

Reshaping
your
world

NORTON BEAR TEX



we've surfaced
faster solutions
**THAT WORK HARD
AND PAY BETTER**

For stripping, deburring, blending, finishing, or polishing surfaces and coatings, Norton Bear-TEX non-woven innovations reduce steps and improve surface finish.



**CLEAN
BOND**
TECHNOLOGY

Our patented Clean Bond Technology eliminates smearing.



Strip Away Old Ideas
Quick and easy rough cleaning and stripping of scale and heavy stock on a variety of materials while maintaining its non-loading feature.



Prep for the Future
For cleaning and conditioning: gain higher material removal, longer life and consistent, smear-free finishes - even on high nickel content alloys.



Blending In is Easy
Polishing and blending with Norton Rapid Blend unified discs and wheels leave a smear-free finish in fewer steps.

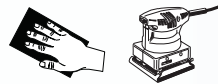


Eliminate the Guesswork
Get the perfect combination of life, cut, and smear-free finish, with our color-coded (by application and abrasive type) GP convolute wheels.

HAND PADS, ROLLS AND SPONGES

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
- Sponge Pad Features:**
- Non-woven material is laminated to a long-lasting sponge for the convenience of 2 pads in one
 - Superior replacement for steel wool
- Roll Features:**
- Economical alternative to cut pads
 - Can be cut to specific sizes
- Machine Used:**



APPLICATION/GRIT RECOMMENDATION GUIDE

	← MORE AGGRESSIVE, ROUGHER FINISH					LESS AGGRESSIVE, FINER FINISH →					
PRODUCT #:	#740	#746	#644	#747	#796	#635	#748	Thin-Flex VF	Thin-Flex UF	Thin-Flex BP	#456
COLOR:	Dark Tan	Gray	Maroon	Maroon	Green	Gray	Gray	Maroon	Gray	Gold	White
DESCRIPTION:	Heavy Duty	Blending	GP – Fine	GP Plus – Very Fine	Scouring	Clean & Finish	Final Shine	Cleaning	Cleaning	Blend Prep	Cleaning
ABRASIVE:	AO	SC	AO	AO	AO	SC	SC	AO	SC	AO	Non-Abrasive
GRIT SIZE:	Medium 100 - 150	Medium 100 - 150	Fine 180 - 220	Very Fine 240 - 360	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro Fine 800 - 1200	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro-Fine 800 - 1200	Non-Abrasive - - -
STEEL WOOL EQUIVALENT:	4 Extra Coarse	3 Coarse	2 Medium Coarse	1 Medium	0 Fine	00 Very Fine	00 Very Fine	00 Very Fine	000 Extra Fine	000 Extra Fine	0000 Super Fine
APPLICATIONS:	<ul style="list-style-type: none"> • Smear-free Clean Bond technology • 2X life • Most durable and aggressive cutting pad • Heavy-duty removal <ul style="list-style-type: none"> » rust » oxidation • Deburring 	<ul style="list-style-type: none"> • Blending and deburring <ul style="list-style-type: none"> » welds » aluminum » stainless 	<ul style="list-style-type: none"> • Cleaning and deburring <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Light cleaning, deburring and finishing <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Removing stains, marks, rust, corrosion or oxidation from stainless equipment • Light cleaning of metal surfaces 	<ul style="list-style-type: none"> • Light cleaning and finishing of most surfaces <ul style="list-style-type: none"> » steel, aluminum » denibbling plastic » scuffing acrylics 	<ul style="list-style-type: none"> • Final finishing <ul style="list-style-type: none"> » final rub on wood » final blend on metal » final finish on plastics and acrylics 	<ul style="list-style-type: none"> • Maximum flexibility for consistent finishes • Cleaning blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	<ul style="list-style-type: none"> • Maximum flexibility for consistent finishes • Cleaning blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	<ul style="list-style-type: none"> • Fine cleaning <ul style="list-style-type: none"> » Fine polishing (most surfaces) • Top coat finishing (water-based and solvent) 	<ul style="list-style-type: none"> • Scratch-free cleaning <ul style="list-style-type: none"> » metal » fiberglass » stone » solid surface » ceramic • Wood <ul style="list-style-type: none"> » high-lighting » rubbing

CROSS REFERENCE GUIDE

	← COARSER				FINER →						
NORTON	#740	#746	#644	#747/847	#796	#635	#748	Thin-Flex VF	Thin Flex UF	#456	
3M	7440	7446	64659	7447/8447 Production Hand Pad	96	64660	7448	Multi-Flex Maroon	Multi-Flex Gray	7445	
Camel	Tan	–	–	Maroon	Green	–	Grey	–	–	White	
Mirka	–	–	–	Maroon/Red VF	–	–	–	Mirlon Total Maroon	Mirlon Total Gray	–	
Sait	Brown	–	–	Maroon	Green	–	Gray	–	–	–	
SIA	6912 Brown	6712 Grey	–	6912 Maroon	6312 Green	–	–	–	–	–	
Standard	HD-Tan AO	–	–	GP-Maroon VF	Green-AO	HP-VF	UF Gray	–	–	Cleaning White	

HAND PADS, ROLLS AND SPONGES

				TIER: BEST		BETTER		GOOD	
				BRAND: Norton		Norton		Norton	
SIZE (W x L)	COLOR	DESCRIPTION	ABRASIVE	GRIT SIZE	STD. PKG.	PART #	PART #	PART #	PART #
Hand Pads									
4-1/2 x 9	Maroon	Thin Flex Cleaning Pad	A/O	VF	25	66623398062			
	Grey	Thin Flex Cleaning Pad	S/C	UF	25	66623398063			
	Gold	Thin Flex Blend Prep	A/O	MF	25	66261113519			
6 x 9	Dark Tan	740 Heavy-Duty Pad	A/O	Med	40				66261074000
	Gray	746 Blending Pad	S/C	Med	40				66261074600
	Maroon	777 General Purpose Very Fine Pad	A/O	VF	60				66261077700
	Maroon	747 General Purpose Plus Pad	A/O	VF	60		66261074700		
	Maroon	847 General Purpose Plus Perforated Pad	A/O	VF	60		66261084700		
	Green	796 Scouring Pad	A/O	VF	60				66261079600
	Lt. Green	696 Food Pro Pad	A/O	VF	60				66261069600
	Gray	851 General Cleaning Pad	S/C	VF	40				66261085100
	Gray	635 Clean & Finish Pad	S/C	UF	60				66261063500
	Gray	748 Final Shine Pad	S/C	MF	60				66261074800
White	456 Cleaning Pad	None	-	60				66261045600	
Hand Pad Holder									
3-1/4 x 5-1/2	N/A	Hand Pad Holder			10				66261047583
Rolls									
4" x 30 Ft.	Maroon	High Strength Roll	A/O	M	3		66261006358		
	Dark Tan	740 Heavy-Duty Roll IMPROVED!	A/O	M	3				66261010081
	Maroon	644 General Purpose Fine Roll	A/O	F	4				66261058364
	Maroon	777 General Purpose Very Fine Roll	A/O	VF	4		66261006373		66261058361
	Maroon	747 General Purpose Plus Roll	A/O	VF	4		66261051701		
	Gray	851 General Cleaning Roll	S/C	VF	4				66261058360
	Gray	635 Clean & Finish Roll	S/C	UF	5				66261058357
6" x 30 Ft.	Maroon	High Strength Roll	A/O	M	2		66261005182		
	Maroon	747 General Purpose Plus Roll	A/O	VF	3		66261016430		
	Maroon	777 General Purpose Very Fine Roll	A/O	VF	3		66261004281		66261058376
	Gray	851 General Cleaning Roll	S/C	VF	3				66261058377
2" x 15 Ft. Handy Roll Pack	Assorted	1 each A/O Fine, A/O VF, SC MF	-	-	1				66261008108
Scouring Pads/Sponges									
3-1/4 x 6-1/4 x 3/4	Green/Yellow	893 Scour-N-Sponge Pad	A/O	VF	40				66261059403
3-1/4 x 6-1/4 x 3/4	White/Yellow	875 Clean-N-Sponge Pad	None	-	40				66261059402

BEAR-TEX®



THIN and FLEXIBLE: Perfect for Tight Spots

Norton Bear-Tex Thin-Flex High-Performance Hand Pads

- Achieve performance benefits of a Coarse and Fine grain product in one hand pad: fast cut and definitively better finish than competing pads.
- Extremely thin and conformable; ideal for deburring, cleaning, blending, and finishing contoured surfaces and tight spaces
- Special coated web design for superior and constant cutting action without added effort from user
- Versatile; ideal for woodworking, metalworking, maintenance operations, and synthetics fabrication



When maximum conformability is needed, tough, Norton nylon brushes' flexible nylon filaments embedded with abrasive grain provide exceptional finishing and polishing and eliminate the need for costly and inconsistent hand deburring applications.

Norton nylon brushes are precision-engineered with the highest quality abrasive grains for those markets with the strictest requirements – for easy integration into today's automated machinery, CNC machining centers, transfer lines, robotic cells, and other highly-specialized machinery, as well as hand tools.

Applications:	Deburring, cleaning, finishing, and polishing
Brush Configurations:	Radial wheel brushes, narrow face wheel brushes, disc brushes, end brushes, and twisted brushes
Markets:	Aerospace/aircraft, automotive, construction/utility products, medical, metal finishing, woodworking
Abrasive Grain:	Ceramic Alumina, Silicon Carbide

WHY CHOOSE NYLON ABRASIVE BRUSHES?

- Abrasive grain cutting points are increased as the grain is exposed and cut equally when pressure is applied to the side or tip of the filament
- Uniform distribution of grain throughout the filaments allows cutting and finishing performance levels to remain consistent throughout the life of the brush – making Norton abrasive brushes ideal for automated applications
- Heat- and stress-resistant filaments prolong brush life and allow for superior conformability to irregular surface shapes
- The grain impregnated filaments act as a flexible file to deburr and radius edge profiles with precision, without gouging or affecting the overall geometry of a part
- The filaments bend at various angles to fit contours, creating a less prominent, more uniform surface finish in comparison to wire wheels or coated abrasive products
- Brush conformability allows usage on variety of complex part shapes without the need for ultra-precise programming and fixturing that is required with other deburring and finishing tools

NORTON BLAZE CERAMIC ALUMINA

BEST CHOICE ENGINEERED SPECIFICALLY FOR JOBS REQUIRING CONTROLLABLE SURFACE REFINEMENT AND UNIFORM FINISHING

FEATURES AND BENEFITS

- Norton Blaze sharp, penetrating ceramic alumina nylon brushes are engineered specifically for jobs requiring controllable surface refinement and uniform finishing; the fastest, longest lasting, consistent performers – brush after brush



NORTON SILICON CARBIDE

GOOD CHOICE FOR USE WHERE MAXIMUM CONFORMABILITY IS NEEDED

FEATURES & BENEFITS

- Feature tough, flexible nylon filaments embedded with abrasive grain to provide finishing and polishing where maximum conformability is needed
- Fast cutting silicon carbide abrasive grain



TIER:	GOOD	GOOD
BRAND:	Norton	Norton
ABRASIVE:	Silicon Carbide	Silicon Carbide
GRIT SIZE:	80	120

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
Stock Abrasive Brush				
7 x 1 x 7/8	6,000	5	66261058830	66261058834
Use with air-cooled rubber back-up pad and retainer nut				
Abrasive Brush Back-up Pads				
7" Medium	8,600	5	63642543422	



BACK-UP PAD

Currently, all Norton Blaze ceramic alumina nylon abrasive brushes are custom-made to your exact requirements. The Norton Blaze Nylon Brushes Brochure #8571 provides technical information and product availability. Your Norton representative would be pleased to review availability, quotations, and lead-times with you.

RIGHT ANGLE GRINDER DISCS



Non-woven depressed center discs have three components: strong synthetic fiber mesh and quality abrasives, bonded together by a smear-resistant adhesive. Rapid Strip discs have an open web construction that enables aggressive cutting action while maintaining a cool, non-loading surface. Rapid Blend discs have a unitized construction with varying weave – from open to tighter – for deburring and finishing. Rapid Prep discs have a more open weave that excels in surface preparation and cleaning. Each product provides excellent cutting action while improving surface finish.

