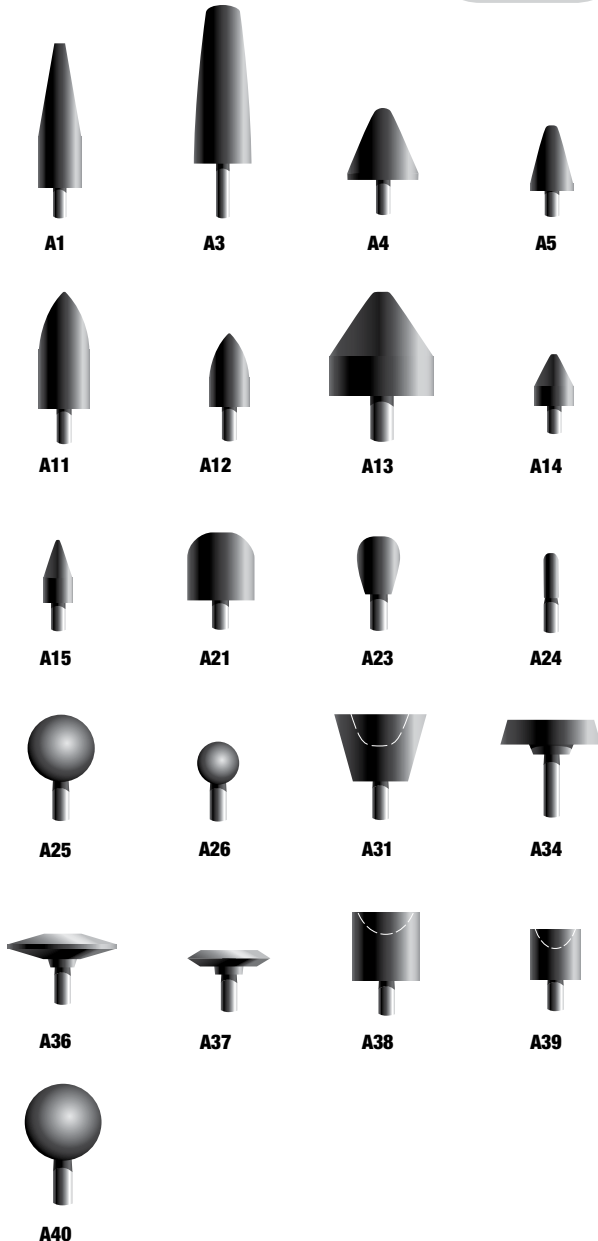
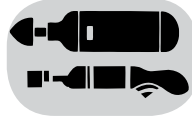
- Quality 38A aluminum oxide abrasive – brown color
- Vitrified bond
- Diverse shapes and sizes

### Benefits

- Cool cutting, less burn
- Long life
- Consistent form holding
- Ideal when initial price is the main purchasing consideration
- Great choice for small job shops

### “A” Shape Applications

Ideal for general maintenance applications in metal fabrication plants.



### “A” Shapes – For General Maintenance

PART NO.	SHAPE	SIZE D x L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
61463624374	A1	3/4 x 2-1/2	1/4	38A36-T	19,800	5/25
61463624375	A1	3/4 x 2-1/2	1/4	38A60-P	19,800	5/25
07660724376	A2	1 x 1/4	1/4	38A60-P	38,200	5/25
61463624377	A3	1 x 2-3/4	1/4	38A36-T	16,100	5/25
61463624378	A3	1 x 2-3/4	1/4	38A60-P	16,100	5/25
61463624380	A4	1-1/4 x 1-1/4	1/4	38A60-P	30,560	5/25
61463624381	A5	3/4 x 1-1/8	1/4	38A36-T	45,000	5/25
61463624382	A5	3/4 x 1-1/8	1/4	38A60-P	45,000	5/25
61463624384	A11	7/8 x 2	1/4	38A36-T	19,860	5/25
61463624385	A11	7/8 x 2	1/4	38A60-P	19,860	5/25
61463624388	A12	11/16 x 1-1/4	1/4	38A60-P	48,000	5/25
61463624389	A13	1-1/8 x 1-1/8	1/4	38A60-P	33,950	5/25
61463624390	A14	11/16 x 7/8	1/4	38A60-P	55,560	5/25
61463624391	A15	1/4 x 1-1/16	1/4	38A60-P	72,750	5/25
61463624392	A21	1 x 1	1/4	38A60-P	34,500	5/25
61463624394	A23	3/4 x 1	1/4	38A60-P	39,370	5/25
61463624395	A24	1/4 x 3/4	1/4	38A60-P	76,500	5/25
61463624396	A25	1" Ball	1/4	38A60-P	35,620	5/25
61463624397	A26	5/8" Ball	1/4	38A60-P	61,120	5/25
61463624399	A31	1-3/8 x 1	1/4	38A60-P	27,780	5/25
61463624402	A34	1-1/2 x 3/8	1/4	38A60-P	25,470	5/25
61463624404	A36	1-5/8 x 3/8	1/4	38A60-P	23,520	5/25
61463624405	A37	1-1/4 x 1/4	1/4	38A60-P	30,560	5/25
61463624406	A38	1 x 1	1/4	38A60-P	34,500	5/25
61463624407	A39	3/4 x 3/4	1/4	38A60-P	47,250	5/25
61463624408	A40	3/4" Ball	1/4	38A60-P	47,250	5/25

Standard shank size is 1/4" x 1-1/2".

Maximum operating speed based on 1/2" overhang.

### Mounted Point Kits – Vitrified Bond

PART NO.	DESCRIPTION	GRADING	KITS/BOX
69083147789	Assorted 1/4" Spindle, 50 pieces	38A60-P	1
1/4" Spindle Mtd. Point Kit contains 5 each of A1, A5, A11, A21, A23, A26, A36, A39, W242 Pacesetter and 5 W220 A80-HBF3			
69083147669	Assorted 1/8" Spindle, 50 pieces	38A60-P	1
1/8" Spindle Mtd. Point Kit contains 5 each of B42, B52, B97, B122, B131, W154, W164, W185, W215 Pacesetter and W163 A80-HBF3			

### TechTip

For best mounted point performance, always run the mounted point at the maximum allowable speed according to ANSI B7.1.

- Use 36 grit for rough grinding.
- Use 60 grit for imparting fine finishes or when grinding on narrow surfaces.

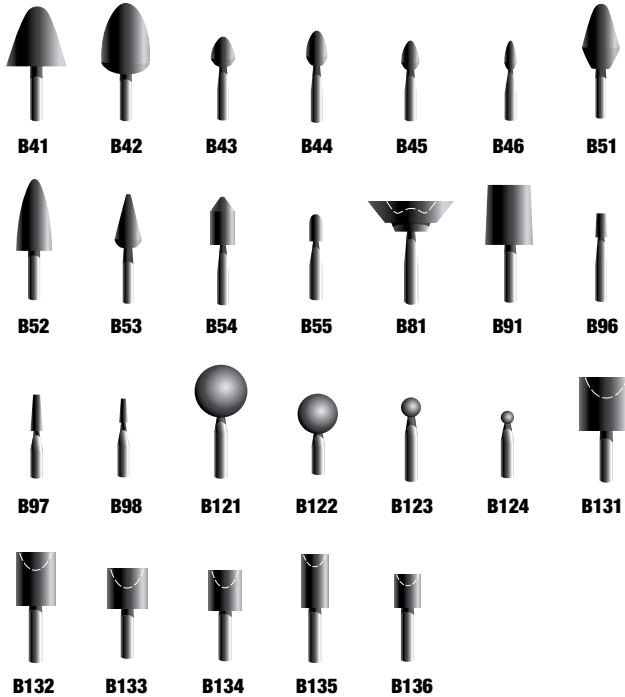
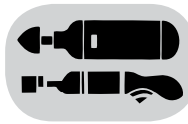


It is the user's responsibility to refer to and comply with ANSI B7.1

## Gemini Aluminum Oxide Abrasive – Vitrified Bond (continued)

### "B" Shape Applications

Ideal for light deburring of machined parts and for finishing/polishing molds and dies.



