

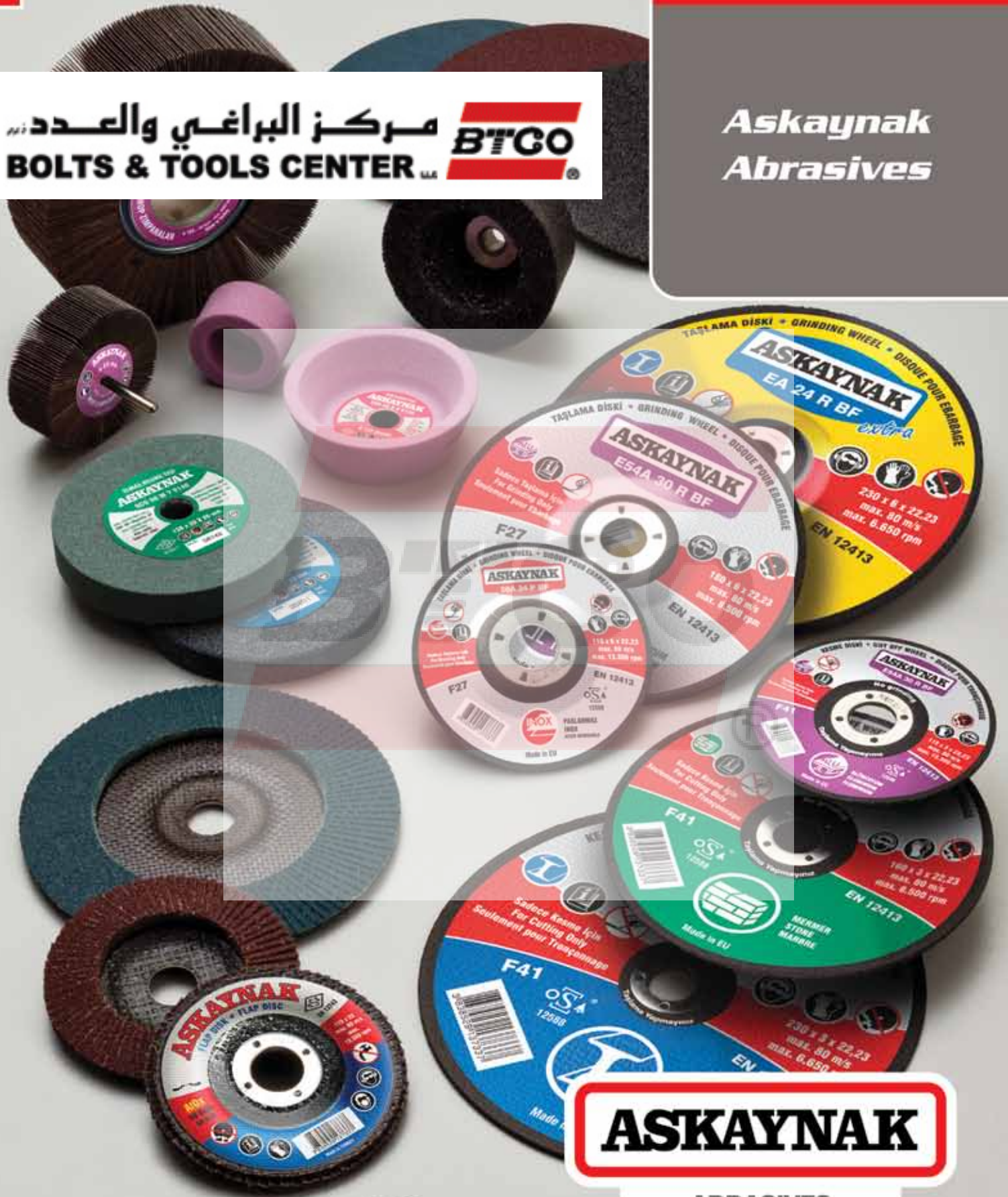
Eczacıbaşı - Lincoln Electric

Eczacıbaşı

LINCOLN  
ELECTRIC

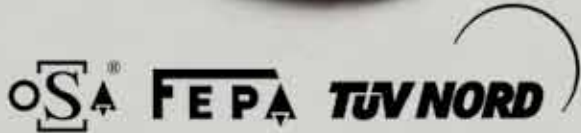
مركز البراغي والعدد  
BTGO  
BOLTS & TOOLS CENTER