Applications: Medium-to-light material removal, deburring, blending, cleaning, finishing, and polishing
 Size Range: 4-1/2" - 7"
 Grit Range: X-Coarse, Coarse, Medium, Fine, Very Fine
 Abrasive Grain: Ceramic Alumina, Silicon Carbide, Engineered Aluminum Oxide, Aluminum Oxide
 Machine Used:



MATERIAL/APPLICATION-TO-PRODUCT RECOMMENDATION GUIDE – FOR ALL DISCS USED ON RIGHT ANGLE GRINDERS

	BEST Highest Productivity; Lowest Total Cost	BETTER Excellent Blend of Performance & Price	GOOD Consistent Performance; Low Initial Price
Removing scale and coarse welding marks	Blaze Rapid Strip Ceramic X/Grse –		Rapid Strip S/C X-Coarse
Removing coatings, epoxy/glue, paint and other clogging material			
Removing rust, oxidation, corrosion and residue			
Removing parting lines and seams on fiberglass parts			
Removing paint/graffiti from concrete/stone			
Removing weld marks and weld splatter	–	Vortex Rapid Blend A/O Coarse	Rapid Blend A/O Coarse
Stainless steel deburring and cleaning			
Removing small flashings and parting lines			
Surface preparation before coatings/plating	–	Vortex Rapid Prep A/O Medium	Rapid Prep A/O Medium
Light cleaning			
Cleaning and prepping welds	–	Vortex Rapid Prep A/O Fine	Rapid Prep A/O Fine
Removing blemishes after welding stainless			
Blending and finishing all metal parts	–	Vortex Rapid Blend A/O Very Fine	Rapid Blend S/C Very Fine
Creating decorative finishes on stainless steel			
Final finishing and polishing			
Final finishing/polishing where high conformability is needed	–	–	Rapid Prep A/O Very Fine

APPLICATION/PRODUCT RECOMMENDATION GUIDE – FOR ALL DISCS USED ON RIGHT ANGLE GRINDERS

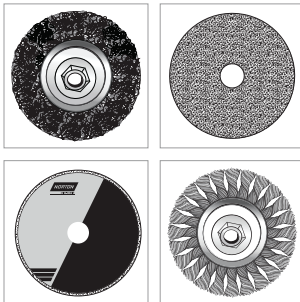
	← MOST AGGRESSIVE / LEAST CONFORMABLE		→ LEAST AGGRESSIVE / MOST CONFORMABLE		
Depressed Center	Blaze Rapid Strip	Vortex Rapid Blend A/O Med. Rapid Blend A/O Coarse	Rapid Blend A/O Medium	Rapid Blend S/C Fine	Rapid Prep Very Fine
Discs With Back-Up Pad		Rapid Prep A/O Coarse	Rapid Prep A/O Medium	Rapid Prep A/O Fine	
Scale Removal	Best Choice				
Stock Removal	Best Choice	Second Choice			
Heavy Deburring	Second Choice	Best Choice			
Light Deburring		Best Choice	Second Choice		
Light Finishing		Second Choice	Best Choice		
Blending			Best Choice	Second Choice	
Finishing			Second Choice	Best Choice	
Polishing				Best Choice	Second Choice

DEPRESSED CENTER DISCS

CROSS REFERENCE GUIDE – FOR ALL DISCS USED ON RIGHT ANGLE GRINDERS

	STRIPPING (EXTRA COARSE)		SURFACE FINISHING (COARSE – MEDIUM – FINE)		SURFACE PREP (VERY FINE)	
	BEST	GOOD	BETTER	GOOD	BETTER	GOOD
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend	Vortex Rapid Prep	Rapid Prep
3M	–	Clean & Strip	–	–	–	SL Surface Conditioning
Bibielle	–	SDR Strip-It/Red	–	BUR Unitized	–	–
Camel	–	EZ Strip Black/Red	–	–	–	–
Flexovit	–	Clean & Strip	–	–	–	–
Hermes	–	Webrax	–	–	–	–
Pearl	–	S/C Stripping	–	–	–	Surface Preparation
Pferd	–	Policlean	–	Poliflex PUR	–	–
Sait	–	Sait-Strip	–	Unitized	–	–
Standard	–	Cleaning	–	Unitized	–	FE, GP, RC
Superior	–	Stripping	–	XL Unitized	–	FD, GD, CC
Walter	–	FX Cleaning	–	–	–	Blendex Surface Conditioning

WHY CHOOSE NON-WOVEN DEPRESSED CENTER 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 an alternative to wire brushes

Blaze Your Way to Greatest Productivity

Norton Blaze Rapid Strip Type 27 Depressed Center Discs

Strip/blend cast iron, steels, aluminum, fiberglass and composites

- Open structure; will not load on sticky coatings, adhesives, and soft metals (e.g. aluminum), or snag and shed like a cloth or fiber disc might
- Norton Blaze ceramic alumina grain provides 2X cut rate and life over silicon carbide
- Will not shed on heavily rust-encrusted pieces
- Extremely versatile; use one disc; stiff enough to stand abuse, but soft enough to prevent gouging and rework
- Use on edge for blending weld root forms
- Apply some pressure to strip or remove coatings; lighter pressure finishes like a surface finishing disc
- Fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap



DEPRESSED CENTER DISCS

NORTON BLAZE RAPID STRIP CERAMIC ALUMINA

BEST CHOICE FOR QUICK AND EASY ROUGH CLEANING AND STRIPPING OF ALL MATERIALS



FEATURES

BENEFITS

- | | |
|--------------------------------------|---|
| • Norton Blaze ceramic alumina grain | • 2X cut rate, 2X life over silicon carbide products |
| • Advanced resin bond | • Does not shed on rust-encrusted pieces, and prevents gouging and rework |
| • Uniform coating process | • Does not snag when used for deburring |
| • Open structure | • Abrasive coating covers the entire disc providing a consistent cut rate |
| | • Sticky coating, adhesives and soft metals will not clog the disc |

TIER:	BEST	GOOD
BRAND:	Norton	Norton
TRADENAME:	BLAZE RAPID STRIP	RAPID STRIP
ABRASIVE:	Ceramic Alumina	Silicon Carbide
GRIT SIZE:	36-50	36-50
GRADE:	X-Coarse	X-Coarse
TYPE/BACKING:	Type 27/Fiberglass	Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #
4-1/2 x 5/8-11	12,000	10	66254498101	66261009585
4-1/2 x 7/8	12,000	10	66623303783	66261009649
5 x 5/8-11	11,000	10	66623303915	
5 x 7/8	11,000	10	66623303916	
7 x 5/8-11	8,000	10	66623303919	66261009650
7 x 7/8	8,000	10	66623303920	66261009586

NORTON VORTEX RAPID BLEND ALUMINUM OXIDE

BETTER CHOICE WITH REVOLUTIONARY TECHNOLOGY FOR HEAVY DEBURRING AND FINISHING



FEATURES

BENEFITS

- | | |
|---|--|
| • Proprietary high-performance, engineered aluminum oxide aggregate grain | • Aggressive, fast stock removal cut rate while providing a fine finish |
| • Superior bond technology | • Twice the wheel life over conventional unified wheels, with minimal shedding |
| • Controlled porosity | • Consistent performance with no smearing |
| | • Cooler and improved cut rate |



TIER:	BETTER	GOOD	GOOD	GOOD	GOOD
BRAND:	Norton	Norton	Norton	Norton	Norton
TRADENAME:	VORTEX RAPID BLEND	RAPID BLEND	RAPID BLEND	RAPID BLEND	RAPID BLEND
ABRASIVE:	Engineered A/O	Aluminum Oxide	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
GRIT SIZE:	100-120	150-180	220-280	320-400	150-180
SPECIFICATION:	Medium	NEX-2AM	NEX-2AF	NEX-2SVF	High Strength Medium
TYPE/BACKING:	Type 27/Fiberglass	Type 27/Fiberglass	Type 27/Fiberglass	Type 27/Fiberglass	Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
4-1/2 x 5/8-11	12,000	10	66254429243	66261023947	66261023946	66261023943	66261023949
4-1/2 x 7/8	12,000	10	66254429268	66261020548	66261020547	66261020546	66261020549

STANDARD BACK-UP PAD DISCS

NORTON VORTEX RAPID PREP ALUMINUM OXIDE DISCS

BETTER CHOICE FOR FINISHING AND BLENDING APPLICATIONS

FEATURES

BENEFITS

- Proprietary, engineered Vortex aluminum oxide abrasive grain, new coating method, and smear-free Clean-Bond technology
- Most consistent cutting and finishing surface conditioning products on the market
- Combine maximum cutting speed with the finish of fine grits
- Reduce process times by 50+% by eliminating 2 to 5 grit sequences to 1 step in your technical blending operations
- More resistant to edge wear; up 4X life vs. competitive products
- Friable grain structure keeps Ra specs throughout disc life and reduces scrap and rework



7/8" Center Hole

		TIER: BETTER	GOOD
		BRAND: Norton	Norton
		TRADENAME: VORTEX RAPID PREP	RAPID PREP
		ABRASIVE: Engineered Aluminum Oxide	Aluminum Oxide
SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
4-1/2	25	66623334973	66623326070
5	25	66623334975	66261090645
6	25	66623341359	
7	25	66623341360	66623326085
Coarse			
4-1/2	25	66623334944	66254473868
5	25	66623334946	66261008293
6	25	66623341361	66623325136
7	25	66623341362	66623325138
Medium			
4-1/2	25	66623333612	66623325915
5	25	66623334963	66261017124
6	25	66623341363	66623325918
7	25	66623341364	66623325919
Fine			
4-1/2	25	66623333608	66623325153
5	25	66623334954	66254469132
6	25	66623341365	66623325159
7	25	66623341366	66623325897
Very Fine			
4-1/2	25	66623333616	66623325938
5	25	66623333618	66623325943
6	25	66623341367	66623325958
7	25	66623341368	66623325959



DESCRIPTION	MAX. RPM	STD. PKG.	PART NO.
Rapid Prep Disc Back-up Pads			
4-1/2" Medium	11,000	5	63642502122
5" Medium	10,000	5	63642543421
7" Medium	8,600	5	63642543422

All Rapid Prep 7/8" center hole discs are non-stock. Ask your Norton representative for current lead-times.

Norton Rapid Prep Surface Conditioning Products

The Perfect Abrasive, Coating, and Bond Built into Every Disc and Belt

- Available in premium Vortex aluminum oxide aggregate grain and Norton aluminum oxide grain; ideal for many aerospace, metal and stainless steel fabrication, and MRO applications
- Our proprietary coating method extends life and delivers consistent finishes by creating a thick layer of grain throughout the product. Grain does not sit on top of fibers as other competitive products can.
- Our new Clean Bond resin system guarantees smear-free finishes, even on high nickel content alloys; will not load on aluminum and soft metals, as competitive products can



SPEED-CHANGE DISCS

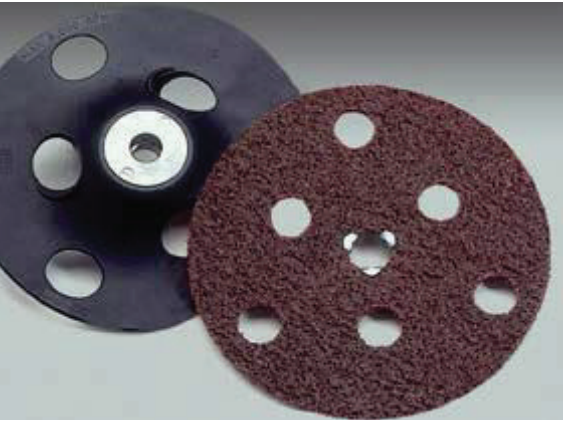
RAPID PREP AVOS SPEED-LOK ALUMINUM OXIDE

GOOD CHOICE FOR LIGHT DEBURRING, CLEANING AND FINISHING

FEATURES

BENEFITS

- Patented hole design
- Scooped holes
- 15 degree angle back-up pad
- Allows interrupted cut, reducing heat up to 30% over standard surface preparation discs
- Cool cutting results in longer disc life
- Provides complete vision into the grinding zone
- Operators can grind more accurately with less re-work
- Create air flow to pull loose abrasive and swarf away from work surface grinding zone – resulting in extended disc life
- Grinding at 5°-15° angle allows greater utilization of disc surface
- Eliminates gouging of workpiece



AVOS Speed-Lok

TIER:	BETTER	GOOD	
BRAND:	Norton	Norton	
TRADENAME:	VORTEX RAPID PREP AVOS	RAPID PREP AVOS	
ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide	
SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
5	10	66623374801	
Coarse			
4-1/2	10		66261010447
5	10		66623374818
7	10		
Medium			
4-1/2	10	66623374806	66261010448
5	10		66623374819
Very Fine			
4-1/2	10		66623374823
5	10		66623374824
7	10	66623374814	



DESCRIPTION	MAX. RPM	STD. PKG.	PART #
AVOS Speed-Lok Back-up Pads – Triangular			
4-1/2 x 5/8-11	13,000	5	63642502985
5 x 3/8-24 Pistol Grip*	20,000	5	63642503029
5 x 5/8-11 Thicker	13,000	5	63642502517
5 x 5/8-11	13,000	5	63642503663
5 x 7/16-20 Pistol Grip*	20,000	5	63642503030
AVOS Speed-Lok Back-up Pads – Round			
7 x 5/8-11 Hard	8,600	5	63642504873

* Use on air pneumatic and high-speed pistol grip sanders.