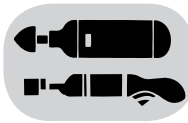
PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>"B" Shapes – For Light Deburring and Finishing</b>						
61463624410	B41	5/8 x 5/8	1/8	38A60-P	33,570	5/25
61463624412	B42	1/2 x 3/4	1/8	38A60-P	33,570	5/25
61463624413	B43	1/4 x 5/16	1/8	38A60-P	81,370	5/25
61463624414	B44	7/32 x 3/8	1/8	38A60-P	68,400	5/25
61463624415	B45	3/16 x 5/16	1/8	38A60-P	104,250	5/25
61463624416	B46	1/8 x 5/16	1/8	38A60-P	105,000	5/25
61463624418	B51	7/16 x 3/4	1/8	38A60-P	45,370	5/25
61463624420	B52	3/8 x 3/4	1/8	38A60-P	45,370	5/25
61463624419	B52	3/8 x 3/4	1/4	38A60-P	81,000	5/25
61463624422	B52	3/8 x 3/4	1/8	38A90-Q	45,370	5/25
61463624423	B53	5/16 x 5/8	1/8	38A60-P	60,000	5/25
61463624424	B54	1/4 x 1/2	1/8	38A60-P	60,000	5/25
61463624425	B55	1/8 x 1/4	1/8	38A60-P	105,000	5/25
61463624437	B81	3/4 x 3/16	1/8	38A60-P	50,930	5/25
61463624443	B91	1/2 x 5/8	1/8	38A60-P	34,500	5/25
61463624448	B96	1/8 x 1/4	1/8	38A60-P	105,000	5/25
61463624449	B96	1/8 x 1/4	1/8	38A90-Q	105,000	5/25
61463624451	B97	1/8 x 3/8	1/8	38A60-P	105,000	5/25
61463624452	B98	3/32 x 1/4	1/8	38A60-P	105,000	5/25
61463624466	B121	1/2" Ball	1/8	38A60-P	45,370	5/25
61463624470	B122	3/8" Ball	1/8	38A60-P	61,650	5/25
61463624471	B122	3/8" Ball	1/8	38A90-Q	61,650	5/25
61463624472	B123	3/16" Ball	1/8	38A60-P	104,250	5/25
61463624474	B124	1/8" Ball	1/8	38A90-Q	105,000	5/25
61463624475	B131	1/2 x 1/2	1/8	38A60-P	34,500	5/25
61463624479	B132	3/8 x 1/2	1/8	38A60-P	45,370	5/25
61463624481	B133	3/8 x 3/8	1/8	38A60-P	54,000	5/25
61463624482	B134	5/16 x 3/8	1/8	38A60-P	61,650	5/25
61463624484	B135	1/4 x 1/2	1/8	38A60-P	60,000	5/25
61463624485	B136	1/4 x 5/16	1/8	38A60-P	77,250	5/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.

### "W" Shape Applications

Ideal for precision grinding machine parts, molds and dies, involving medium to heavy stock removal.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>"W" Shapes – For Medium to Heavy Stock Removal</b>						
61463624488	W144	1/8 x 1/4	1/8	38A60-P	105,000	5/25
61463624489	W145	1/8 x 3/8	1/8	38A60-P	105,000	5/25
61463624491	W146	1/8 x 1/2	1/8	38A60-P	105,000	5/25
61463624495	W152	3/16 x 1/4	1/8	38A60-P	105,000	5/25
61463624496	W153	3/16 x 3/8	1/8	38A60-P	80,850	5/25
61463624497	W154	3/16 x 1/2	1/8	38A60-P	70,500	5/25
61463624501	W160	1/4 x 1/4	1/8	38A60-P	81,370	5/25
61463624503	W162	1/4 x 3/8	1/8	38A60-P	64,800	5/25
61463624504	W163	1/4 x 1/2	1/8	38A60-P	60,000	5/25
61463624505	W164	1/4 x 3/4	1/8	38A60-P	45,900	5/25
61463624511	W170	5/16 x 1/2	1/8	38A60-P	52,500	5/25
61463624516	W175	3/8 x 3/8	1/8	38A60-P	54,000	5/25
61463624517	W176	3/8 x 1/2	1/8	38A60-P	45,370	5/25
61463624518	W177	3/8 x 3/4	1/8	38A60-P	33,750	5/25

PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
<b>"W" Shapes – For Medium to Heavy Stock Removal</b>						
61463624525	W185	1/2 x 1/2	1/8	38A60-P	34,500	5/25
61463624526	W185	1/2 x 1/2	1/4	38A60-P	61,500	5/25
61463624528	W186	1/2 X 3/4	1/4	38A60-P	51,000	5/25
61463624530	W188	1/2 x 1-1/2	1/4	38A60-P	30,370	5/25
61463624531	W189	1/2 x 2	1/4	38A60-P	24,000	5/25
61463624539	W196	5/8 x 1	1/4	38A60-P	35,250	5/25
61463624543	W200	3/4 x 1/8	1/8	38A60-P	50,930	5/25
61463624544	W200	3/4 x 1/8	1/8	38A90-Q	50,930	5/25
61463624549	W204	3/4 x 3/4	1/4	38A60-P	42,750	5/25
61463624550	W205	3/4 x 1	1/4	38A60-P	34,500	5/25
61463624553	W208	3/4 x 2	1/4	38A60-P	18,750	5/25
61463624560	W215	1 x 1/8	1/8	38A60-P	38,200	5/25
61463624562	W216	1 x 1/4	1/4	38A60-P	38,200	5/25
61463624564	W218	1 x 1/2	1/4	38A60-P	38,200	5/25
61463624566	W220	1 x 1	1/4	38A60-P	25,500	5/25
61463624567	W221	1 x 1-1/2	1/4	38A60-P	19,120	5/25
61463624569	W222	1 x 2	1/4	38A60-P	15,900	5/25
61463624578	W230	1-1/4 x 1-1/4	1/4	38A60-P	20,400	5/25
61463624583	W235	1-1/2 x 1/4	1/4	38A60-P	25,470	5/25
61463624585	W236	1-1/2 x 1/2	1/4	38A60-P	25,470	5/25
61463624587	W237	1-1/2 x 1	1/4	38A60-P	22,500	5/25
61463624588	W238	1-1/2 x 1-1/2	1/4	38A60-P	15,600	5/25
61463624592	W242	2 x 1	1/4	38A60-P	19,100	5/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.



## Abrasive Benchstones

### Features

- Sharp, silicon carbide abrasive
- Aluminum oxide abrasive
- Arkansas natural Ozark quartz
- Vitrified bond

### Benefits

- Enhanced cutting action
- Fast stock removal
- Fast, cool cutting action
- Maintains high part tolerance
- High finishes
- Excellent conformability
- Long life and excellent form holding



SINGLE GRIT STONE



COMBINATION GRIT STONE

### Single Grit Benchstones:

Aluminum oxide benchstones are used to provide sharp edges and quality finishes, clean and deburr.

Arkansas natural benchstones are made of natural novaculite, quarried in Arkansas. Natural stones provide the sharpest edges and near-mirror finishes. Use for fine honing after India stone.

### Combination Grit Benchstones:

Silicon carbide combination benchstones have both coarse and fine grit silicon carbide surfaces. These fast-cutting stones are used to sharpen edges on tools to moderate tolerances quickly. Dark gray in color.

Aluminum oxide combination benchstones have both coarse and fine grit aluminum oxide abrasive surfaces to produce strong, keen, long-lasting edges on quality tools. Orange/brown in color.

Crystolon/India combination benchstones have fast-sharpening, medium grit silicon carbide (Crystolon) and fine aluminum oxide (India) abrasive surfaces for keen, long-lasting edges. Crystolon side is dark gray in color, India side is orange.

### Oil Stone Instructional DVD:

Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life – to make all your sharpening, honing, etc. applications easier.

### Sharpening Stone Oil:

Highly-refined lubricating oil specifically formulated for sharpening stone use, but equally ideal for all lubricating jobs. Meets U.S.A. Pharmacopoeia standards for mineral oil purity and may be used around food preparation operations.



PART NO.	SIZE	GRIT SIZE	PRODUCT NO.	QTY PKG/CASE
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### Single Grit Benchstones (continued)

#### Hard Translucent Arkansas

61463685655	4 x 2 x 3/4-1	Ultra Fine	HB4	1/5
61463685660	6 x 2 x 3/4-1	Ultra Fine	HB6	1/5
61463685665	8 x 2 x 3/4-1	Ultra Fine	HB8	1/5

#### Soft Arkansas

61463687560	3 x 1 x 3/8	Extra Fine	SB13	5/10
61463685670	4 x 2 x 3/4-1	Extra Fine	SB4	1/5
61463685675	6 x 2 x 3/4-1	Extra Fine	SB6	1/5
61463685680	8 x 2 x 3/4-1	Extra Fine	SB8	1/5

### Combination Grit Benchstones

#### Crystolon (Silicon Carbide)

61463685435	4 x 1 Round	Coarse/Fine	JB64	1/5
61463685440	4 x 1-3/4 x 5/8	Coarse/Fine	JB134	1/5
61463685445	5 x 2 x 3/4	Coarse/Fine	JB45	1/5
61463685450	6 x 2 x 1	Coarse/Fine	JB6	1/5
61463685455	8 x 2 x 1	Coarse/Fine	JB8	1/5
61463685840	11-1/2 x 2-1/2 x 1	Coarse/Fine	JUM3	1/2
61463685855	12 x 2-1/2 x 1-1/2	Coarse/Fine	JUM4	1/2

#### India (Aluminum Oxide)

61463685545	4 x 1 Round	Coarse/Fine	IB64	1/5
61463685550	4 x 1-3/4 x 5/8	Coarse/Fine	IB134	1/5
61463685555	5 x 2 x 3/4	Coarse/Fine	IB45	1/5
61463685560	6 x 2 x 1	Coarse/Fine	IB6	1/5
61463685565	8 x 2 x 1	Coarse/Fine	IB8	1/5
61463685851	11-1/2 x 2-1/2 x 1	Coarse/Fine	IM2	1/2

#### Crystolon/India

61463685643	6 x 2 x 1	Medium/Fine	IC6	1/5
61463687239	11-1/2 x 2 x 1	Medium/Fine	IC11	1/2