Askaynak  
Abrasives



**ASKAYNAK**

ABRASIVES



EN 12413  
EN 13743

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## Askaynak Abrasives

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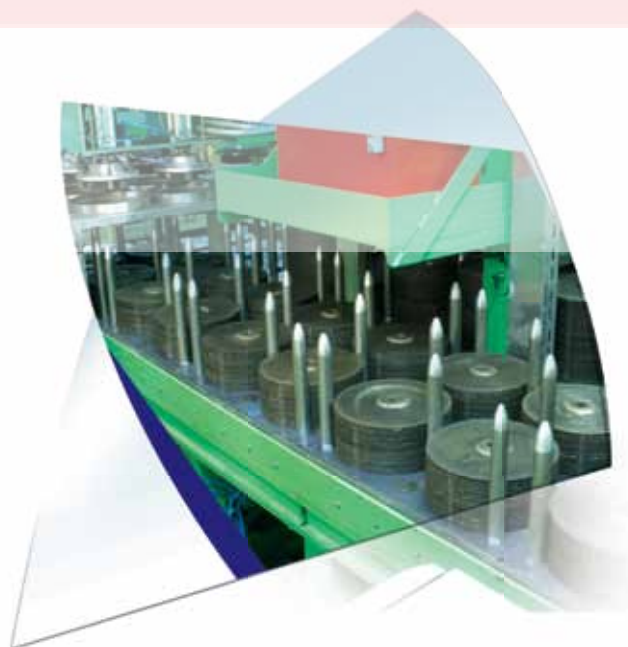
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# Proper Storage and Usage

## Askaynak Abrasives

Store in dry and well-ventilated areas in temperatures between 10°-30°C and 70 % relative humidity).

During transport, the storage areas should be as close to the place of use in order to avoid mechanical damage.



### Do

- ✓ DO always visually inspection on wheels before mounting for possible damage. Never use damaged ones.
- ✓ DO always allow new wheels to run at operating speed before grinding and cutting operation for at least 10 seconds to observe if there is something wrong with the wheel or not.
- ✓ DO always switch off the power at the supply before changing the wheel.
- ✓ DO always use the proper tools for changing the wheel.
- ✓ DO always wear protective gear: safety clothing, dust masks, eye protection (glasses or shield), gloves and ear protection.
- ✓ DO use reinforced cutting-off wheels on portable machines.
- ✓ DO always secure the workpiece firmly before beginning cutting or grinding operation. Fix the workpiece if possible.
- ✓ DO use wheels in proper ventilated areas.
- ✓ DO maintain the angle between cutting off wheel and the workpiece 90 degrees in cutting operations.
- ✓ DO grind with the prescribed angle in instructions for use section.

### Do Not

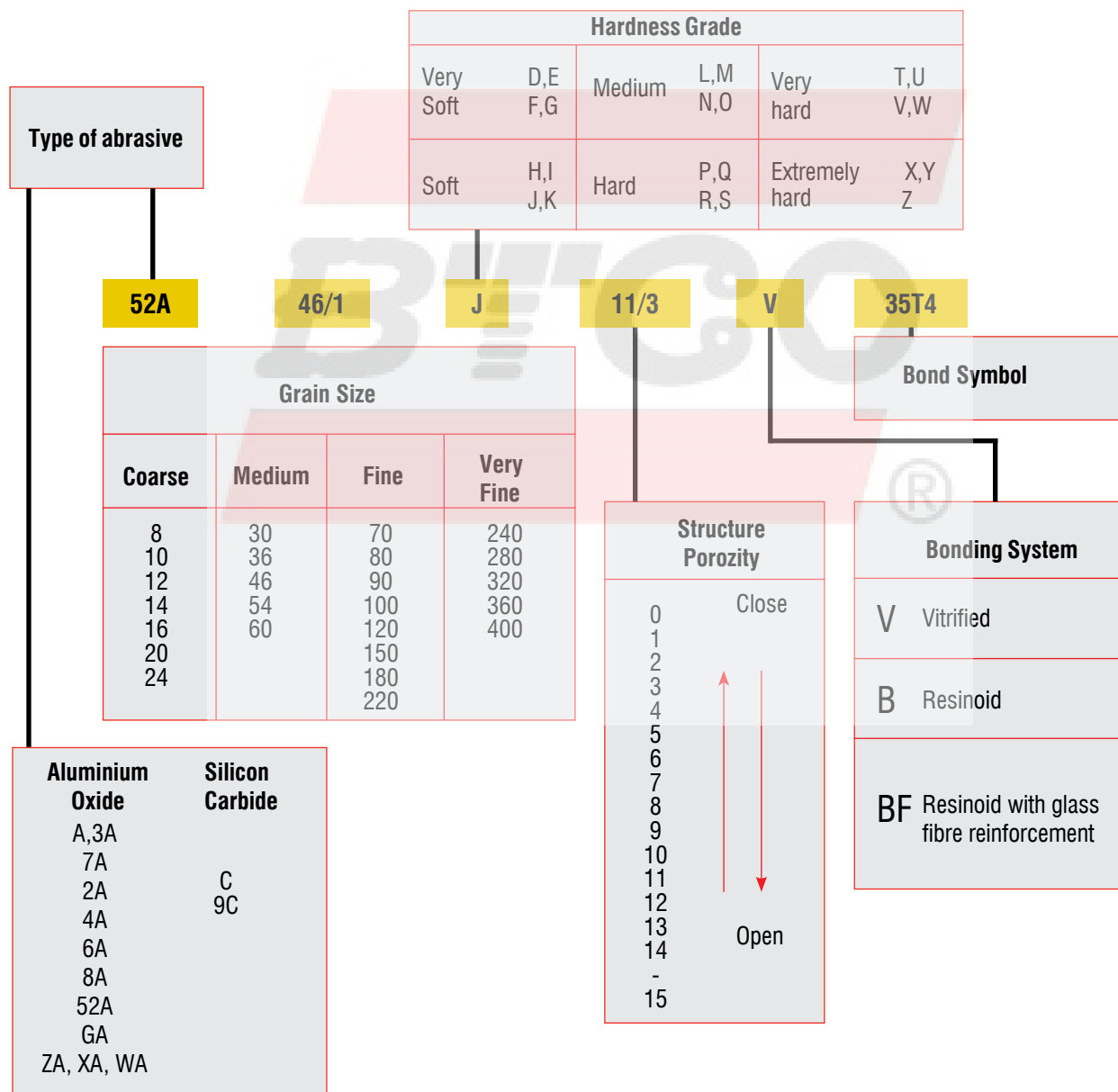
- ✗ DON'T apply too much force on grinding machine while operating.
- ✗ DON'T mount broken or damaged wheels on grinding machines.
- ✗ DON'T mount the wheels on grinding machines with improper or damaged flanges.
- ✗ DON'T tighten flange excessively. This may cause damage of flange.
- ✗ DON'T use grinding machines with higher operating speed than the speed marked on the wheels.
- ✗ DON'T use damaged, broken down or improper grinding machines.
- ✗ DON'T smell the fume which could be occurred in cutting or grinding operation.
- ✗ DON'T stop the wheel after the operation by applying pressure on the floor or workpiece.
- ✗ DON'T use cutting-off wheels for grinding.
- ✗ DON'T store wheels in a damp atmosphere or in extreme temperatures.
- ✗ DON'T use a machine without a wheel guard.
- ✗ DON'T take the wheels out from the machine by hitting the wheel on the floor or workpiece. This may cause balance out or disintegration failure.