Speed Change 5/8"-11

TIER:	BETTER	GOOD	
BRAND:	Norton	Norton	
TRADENAME:	VORTEX RAPID PREP	RAPID PREP	
ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide	
SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
4-1/2	25	66623373667	66623373690
5	25	66623373669	
7	25	66623373670	66623373692
Coarse			
4-1/2	25	66623373671	66623373693
5	25	66623373674	66254498516
7	25	66623373675	66261192908
Medium			
4-1/2	25	66623373678	66623308157
5	25	66623373679	66623373694
7	25	66623373680	66261192913
Fine			
4-1/2	25	66623373681	
5	25	66623373682	66623373695
7	25	66623373684	
Very Fine			
4-1/2	25	66623373685	
5	25	66623373686	66623373699
7	25	66623373687	66623373700



DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Smooth-Face Back-up Pads for 5/8-11 Speed-Change Discs			
4-1/2" Medium	20,000	5	66254492277
5" Medium	12,000	5	63642543235
7" Hard	8,600	5	63642543240
7" Medium	8,600	5	63642543245
7" Soft	8,600	5	63642543250
9" Medium	7,000	5	63642543270

Non-Woven Hook and Loop Discs

NORTON VORTEX RAPID PREP

BETTER CHOICE FOR FINISHING AND BLENDING APPLICATIONS

FEATURES

BENEFITS

- Proprietary engineered Vortex aluminum oxide abrasive grain and coating method
- Clean Bond resin system, aerospace-tailored
- Strong hook and loop backing
- Most consistent cutting and finishing of surface conditioning products on the market
- Combine maximum cutting speed with the finish of finer grits
- Reduce process times by 50+% by combining multiple grit sequences to 1 step in a blending operation
- More resistant to edge wear; up 4X life vs. competitive products
- Friable grain structure keeps Ra specs throughout disc life and reduces scrap and rework
- Smear-free, even on high nickel content alloys
- Will not load on aluminum and soft metals, as competitive products can
- Will not fly off rotary sanders
- Discs sit flatter on back-up pads, resulting in a more consistent finish on DA applications



TIER:	BETTER	GOOD
BRAND:	Norton	Norton
TRADENAME:	VORTEX RAPID PREP	RAPID PREP
ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide

SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
1-1/2	50	66623325061	66623340098
2	50	66623334970	66261017900
3	25	66623333620	66623326059
4	25	66623334971	66261017382
4-1/2	25	66623334972	66261017906
5	25	66623334974	66261017215
6	25	66623333621	66623326077
7	25	66623334976	66261192846
8	25	66623334977	
Coarse			
1-1/2	50	66623325057	66623340099
2	50	66623334882	66261004431*
3	25	66623334883	66261055015
4	25	66623334884	66261055018
4-1/2	25	66623334943	66261017806
5	25	66623334945	66261004435
6	25	66623334949	66261006910
7	25	66623334951	66261055027
8	25	66623334953	66261006913
Medium			
1-1/2	50	66623325059	66623338571
2	50	66623334958	66261004441
3	25	66623334956	66261004442
4	25	66623334959	66261055019
4-1/2	25	66623334961	66261004444
5	25	66623334962	66261055022
6	25	66623334964	66261006911
7	25	66623334965	66261017813
8	25	66623334966	66261017815
Fine			
1-1/2	50	66623325058	66623340101
2	50	66623333604	66623325141
3	25	66623333605	66623325143
4	25	66623333606	66623325145
4-1/2	25	66623333607	66623325147
5	25	66623333609	66623325154
6	25	66623333610	66623325160
7	25	66623334955	66261199465
8	25	66623333611	66623325907

* Standard Package = 80
Continued

Non-Woven Hook and Loop Discs continued

		TIER: BETTER	GOOD
		BRAND: Norton	Norton
		TRADENAME: VORTEX RAPID PREP	RAPID PREP
		ABRASIVE: Engineered Aluminum Oxide Aluminum Oxide	
SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Very Fine			
1-1/2	50	66623325060	66623340100
2	50	66623333613	66623325926
3	25	66623333614	66623325934
4	25	66623334967	66261055020
4-1/2	25	66623333615	66623325936
5	25	66623333617	66623325941
6	25	66623334968	66261055026
7	25	66623334969	66261019990
8	25	66623333619	66623325972

Back-Up Pads for Hook And Loop Discs

				TIER: GOOD	GOOD	
				BRAND: Norton	Merit	
PAD DIAMETER	SPINDLE OR HOLE SIZE	MAX. RPM	3M EQUIVALENT	STD. PKG.	PART #	PART #
Back-Up Pads for Hook And Loop Discs						
2	1/4 Steel Shank	23,000	922	5	66261059352	08834168025*
3	1/4 Steel Shank	20,000	923	5	66261059354	08834168026*
4	1/4 Steel Shank	18,000	924	5	66261059356	
	5/8-11	13,000	914	5	66261059304	08834168984*
	M10 x 1.250	13,000		5	66261059305	
4-1/2	5/8-11	10,000	9145	5	66261006948	05539562718
5	5/16-24 Male	10,000	905	5	66261059360	08834168993**
	3/8-24 Male	10,000	905	5	66261059308	
	5/8-11	10,000	915	5	66261059310	08834168967*
6	5/8-11	8,000	916	5	66261059312	05539562723
7	5/8-11	6,000	917	5	66261059368	08834168032*
8	5/8-11	4,500	918	5	66261059372	

* = 1 per Pkg, ** = 2 Per Std Pkg.





Norton and Merit non-woven quick-change discs are a combination of strong synthetic mesh and quality abrasives, bonded together by a smear-resistant adhesive. 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, and decorative finishing
- Size Range: 3/4" – 4" diameter
- Grit Range: X-Coarse, Coarse, Medium, Fine, Very Fine, Super Fine
- Abrasive Grain: Ceramic Alumina, Engineered Aluminum Oxide, 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
- Machine Used:



QUICK-CHANGE ATTACHMENT SYSTEMS AND CROSS REFERENCE GUIDE

Each system enables quick, tool-free, safe disc changes, reducing downtime and operating expenses.

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)

- Features a snap-on/snap-off style fastener
- Fastener is made of nylon



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

APPLICATION/GRIT RECOMMENDATION GUIDE

MOST AGGRESSIVE

LEAST AGGRESSIVE

	Rapid Strip	Vortex Rapid Blend	Vortex Rapid Prep	Rapid Prep	HS Buffing, Buffing
NORTON					
MERIT		Deburring & Blending			
Scale Removal	Best Choice				
Stock Removal	Best Choice	Second Choice			
Heavy Deburring	Second Choice	Best Choice			
Light Deburring		Best Choice	Second Choice		
Light Finishing			Best Choice	Second Choice	
Blending			Best Choice	Second Choice	
Cleaning			Second Choice	Best Choice	
Finishing				Best Choice	Second Choice

CROSS REFERENCE GUIDE

	STRIPPING			HEAVY/LIGHT DEBURRING		LIGHT DEBURRING/BLENDING/CLEANING/FINISHING	
	BEST	GOOD	BETTER	GOOD	BETTER	GOOD	GOOD
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend	Vortex Rapid Prep	Rapid Prep	
MERIT				Deburring & Blending			HS Buffing, Buffing
3M	-	Clean & Strip Clean Strip XT	-	EXL Unitized	-	Surf Cond, SL, SE	-
Standard	-	Cleaning Disc	-	500-900 Series Unitized	-	FE, GP, RC	Buff & Blend - HS, Buff & Blend
Fiberal/SIA	-		-		-	Meteor, Type B & C	-
Superior	-	Type R	-	XL Unitized	-	FD, GD, CC	HS, HD A/O
Arc	-	Arcstrip	-	-	-	Surface Cond	Blend & Finish
Pferd	-	Policlean	-	-	-	Finishing Disc - Hard & Soft	-
Sait	-	SAIT-Strip	-	-	-	HD, GP	Sand-Light Blending
Camel	-	EZ Strip - Black	-	-	-	-	-
Klingspor	-	Strip-It Black	-	-	-	-	-
Garryson	-		-	-	-	Surface Cond	-
Bibielle	-		-	BUR Unitized	-		-

ABRASIVE/GRIT/DENSITY KEY

ABRASIVE	SILICON CARBIDE			ALUMINUM OXIDE		CERAMIC ALUMINA
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN			MORE DURABLE, LONGER LASTING, POLISHED FINISH		
GRIT SIZE	XC (24-36)	C (50-80)	M (100-150)	F (180-220)	VF (240-360)	SF (400-600)
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH			REDUCED CUT RATE, FINER FINISH		
DENSITY	2			9		
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING			HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH		

Quick-Change Rapid Strip Discs

NORTON BLAZE RAPID STRIP CERAMIC ALUMINA AND NORTON RAPID STRIP SILICON CARBIDE

BEST CHOICE IDEAL FOR REMOVING COATINGS ON A VARIETY OF SUBSTRATES, SUCH AS WOOD, METAL AND PLASTICS

FEATURES

- Manufactured with extruded nylon fibers, flexible resin technology, and extra-coarse abrasive grains
- Rapid Strip Blaze

BENEFITS

- Provide a unique combination of aggressive performance, long life, improved finish
- Outperform traditional coated abrasive products, leaving a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as coating, painting and soldering
- Great alternative to wire brushes
- Will not load on sticky coatings, adhesives, and soft metals, or snag and shed like a fiber disc
- 2X faster cutting than competitive discs; lasts 2X (plus) as long
- Stiff enough to stand abuse; soft enough to prevent gouging and rework. Apply some pressure to strip/remove coatings; lighter pressure finishes like a surface finishing disc

TIER: **BEST**

BRAND: Norton

TRADENAME: BLAZE RAPID STRIP

ABRASIVE: Ceramic Alumina

GRADE: XC

ATTACHMENT: TR (Type III)



GOOD

Norton

RAPID STRIP

Silicon Carbide

XC

TR (Type III)



GOOD

Norton

RAPID STRIP

Silicon Carbide

XC

TS (Type II)



SIZE (DIAMETER)	MAX. RPM	STD. PKG.	PART #	STD. PKG.	PART #	STD. PKG.	PART #
2 x 1/2	15,500	25	66623303912	10	66261013402		
3 x 1/2	12,000	25	66261096557	10	66261013403	25	66623333374
4 x 1/2 TR+	8,000	5	66623303921	5	66261016580		

Refer to the end of this section for a list of quick-change back-up pads.

Deburring & Blending Unified Discs

NORTON BLAZE RAPID BLEND CERAMIC ALUMINA

REVOLUTIONARY TECHNOLOGY FOR HEAVY DEBURRING AND FINISHING

FEATURES & BENEFITS

- Norton Blaze SG ceramic alumina grain provides quickest cut rate and up to 8X longer life than competitive aluminum oxide discs
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing
- New construction: abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used – versus competitive discs' one bottom layer of abrasive
- 3 - 8 times the life of competitive surface blending discs with fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap

NORTON VORTEX RAPID BLEND ALUMINUM OXIDE

REVOLUTIONARY TECHNOLOGY FOR HEAVY DEBURRING AND FINISHING

FEATURES & BENEFITS

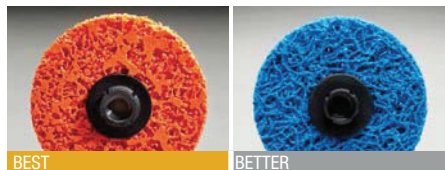
- Proprietary engineered Vortex aluminum oxide aggregate grain performs the medium to fine grit steps of traditional discs in an easy one-step operation
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing
- New construction: abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used – versus competitive discs' one bottom layer of abrasive
- 3 - 8 times the life of competitive surface blending discs with fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap

NORTON RAPID BLEND ALUMINUM OXIDE

GOOD CHOICE FOR LIGHT DEBURRING, BLENDING, AND CLEANING

FEATURES & BENEFITS

- Open mesh construction is waterproof, washable, conformable, and non-loading: designed for surface generation where stock removal is not required
- New construction: abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used – versus competitive discs' one bottom layer of abrasive
- 3 - 8 times the life of competitive surface blending discs with fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap
- No smearing



TIER:	BEST	BETTER
BRAND:	Norton	Norton
TRADENAME:	BLAZE RAPID BLEND	VORTEX RAPID BLEND
ABRASIVE:	Ceramic Alumina	Engineered Aluminum Oxide
ATTACHMENT:	TS (Type II)	TS (Type II)



SIZE (D x T)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #
1 x 1/4	Ceramic Alumina	XC	1	35,100	100	66623313920	
1-1/2 x 1/4	Ceramic Alumina	XC	1	35,100	80	66623313922	
2 x 1/4	Ceramic Alumina	XC	1	12,100	25	66623313925	
	Aluminum Oxide	M	1	12,100	25		66254497070
3 x 1/4	Ceramic Alumina	XC	1	12,100	25	66623313931	
	Aluminum Oxide	M	1	12,100	25		66254497069

Refer to the end of this section for a list of quick-change back-up pads.