PART NO.	DESCRIPTION	QTY PKG/CASE
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### Oil Stone Instructional DVD

07660787945	Oil Stone DVD	1/1
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PART NO.	SIZE	DESCRIPTION	PRODUCT NO.	QTY PKG/CASE
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### Sharpening Stone Oil

61463687760	4-1/2 Ounces	Oil	XB1	1/20
61463687770	1 Pint	Oil	XB5	1/20
61463687775	1 Quart	Oil	XB2	1/5

PART NO.	SIZE	GRIT SIZE	PRODUCT NO.	QTY PKG/CASE
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### Single Grit Benchstones

#### India (Aluminum Oxide)

61463685580	4 x 1 x 1/4	Coarse	CB14	1/5
61463685575		Medium	MB14	
61463685570		Fine	FB14	
61463685595	4 x 1 x 1/2	Coarse	CB24	1/5
61463685590		Medium	MB24	
61463685585		Fine	FB24	
61463685605	5 x 2 x 5/8	Medium	MB35	1/5
61463685600		Fine	FB35	
61463685620	6 x 2 x 1	Coarse	CB6	1/5
61463685615		Medium	MB6	
61463685610		Fine	FB6	
61463685635	8 x 2 x 1	Coarse	CB8	1/5
61463685630		Medium	MB8	
61463685625		Fine	FB8	

# Sticks and Stones

## Waterstones

### Features

#### Waterstones

- System of four synthetic “Japanese-type” stones designed to work together, with water
- Softer than traditional oilstones – providing lapping action

### Benefits

- Fast sharpening, fine finish
- Superb results with low pressure

#### Prep Stone

- Synthetic stone raises the slurry

- Speeds up the slurry-making process needed to cut and polish with waterstones

#### Flattening Stone

- Coarse grit silicon carbide stone
- Diagonal grooves
- Superbly flat with hard bond

- Promotes maximum cutting for all grit sizes of waterstones
- Provide swarf removal
- Produces extremely flat results on all waterstones

The waterstone system was designed in a carefully planned sequence to create sharpening efficiency.

PART NO.	SIZE	GRADING	QTY PKG/CASE
<b>Waterstones</b>			
<b>Combination Grit (Bulk-packed)</b>			
61463624335	8 x 3 x 1	220 / 1000	1/5
61463624450		1000 / 4000	
69936655039		1000 / 8000	
61463624336		4000 / 8000	
<b>Prep Stone</b>			
66243439361	20mm x 20mm x 3"	Aluminum Oxide	1/5
<b>Flattening Stone</b>			
69936687444	9 x 3 x 3/4	Silicon Carbide	1/5
<b>Waterstone Instructional DVD</b>			
07660787944		Waterstone DVD	1/1



### TechTip

#### MAXIMIZE WATERSTONE PERFORMANCE

- Wet waterstone
- Rub evenly with the prep stone to create slurry
- Evening off the high spots will make for less-frequent flattening of the waterstones
- Waterstones wear concave with use; periodically flatten with flattening stone



It is the user's responsibility to refer to and comply with ANSI B7.1

## Diamond Benchstones

NEW!

### Features

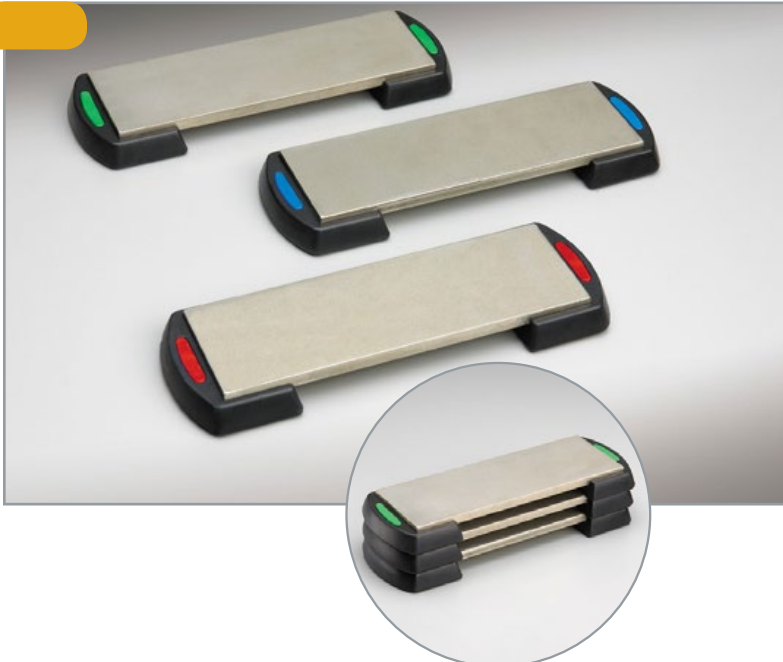
- Flat, diamond surface placed onto a nickel-coated steel bar precision ground to a tolerance of .001"
- Even diamond distribution; continuous diamond
- Sharpening surface

### Benefits

- Fast, even blade and tool edge sharpening
- Easily lubricated with water, but oil may be used
- Excellent sharpening performance across entire surface of stone
- Quicker sharpening than conventional interrupted-surface diamond stones

Typical applications include initial sharpening procedures, rapid stock removal, sharpening any hard material including carbide, tool and knife repair, deburring, filing and abrading.

PART NO.	SIZE	GRID SIZE	QTY PKG/CASE
<b>Diamond Benchstones</b>			
<b>Stackable with Non-skid Rubber Feet</b>			
66253268082	6 x 2 x 1/4	220	1/5
66253268081		325	
66253268080		600	
66253268087	8 x 2 x 1/4	220	1/5
66253268086		325	
66253268083		600	



See the Saint-Gobain Abrasives Professional Sharpening Products and Dressing Sticks catalog #200 to view the complete list and descriptions of our many sharpening products.



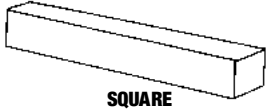
## Dressing and Finishing Sticks

### Features

- Aluminum oxide abrasive – white
- Silicon carbide abrasive – black
- Norbide and boron carbide – black
- Vitrified bond

### Benefits

- Free dressing action
- Sharp, durable
- Hard, durable and wear-resistant
- Excellent conformability



SQUARE

*Aluminum oxide dressing sticks work best on CBN grinding wheels, but can also be used on diamond grinding wheels.*

*Silicon carbide dressing sticks in coarse grit sizes and hard grades*

*are used for dressing conventional vitrified wheels. Silicon carbide dressing sticks in fine grit sizes and softer grades are used for dressing diamond wheels.*

*Norbide and boron carbide dressing sticks are used to dress medium grit/soft and medium grade conventional abrasive vitrified grinding wheels.*



PART NO.	SIZE THICKNESS X WIDTH X LENGTH	GRADING	STICKS/ BOX
<b>Dressing Sticks</b>			
<b>High Performance Long Life</b>			
61463610148	1/4 x 1/2 x 3	Norbide Stick	5
<b>Aluminum Oxide</b>			
61463610555	1/2 x 1/2 x 4	38A220-HVBE	5
61463610303	1/2 x 1/2 x 6	38A150-IVBE	5
61463610103 B		38A220-HVBE	
61463610415	1/2 x 3/4 x 4	38A60-LVBE	5
61463610440	3/4 x 3/4 x 4	38A60-LVBE	5
61463610362		38A80-MVBE	
61463610291		38A150-HVBE	
61463610368		38A150-IVBE	
61463610290		38A220-HVBE	
61463610280	3/4 x 3/4 x 8	38A220-HVBE	5
61463610405	1 x 1 x 6	38A150-HVBE	5
61463610453		38A150-IVBE	
61463610406 B		38A220-HVBE	
61463610390	1 x 1 x 8	38A120-IVBE	5
61463610455		38A150-IVBE	

**B = Best Seller**

PART NO.	SIZE	GRADING	STICKS/ BOX
<b>Dressing Sticks</b>			
<b>Silicon Carbide</b>			
61463610201	1/2 x 1/2 x 6	37C100-LV	5
61463610205		37C150-KV	
61463610206		37C150-LV	
61463610207		37C150-MV	
61463610214		37C220-KV	
61463610375	3/4 x 3/4 x 6	37C150-LV	5
61463610459	1 x 1 x 6	37C20-SVK	5
61463610462		37C24-SVK	
61463610354		37C24-TVK	
61463610466		37C46-RVK	
61463610393		37C80-NV	
61463610438		37C150-KV	
61463610398		37C220-KV	
07660710466	1 x 1 x 6	S/C Medium Grit	5
	Retail Carded		
61463610469	1 x 1 x 8	37C20-SVK	5
61463610471		37C24-SVK	
61463610482	1 x 2 x 8	37C16-TVK	5
61463610485		37C24-TVK	
61463610490	2 x 2 x 8	37C24-SVK	5



## Spec Check

Selecting the appropriate dressing stick for each application depends on the wheel size, type, speed, specification, and grit size, as well as the workpiece material. Initial starting specifications are listed below. We recommend testing several sticks to find the best one for your application.

- For Resin Bond Diamond and CBN Wheels: Choose a dressing stick one or two grit sizes finer than the abrasive in the wheel – in a soft grade (H or I).