# Marking System of Abrasives

## Askaynak Abrasives

The specification of a grinding tool is determined by the following elements:

- Type of abrasive grain
- Grain size (and its combination)
- Hardness
- Structure
- Bonding system



# Specification of Abrasives

## Askaynak Abrasives

The grinding tool consists of the abrasive grains, the binding components and pores. The abrasive grains function as cutting blades, while the bond holds the cutting particles together and forms together with them a compact unity.

### ABRASIVE TYPES

#### **NK - Regular aluminium oxide:**

It is suitable for processing low-alloyed, unhardened steels with tensile strength between 300-500 N/mm<sup>2</sup>.

#### **EKW - Semi-friable aluminium oxide:**

It is suitable for processing tempered tool steels and HSS.

#### **EKR - Pink aluminium oxide:**

It is suitable for processing high-alloyed steels with tensile strength greater than 500 N/mm<sup>2</sup>.

#### **SCG - Green silicon carbide:**

Is an extremely hard material. It is suitable for processing carbide metals, grey iron and chilled iron, plastics, rubber, non-ferrous metals, ceramics, glass, nitralloy steels and acid-resistant steels.

#### **SC - Black silicon carbide:**

Is a little less brittle than silicon carbide and is used for grinding grey iron, non-ferrous metals, ceramics, glass, nitralloy steels and acid-resistant steels.

### GRAIN SIZE

Grain size is specified with grit number which is the designation of abrasive grain size, reflecting the number of the smallest openings per linear inch in the screen through which the grain will pass. According to the fineness of abrasive wheel, grains can be coarse (grains 8-24), medium (grains 30-60), fine (grains 70-220) and very fine (grains 240-360). Abrasive wheels with coarse grains are chosen for coarse grinding of materials, and wheels with fine grains are chosen for precision grinding.

### HARDNESS GRADE

The hardness of the grinding tools is proportional to the bond strength with which a single grain is tied in the bond-matrix. The grade of hardness is expressed by classes of hardness, designated with English alphabet letter symbols (capitals-D-Z).

It depends on the following:

- The quantity and type of bond
- The structure
- The type of the abrasive grain
- Grinding tool making procedure

### STRUCTURE

Structure is determined by the volume and arrangement of abrasive grains within a abrasive tool. It is designated with number symbols from 0-18. It depends upon the relative distance between the individual abrasive grains. "Open" structured products provide better chip clearance, and "closed" structure products are used for low stock removal.

### BOND

Wheel bond, how the wheel holds the abrasives, affects finish, coolant, and minimum/maximum wheel speed.