Deburring & Blending Unified Discs continued



TIER:	BEST	BETTER	GOOD	GOOD
BRAND:	Norton	Norton	Norton	Merit
TRADENAME:	BLAZE RAPID BLEND	VORTEX RAPID BLEND	RAPID BLEND	DEBURR/BLEND
ABRASIVE:	Ceramic Alumina	Engineered Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
ATTACHMENT:	TR (Type III)	TR (Type III)	TR (Type III)	TR (Type III)

SIZE (D x T)	ABR.	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
1 x 1/4	C/A	XC	1	35,100	100	66623313919			
1-1/2 x 1/4	C/A	XC	1	35,100	80	66623313921			
2 x 1/8	A/O	M	4-6	22,000	60		66254425632		
	A/O	M	7-9	22,000	60		66254433509		
2 x 3/16	A/O	M	2-3	22,000	60		66254428236		
2 x 1/4	C/A	XC	1	35,100	25	66623313923			
	A/O	C	7-9	22,000	60			66261014921	66261054187
	A/O	M	1	12,100	25		66254497067		
	A/O	M	2-3	22,000	60		66254428237	66261014897	66261054183
	A/O	M	4-6	22,000	60		66254413660	66261014911	66261054185
	A/O	M	7-9	22,000	60		66254433510	66261014935	66261054186
	S/C	F	2	22,000	60			66261014889	
	S/C	F	3	22,000	60			66261017306	
	S/C	F	2-3	22,000	60				66261054182
	S/C	F	4-6	22,000	60				66261054184
3 x 1/8	A/O	C	7-9	15,000	40				
	A/O	M	2-3	15,000	40				
	A/O	M	4-6	15,000	40		66261093556		
	A/O	M	7-9	15,000	40		66261090909		
	A/O	F	2-3	15,000	40				
	A/O	F	4	15,000	40				
3 x 3/16	A/O	F	6	15,000	40				
3 x 1/4	A/O	M	7-9	15,000	40		66254428239		
	C/A	XC	1	12,100	25	66623313930			
	A/O	C	7-9	15,000	40			66261014922	66261054198*
	A/O	M	1	12,100	25		66254497068		
	A/O	M	2-3	15,000	40		66254428238	66261014898	66261054193*
	A/O	M	4-6	15,000	40		66254413661	66261014912	66261054196*
	A/O	M	7-9	15,000	40		66254406395	66261014936	66261054197*
	A/O	F	2-3	15,000	40				66261054192*
	A/O	F	4-6	15,000	40			66261015419	66261054194*
	S/C	F	2	15,000	40			66261014890	
	S/C	F	3	15,000	40			66261016005	
	S/C	F	4-6	15,000	40				66261054195*

* Std. Pkg. = 20 discs

For additional unified wheels – with arbor holes – see the non woven unified wheel section. Refer to the end of this section for a list of quick-change back-up pads.

Surface Preparation Discs

NORTON VORTEX RAPID PREP ALUMINUM OXIDE

BETTER CHOICE FOR FINISHING AND BLENDING APPLICATIONS

FEATURES & BENEFITS

- Proprietary engineered Vortex aluminum oxide abrasive grain and coating method combine maximum cutting speed with the consistent finish of finer grits to reduce process times by 50+% by combining multiple grit sequences to 1 step
- More resistant to edge wear; up 4X life versus competitive products; friable grain structure keeps Ra specs throughout disc life, reducing scrap/rework; extended form holding; lowest total cost of consumable tooling per workpiece
- Clean Bond resin system, aerospace-tailored, remains smear-free, even on high nickel content alloys; will not load on aluminum and soft metals, as competitive products can

NORTON RAPID PREP ALUMINUM OXIDE

GOOD CHOICE FOR FINISHING AND BLENDING APPLICATIONS

FEATURES & BENEFITS

- Clean Bond resin system, aerospace-tailored, remains smear-free, even on high nickel content alloys; will not load on aluminum and soft metals, as competitive products may
- Proprietary coating method; thick layer of grain throughout the product extends life; grain does not sit on top of fibers as other competitive products can

TIER:	BETTER	GOOD	BETTER	GOOD	BETTER	GOOD
BRAND:	Norton	Norton	Norton	Norton	Norton	Norton
TRADENAME:	VORTEX RAPID PREP	RAPID PREP	VORTEX RAPID PREP	RAPID PREP	VORTEX RAPID PREP	RAPID PREP
ABRASIVE:	Engineered A/O	Aluminum Oxide	Engineered A/O	Aluminum Oxide	Engineered A/O	Aluminum Oxide
ATTACHMENT:	TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)	TP (Type I)	TP (Type I)

SIZE (DIAM.)	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
Extra Coarse							
3/4	50	66623325001	66623340002	66623335324	66261022401	66623325000•	66623340000
1	50	66623325004•	66623340007•	66623325003	66623340006	66623325002	66623340004
1-1/2	50	66623325007	66623340011	66623325006	66623340010	66623325005	66623340008
2	50	66623335326	66261016373	66623335325	66261017819	66623325008	66623340012
3	25	66623335327	66261016994	66623325010	66261017818	66623325009	66623340015
4	25	66623335329	66261016374	66623335328	66623310706	66623325011	66623340018
Coarse							
3/4	50	66623325013	66623340021	66623335410	66261095015	66623325012•	66623340020•
1	50	66623325015	66623340023	66623335537	66261024310	66623325014	66623340022
1-1/2	50	66623335411	66261047579	66623325017	66623340026	66623325016	66623340024•
2	50	66623335414	66261004437	66623335413	66261009183	66623335412•	66254498593
3	25	66623335417	66261009194	66623335416	66261009186	66623335415	66254498596
4	25	66623335419	66261008822	66623335418	66261055349	66623325018	66623340030
Medium							
3/4	50	66623325020	66623340032	66623335420	66254428059	66623325019	66623340031•
1	50	66623335422	66254482331	66623335421	66254482327	66623325021	66623340033
1-1/2	50	66623335424	66254482332	66623335423	66254482328	66623325022	66623340034•
2	50	66623335427	66261009190*	66623335426	66261009182	66623335425•	66254498520
3	25	66623335430	66261017522	66623335429	66261009185	66623335428	66254498595
4	25	66623335432	66261008821	66623335431	66261055350	66623325023	66623340039
Fine							
3/4	50	66623325026	66623340058	66623325025	66623340056	66623325024•	66623340054•
1	50	66623325029	66623340064	66623325028	66623340062	66623325027•	66623340060
1-1/2	50	66623325032	66623340070	66623325031	66623340068	66623325030•	66623340066•
2	50	66623325035	66623340077	66623325034	66623340074	66623325033	66623340072
3	25	66623325038	66623340085	66623325037	66623340082	66623325036	66623340080
4	25	66623325041	66623340092	66623325040	66623340090	66623325039	66623340088•
Very Fine							
3/4	50	66623325044	66623340044	66623325043	66623340042	66623325042	66623340041•
1	50	66623325047	66254482339	66623325046	66254482335	66623325045•	66623340045
1-1/2	50	66623325050	66254482340	66623325049	66254482336	66623325048•	66623340046•
2	50	66623335433	66261009189*	66623325052	66254482337	66623325051•	66254498594
3	25	66623335437	66261009192	66623335436	66261009184	66623325053•	66254498597
4	25	66623325056	66623340053	66623325055	66623340052	66623325054	66623340051
Super Fine							
2	50		66261091459				
3	25		66261091460				

• Non-stock. Ask your Norton representative for current lead-times and order quantities

Surface Preparation Stars

MERIT SURFACE PREPARATION STARS

THE PERFECT ITEM FOR ID WORK

- | FEATURES | BENEFITS |
|------------------|--|
| • Star shape | • Penetrates the ID and polishes or cleans the surface without disturbing any tolerances |
| • 1/4-20 eyelets | • Attach to Merit MM20-4 mandrel, Part # 08834183164 (See description at end of Overlap Slotted Disc Section.) |

TIER: **GOOD**
 BRAND: Merit
 TRADENAME: SURFACE PREP
 ABRASIVE: Aluminum Oxide
 ATTACHMENT: 1/4-20 Eyelet

SIZE (D x EYELET)	GRIT	STD. PKG.	PART #
1-1/2" x 1/4-20	C	100	08834185923
	M	100	08834185924
	VF	100	08834185925
2" x 1/4-20	C	100	08834185926
	M	100	08834185927
	VF	100	08834485928
3" x 1/4-20	C	100	08834185929
	M	100	08834185678
	VF	100	08834185931
4" x 1/4-20	C	100	08834185932
	M	100	08834185933
	VF	100	08834185934

2", 3" and 4" Merit Surface Prep Stars are non-stock. Ask your Norton/Merit representative for lead-times.

Cross Buffs

MERIT CROSS BUFFS

EXCELLENT FOR BLENDING, POLISHING AND ID USAGE

- | FEATURES | BENEFITS |
|-----------------|---|
| • Unique design | • Durable non-woven construction that delivers longer life and cool running |
| • 8-32 eyelets | • Attach to Merit MM32-4 mandrel. Part No. 08834183163 (See description at end of Overlap Slotted Disc Section) |

TIER: **BETTER** **GOOD**
 BRAND: Merit Merit
 TRADENAME: HIGH STRENGTH BUFFING
 ABRASIVE: Aluminum Oxide Aluminum Oxide
 ATTACHMENT: 8-32 Eyelet 8-32 Eyelet

SIZE (D x W)	GRIT	PLY	STD. PKG.	PART #	PART #
1-1/2 x 1/2	Coarse	2	100		08834188761
	Medium	2	100	08834189306	08834187312
	Very Fine	2	100	08834189307	08834188585
1-1/2 x 1/2	Coarse	3	100		66623301763
	Medium	3	100	08834189308	08834187311
	Very Fine	3	100	08834189309	08834188586

Buffing/Polishing Discs

NORTON & MERIT BUFFING/POLISHING DISCS

DESIGNED FOR LIGHT REMOVAL OF PAINT OR RUST

FEATURES

- High-strength discs
- For light removal of paint or rust

BENEFITS

- Tough, yet conformable, and resist tearing on burrs and sharp edges
- Smear-proof
- Does not affect the base product

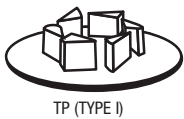
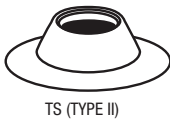
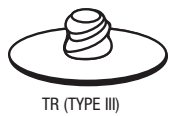
TIER: **BEST**
 BRAND: Norton
 TRADENAME: HIGH-STRENGTH
 ABRASIVE: Aluminum Oxide
 ATTACHMENT: TR (Type III)

BETTER	BETTER	GOOD	GOOD	GOOD
Merit	Merit	Merit	Merit	Merit
HIGH-STRENGTH	HIGH-STRENGTH	BUFFING	BUFFING	BUFFING
Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
TR (Type III)	TS (Type II)	TR (Type III)	TS (Type II)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART #	STD. PKG.	PART #	PART #	PART #	PART #	PART #
1-1/2	M			100			08834166368	08834166392	08834166292
	F			100			08834166369		08834166332
2	C			50			08834161649	08834166394	08834161627
	M	160	66261014792	50	08834164064	08834164244	08834166303	08834166395	08834166280
	F			50			08834166304	08834166396	08834166281
3	VF			50	08834163987	08834164245	08834166305	08834166405	08834166282
	C			25			08834161651	08834166397	08834166293
	M	80	66261014793	25	08834164065	08834164252	08834166308	08834166398	
	F			25			08834166309	08834166399	08834166285
	VF			25	08834163559	08834164255	08834166310	08834166403	08834166286

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



TIER: **GOOD**
 BRAND: Norton
 ATTACHMENT: TR (Type III)

GOOD	GOOD	GOOD	GOOD	GOOD
Merit	Merit	Norton	Merit	Merit
TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)	TP (Type I)

SIZE (DIAMETER)	MAX. RPM	DENSITY	PART #	PART #	PART #	PART #	PART #
Quick-Change Back-up Pads							
3/4"	40,000	Medium		08834164038		08834164206	08834164001
1"	40,000	Medium		08834164037		08834164651	08834164002
1-1/2"	30,000	Hard				08834164622	08834163996
		Medium	66261047580	08834161174		08834164146	08834164003
2"	30,000	Hard		08834164643	63642543205	08834164624	08834163997
		Medium	66261055103	08834164922	63642543210	08834164198	08834164004
		Soft		08834164641		08834161625	08834163949
3"	20,000	Hard	63642504900	08834164036	63642543220	08834161626	08834163998
		Medium	66261055105	08834164949	63642543225	08834164113	08834164005
		Soft		08834164644		08834164626	08834163948
4"	15,000	Medium	66261047581	08834164655	63642543232	08834164135	08834164006
4" TR+	8,000	Medium	66261016581	63642555106			

All quick-change back-up pads have a 1/4" diameter shank. Std. Pkg. = 1

Refer to the end of the Coated Abrasive Quick-Change Discs section for a complete list of back-up pads and mandrels.