### STARTING RECOMMENDATIONS FOR DRESSING WHEELS

#### SUPERABRASIVE WHEELS

##### RESIN BOND

-100 AND 120 GRIT

-150 AND 220 GRIT

#### VITRIFIED STICK SPECIFICATION

38A150-HVBE

38A220-HVBE

#### CONVENTIONAL VITRIFIED BOND WHEELS

- 46 GRIT AND FINER AND M GRADE AND SOFTER

37C24-SVK

# Bonded Abrasive Basics

## How to Read a Bonded Abrasive Specification

### Wheel Symbols and Markings

Carborundum abrasive wheels are marked according to the system which is standard throughout the industry. This standard marking system consists of six positions. The characters in each position denote a specific characteristic of the wheel.

## Bonded Abrasive Terminology Key

Position 1 <b>AA</b> ABRASIVE	Position 2 <b>46</b> GRIT SIZE			Position 3 <b>K</b> GRADE	Position 4 <b>8</b> STRUCTURE	Position 5 <b>V</b> BOND TYPE	Position 6 <b>40</b> BOND MODIFICATION
MEDALIST - BLUE CERAMIC ALUMINA	<b>COARSE</b>	<b>MEDIUM</b>	<b>FINE</b>	E - SOFT	1 - DENSE	V - VITRIFIED	<b>40</b>
MEDALIST R- PURPLE CERAMIC ALUMINA	14	46	220	F -	2 -	B - RESINOID	P = Porous
MZ - CERAMIC ALUMINA/ZA BLEND	16	54	240	G -	3 -	RR - RUBBER	
32AR - GRAY/PURPLE ALUMINUM OXIDE	20	60	280	H -	4 -		
38A - ALUMINUM OXIDE	24	70	320	I -	5 -		
A - ALUMINUM OXIDE	30	80	400	J -	6 -		
AA - WHITE ALUMINUM OXIDE	36	100	600	K -	8 -		
AR - RUBY ALUMINUM OXIDE		120	800	L -	9 -		
AZ - ZA/AO BLEND		150	900	M -	10 -		
BA - ALUMINUM OXIDE				N -	11 -		
DA - GRAY ALUMINUM OXIDE BLEND				O -	12 -		
GA - ALUMINUM OXIDE				P -			
GRA - GA/RA BLEND				Q -			
PA - PINK ALUMINUM OXIDE				R -			
RA - PINK/PURPLE ALUMINUM OXIDE				S -			
RGA - ALUMINUM OXIDE				T -			
37C - BLACK SILICON CARBIDE				U -			
C - BLACK SILICON CARBIDE				V -			
CA - BLACK SILICON CARBIDE				TO - TO			
CGA - ALUMINUM OXIDE/SILICON CARBIDE BLEND				HARD			
DAC - ALUMINUM OXIDE/SILICON CARBIDE BLEND							
GC - GREEN SILICON CARBIDE							
Z - ZIRCONIA ALUMINA							
AZA - ZA/AO BLEND							
ZA - ZA/AO BLEND							
2ZA - ZA/GA BLEND							
2ZC - ZA/C BLEND							
3AZA - ZIRCONIA ALUMINA/ALUMINUM OXIDE BLEND							
3ZA - ZIRCONIA ALUMINA/ALUMINUM OXIDE BLEND							
NORZON - PREMIUM ZIRCONIA ALUMINA							
PR - ZIRCONIA ALUMINA							
CHARGER - ZIRCONIA ALUMINA							



## Wheel Speeds - Conversion Table

Example: Find the machine RPMs. This should be written on the machine itself. For this example, assume that the machine RPM is 1,773 and that the wheel diameter is 14".

- Find the diameter of 14" in either the left-most or right-most column of the chart.
- Follow the row horizontally to RPM of 1,773 as this is the spindle speed of the machine.
- Follow column directly upwards to find SFPM of 6,500.

	SURFACE SPEED IN FEET PER MINUTE (SFPM)																	
	4,000	4,500	5,000	5,500	6,000	6,500	7,000	7,500	8,000	8,500	9,000	9,500	10,000	12,000	12,500	14,200	16,000	
<b>REVOLUTIONS PER MINUTE (RPM)</b>																		
1"	15,279	17,189	19,098	21,008	22,918	28,647	24,828	26,737	30,558	32,467	34,377	36,287	38,196	45,836	47,745	54,240	61,116	
2"	7,639	8,594	9,549	10,504	11,459	14,328	12,414	13,368	15,278	16,238	17,188	18,143	19,098	22,918	23,875	27,120	30,558	
3"	5,093	5,729	6,366	7,003	7,639	9,549	8,276	8,913	10,186	10,822	11,459	12,096	12,732	15,278	15,915	18,080	20,372	
4"	3,820	4,297	4,775	5,252	5,729	6,207	6,685	7,162	7,640	8,116	8,595	9,072	9,549	11,459	11,940	13,560	15,278	
5"	3,056	3,438	3,820	4,202	4,584	4,966	5,348	5,720	6,112	6,494	6,876	7,258	7,640	9,168	9,550	10,850	12,224	
6"	2,546	2,865	3,183	3,501	3,820	4,138	4,456	4,775	5,092	5,411	5,729	6,048	6,366	7,639	7,960	9,040	10,186	
7"	2,183	2,455	2,728	3,001	3,274	3,547	3,820	4,092	4,366	4,638	4,911	5,183	5,456	6,548	6,820	7,750	8,732	
8"	1,910	2,148	2,387	2,626	2,865	3,103	3,342	3,580	3,820	4,058	4,297	4,535	4,775	5,729	5,970	6,780	7,640	
9"	1,698	1,910	2,122	2,334	2,546	2,758	2,970	3,182	3,396	3,606	3,820	4,032	4,244	5,092	5,305	6,030	6,792	
10"	1,528	1,719	1,910	2,101	2,292	2,483	2,674	2,865	3,056	3,247	3,438	3,629	3,820	4,584	4,775	5,425	6,112	
12"	1,273	1,432	1,591	1,751	1,910	2,069	2,228	2,386	2,546	2,705	2,864	3,023	3,183	3,820	3,980	4,520	5,092	
14"	1,091	1,228	1,364	1,500	1,637	1,773	1,910	2,046	2,182	2,319	2,455	2,592	2,728	3,274	3,410	3,875	4,366	
16"	955	1,074	1,194	1,313	1,432	1,552	1,672	1,791	1,910	2,029	2,149	2,268	2,387	2,865	2,985	3,390	3,820	
18"	849	955	1,061	1,167	1,273	1,379	1,485	1,591	1,698	1,803	1,910	2,016	2,120	2,546	2,655	3,015	3,396	
20"	764	859	955	1,050	1,146	1,241	1,337	1,432	1,528	1,623	1,719	1,814	1,910	2,292	2,390	2,715	3,056	
22"	694	781	868	955	1,042	1,128	1,215	1,303	1,388	1,476	1,562	1,649	1,736	2,084	2,170	2,465	2,776	
24"	637	716	796	875	955	1,034	1,115	1,194	1,274	1,353	1,433	1,512	1,591	1,910	1,990	2,260	2,546	
26"	588	661	734	808	881	955	1,028	1,101	1,176	1,248	1,322	1,395	1,468	1,762	1,840	2,090	2,352	
28"	546	614	682	750	818	887	955	1,023	1,092	1,159	1,228	1,296	1,364	1,637	1,705	1,940	2,182	
30"	509	573	637	700	764	828	891	955	1,018	1,082	1,146	1,210	1,274	1,528	1,595	1,810	2,056	

Note: The calculated RPM figures listed above are rounded off to the next higher 5 for wheel marking purposes.

For intermediate diameters not listed, use the formula listed in Section 1,2,10 of ANSI B7.1 (SFPM = .262 x wheel diameter in inches x RPM) Note: SFPM ÷ 196.85 = m/s (meters per second)





## Abrasive Grains

The abrasive grains (ceramic alumina, zirconia alumina, aluminum oxide and silicon carbide) perform the cutting action. An ideal grinding abrasive has the ability to fracture before serious dulling occurs and offers maximum resistance to point wear. Each abrasive has special crystal structure and fracture characteristics, making it suitable for grinding operations on specific materials.

### Medalist - Ceramic Alumina

A superior performing grain for high temperature alloys such as Inconel, Waspalloy and Haspalloy, hardened tool steels, spray metal or Stellite and other hardened steels.

### Zirconia Alumina

A tough, sharp abrasive designed for optimum performance in cut-off wheels, snagging wheels and depressed center wheels for grinding or cutting cast steel, alloy steel, and malleable and ductile iron.

### Aluminum Oxide

A tough, sharp grain produced under controlled conditions and especially adapted to grinding or cutting materials of high tensile strength, such as alloy steel, high speed steel, annealed, malleable iron, and tough bronze.

### Silicon Carbide

This is a very hard, sharp abrasive grain used in the grinding of tungsten carbide and low tensile strength materials such as cast iron, bronze, aluminum, copper, and non-metallic materials such as plastics, glass, marble, granite and stone.



## Grade

The grade is the strength of bonding of a grinding wheel, and is frequently referred to as its hardness. The higher the letter designation, the stronger the bond.