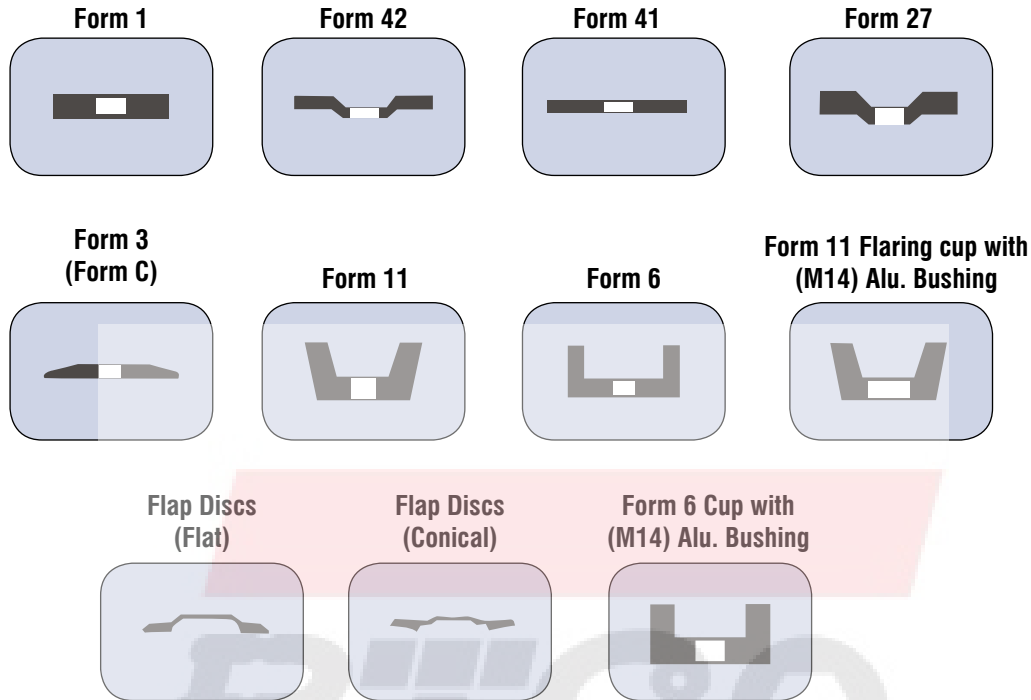
**Vitrified Bond (V):** This bond is brittle, it has no elasticity and is quite resistant to deformation.

**Resinoid (B):** This bond is less brittle, a little more elastic and is less resistant to deformation than the vitrified bonds. It also is a little less impact and percussion sensitive and less affected by changes in temperature than vitrified bonds

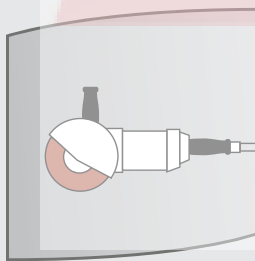
**Reinforced resinoid bond (BF):** It is a variety of resinoid bond with fibreform material added (usually fibreglass-fabric). The bond thus reinforced exhibits a much greater range of strength and gives the products greater hardness as well as enables usage by increased operating speeds and side loads.

# General Pictogram Informations

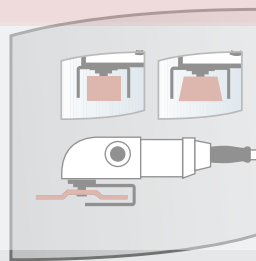
## Askaynak Abrasives



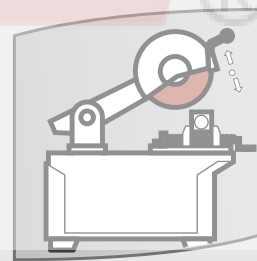
## MACHINES



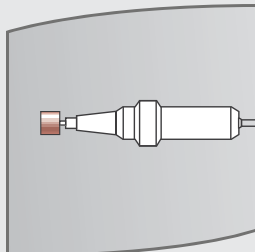
Manual angle cutting machine



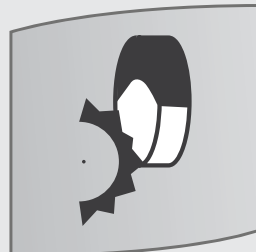
Manual angle grinding machine



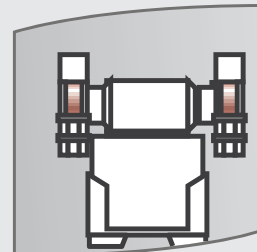
Stationary cutting machine



Straing manual grinding machine



Tool Grinding machine



Bench grinding machine

# RESIN BONDED ABRASIVES







# Pictogram Informations of Flex Wheels

## Resin Bonded Abrasives

### SAFETY INSTRUCTIONS



Please read the instructions **carefully**.



Use a safety shield or protective eyewear.



Use ear protection.



Use a dust mask.



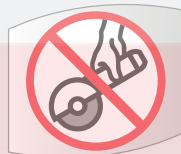
Use protective gloves.



Use an appropriate safety shield when grinding.



Grinding **prohibited**.



Don't use free-hand grinding or cutting machine.



Wet cutting **prohibited**.