ARBOR HOLE (GANGABLE) DISCS

Non-Woven High Strength Discs

NORTON & MERIT HIGH STRENGTH AND FASTCUT DISCS

BETTER CHOICE FOR LIGHT DEBURRING AND FINISHING

FEATURES

- Firm, durable web
- Tough, yet conformable
- Strong, smear-proof resin binders

BENEFITS

- High resistance to tearing on burrs and sharp edges
- Can be "ganged" together and used as a wheel
- Produce light satin finishes

Applications include rust/oxide or coating removal, pipe ID and OD polishing, casting cleaning, highlighting (antiqing), contaminant removal, removal of handling marks, gasket removal, cleaning and blending of surface imperfections, prepping prior to soldering, removal of filling materials, cleaning and odd shapes. Will not stretch or shed. Ganging increases versatility.

TIER:	BEST	BETTER	GOOD
BRAND:	Norton	Norton	Merit
TRADENAME:	FAST CUT	HIGH STRENGTH	HIGH STRENGTH
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	STD. PKG.	PART #
6 x 1/4	VF	4,000	70				
6 x 1/2	M	4,000	70			25	08834162410
	F	4,000	70			25	08834167735
	VF	4,000	70	66261000601		25	08834162411
8 x 1/2	M	3,000	50			25	08834162412
	VF	3,000	50			25	08834162413
12 x 1-1/4	VF	1,900	25				



FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	PART #
Mandrel Assemblies For Using Discs On Edge							
1/4"	1/2" (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	66261009502
1/2"	1/2" (Standard)	Up to 8"	1/4"	3-1/8"	2-1/4"	1	66261059420

Non-Woven Disc Wheels

MERIT DISC WHEELS

GOOD CHOICE FOR LIGHT DEBURRING AND FINISHING

FEATURES

- Discs are "ganged" together to form a wheel
- Strong and durable

BENEFITS

- Mounted on a 1/4" steel mandrel embedded in an epoxy core
- Strong and durable

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide

SIZE (D x W x 1/4 SHANK)	GRIT	PLY	MAX. RPM	STD. PKG.	PART #
2 x 1/2	Medium	2 Ply	12,000	10	08834131551
2 x 1	Medium	4 Ply	12,000	10	08834131554
3 x 1/2	Medium	2 Ply	8,000	10	08834131558
	Very Fine	3 Ply	8,000	10	08834131560
3 x 1	Medium	4 Ply	8,000	10	08834131496
	Fine	5 Ply	8,000	10	08834131557
	Very Fine	5 Ply	8,000	10	08834131497
4 x 1/2	Fine	3 Ply	6,000	10	08834131562
4 x 1	Medium	4 Ply	6,000	10	08834131564
5 x 1/2	Medium	2 Ply	4,000	10	08834131567
5 x 1	Medium	4 Ply	4,000	10	08834131570
	Fine	5 Ply	4,000	10	08834131571

Disc wheels are constructed by number of plies. The actual face width will vary and will not match the listed width exactly. Discs given for reference only.

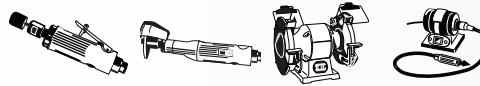
Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. The industry's broadest offering is available for light stock removal, deburring, blending, finishing and polishing. Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

Applications: Cleaning and removing imperfections on metal surfaces, cleaning built-up residue, deburring or finishing a variety of surfaces, blending weld seams or creating decorative finishes. Non-woven surface finishing products have excellent versatility.

Abrasive Grain: Ceramic Alumina, Engineered Aluminum Oxide, Aluminum Oxide, Silicon Carbide

Grit Range: Extra Coarse (XC), Coarse (C), Medium (M), Fine (F),

Machine Used:



APPLICATION/GRIT RECOMMENDATION GUIDE

	MOST AGGRESSIVE							LEAST AGGRESSIVE	
NORTON	Rapid Strip Wheels	Rapid Blend Unified Wheels	Rapid Finish GP Convolute Wheels	Metal Finishing Convolute Wheels	Clean & Finish Convolute Wheels	Light Finishing Convolute Wheels	Non-Woven / Interleaf Flap Wheels		
Scale Removal	Best Choice								
Stock Removal		Best Choice	Second Choice						
Heavy Deburring		Best Choice	Second Choice						
Decorative Finishing				Best Choice	Second Choice				
Blending			Best Choice	Second Choice					
Cleaning				Second Choice	Best Choice				
Light Deburring			Second Choice			Best Choice			
Light Finishing			Second Choice			Best Choice			
Polishing						Best Choice		Second Choice	
Buffing								Best Choice	

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 High Rms Reading	Smooth Surface Lower Rms Reading
1. Wheel Speed	Slow	Fast
2. Feed Speed	Faster (Long Scratch)	Slower (Short Scratch)
3. Oscillation	No Oscillation	Oscillation
4. Lubricants	Dry	Water
		Soluble Oil
		Straight Oil
		Compounds

NON-WOVEN MARKING SYSTEM

ABRASIVE	SILICON CARBIDE	ALUMINUM OXIDE
	← SHARPER, FINER/BRIGHTER SCRATCH PATTERN	→ MORE DURABLE, LONGER LASTING, POLISHED FINISH
GRIT SIZE	XC (24-36)	C (50-80) M (100-150) F (180-220)
	← FASTER, AGGRESSIVE CUT, ROUGHER FINISH	→ REDUCED CUT RATE, FINER FINISH
DENSITY	2	9
	← SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING	→ HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH

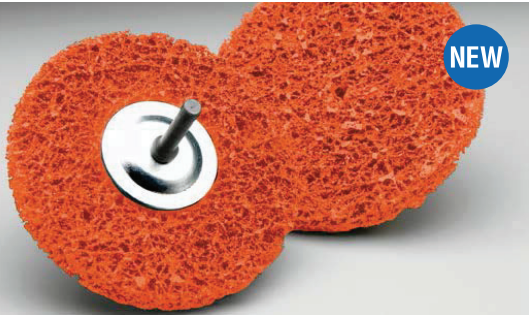
CROSS REFERENCE GUIDE

	STRIPPING		HEAVY/LIGHT DEBURRING		LIGHT DEBURRING/BLENDING/POLISHING			CLEANING/FINISHING			
	BEST	GOOD	BEST	GOOD	BEST	BEST	BETTER	BEST	BEST	BEST	GOOD
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	NEX Rapid Blend	Rapid Finish GP	Series 4000	Series 1000	Light Finishing	Metal Finishing	Clean & Finish	Non-Woven / Interleaf Flap Wheels
3M		Clean Strip	Cut & Polish Unitized	EXL Unitized	3M EXL, General Purpose	EX2 & EX3	EXL Deburring	Light Deburring	Metal Finishing	Multi Finishing	Finishing Flap Brush
Standard		Britestrip	800 & 900 Series	500 - 700 Series	General Purpose Plus, Light Deburring	GP Plus	Deburring Convolute	LDW	Metal Finishing	Multi Finishing	Buff & Blend Flap Brush

Rapid Strip Wheels

NORTON BLAZE RAPID STRIP CERAMIC ALUMINA

BEST CHOICE FOR REMOVING COATINGS ON A VARIETY OF SUBSTRATES, SUCH AS WOOD, METAL AND PLASTICS



FEATURES & BENEFITS

- Norton Blaze ceramic alumina grain provides 2X cut rate, 2X life over silicon carbide products
- Advanced resin bond does not shed on rust-encrusted pieces, and prevents gouging and rework; does not snag when used for deburring
- Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering.



TIER:	BEST	GOOD
BRAND:	Norton	Norton
TRADENAME:	BLAZE RAPID STRIP	RAPID STRIP
ABRASIVE:	Ceramic Alumina	Silicon Carbide
GRIT:	Extra Coarse	Extra Coarse

SIZE	MAX. RPM	STD. PKG.		PART #
Arbor Hole				
4 x 1/4	8,000	25	66261009324	66261008008
4 x 1/2	8,000	25	66623304856	66261007916
6 x 1/4	4,000	15	66623340171	66261007988
6 x 1/2	4,000	15	66261099378	66261008051

Note: Blaze Rapid Strip shown with mandrel inserted into arbor hole.

Rapid Blend Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning original and composites. Easily preformed for use on a wide variety of shapes/contours. Hold shape well; less wheel dressing. Non-metallic so no contamination of workpiece. Construction maintains part tolerance; prevents cutting or gouging.

NORTON VORTEX RAPID BLEND ALUMINUM OXIDE

BETTER CHOICE FOR LIGHT WELD BEAD AND WELD SPLATTER REMOVAL, HEAVY DEBURRING AND FINISHING APPLICATIONS

FEATURES

BENEFITS

- High-performance engineered grain and improved resin bond system
- Thick nylon web
- Controlled porosity
- Aggressive, fast, stock removal, reduced cycle times, and increased part quality
- 2X longer life and faster finishing – with minimal shedding
- Cool cutting and improved cut rate

TIER:	BETTER
BRAND:	Norton
TRADENAME:	VORTEX RAPID BLEND UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT SIZE	STD. PKG.	MAX. RPM	3 DENSITY PART #	MAX. RPM	5 DENSITY PART #	MAX. RPM	7 DENSITY PART #	MAX. RPM	9 DENSITY PART #
2 x 1/8 x 1/8	A/O	M	60			22,000	66254425657	20,000	66254410849		
2 x 1/8 x 1/4	A/O	M	60					22,000	66261191446		
2 x 1/4 x 1/4	A/O	M	60	18,000	66254428456	22,000	66254433504	22,000	66261080270		
2 x 1 x 1/4	A/O	M	15					22,000	66261080269		
3 x 1/8 x 1/4	A/O	M	40			18,000	66261093448	18,000	66261191445		
3 x 1/8 x 3/8	A/O	M	40			18,000	66254433503	18,000	66254401131		
3 x 1/4 x 1/4	A/O	M	40	12,000	66254428454	18,000	66254414832	18,000	66261199696		
3 x 1/4 x 3/8	A/O	M	40	12,000	66254433505	12,000	66254433506				
3 x 1/2 x 1/4	A/O	M	20			18,000	66254432925	18,000	66261080267	18,000	66254433507
3 x 1/2 x 3/8	A/O	M	20			18,000	66254433508	18,000	66261080266	18,000	66254420696