## Wheel Structures

Wheel structures (the spacing between grain particles) range from open to dense and vary with different grinding operations, depending upon the area of contact and type of material being ground, rate of stock removal and finish required. Carborundum offers standard structure wheels that will perform well on a wide range of materials.

## Bonds

The purpose of the bonding material is to hold the abrasive grain particles together.

### Vitrified Bonds

Vitrified wheels have a glass bond composition. Vitrified wheels hold form extremely well and produce a high ratio of stock removal to wheel use. Vitrified wheels are commonly used for precision grinding in the tool and die market.

### Porosity

Vitrified wheels can be manufactured with induced porosity. All vitrified bonds that end in P (VLP, V40P, VPP) indicate induced porosity. This porosity allows excellent coolant flow and chip clearance. For materials that load or for wide surface area contact, this provides a cooler cutting action, less loading and less chance of burn on the workpiece.

### Resinoid Bonds

Resinoid, or organic compound, bonds are more shock resistant than vitrified bonds and are generally operated at higher peripheral speeds. Most resinoid bond wheels are used for fast stock removal in the metal fabrication and foundry markets.

## Procedures for Proper Handling and Storage of Bonded Abrasive Products

### Handling

All grinding wheels are relatively fragile and must be handled with care. This applies to all types of bonds: vitrified, resinoid and rubber.

#### Do:

- Inspect all wheels upon receipt.
- Use pallets or trucks to transport.
- Support firmly at all times.
- Place wheels carefully in racks.

#### Do Not:

- Leave wheels packed in absorbent material.
- Roll wheels on floor.
- Lean wheel against equipment.
- Place tools or parts on top of wheels.

### Storage

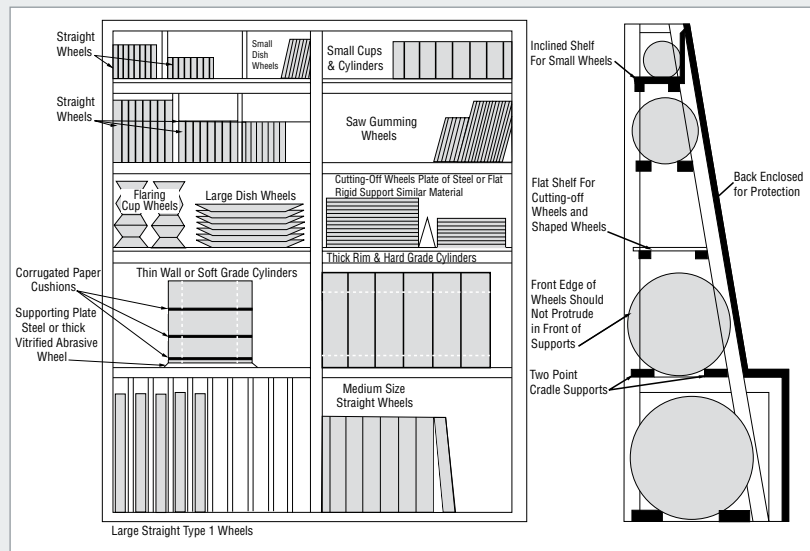
Suitable racks, cradles and drawers should be provided to store the various types of wheels used.

#### Do:

- Store wheels correctly supported.
- Stack thin wheels flat.
- Ensure storage in dry conditions.

#### Do Not:

- Store in damp or humid conditions.
- Subject wheels to dramatic change in temperature.
- Subject wheels to temperatures at or approaching freezing.



THIS DRAWING ILLUSTRATES A RACK DESIGN WHICH IS SUITABLE FOR SAFELY STORING A WIDE VARIETY OF ABRASIVE WHEELS.

## Knotted Wire Cup Brushes

### Features

- Rigid structure
- Available with or without plastic guard
- Protective guard opens up into a shield

### Benefits

- High impact cutting and cleaning
- Application-specific
- Prevents wire, dust and any kind of projection from reaching the end-user during work
- Provides for a friendly handling of the brush, preventing potential pricking caused by the wire ends, for safety before, during and after work
- Limits flaring of the brush on corners and angles
- More aggressive; provides twice the cutting points of a single row cup brush

- **Knotted Cup – Single Row**  
Single row, twist knot construction
- **Knotted Cup – Double Row**  
Double row, twist knot construction



WITH PROTECTIVE GUARD



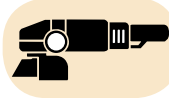
RED COLOR-CODED FOR STEEL



BLUE COLOR-CODED FOR STAINLESS

*High-impact cutting and cleaning on more demanding applications such as heavy deburring, weld cleaning and cleaning larger surfaces.*

*Use Double Row Knotted Cup brushes for heavy-duty, aggressive action in very severe applications.*



*Powder-coated and color-coded hubs prevent cross-contamination and rust.*

*Red = for steel/metal use*

*Blue = for stainless steel use*



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
<b>For Stainless Steel</b>				
<i>Knotted Cup – Single Row</i>				
69936653340	2-3/4 x .020 x 5/8-11	Stainless	15,000	5
66252833947	4 x .020 x 5/8-11	Stainless	9,000	5
<b>For Steel/Metal</b>				
<i>Knotted Cup with Protective Guard – Single Row</i>				
66252833492	2-3/4 x .020 x 5/8-11	Carbon	15,000	5
66252833496	4 x .020 x 5/8-11	Carbon	9,000	5
66252833497	5 x .020 x 5/8-11	Carbon	6,500	5
<i>Knotted Cup – Single Row</i>				
69936653336	2-3/4 x .020 x 5/8-11	Carbon	15,000	5
69936653345	4 x .020 x 5/8-11	Carbon	9,000	5
69936605965	6 x .020 x 5/8-11	Carbon	6,000	5
69936602003	6 x .035 x 5/8-11	Carbon	6,000	5
<i>Knotted Cup – Double Row</i>				
69936653346	6 x .020 x 5/8-11	Carbon	6,000	1*

### For Stainless Steel

#### *Knotted Cup – Single Row*

69936653340 2-3/4 x .020 x 5/8-11 Stainless 15,000 5

66252833947 4 x .020 x 5/8-11 Stainless 9,000 5

### For Steel/Metal

#### *Knotted Cup with Protective Guard – Single Row*

66252833492 2-3/4 x .020 x 5/8-11 Carbon 15,000 5

66252833496 4 x .020 x 5/8-11 Carbon 9,000 5

66252833497 5 x .020 x 5/8-11 Carbon 6,500 5

#### *Knotted Cup – Single Row*

69936653336 2-3/4 x .020 x 5/8-11 Carbon 15,000 5

69936653345 4 x .020 x 5/8-11 Carbon 9,000 5

69936605965 6 x .020 x 5/8-11 Carbon 6,000 5

69936602003 6 x .035 x 5/8-11 Carbon 6,000 5

#### *Knotted Cup – Double Row*

69936653346 6 x .020 x 5/8-11 Carbon 6,000 1\*

*All brushes are individually clamshell packaged unless otherwise noted.*

*\*These brushes are bulk packed.*

## High Performance (HP) Cable Crimped Wire Cup Brushes with Protective Guard

### Features

- 12 wires of .009" brass-coated steel (12 x .009) are bundled together into a group then crimped
- Cable crimped wire breaks down in smaller pieces than standard crimped brushes

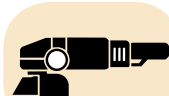
### Benefits

- Provides for a 50% longer lasting brush compared to standard crimped brushes
- Better flexibility on irregular surfaces
- Safer wire to use



RED COLOR-CODED FOR STEEL

*For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing.*



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
<b>For Steel/Metal</b>				
<i>Crimped Cup with Protective Guard – Single Row</i>				
66252833493	3 x (12 x .009) x 5/8-11	Carbon	13,000	5
66252833494	4 x (12 x .009) x 5/8-11	Carbon	9,000	5

### *Crimped Cup with Protective Guard – Single Row*

66252833493 3 x (12 x .009) x 5/8-11 Carbon 13,000 5

66252833494 4 x (12 x .009) x 5/8-11 Carbon 9,000 5

*All these brushes are individually clamshell packaged.*

## Crimped Wire Cup Brushes

### Features

- Highly flexible
- Heavy wire fill

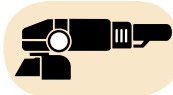
### Benefits

- Fast cutting



RED COLOR-CODED FOR STEEL

For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing.



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
<b>For Steel/Metal</b>				
69936653341	3 x .014 x 5/8-11	Carbon	13,000	5
69936653347	4 x .014 x 5/8-11	Carbon	9,000	5
69936653348	6 x .014 x 5/8-11	Carbon	6,000	5
69936653349	6 x .020 x 5/8-11	Carbon	6,000	1*

All brushes are individually clamshell packaged unless otherwise noted.

\*These brushes are bulk packed.

## Wire Saucer Cup Brushes

EXPANDED OFFERING!

### Features

- Twist knot style
- Crimped style

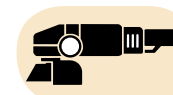
### Benefits

- For heavy-duty cleaning
- For light- to medium-duty cleaning



RED COLOR-CODED FOR STEEL

Ideal for cleaning corners and other hard to reach areas.