Don't use damaged products.

### APPLICATION AREAS



Steel



Inox



Aluminium



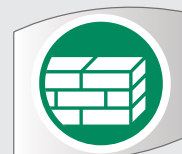
Cast Iron



Asphalt



Concrete



Stone

# Proper Usage

## Resin Bonded Abrasives



Proper cutting methods of various metal forms.



Cutting of sheet metals

Cutting of thicker pieces

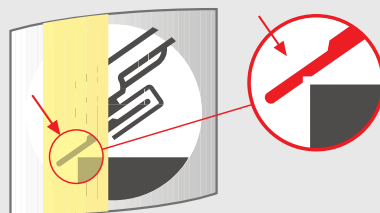


Always maintain the angle between grinding wheel and the workpiece 25-35 degrees to get the best grinding performance.

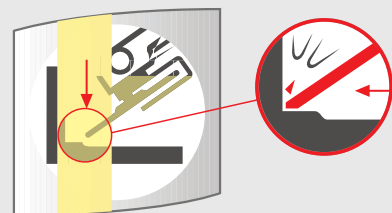
**NEVER** use cutting-off wheels for grinding!



**NEVER** grind laterally or using the flat part the grinding wheel!



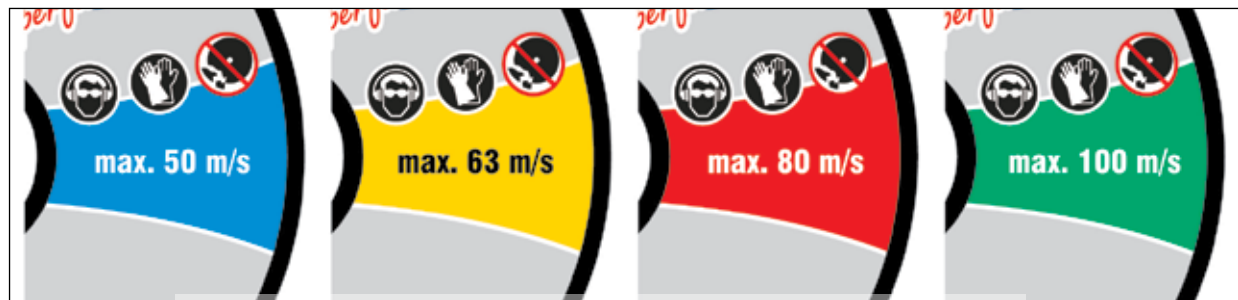
During grinding be careful not to contact any surfaces which you do not want grind with the grinding wheel!



# Maximum Operating Speeds

## Resin Bonded Abrasives

The maximum operating speeds are marked with a color line through the center.



The grinding wheel operating speed is determined using the following equation:

$$v = \frac{D \times \pi \times n}{60000}$$

The necessary rpms are determined with equation:

$$n = \frac{60000 \times v}{D \times \pi}$$

v- operating speed (m/s)  
D- wheel diameter (mm)  
n- Rpm (1/min)  
 $\pi$ - 3.14






### Maximum Operating Speed m/s

D mm	16	20	25	32	35	40	45	50	63	80	100	125
6	51000	64000	80000	102000	112000	128000	143240	160000	201000			
8	38200	48000	60000	76500	84000	95500	107430	120000	150500	191000		
10	30600	38200	48000	61200	67000	76500	86000	95500	120500	153000	191000	184000
13	23550	29500	35600	47100	51500	58800	66500	73500	92600	118000	147000	150000
18	19100	23900	29850	38200	41800	47800	54000	59700	75200	95500	120000	120000
20	15300	19100	23900	30600	33500	38200	43000	47800	60200	76500	95500	95500
25	12300	15300	19100	24500	26800	30600	34400	38200	48200	61200	76500	75000
32	9550	11950	14950	29100	20900	23900	26900	30000	37600	48000	60000	59700
40	7650	9550	11950	15300	16750	19100	21500	23900	30100	38200	47200	47750
50	6150	7650	9550	12250	13400	15300	17200	19100	24100	30600	38200	37900
63	4850	6100	7600	9750	10650	12150	13650	15200	19100	24300	30250	29850
80	3850	4800	6000	7650	8400	9550	10750	12000	15100	19100	23900	23900
100	3100	3850	4800	6150	8700	7650	8600	9550	12100	15300	19100	20800
115	2700	3350	4200	5350	5850	6500	7500	8350	10500	13300	16650	19100
125	2450	3100	3850	4900	5350	6150	6900	7650	9850	12250	15300	16000
150	2050	2550	3200	4100	4500	5100	5750	6400	8050	10200	12700	13300
180	1700	2150	2700	3400	3750	4250	4800	5350	6700	8500	10650	11950
200	1550	1950	2400	3100	3350	3850	4300	4800	6050	7650	9550	10400
230	1350	1700	2100	2700	2950	3350	3750	4200	5250	6650	8350	9550
250	1250	1550	1950	2450	2700	3100	3450	3850	4850	6150	7650	8000
300	1050	1300	1600	2050	2250	2550	2870	3200	4050	5100	6400	6850
350/356	875	1100	1400	1750	1950	2200	2450	2750	3450	4400	5500	6000
400/406	765	960	1200	1550	1700	1950	2150	2400	3050	3850	4800	5350
450/457	680	850	1100	1400	1500	1700	1950	2150	2700	3400	4250	4800
500/508	615	765	960	1250	1350	1550	1750	1950	2450	3100	3850	4000
600/610	510	640	800	1050	1150	1300	1450	1600	2050	2550	3200	3620
650/660	460	580	720	930	1010	1160	1300	1450	1820	2320	2900	