Rapid Blend Unified Wheels continued

NORTON NEX RAPID BLEND A/O & S/C

GOOD CHOICE FOR LIGHT DEBURRING AND BLENDING

FEATURES

- Uniform construction
- Smear-resistant formula

BENEFITS

- Extra long life
- Excellent, consistent, smear-free finishes

TIER: **GOOD**

BRAND: Norton

TRADENAME: NEX RAPID BLEND UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	2 DENSITY PART #	3 DENSITY PART #	4 DENSITY PART #	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #
1 x 1 x 3/16	A/O	C	30,000	50						66261014915
	A/O	M	18,000	50	66261014891					
	A/O	M	30,000	50				66261014908		66261014924
	S/C	F	18,000	50	66261014883					
	S/C	F	30,000	50				66261014904		66261014923
2 x 1/8 x 1/4	A/O	M	22,000	60						66261014927
2 x 1/4 x 1/4	A/O	M	18,000	60	66261014892					
	A/O	M	22,000	60						66261014926
	A/O	F	22,000	60				66261014901		
	S/C	F	18,000	60	66261014884					
2 x 1/2 x 1/4	A/O	M	22,000	30						66261014925
3 x 1/4 x 1/4	A/O	C	18,000	40						66261014919
	A/O	M	18,000	40				66261014909		66261014930
	S/C	F	12,000	40	66261014886					
3 x 1/4 x 3/8	A/O	C	18,000	40						66261014920
	A/O	M	12,000	40	66261014895					
	A/O	M	18,000	40				66261014910		66261014933
	A/O	F	12,000	40			66261014899			
3 x 1/2 x 1/4	S/C	F	12,000	40	66261014887	66261016006				
	A/O	M	12,000	20	66261014893					
	A/O	M	18,000	20				66261014928		
3 x 1/2 x 3/8	S/C	F	12,000	20	66261014885					
	A/O	M	18,000	20						66261014929
3 x 1 x 3/8	S/C	XC	14,000	10				66261014914		
6 x 1/2 x 1	A/O	M	7,500	4						66261014931
6 x 1 x 1	S/C	F	5,000	2	66261014888					

NORTON RAPID BLEND DEBURRING A/O & S/C

GOOD STARTING SPECIFICATION FOR HIGH-SPEED DEBURRING APPLICATIONS

FEATURES

- Controlled density range

BENEFITS

- More durable than General Duty Wheels

TIER: **GOOD**

BRAND: Norton

TRADENAME: RAPID BLEND DEBURRING UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	PART #
2 x 1/4 x 1/4	A/O	220	20,000	60	66261052200
2 x 1/2 x 1/4	A/O	120	20,000	40	66261058876
	S/C	220	20,000	40	66261058782
3 x 1/4 x 1/4	A/O	220	18,000	40	66261058877
	S/C	220	18,000	40	66261058854
3 x 1/2 x 1/4	S/C	220	18,000	20	66261058859
3 x 3/4 x 1/4	A/O	220	18,000	20	66261058881

Rapid Blend Unified Wheels continued

NORTON RAPID BLEND GENERAL DUTY DEBURRING

GOOD CHOICE FOR GENERAL PURPOSE LIGHT DEBURRING APPLICATIONS

FEATURES

- Excellent resistance to snagging

BENEFITS

- For general purpose light deburring applications

TIER: **GOOD**
 BRAND: Norton
 TRADENAME: RAPID BLEND
 GENERAL DUTY UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
1 x 1 x 3/16	A/O	C	8	15,000	50	66261000938
2 x 1/4 x 1/4	A/O	C	8	11,000	60	66261052275
2 x 1/2 x 1/4	A/O	F	4	11,000	40	66261058764
3 x 1/4 x 1/4	A/O	C	8	8,000	40	66261052276
	A/O	F	4	8,000	40	66261058816
3 x 1/2 x 1/4	S/C	F	4	8,000	40	66261000745
	A/O	F	4	8,000	20	66261054046
3 x 3/4 x 1/4	S/C	F	4	8,000	20	66261054048
	A/O	F	4	8,000	20	66261058769
6 x 1/2 x 1/2	S/C	M	4	8,000	20	66261058773
	S/C	F	4	8,000	20	66261058771
6 x 1 x 1/2	S/C	M	4	4,800	4	66261058779
	S/C	F	4	4,800	4	66261058790
6 x 1 x 1	S/C	F	4	4,800	4	66261058797

Assemblies and Mandrels for Unified Wheels

FITS WHEEL CENTER HOLE	FOR WHEEL WIDTH	FOR WHEEL DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	PART #
Mandrel Assemblies for Unified Wheels and Discs On Edge								
3/16	1/8 – 1/2	1 – 2	1/4	2	7/16	994	1	66261009852
1/4 – 5/16	Up to 1/2	Up to 2	1/4	2	5/8	932	1	66261015146
1/4 – 5/16	Up to 1	Up to 2	1/4	2-1/2	5/8	932	1	66261059422
	Up to 1	2 – 3	1/4	2-1/2	1	933	1	66261059421
3/8	Up to 1/2	2 – 4	1/4	2-1/2	1	990	1	66261009851
1/2	Up to 1	3 – 6	1/4	3-1/8	1-5/8	934	1	66261009850

FOR CENTER HOLE	USE WITH UNIFIED WHEEL	SHANK DIAMETER	SHANK LENGTH	3M EQUIVALENT	STD. PKG.	PART #
Threaded Mandrel for Unified Wheels						
3/16	1 x 1 x 3/16	1/4"	1-3/4"	948	5	66261047584



MANDREL ASSEMBLY 66261059421



MANDREL ASSEMBLY 66261059422



THREADED MANDREL 66261047584



Convolute Wheels

Formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core. Convolute wheels offer a wide range of uses:

- Burr and flashing removal
- Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

TIP

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.
- Light to medium pressure is recommended. Excessive pressure may result in part damage.
- Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.



It is the user's responsibility to refer to and comply with ANSI B7.1

NORTON RAPID FINISH GENERAL PURPOSE A/O & S/C

BEST CHOICE FOR BROAD RANGE OF APPLICATIONS: GENERAL DEBURRING, BLENDING, AND FINISHING ON ALL MATERIALS INCLUDING METALS, WOOD, GLASS

FEATURES & BENEFITS

- Eliminate smearing and loading on a wide range of workpieces (from high-nickel-content alloys to aluminum and other soft metals with patent-pending Norton Clean Bond resin technology)
- Increase throughput with a 30% faster finish through new Norton grain/bond configuration
- Decrease wheel changes with a 10-30% longer life, provided by a new fiber and the high-temperature resin bond
- Ease wheel selection with color-coding wheel to match the primary use (maroon for General Purpose), and fiberglass core to match the abrasive (black for silicon carbide and white for aluminum oxide)
- Use wet or dry

TIER: BEST

BRAND: Norton

TRADENAME: RAPID FINISH GENERAL PURPOSE

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	PRODUCT CODE	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #	9 DENSITY PART #
6" x 1/2" x 1"	A/O	Med.	6,000	4	C2315		66261134177	66261134178	66261134179
	S/C	Med.	6,000	4	C4315				66261108076
	S/C	Fine	6,000	4	C4415		66261133213	66261106732	66261112985
6" x 1" x 1"	A/O	Med.	6,000	3	C2315	6626113418	66261134181	66261134182	66261134183
	A/O	Fine	6,000	3	C2408	66261132100	66261132322	66261132324	
	S/C	Med.	6,000	3	C4315		66261108074	66261133215	66261108075
	S/C	Fine	6,000	3	C4415	66261114475	66261119988	63642577269	63642581587
	S/C	Very Fine	6,000	3	C4515	66261131970			
6" x 2" x 1"	A/O	Med.	6,000	2	C2315		66261134184		
	S/C	Med.	6,000	2	C4315		66261114471		
	S/C	Fine	6,000	2	C4415		66261132325		66261114485
8" x 1" x 3"	S/C	Med.	4,500	3	C4315		66261108066	66261108069	
	S/C	Fine	4,500	3	C4415	66261108064	66261108065	63642553754	63642576004
	S/C	Very Fine	4,500	3	C4515				66261133209
8" x 2" x 3"	S/C	Med.	4,500	2	C4315		66261114473		
	S/C	Fine	4,500	2	C4415		66261114480	66261114483	66261114486
	S/C	Very Fine	4,500	2	C4515				66261133210
10" x 1" x 5"	A/O	Med.	3,600	3	C2315		66261134185		
	S/C	Fine	3,600	3	C4415			66261106554	66261114488
10" x 2" x 5"	S/C	Fine	3,600	1	C4415			63642581044	66261114489
12" x 1" x 5"	A/O	Med.	3,000	2	C2315				66261134186
	S/C	Fine	3,000	2	C4415	66261108053	66261114481	66261114484	66261114074
	S/C	Very Fine	3,000	2	C4515				66261134187
12" x 2" x 5"	S/C	Fine	3,000	1	C4415		66261114482	66261112766	66261114490

NEW



NORTON SERIES 4000 A/O & S/C

BEST CHOICE FOR HEAVY DEBURRING APPLICATIONS

FEATURES

- Advanced resin bond system
- High quality synthetic web

BENEFITS

- Free cutting
- Use both wet and dry
- Long life for heavy deburring, edge breaking and removing parting lines on exotic metals

TIER: **BEST**

BRAND: **Norton**

TRADENAME: **SERIES 4000 CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	4		66261004021
6 x 1 x 1	A/O	M	6,000	3	66261004208	
	S/C	F	6,000	3		66261004142
8 x 1 x 3	A/O	M	4,500	3	66261004165	
	S/C	F	4,500	3		66261004123
12 x 1 x 5	S/C	F	3,000	2	66261004284	66261004148
12 x 2 x 5	S/C	F	3,000	1		66261004011

NORTON SERIES 1000 LONG LIFE A/O & S/C

BETTER CHOICE FOR GENERAL DEBURRING, BLENDING, AND FINAL FINISHING

FEATURES

- Smear and heat-resistant formula
- Dense web construction (9 density)
- More open web construction (7 density)
- Waterproof
- Non-metallic
- Optimum grain/resin formulation
- Conformable and flexible

BENEFITS

- Consistent, high quality results
- Starting point for deburring, blending, polishing and finishing applications
- Smear-resistant and cool cutting on light deburring applications
- Use dry, wet or with oil
- No contamination of workpiece
- Durable, long life construction with versatile application range and consistent cut rate and shed resistance
- Less operator fatigue

TIER: **BETTER**

BRAND: **Norton**

TRADENAME: **SERIES 1000 LONG LIFE CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	7 DENSITY PART #	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	A/O	M	6,000	4	66261018857		66261018650
	S/C	M	6,000	4			66261019540
	S/C	F	6,000	4	66261018628		66261018629
6 x 1 x 1	A/O	M	6,000	3	69957397884	66261018636	66261019337
	S/C	M	6,000	3	69957397882	69957397883	66261018630
	S/C	F	6,000	3	66261018631	66261018774	66261018632
8 x 1 x 3	A/O	M	4,500	3	69957397885	66261018855	66261018633
	S/C	M	4,500	3	69957394610	66261018673	66261018997
	S/C	F	4,500	3	66261018639	66261018640	66261018641
12 x 1 x 5	A/O	M	3,000	2	69957397887		66261018896
	S/C	M	3,000	2		66261018786	66261018908
	S/C	F	3,000	2			66261018626

NORTON LIGHT FINISHING SILICON CARBIDE

BEST CHOICE FOR LIGHT DEBURRING, POLISHING, AND FINE FINISHING APPLICATIONS

FEATURES

- Controlled cut rate
- Very conformable
- Superior form holding
- Durable resin bond system
- Advanced manufacturing process

BENEFITS

- Prevents “over benching”
- Deburs and polishes without altering geometry
- Operator friendly, reduces fatigue
- Consistent, reliable edge breaking and finishing with minimal wheel dressing and reshaping
- Less dust and shedding with more uniform wear
- Substantial extended wheel life in a soft, conformable wheel
- Consistent web forming and grain distribution produce consistent finish on intricate polishing applications

TIER: **BEST**

BRAND: **Norton**

TRADENAME: **LIGHT FINISHING CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	66261092322	66261092324	66254421572
6 x 1 x 1	S/C	F	6,000	66254403708	66254403709	66254421573
8 x 1/2 x 3	S/C	F	4,500	66254403707	66254409698	66254421575
8 x 1 x 3	S/C	F	4,500	66261095702	66254409924	66254421577

All Light Finishing convolute wheels are non-stock. Ask your Norton representative for current lead-times and order quantities.