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
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### For Stainless Steel

#### Twist Knot Saucer Cup

66252835586	5 x .020 x 5/8-11	Stainless	12,500	10
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### For Steel/Metal

#### Twist Knot Saucer Cup

66252833483	4 x .020 x 5/8-11	Carbon	9,000	5
66252835585	5 x .020 x 5/8-11	Carbon	12,500	10

All these brushes are individually clamshell packaged.

## End Brushes

### Features

- Knot Wire End Brushes
- Crimped Wire End Brushes

### Benefits

- For more aggressive cutting
- For lighter brushing action and contoured surfaces



KNOTTED



CRIMPED

For use on die grinders to clean and deburr a recessed area or the inside diameter of a tube or pipe.



Powder-coated and color-coded hubs prevent cross-contamination and rust.

**Red** = for steel/metal use

**Blue** = for stainless steel use

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
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### For Stainless Steel

#### Stem Mounted Crimped

69936606145	3/4 x .006 x 1/4 Shank	Stainless	20,000	10*
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### For Steel/Metal

#### Stem Mounted Knotted

69936653316	3/4 x .020 x 1/4 Shank	Carbon	20,000	10*
69936606279	1 x .014 x 1/4 Shank	Carbon	20,000	10*
69936653310	1 x .020 x 1/4 Shank	Carbon	20,000	10*

#### Stem Mounted Crimped

69936653317	3/4 x .014 x 1/4 Shank	Carbon	20,000	10*
69936653309	1 x .020 x 1/4 Shank	Carbon	20,000	10*

#### Copper Center

69936653320	2-1/2 x .014 x 1/2-3/8	Carbon	20,000	12*
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\* All end brushes are bulk packed .

## TechTip

- Stainless brushes are made of 304L stainless steel with high chromium content to resist corrosion, high tensile resistance and lower carbon content.
- These brushes are suitable for all applications requiring corrosive resistance like the dairy, food processing, chemical processing and aircraft industries, among others.



It is the user's responsibility to refer to and comply with ANSI B165.1



## Crimped Wire Wheel Brushes

### Features

- Dense, high-quality, tempered crimped wire construction

### Benefits

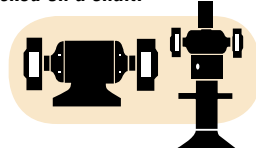
- Offers excellent performance for deburring, removing rust, corrosion and dirt, or for surface preparation



RED COLOR-CODED FOR STEEL

*Narrow-faced brushes are ideal for general purpose brushing of uneven or difficult-to-reach surfaces. Medium-faced brushes clean larger areas and have longer life.*

*Brushes may be used individually or stacked on a shaft.*



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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### For Steel/Metal

#### Crimped Narrow 1/2" Face

69936653306	6 x .014 x 1/2-2**	Carbon	6,500	1
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#### Crimped Medium 3/4" Face

69936653324	6 x .014 x 1/2-2**	Carbon	6,500	1
69936653326	8 x .014 x 1/2-2**	Carbon	4,500	1

*All these brushes are individually clamshell packaged.*

*\*\*7 bushing sizes are included with each brush.*

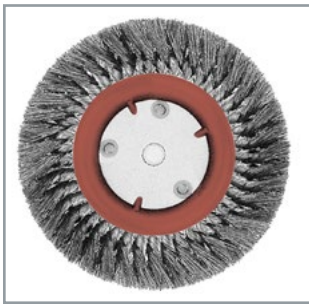
## Standard Twist Knot Wire Wheel Brushes

### Features

- Knotted wire design
- Application-specific sizes

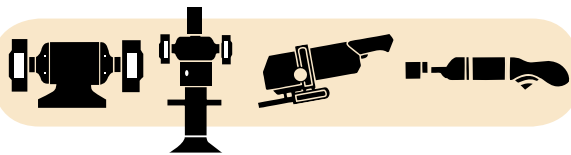
### Benefits

- Provides added rigidity for extra cutting power
- Use 3" wheels on die grinders
- Use 4" on right angle grinders
- Use 6" wheels on bench grinders



*Knot wire brushes are ideal for welding and metal fabrication applications such as removing weld scale and spatter, removing extra-heavy rust and corrosion, or surface roughening.*

*Small diameter wheels are used for small- to medium-duty jobs requiring flexibility and lighter brushing action.*



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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### For Stainless Steel

66252836362	3 x .014 x 5/8-11	Stainless	20,000	5
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### For Steel/Metal

69936606275	4 x .020 x 5/8-11	Carbon	15,000	5
69936653327	6 x .020 x 1/2-2**	Carbon	12,500	5

*All these brushes are individually clamshell packaged.*

*\*\*7 bushing sizes are included with each brush.*

## Full Cable Twist Knot Wire Wheel Brushes

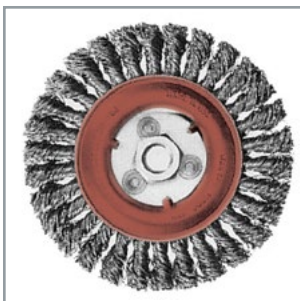
### Features

- Full cable twist knot brushes

### Benefits

- Provide very low flex and high impact cutting and cleaning

*For the tougher applications, especially for weld passes or other demanding applications.*



*Powder-coated and color-coded hubs prevent cross-contamination and rust.*

*Red = for steel/metal use*

*Blue = for stainless steel use*

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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### For Stainless Steel

69936653333	4 x .020 x 5/8-11	Stainless	20,000	5
66252833488	5 x .020 x 5/8-11	Stainless	12,500	5

### For Steel/Metal

66252838300	4 x .020 x 5/8-11	Carbon	20,000	5
69936653331	4-1/2 x .020 x 5/8-11	Carbon	20,000	6*
66252840466	4-1/2 x .020 x 5/8-11	Carbon Pipeline	20,000	6*
66252833487	5 x .020 x 5/8-11	Carbon	12,500	5
69936653352	6 x .020 x 5/8-11	Carbon	12,500	5

*All brushes are individually clamshell packaged unless otherwise noted.*

*\* These items are bulk packed*



## Stringer Bead Knot Wire Wheel Brushes

### Features

- Narrow face stringer bead wire
- Joint/Crack cleaning wire wheel brushes

### Benefits

- Delivers high-impact cutting and cleaning for toughest applications
- Used for brushing joints, cleaning cracks in concrete and asphalt, and preparing expansion joints for filling and scaling

*Specially suited for groove and weld bead, corners and t-connections.*



**BLUE COLOR-CODED FOR STAINLESS**



**RED COLOR-CODED FOR STEEL**

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
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### For Stainless Steel

#### For Right Angle Grinders

69936606278	4 x .020 x 5/8-11	Stainless	20,000	5
66252833491	5 x .020 x 5/8-11	Stainless	12,500	6*
69936653351	6 x .023 x 5/8-11	Stainless	9,000	5

### For Steel/Metal

#### For Right Angle Grinders

69936606277	4 x .020 x 5/8-11	Carbon	20,000	5
66252833489	4 x .020 x 5/8-11	Carbon	20,000	6*
66252840467	4 x .020 x 5/8-11	Carbon Pipeline	20,000	6*
66252833490	5 x .020 x 5/8-11	Carbon	12,500	6*
69936653350	6 x .020 x 5/8-11	Carbon	12,500	10*
66252840469	6 x .020 x 5/8-11	Carbon Pipeline	12,500	10*
69936653329	6-7/8 x .020 x 5/8-11	Carbon	9,000	10*
66252840468	6-7/8 x .020 x 5/8-11	Carbon Pipeline	9,000	10*
66252837993	9 x .020 x 5/8-11	Carbon	6,000	2

#### For Walk-Behind Machines - Joint/Crack Cleaning Brushes

69936606280	12 x .035 x 1 - DP	Carbon	4,500	2*
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*All brushes are individually clamshell packaged unless otherwise noted.*

*\* These items are bulk packed*

## Hand Brushes

### Features

- Plastic handle scratch brush
- Long handle and shoe handle brushes

### Benefits

- Ergonomic handle
- Crimped wire for longer life; all other scratch brushes are straight wire
- Wires are wrapped up and around the metal post so they never come out
- Steel scratch brushes are made with high-carbon brass-coated steel; stainless steel brushes are made with a 304L stainless steel

*Narrow brush allows access into tight areas and slots. Curved face for hard-to-reach places.*



PART NO.	BRUSH SIZE DESCRIPTION/SIZE	WIRE TYPE	BRUSHES/ BOX
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### Hand Brushes - For Stainless Steel

66252833950	Scratch Brush 3 x 19 Long Handle	Stainless	12
66252833951	Scratch Brush 4 x 16 Shoe Handle	Stainless	24
66252833953	Scratch Brush Plastic Handle	Stainless	24
66252833952	Inspection Brush 3 x 7	Stainless	36

### Hand Brushes - For Steel/Metal

66252833948	Scratch Brush 3 x 19 Long Handle	Carbon	12
66252833949	Scratch Brush 4 x 16 Shoe Handle	Carbon	24
66252833954	Scratch Brush Plastic Handle	Carbon	24

*All brushes are individually clamshell packaged unless otherwise noted.*

## TechTip

### Observe Wire Brush Safety Warnings to Avoid Injury

- 1 Safety Goggles: Safety goggles or full face shields worn over safety glasses with side shields must be worn by all operators and others in the area of power brush operations. Comply with the requirements of ANSI Z87.1 "Occupational Eye and Face Protection".
- 2 Guards: Keep all machine guards in place.
- 3 Speeds: Observe all speed restrictions indicated on the brushes, containers, labels, or printed in pertinent literature. "MSFS" means Maximum Safe Free Speed (RPM) - free spinning wheel with no work applied. For reasons of safety, the MSFS should not be exceeded under any circumstance.
- 4 Safety Standard: Comply with the safety Standards of the Industrial Division of the American National Standards Institute ANSI B165.1 "Safety Requirements - Power Brushes" and refer to the "Safety" section in the [carborundumabrasives.com](http://carborundumabrasives.com) web site.
- 5 Protective Equipment: Appropriate protective clothing and equipment (such as gloves, respirator, etc.) must be used.