# Flex Cut-Off Wheels

## Resin Bonded Abrasives



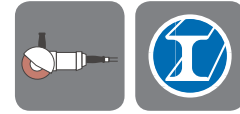
✓✓✓ Excellent performance ✓✓ Good performance ✓ Can also be used on..					
	<b>METAL</b> A30 S	<b>INOX</b> 20A 30 P E20A 60 S E20A 46 S	<b>CAST IRON</b> 19A 30 S	<b>STONE</b> C 30 S	<b>ALUMINIUM</b> E54A 30 R E54A 60 S E54A 46 S
General construction steel	✓✓✓				
High strength construction steel	✓✓				
Tool steel	✓✓				
Low alloyed stainless steel	✓	✓✓✓			
High alloyed stainless steel	✓	✓✓✓			
Stainless steel sheet	✓	✓✓✓			
Grey cast iron	✓✓		✓✓✓		✓✓
Spherical cast iron	✓✓		✓✓✓		✓✓
Malleable cast iron	✓✓		✓✓✓		
Aluminium		✓✓	✓✓		✓✓✓
Brass		✓✓	✓		✓✓✓
Bronze		✓✓	✓		✓✓✓
Brick				✓✓✓	
Concrete				✓✓✓	
Ceramic				✓✓✓	
Marble and Granite				✓✓✓	
Stone				✓✓✓	

# Flex Cut-Off Wheels

## Resin Bonded Abrasives

### Metal Cut-off Wheels – A30 S BF

**Application Area:** Used for cutting operation of iron, steel and castings which have moderate hardness.



FLAT DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	A 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	A 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	A 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	A 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	A 30 S BF	80 m/s	6650	25

- Regular aluminium oxide
- For general applications
- Faster cutting
- Long life
- High cutting performance

### Inox Cut-off Wheels – 20A 30 P BF / E20A 60 S BF / E20A 46 S BF

**Application Area:** Used for cutting operation of low and high alloyed stainless steel materials, plates and sheets.



FLAT DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 3 x 22.23	20A 30 P BF	80 m/s	13300	25
125 x 3 x 22.23	20A 30 P BF	80 m/s	12250	25
180 x 3 x 22.23	20A 30 P BF	80 m/s	8500	25
230 x 3 x 22.23	20A 30 P BF	80 m/s	6650	25

FLAT

#### THINLINE - E20A 60 S BF / E20A 46 S BF

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 1 x 22.23	E20A 60 S BF	80 m/s	13300	50
115 x 1.6 x 22.23	E20A 60 S BF	80 m/s	13300	50
125 x 1 x 22.23	E20A 60 S BF	80 m/s	12250	50
125 x 1.6 x 22.23	E20A 60 S BF	80 m/s	12250	50
180 x 1.9 x 22.23	E20A 46 S BF	80 m/s	8500	40
230 x 1.9 x 22.23	E20A 46 S BF	80 m/s	6650	40

- Semi-friable aluminium oxide
- Faster cutting
- Cool cutting
- Long life
- Excellent quality
- THINLINE products are Fe, S and Cl free

# Flex Cut-Off Wheels

## Resin Bonded Abrasives

### Cast Iron Cut-off Wheels – 19A 30 S BF

**Application Area:** Used for cutting operation of grey cast iron, spherical cast iron and malleable cast iron.



FLAT  DPC. 

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	19A 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	19A 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	19A 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	19A 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	19A 30 S BF	80 m/s	6650	25

- % 50 Aluminium oxide and % 50 Silicon carbide mixture
- Specially developed for cast iron
- Fast and easy cutting
- Long life
- Excellent quality

### Stone Cut-off Wheels – C 30 S BF

**Application Area:** Used for cutting operation of marble, granite, brick and similar materials.



FLAT  DPC. 