NORTON METAL FINISHING ALUMINUM OXIDE

BEST CHOICE FOR DECORATIVE FINISHING, BLENDING, AND FINAL FINISHING

FEATURES

- Premium, medium grit aluminum oxide grain
- Dense, very durable web
- Strongest resin binders
- Uniform grain dispersion and coating
- Available in 5 and 6 densities

BENEFITS

- Generates uniform distinct satin and antique finishes
- Can be used for blending applications
- Resilient, long life construction
- Clean and condition without gouging or changing dimensions of workpiece
- Ideal for blending and matching #3 and 4 mil. finishes, and surface prep for buffing, polishing and applying decorative finishes

TIER: **BEST**

BRAND: **Norton**

TRADENAME: **METAL FINISHING CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
6 x 1 x 1	A/O	M	5	6,000	3	66261007936
		M	6	6,000	3	66261010148
6 x 2 x 1	A/O	M	5	6,000	2	66261007957
		M	6	6,000	2	66261009635
8 x 1 x 3	A/O	M	5	4,500	3	66261007831
8 x 2 x 3	A/O	M	5	4,500	2	66261007904
		M	6	4,500	2	66261012971
12 x 1 x 5	A/O	M	5	3,000	2	66261007434
		M	6	3,000	2	66261009481
12 x 2 x 5	A/O	M	5	3,000	1	66261007212
14 x 2 x 8	A/O	M	5	2,550	1	66261007817
		M	6	2,550	1	66261012041



NORTON CLEAN & FINISH SILICON CARBIDE

BEST CHOICE FOR FINE FINISHING WITH LIGHT PRESSURE

FEATURES

- Silicon carbide grain
- Open mesh construction

BENEFITS

- Good for blending, rust removal, applying decorative, contrast finishes and low- to moderate-speed applications
- Not used for deburring
- Used with light to moderate pressure, low speed

TIER: **BEST**

BRAND: Norton

TRADENAME: CLEAN & FINISH
 CONVOLUTE WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
4 x 1 x 1	S/C	M	4	4,000	10	66261058502
		F	4	4,000	10	66261058501
6 x 1 x 1	S/C	M	4	3,000	4	66261058507
		F	4	3,000	4	66261058506
6 x 2 x 1	S/C	M	4	3,000	2	66261058510
		F	4	3,000	2	66261058509
6 x 3 x 1	S/C	M	4	3,000	1	66261058512
6 x 4 x 1	S/C	M	4	3,000	1	66261058514
8 x 1 x 3	S/C	M	4	2,500	3	66261058518
8 x 2 x 3	S/C	M	4	2,500	2	66261058521
8 x 3 x 3	S/C	M	4	2,500	1	66261058524
8 x 4 x 3	S/C	M	4	2,500	1	66261058526

Aluminum Reducing Bushings for Flap and Convolute Wheels

- Durable, aluminum one-piece-design flanges with integrated "contact washer"
- Snug fit; extended usable life
- Available in stock and non-stock sizes in many combinations of ID hole reduction

WHEEL CENTER HOLE	BUSHING REDUCES HOLE SIZE TO	FOR WHEEL DIAMETER	STD. PKG.	PART #
1	3/8	4 - 6	1 Pair	66261080522
	1/2	4 - 6	1 Pair	66261080523
	5/8	4 - 6	1 Pair	66261080524
	3/4	4 - 6	1 Pair	66261080525
	7/8	4 - 6	1 Pair	66261080526
2	1/2	6	1 Pair	66261080527
	5/8	6	1 Pair	66261080528
	1	6	1 Pair	66261080529
	1-1/4	6	1 Pair	66261080530
3	1	8	1 Pair	66261080531
	1-1/4	8	1 Pair	66261080532
	1-1/2	8	1 Pair	66261080383
	2	8	1 Pair	66261080514
5	1	10 and 12	1 Pair	66261080533
	1-1/4	10 and 12	1 Pair	66261080534
	3	10 and 12	1 Pair	66261080535
8	1-1/4	14	1 Pair	66261080536
10	1-1/4	16	1 Pair	66261080520





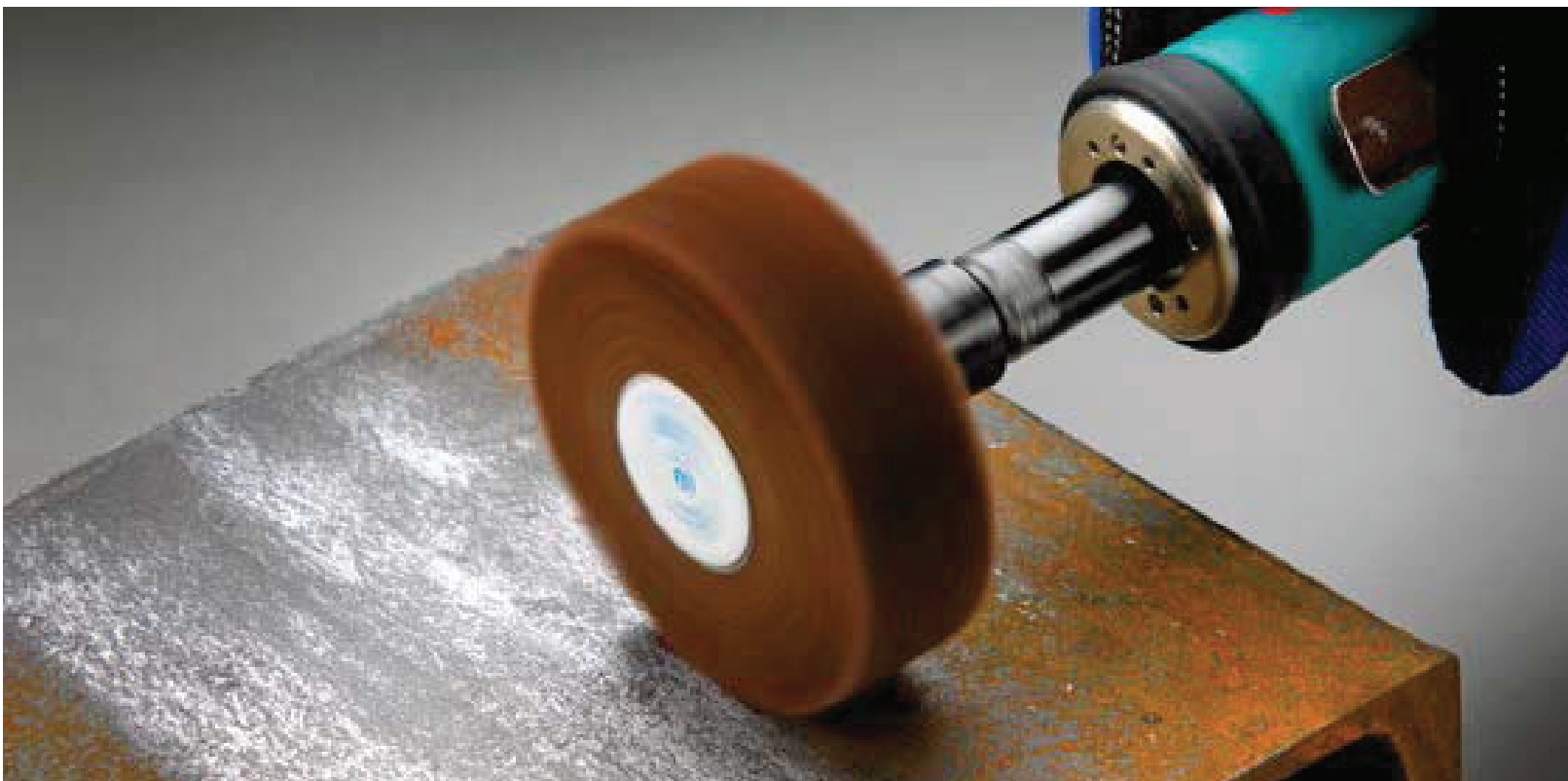
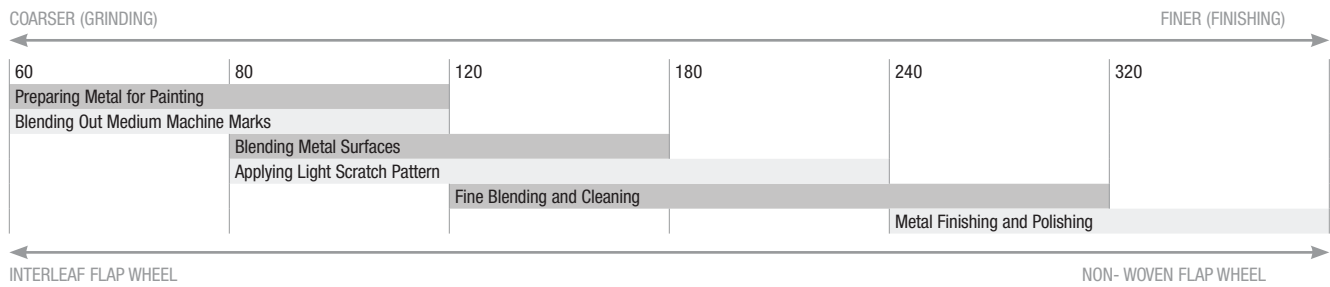
Non-woven surface finishing flap wheels are an ideal choice for a wide variety of blending and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform 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.

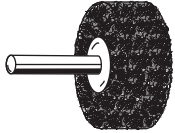
- Applications: Used for a wide range of metal fabrication and welding applications including blending, deburring, cleaning, finishing, and polishing
- Size Range: Flap wheels with mounted steel shanks: 2" – 4" diameter
Flap wheels with arbor holes: 3" – 12" diameter
- Grit Range: 60 – 320
- Abrasive Grain: Aluminum Oxide, Silicon Carbide
- Machine Used:



APPLICATION/GRIT RECOMMENDATION GUIDE



1/4" Mounted Steel Shanks



TIER:	BETTER	GOOD	BETTER	GOOD
BRAND:	Norton	Merit	Norton	Merit
TRADENAME:	INTERLEAF	INTERLEAF	NON-WOVEN	NON-WOVEN

SIZE (D x W x SK.)	ABRASIVE	CA GRIT	NON-WOVEN GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
2 x 1 x 1/4	A/O	60	Coarse	12,000	10	66261051720*	08834138122		
	A/O	80	Medium	12,000	10	66261051721*	08834138123		
	A/O	120	Medium	12,000	10	66261051722	08834144457	66261051716*	66261189992*
	A/O	180	Fine	12,000	10		08834144458		
2 x 1-1/2 x 1/4	A/O	320	Very Fine	12,000	10		08834144459	66261051717*	69957399202
	A/O	80	Medium	12,000	10		08834138125		
	A/O	120	Medium	12,000	10		08834138126		
3 x 1 x 1/4	A/O	320	Very Fine	12,000	10		08834138128		
	A/O	60	Coarse	12,000	10		08834138129		
	A/O	80	Medium	12,000	10		08834138130		
	A/O	120	Medium	12,000	10	66261051725*	08834138118	66261051718*	08834131921
	A/O	180	Fine	12,000	10		08834138120		
	A/O	-	Very Fine	12,000	10			66261051719*	
3 x 2 x 1/4	A/O	320	Very Fine	12,000	10		08834138119		
	A/O	120	Medium	8,000	10		08834144460	66261058474	
	A/O	180	Medium	8,000	10		08834144461		
4 x 2 x 1/4	A/O	80	Coarse	12,000	10		08834121115		
	A/O	120	Medium	12,000	10		08834120458		

*Standard package quantity = 20

Refer to Non-Woven Convolute Wheel section for Flap Wheel Reducing Bushings.



Arbor Hole Mounts



TIER: BETTER GOOD BETTER GOOD
 BRAND: Norton Merit Norton Merit
 TRADENAME: INTERLEAF INTERLEAF NON-WOVEN NON-WOVEN

SIZE (D x W x SK.)	ABRASIVE	CA GRIT	NON-WOVEN GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
3 x 2 x 3/8	A/O	60	Coarse	12,000	10		08834139000		
	A/O	120	Medium	12,000	10		08834139001		
	A/O	240	Very Fine	12,000	10		08834139028		
	A/O	320	Very Fine	12,000	10		08834139024		
4 x 2 x 5/8	A/O	60	Coarse	12,000	10		08834126025		
	A/O	240	Very Fine	12,000	10		08834126014		
	A/O	320	Very Fine	12,000	10		08834126027		
6 x 1 x 1	A/O	120	Medium	6,000	10		08834126006		
	A/O	240	Very Fine	6,000	10		08834126030		
6 x 1 x 2	A/O	—	Medium	3,000	4			66261058456	
	A/O	180	Fine	3,000	4			66261058487	
	S/C	—	Fine	3,000	4			66261058451	
	S/C	—	Very Fine	3,000	4			66261058450	05539512658
6 x 2 x 1	A/O	80	Medium	6,000	10		08834126009		
	A/O	180	Fine	6,000	10		08834126018		
6 x 3 x 1	A/O	80	Medium	6,000	6		08834126055		
8 x 1 x 3	A/O	120	Medium	2,500	3	66261010711			
	—	—	Fine	2,500	3			66261058491	
8 x 2 x 3	A/O	—	Medium	2,500	2			66261000889	
	A/O	—	Medium	2,500	2				05539512677
	A/O	—	Fine	2,500	2			66261058493	
12 x 1 x 5	A/O	80	Medium	1,900	2	66261010712			
12 x 2 x 5	A/O	—	High Strength	1,900	1			66261005070	05539562637

MERIT





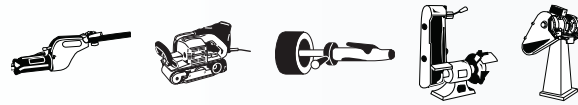
Norton non-woven belts are a combination of strong synthetic mesh and quality abrasive, bonded together by a smear-resistant adhesive. The open construction of non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

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.