**Warning:** In normal power brushing operations, the material being removed, such as burrs, scale, dirt, weld slag, or other residue, will fly off the brush with considerable force along with the brush filaments which break off due to fatigue.

The potential of serious injury exists for both the brush operator and others in the work area (possibly 50 or more feet from the brush). To protect against this hazard, before rotating the brush, operators and others in the area must wear SAFETY GOGGLES or FULL FACE SHIELDS WORN OVER SAFETY GLASSES WITH SIDE SHIELDS, along with PROTECTIVE CLOTHING.



*It is the user's responsibility to refer to and comply with ANSI B165.1*

# Masking Tapes and Wipes

## Masking Tapes

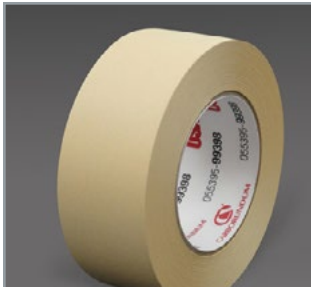
### Features

- Rubber-based adhesive
- Saturated crepe paper

### Benefits

- Superior quick stick
- Stays in place
- Easily removed without adhesive transfer
- Conforms to curved surfaces without lifting or tearing
- Resists moisture and solvents
- No bleed-through
- No curling edges or roll-back

Quick stick and stays in place with no lifting or roll-back.



### Tan Masking Tape

*Carborundum Tan Masking Tape goes on easy, sticks fast and holds tight. It conforms easily to contours and irregular surfaces. Carborundum Tan Masking Tape can be baked up to 260°F and be exposed to wet sanding without adhesive transfer. There is no bleed-through or flaking upon removal.*



### Gold Masking Tape

*A value masking tape recommended for all automotive finish systems and multiple bake cycles. Resistant to temperatures up to 260°F for 1 hour. Can be exposed to wet sanding without adhesive transfer. No flaking or bleed-through upon removal.*



### Carbo PG and Carbo AM Masking Tape

*Carbo PG is a high-quality masking tape with clean and easy removal from either hot or cold surfaces. Resistant to temperatures up to 325°F.*

*Carbo AM has a rubber-based adhesive that provides secure adhesion to painted/bare metals and plastics and removes cleanly. Resistant to temperatures up to 212°F.*

*Both work well with both solvent and waterborne paints.*

PART NO.	COLOR	ROLLS/PKG.	ROLLS/CASE
<b>18mm (3/4") x 55m (60 yard) Roll</b>			
05539599396	Tan	1	48
<b>36mm (1-1/2") x 55m (60 yard) Roll</b>			
05539599397	Tan	1	24
<b>48mm (2") x 55m (60 yard) Roll</b>			
05539599398	Tan	1	24

PART NO.	COLOR	ROLLS/PKG.	ROLLS/CASE
<b>18mm (3/4") x 55m (60 yard) Roll</b>			
05539599366	Gold	1	48
<b>36mm (1-1/2") x 55m (60 yard) Roll</b>			
05539599367	Gold	1	16
<b>48mm (2") x 55m (60 yard) Roll</b>			
05539599368	Gold	1	12

PART NO.	COLOR	ROLLS/PKG.	ROLLS/CASE
<b>18mm (3/4") x 54.8m (60 yard) Roll</b>			
05539599584	Carbo PG	1	48
05539599587	Carbo AM	1	48
<b>36mm (1-1/2") x 54.8m (60 yard) Roll</b>			
05539599585	Carbo PG	1	24
05539599588	Carbo AM	1	24
<b>48mm (2") x 54.8m (60 yard) Roll</b>			
05539599586	Carbo PG	1	24
05539599589	Carbo AM	1	24

## EZ Wipe Micro-Fiber Cloth



*Picks up dirt like a magnet with thousands of advanced micro-fabric fibers. Can hold seven times its weight in water. Perfect for fine detailing.*



PART NO.	GRADING	WIPES/PKG.	WIPES/CASE
<b>16" x 16"</b>			
05539564024	Micro-Fiber	1	20

# Part Number-to-Page Number Cross Reference

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## SafetyTIPS

### Depressed Center, Cut-off, and Snagging Wheels

#### Do's

- Check all wheels for cracks or damage before use
- Check machine speed against established safe operating speed marked on the wheel
- Always use the guard furnished with machine
- Run wheel in a protected area for one minute at operating speed before grinding

#### Don'ts

- Don't use wheels that have been dropped or otherwise damaged
- Don't use heavy side pressure on any thin Type O1 cut-off wheel or Type 27/42 thin depressed center wheel
- Never use a grinding wheel with a rated speed less than that of the grinder

### Proper Grinding Wheel Operating Speeds and Safety!

As abrasive wheel producers have known for many years, most grinding wheel breakages and injuries are caused by one major oversight. That oversight is operating a grinding wheel in an over-speed condition. A grinding wheel should never be operated at speeds greater than the wheel's rated speed.

- Never mount grinding wheels on sanders (Pistol Grip Air Sanders)
- Never mount grinding wheels directly on electric motors
- Never mount grinding wheels on the wrong size machine for the grinding wheel
- Always properly maintain your machine: especially governors on pneumatic machines and linkage on floorstand machines
- Never use the incorrect air, hydraulic or electric power supply
- Never use the improper speed setting on a machine

### Toolroom Wheels

#### Do's

- Check all wheels for cracks or damage before use
- Always use a safety guard and ensure work rest is properly adjusted on a bench grinder
- Always handle and store wheels in a careful manner
- Check mounting flanges for equal and correct diameter and use blotters when supplied
- Check machine speed against established safe operating speed marked on wheel

#### Don'ts

- Don't use a cracked wheel or one that has been dropped or damaged
- Don't exceed recommended operating speeds
- Don't tighten the mounting nut excessively
- Don't jam work into the wheel
- Do not sand wood, plastic or any other non-metallic material on benchstand pedestal grinders

### A Deadly Equation

**Pistol Grip Air Sander  
+ Grinding Wheel  
= Certain Injury!**

- Never use a high-speed air sander as a portable grinder
- Use only sanding discs specifically designed for sanders
- Because the speed of these sanders far exceeds the maximum rated speeds for grinding wheels, a potentially lethal wheel breakage might occur



PISTOL GRIP AIR SANDER



**It is the user's responsibility to refer to and comply with ANSI B7.1 and B7.7 safety standards**



**Call your local Distributor for our safety DVD:**

**"Safety, It's The Smart Thing To Do!"**



## Safety Symbols



### Face Protection

Always wear government-approved face and eye protection when using abrasive products.



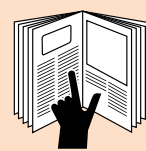
### Safety Gloves

Grinding applications are conducted in harsh environments. The use of proper fitting gloves is recommended.



### Dust Protection

Exposure to dust generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury. Use dust capture or local exhaust as stated in the MSDS. Wear government-approved respiratory protection and eye and skin protection. Failure to follow this warning can result in serious lung damage and/or physical injury. This is a general dust warning and does not cover specific situations. For more information, refer to the MSDS dust warning provided with your products, and workpiece.



### Safety Guides, MSDS & Wheel Warning Messages

Before using any abrasive materials, READ:

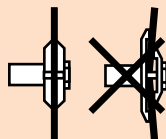
- The Safety Guides
- Wheel Warning Messages and Material Safety Data Sheets (MSDS)

Carborundum provides information pertaining to the safe use of all products. Please take the time to read it carefully. Contact suppliers of the workpiece and abrasive materials for copies of the MSDS if one is not readily available. Carborundum abrasives MSDS can be obtained on-line at [www.carborundumabrasives.com](http://www.carborundumabrasives.com)



### Hearing Protection

Use of abrasive products might create elevated sound levels. Hearing protection must be worn where required.



### Flanges

When mounting most grinding wheels, use flanges of equal diameter and bearing surface. For exceptions, see ANSI B7.1.



### Wheel Guard

Always use the wheel guard as supplied by the machine manufacturer, in the proper position.



### Speeds

Check machine spindle speed and speed listed on machine against safe maximum operating speed marked on the grinding wheel. Do not overspeed the wheel.