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	C 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	C 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	C 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	C 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	C 30 S BF	80 m/s	6650	25

- Silicon carbide
- Specially developed for marble and ceramics
- Long life
- High cutting capacity

# Flex Cut-Off Wheels

## Resin Bonded Abrasives

### Aluminium Cut-off Wheels – E54A 30 R BF / E54A 60 S BF / E54A 46 S BF

**Application Area:** Used for cutting operation of aluminium and non-ferrous metals.



FLAT DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	E54A 30 R BF	80 m/s	15300	25
115 x 3 x 22.23	E54A 30 R BF	80 m/s	13300	25
125 x 3 x 22.23	E54A 30 R BF	80 m/s	12250	25
180 x 3 x 22.23	E54A 30 R BF	80 m/s	8500	25
230 x 3 x 22.23	E54A 30 R BF	80 m/s	6650	25

- Semi-friable aluminium oxide
- Specially developed for aluminium and non-ferrous metals
- Long life
- Excellent quality

FLAT

THINLINE: E54A 60 S BF / E54A 46 S BF				
DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 1 x 22.23	E54A 60 S BF	80 m/s	13300	50
115 x 1.6 x 22.23	E54A 60 S BF	80 m/s	13300	50
125 x 1 x 22.23	E54A 60 S BF	80 m/s	12250	50
125 x 1.6 x 22.23	E54A 60 S BF	80 m/s	12250	50
180 x 1.9 x 22.23	E54A 46 S BF	80 m/s	8500	40
230 x 1.9 x 22.23	E54A 46 S BF	80 m/s	6650	40

# Flex Cut-Off Wheels

## Resin Bonded Abrasives

### Stationary Cutting Machine Wheels (NK) – A 30 S BF

**Application Area:** Used for cutting operation of iron and steel materials at stationary cutting machine.



DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
300 x 3 x 25.4	A 30 S BF	80 m/s	5100	25
300 x 3 x 30	A 30 S BF	80 m/s	5100	25
350 x 3.5 x 25.5	A 30 S BF	80 m/s	4400	10
350 x 3.5 x 30	A 30 S BF	80 m/s	4400	10
400 x 4 x 40	A 24 S BF	80 m/s	3850	10

- Regular aluminium oxide

### Stationary Cutting Machine Wheels (SC) – C 30 S BF

**Application Area:** Used for cutting operation of marble and cast iron at stationary cutting machine.



DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
300 x 3 x 25.4	C 30 S BF	80 m/s	5100	25
300 x 3 x 30	C 30 S BF	80 m/s	5100	25
350 x 3.5 x 25.5	C 30 S BF	80 m/s	4400	10
350 x 3.5 x 30	C 30 S BF	80 m/s	4400	10
400 x 4 x 40	C 30 S BF	80 m/s	3850	10





- Silicon carbide



# Flex Grinding Wheels

## Resin Bonded Abrasives



								
✓✓✓ Excellent performance ✓✓ Good performance ✓ Can also be used on..	METAL PERFORMANCE A 24 Q	METAL ENDURO A 24 S	METAL EXTRA EA 24 R	INOX 20A 24 P	CAST IRON 19A 24 S	STONE C 24 S	ALUMINIUM E54A 30 R	ZIRCON ZA 24 R
General construction steel	✓✓✓	✓✓✓	✓✓✓			®		
Heat treated steel	✓✓	✓	✓✓✓					✓✓
For welding groove	✓✓✓	✓✓	✓✓✓					✓✓✓
Welding burr grinding	✓✓✓	✓✓	✓✓✓					✓✓✓
High strength construction steel	✓✓	✓✓	✓✓✓					✓✓✓
Tool steels	✓✓	✓	✓✓✓					
Low alloyed stainless steel	✓	✓	✓✓	✓✓✓				
High alloyed stainless steel	✓	✓	✓✓	✓✓✓				
Stainless steel sheet	✓	✓	✓✓	✓✓✓				
Grey cast iron	✓	✓✓			✓✓✓		✓✓	✓✓✓
Spherical cast iron	✓	✓✓			✓✓✓		✓✓	✓✓✓
Malleable cast iron	✓	✓✓			✓✓✓			✓✓✓
Aluminium			✓	✓✓	✓✓		✓✓✓	
Brass			✓	✓✓	✓✓		✓✓✓	
Bronze			✓	✓✓	✓✓		✓✓✓	
Marble and granite						✓✓✓		
Stone						✓✓		

# Flex Grinding Wheels

## Resin Bonded Abrasives

### Metal Grinding Wheels / Performance – A 24 Q BF

**Application Area:** Used for grinding operation of iron, steel and castings at moderate hardness with high stock removal performance.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	A 24 Q BF	80 m/s	15300	10
115 x 6 x 22.23	A 24 Q BF	80 m/s	13300	10
125 x 6 x 22.23	A 24 Q BF	80 m/s	12250	10
180 x 6 x 22.23	A 24 Q BF	80 m/s	8500	10
180 x 8 x 22.23	A 24 Q BF	80 m/s	8500	10
180 x 10 x 22.23	A 24 Q BF	80 m/s	8500	10
230 x 6 x 22.23	A 24 Q BF	80 m/s	6650	10
230 x 8 x 22.23	A 24 Q BF	80 m/s	6650	10
230 x 10 x 22.23	A 24 Q BF	80 m/s	6650	10