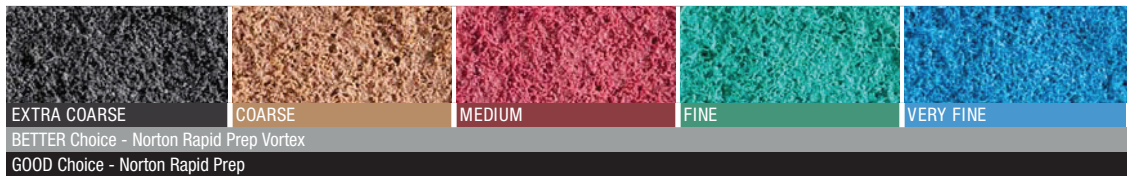
Abrasive Grain: Engineered Aluminum Oxide, Aluminum Oxide

Grit Range: Extra Coarse (Black), Coarse (Brown), Medium (Maroon), Fine (Green), Very Fine (Blue)

Machine Used:



APPLICATION/GRIT RECOMMENDATION GUIDE



Scale Removal	X				
Stock Removal		X			
Heavy Deburring		X			
Light Deburring			X		
Light Finishing			X		
Blending				X	
Finishing					X

NORTON VORTEX RAPID PREP ALUMINUM OXIDE

BETTER CHOICE FOR FINISHING AND BLENDING APPLICATIONS



FEATURES	BENEFITS
<ul style="list-style-type: none"> Proprietary engineered Vortex aluminum oxide abrasive grain and new coating method 	<ul style="list-style-type: none"> Most consistent cutting and finishing of surface conditioning products on the market Combine maximum cutting speed with the finish of fine grits Reduce process times by 50+% by eliminating 2 to 5 grit sequences to 1 step in your technical blending operations More resistant to edge wear; up to 4X the life of competitive products Friable grain structure keeps Ra specs throughout belt life and reduces scrap and rework
<ul style="list-style-type: none"> Clean Bond resin system, aerospace-tailored 	<ul style="list-style-type: none"> Smear-free, even on high nickel content alloys Will not load on aluminum and soft metals, as competitive products can

NORTON RAPID PREP ALUMINUM OXIDE

GOOD CHOICE FOR FINISHING AND BLENDING APPLICATIONS



FEATURES	BENEFITS
<ul style="list-style-type: none"> Clean Bond resin system, aerospace-tailored 	<ul style="list-style-type: none"> Smear-free, even on high nickel content alloys Will not load on aluminum and soft metals, as competitive products can
<ul style="list-style-type: none"> Proprietary new coating method 	<ul style="list-style-type: none"> Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as other competitive products can
<ul style="list-style-type: none"> Extended form holding 	<ul style="list-style-type: none"> Lowest total cost of consumable tooling per workpiece 50% better life than competitive aluminum oxide products

Norton Rapid Prep Vortex

		TIER: BETTER	BETTER	BETTER	BETTER	BETTER	
		BRAND: Norton	Norton	Norton	Norton	Norton	
		TRADENAME: VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	
		ABRASIVE: Engineered A/O	Engineered A/O	Engineered A/O	Engineered A/O	Engineered A/O	
		GRIT/COLOR: EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE	
WIDTH	LENGTH	STD. PKG.	PART #	PART #	PART #	PART #	
2	18-15/16	12	66623313274	66623335031	66623333675	66623333649	66623333688
2-3/4	15-1/2	10	66623333718	66623333628	66623333676	66623333655	66623333694
3	10-11/16	12	66623333719	66623335039	66623335110	66623333656	66623333695
	18	10	66623335149	66623335040	66623335112	66623333657	66623335135
3-1/2	15-1/2	8	66623333725	66623335042	66623335118	66623333665	66623335139
4	24	8			66623335119		

Norton Rapid Prep

		TIER: GOOD	GOOD	GOOD	GOOD	GOOD
		BRAND: Norton	Norton	Norton	Norton	Norton
		TRADENAME: RAPID PREP	RAPID PREP	RAPID PREP	RAPID PREP	RAPID PREP
		ABRASIVE: Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		GRIT/COLOR: EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
WIDTH	LENGTH	STD. PKG.	PART #	PART #	PART #	PART #
1/4	18	24	66261011420	66261012524	66623333424	66623333511
	24	24	69957392606	66261097565	66623333425	66623333512
1/2	12	24	66261003177	66261006465	66623318175	66254499884
	18	24	66261055309	66261055310	66623333426	66261055311
	24	24	66261055312	66261008972	66254490859	66261019876
3/4	18	12	66261002111	66261015808	66254490858	66261003622
	20-1/2	12	66261083899	66261003260	66623333427	66623333515
	80	12	66623333411	66623333505	66623333428	66623333516
1	18	12	66261007023	66261017898	66623333429	66623333518
	21	12	66623333412	66623336005	66623333430	66623333519
	30	12	66261019801	66623336006	66623333431	66261001972
	42	12	66261008317	66254441289	66623333432	66623333521
	60	12	66623333413	66623333506	66623333433	66261055412
	64	12	66623333414	66623301513	66623333434	66261055413
	72	12	66261194240	66261006378	66254493830	66261005583
	132	10	66623314981	66261011414	66254436886	66623333525
1-1/2	60	8	66623333415	66261007644	66623333435	66623303624
2	18-15/16	12	66261018226	66623333507	66623333436	66623333528
	34	12	66261063309	66623312203	66623333437	66623333529
	48	10	66261006504	66261006648	66623333438	66623333531
	60	8	66623333416	66261189669	66623333439	66623333532
	72	8	66261002571	66261007757	66623333440	66261002307
	132	6			66261069525	66623333533
2-1/2	60	6	66254429365	66254441491	66623333441	66623333534
2-3/4	15-1/2	10	66623333578	66623333417	66623333508	66623333535
3	10-11/16	12	66623333580	66261018076	66261067469	66623333443
	18	10	66254428772	66254496043	66254428776	66623333444
	21	10	66623333584	66623333418	66261010870	66623333445
	24	10	66254433359	66623314158	66254428773	66623333446
	72	6	66623333419	69957396833	66623333447	66261003176
	80	4	66623333420	66623333420	66261007149	66623333542
	90	4	66623333421	66623333509	66623333449	66623333541
	118	4	66623333422	66623333510	66623333450	66261047121
	132	4	66254490470	66261055322	66623333451	66623333543
3-1/2	15-1/2	8	66623333595	66261055324	66254444576	66623333452
4	24	8	66623333596	66254495931	66261031667	66623333453
	36	6	66623333423	66261002321	66623333454	66623333546
	132	2	66261009056	66261006898	66623333455	66623333547
	168	2	63642576650	66261009174	66623333456	66623333548
6	48	4	66261055330	66261055331	66623333457	66261055332

If you do not see the Rapid Prep belts you need in our stock offering, call your local Norton distributor to check for made-to-order availability .

Introduction

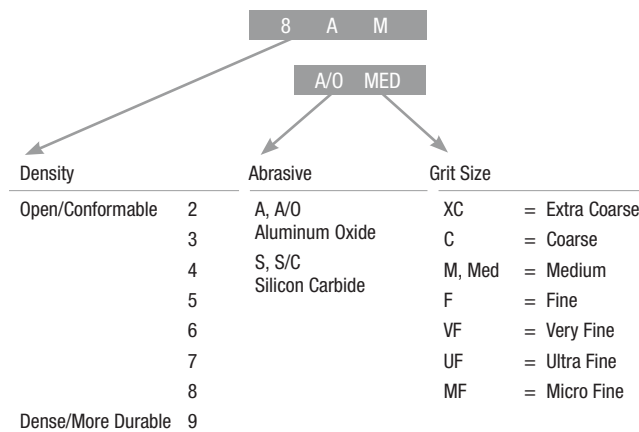
Most Norton Bear-Text and Merit products consist of a non-woven web of nylon fibers impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting. The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Norton Bear-Text and Merit products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic and non-rusting. Non-woven wheels are easily pre-formed to conform to special-shaped work pieces.

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 material makes it ideal as a finishing tool. While 60 to 80 grits are considered intermediate sizes in other products, they are considered coarse for non-woven items.

Used wet or dry, Norton Bear-Text and Merit non-woven products offer the following advantages: controlled cut (with little or no stock removal) allows for increased productivity, consistent, uniform finish, ability to automate operations, minimized smearing and reduced operator training. These advantages make our non-woven products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds and steel wool.

Product Identification System



Abrasives

Ceramic alumina, silicon carbide and aluminum oxide abrasives are offered. Ceramic alumina cuts the fastest and is the most cost effective on large-volume applications. Silicon carbide is sharper, cuts faster than aluminum oxide, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer. It causes less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Norton Bear-Text hand pads are also available in a non-abrasive material.

Grits

Grit refers to the size of the abrasive grain impregnated into the nylon web. The coarser the grit, the more aggressive the cut, the rougher the finish. The finer the grit, the less aggressive the cut and the resulting surface finish will be finer, if all other conditions are equal.

GRIT DESIGNATIONS	GRIT SIZE
Extra Coarse (XC)	24 – 36
Coarse (C)	50 – 80
Medium (M)	100 – 150
Fine (F)	180 – 220
Very Fine (VF)	240 – 360
Super Fine (SF)	400
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 density wheels cut faster, last longer and produce finer finishes than softer density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the work piece.

Fiber Sizing

Several nylon fiber sizes are used in the manufacture of Norton Bear-Text and Merit web material because the fiber size is a significant factor in the coating process, as each produces distinct cutting characteristics.

Bonding Agents

Waterproof resins are used in the manufacture of Norton Bear-Text and Merit web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web.

Conventional Finishing Methods Versus Norton Bear-Text and Merit Non-Woven Products

The following chart outlines the advantages achievable when using our products as alternatives to other cleaning, blending, deburring and finishing methods. These 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	NORTON/MERIT PRODUCT ALTERNATIVES	ADVANTAGES OF NORTON/MERIT PRODUCT VERSUS ALTERNATE FINISHING METHODS
Bristle Brushes	Cleaning	Clean & Finish Wheels Metal Finishing Wheels Flap Wheels	Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminate compound dust
Greaseless Compounds	Finishing	Flap Wheels Convolute Wheels Unified Wheels	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate
Set-up Wheels	Blending/ Deburring	Convolute Wheels Unified Wheels	No break-in time required More consistent cut More uniform finish Maintain geometry Safer, no flying wheel pieces
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters

Getting the Most Out of Norton Bear-Tex and Merit Wheels

Maximum wheel life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

1) Wheel Direction

Convolute wheels and interleaf flap wheels must always run in the direction indicated by the arrow printed on the side of each wheel. Conventional flap wheels and unified wheels can be run in either direction.

2) Wheel Speed

Wheel 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 might 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 might result in wheel deformation and damage to the work surface.

4) Feed Speed

Low 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 might 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.

Factors in Wheel Choice

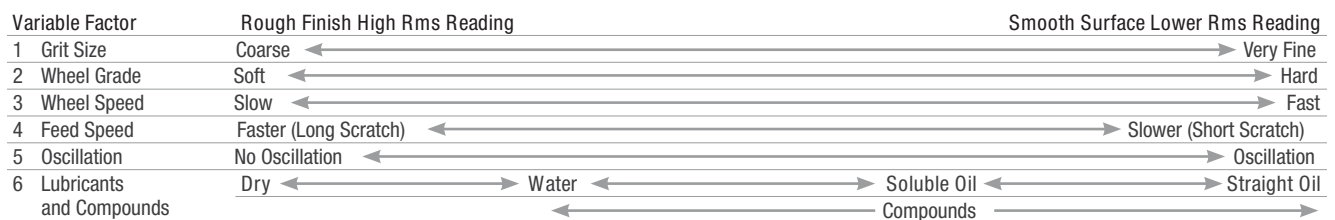
This chart provides a relative comparison of other Norton Bear-Tex wheel variables. It can serve as a useful guide in choosing the most suitable product for a given application. However, as many other factors affect wheel performance, this chart can only be general in nature. The most cost-effective wheel can always be obtained by wheel testing on the application.



* On steel surfaces, silicon carbide wheels will produce a brighter finish than aluminum oxide wheels.

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the work piece. This chart shows the effect on surface finish of 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.





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