## WARNING

**This warning icon appears on our products and packaging. It is intended to draw your attention to the specific safety warning practices outlined after it.**

## Safety on the Web

As part of Saint-Gobain Abrasives' ongoing commitment to safety, each month a new safety article is published on the Carborundum website. Topics include proper abrasive storage, equipment maintenance, proper wheel mounting, using blotters, ring testing a grinding wheel, wheel dressing and much more.

Visit the Carborundum website at [www.carborundumindustrial.com](http://www.carborundumindustrial.com) and check the "News" section for the newest article. Or click on "Safety" to review our archived safety articles.

For more information on product safety, ask your Carborundum Abrasives distributor for these publications:

- "Play it Safe at the Wheel" pamphlet CA8900, and "Safety, It's the Smart Thing to Do" DVD
- ANSI Standard B7.1 Safety Requirements for the Use, Care and Protection of Abrasives Wheels
- ANSI Standard B7.7 Safety Requirements for Abrading Materials with Coated Abrasive Systems

For additional safety information, visit our website at [www.carborundumindustrial.com](http://www.carborundumindustrial.com)



## Safety – It's the Smart Thing to Do

**Safe operating practices must be part of every grinding wheel user's operation.**

- 1 Be sure to read any safety material/guidelines provided with the abrasive product.
- 2 Always check the wheel for cracks or damage before use.
- 3 Before mounting the wheel, use a tachometer to measure the spindle speed. Wheel speeds should never exceed the maximum speed shown on the wheel or package.
- 4 Ensure the mounting flanges, backplate or adapter supplied by the machine manufacturer are properly used and kept in good condition. ANSI Safety Requirement B7.1 provides wheel mounting requirements. Check mounting flanges for equal and correct diameter and use blotters when supplied.
- 5 Always mount, true and dress the wheel in compliance with the guidelines published in the ANSI Safety Requirements B7.1.
- 6 Ensure the correct wheel guard is in place before starting the wheel. Allow the wheel to come up to full operating speed for a minimum of 1 minute before starting to grind. Stand out of the plane of rotation.
- 7 NEVER use a high speed air sander as a portable grinder.
- 8 Never use a grinding wheel with a rated speed less than the grinder.
- 9 NEVER exceed the maximum operating speed marked on the wheel being used. The following formula may be used to convert wheel speed from RPM to SFPM.

**SFPM = Spindle Speed in RPM x Wheel Diameter in inches x .262**

*(or refer to the Wheel Speeds Conversion Table, where applicable, in Bonded Abrasives Basics, page 102.)*

- 10 When not using the wheel, store the wheel in its original packing materials and avoid dropping or bumping the wheel. This protects the wheel from chips and cracking, as well as provides easy identification of the wheel.

To obtain the maximum performance of the wheel, your operating procedures must include the care of the product both before and after its actual use. The greatest efficiency and lowest overall abrasive cost can be realized only if proven care and use techniques become standard practice.

### Saint-Gobain Abrasives Trademarks

Abrasotex®	Dri-Lube®	FlexEdge™	Medalist®	ShurStik™
Carbo CleanAir®	Edger™	fx™ (flexible)	Merit®	Stick-On™
Carbo Cool®	EZ Touch™	Flex-Loc™	PowerLock®	Surface Finish™
Carbo-Cut™	E-ZView™	Gold™	Premier™	Surface Prep™
Carbo Gold™	Fat Boy™	GoldCut™	Premier Red™	Surface Strip™
Carborundum®	Fibratex®	Gold MaXX™	Premier RedCut™	and others
Carborundum logo®	FlexDrum™	Grip-On®	Sand-O-Flex™	

#### Product Warranty

WARRANTY – Carborundum warrants the products in this catalog to be free from defects in material or workmanship for a period of one year from the date of purchase. Carborundum's sole obligation under this warranty shall be to repair or replace, at Carborundum's option, any product which is non-conforming provided any such product failure was not caused by a subsequent modification of the product, misuse or a failure to follow any applicable instructions for the product. EXCEPT FOR THE FOREGOING, CARBORUNDUM EXPRESSLY DISCLAIMS ALL OTHER GUARANTIES AND/OR WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

#### Product Quality Complaints

All product quality complaints should be submitted to your local Carborundum Distributor.

#### Liability Limitation

CARBORUNDUM'S LIABILITY FOR ANY LOSS OR DAMAGE ARISING OUT OF OR RESULTING FROM THE USE OF THE PRODUCT SHALL NOT EXCEED THE PURCHASE PRICE THEREOF, REGARDLESS OF WHETHER SUCH LIABILITY ARISES IN CONTRACT, TORT (INCLUDING WITHOUT LIMITATION NEGLIGENCE OR STRICT LIABILITY), OR OTHERWISE, AND IN NO EVENT SHALL CARBORUNDUM BE LIABLE FOR INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY KIND. NO REPRESENTATIVE OF CARBORUNDUM, NOR ANY OF CARBORUNDUM'S DISTRIBUTORS OR DEALERS, IS AUTHORIZED TO MODIFY THIS WARRANTY OR ISSUE ANY WARRANTY REGARDING THE PRODUCTS IN THIS CATALOG.



# CARBORUNDUM

GUARANTEED

# NO RISK

TEST POLICY

## Judge for Yourself

Carborundum/Saint-Gobain is so confident of the superior performance of our abrasive products, as recommended for specific applications, that we invite in-plant tests against any other brand of abrasive product on the market.

### The Carborundum No-Risk Test Policy

- 1 The test will be conducted in the user's own plant, on their own machines, using their own work-pieces.
- 2 Even if the user purchases only a minimum quantity of Carborundum abrasive products, the user will receive the same quantity discount as would apply to their normal production orders.
- 3 If the Carborundum product tested proves completely unsatisfactory, the user will receive a full refund.
- 4 If the Carborundum product tested performs at a lower level than the product presently in production, the user will receive an adjustment to make up the difference in performance.
- 5 The user is the final judge of performance!



## Customer Service

To place an order, contact our customer service support center with:

- Customer number and contact name
- Complete product information:
  - 11-digit Part Number
  - Product description
  - Quantity and unit of measure
  - Price by unit of measurement

To ensure minimal errors and faster turnaround, using electronic media is preferred. For assistance with [www.abrasiveconnection.com](http://www.abrasiveconnection.com) or EDI setup, contact us at:

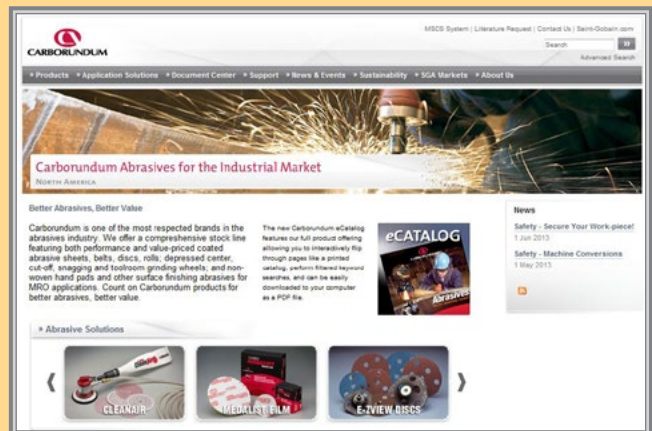
Email: [abrasive.connection@saint-gobain.com](mailto:abrasive.connection@saint-gobain.com)  
Phone: 888-383-2236

EMAIL: [nacustomerservice@saint-gobain.com](mailto:nacustomerservice@saint-gobain.com)  
U.S. PHONE: 800-231-4154 FAX: 800-458-3448  
CDN PHONE: 800-268-2262 FAX: 800-561-9490

## Online

The printed catalog is a great starting resource for Carborundum and Merit product selection. Our website is the ideal resource for a more comprehensive outline of product and application information. It is continually updated with all our most current information and offers more electronic queries for deeper detail, at the click of a button.

[www.carborundumindustrial.com](http://www.carborundumindustrial.com)



# Double Your Productivity With Twice the Product Lines



## Less Dust; More Productivity

### Carbo CleanAir System

- 30% increase in dust extraction versus traditional vacuum sanding discs
- Same abrasive surface area as traditional 6 hole discs
- Continual cut for life of disc with no clogging



## Your Surface Conditioning Solution

### Merit Surface Prep Discs and Belts

- Replace many multi-step operations with one product
- Up to 35% reduction in process time on light deburring and blending non-woven operations
- 15+% performance versus competitive conditioning products



## Two Wheels in One! Gold High-Speed Gas and Electric Saw Wheels

- Our new 1"/20mm universal arbor hole wheels fit on all 20mm high-speed saws
- Remove the 20mm bushing – and the same wheel fits on 1" arbor hole saw!



## Access to Two Saint-Gobain Abrasive Lines

### Sharpening Stones Catalog #200 and Stock Mounted Points

- Find popular benchstones and dressing sticks in this catalog
- And, heavy-duty resin bond and vitrified precision mounted points



## Your One Source for Two Abrasive Industry Leaders – Includes Complete Carborundum and Merit Abrasive Product Lines

For more product information or to place an order, contact your local Carborundum distributor.  
Visit our web site: [www.ind.carborundumindustrial.com](http://www.ind.carborundumindustrial.com)



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