- Regular aluminium oxide
- Easy use
- For general applications
- High performance
- Efficiency advantage

### Metal Grinding Wheels / Enduro – A 24 S BF

**Application Area:** Used for grinding operation of iron, steel and castings at moderate hardness with long life



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	A 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	A 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	A 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	A 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	A 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	A 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	A 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	A 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	A 24 S BF	80 m/s	6650	10

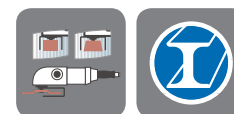
- Regular aluminium oxide
- For general applications
- Long life
- Specially developed for high strength steels

# Flex Grinding Wheels

## Resin Bonded Abrasives

### Metal Grinding Wheels / Extra – EA 24 R BF

**Application Area:** Primarily used for grinding operation of hardened steel and stainless steels, and also for grinding welding grooves and burrs.



- Regular aluminium oxide
- For general applications
- Cool cutting
- Long life
- High grinding performance
- Fast grinding

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	EA 24 R BF	80 m/s	15300	10
115 x 6 x 22.23	EA 24 R BF	80 m/s	13300	10
125 x 6 x 22.23	EA 24 R BF	80 m/s	12250	10
180 x 6 x 22.23	EA 24 R BF	80 m/s	8500	10
180 x 8 x 22.23	EA 24 R BF	80 m/s	8500	10
180 x 10 x 22.23	EA 24 R BF	80 m/s	8500	10
230 x 6 x 22.23	EA 24 R BF	80 m/s	6650	10
230 x 8 x 22.23	EA 24 R BF	80 m/s	6650	10
230 x 10 x 22.23	EA 24 R BF	80 m/s	6650	10

### Inox Grinding Wheels – 20A 24 P BF

**Application Area:** Used for grinding operation of stainless steel materials.



- Semi-friable aluminium oxide
- Specially designed for stainless steel
- Cool grinding
- Long life

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	20A 24 P BF	80 m/s	15300	10
115 x 6 x 22.23	20A 24 P BF	80 m/s	13300	10
125 x 6 x 22.23	20A 24 P BF	80 m/s	12250	10
180 x 6 x 22.23	20A 24 P BF	80 m/s	8500	10
180 x 8 x 22.23	20A 24 P BF	80 m/s	8500	10
180 x 10 x 22.23	20A 24 P BF	80 m/s	8500	10
230 x 6 x 22.23	20A 24 P BF	80 m/s	6650	10
230 x 8 x 22.23	20A 24 P BF	80 m/s	6650	10
230 x 10 x 22.23	20A 24 P BF	80 m/s	6650	10

# Flex Grinding Wheels

## Resin Bonded Abrasives

### Cast Iron Grinding Wheels – 19A 24 S BF

**Application Area:** Used for grinding operation of grey cast iron, spherical cast iron and malleable cast iron.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	19A 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	19A 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	19A 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	19A 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	19A 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	19A 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	19A 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	19A 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	19A 24 S BF	80 m/s	6650	10

- % 50 Aluminium oxide and
- % 50 Silicon carbide mixture
- Specially designed for cast iron
- Long life
- Fast grinding

### Marble Grinding Wheels – C 24 S BF

**Application Area:** Used for grinding operation of marble, granite and ceramic materials.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	C 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	C 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	C 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	C 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	C 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	C 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	C 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	C 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	C 24 S BF	80 m/s	6650	10

- Silicon carbide
- Specially designed for marble and granite
- Long life
- High grinding capacity

# Flex Grinding Wheels

## Resin Bonded Abrasives

### Aluminium Grinding Wheels – E54A 30 R BF

**Application Area:** Used for grinding operation of aluminium and non-ferrous materials.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	E54A 30 R BF	80 m/s	15300	10
115 x 6 x 22.23	E54A 30 R BF	80 m/s	13300	10
125 x 6 x 22.23	E54A 30 R BF	80 m/s	12250	10
180 x 6 x 22.23	E54A 30 R BF	80 m/s	8500	10
180 x 8 x 22.23	E54A 30 R BF	80 m/s	8500	10
180 x 10 x 22.23	E54A 30 R BF	80 m/s	8500	10
230 x 6 x 22.23	E54A 30 R BF	80 m/s	6650	10
230 x 8 x 22.23	E54A 30 R BF	80 m/s	6650	10
230 x 10 x 22.23	E54A 30 R BF	80 m/s	6650	10

- Aluminium oxide
- Specially designed for aluminium
- Long life
- No clogging

### Zirconia Aluminium Oxide Grinding Wheels / Zircon - ZA 24 R BF

**Application Area:** Used for grinding operation of grey cast iron, spherical cast iron, and also for all steel castings.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	ZA 24 R BF	80 m/s	15300	10
115 x 7 x 22.23	ZA 24 R BF	80 m/s	13300	10
125 x 7 x 22.23	ZA 24 R BF	80 m/s	12250	10
180 x 7 x 22.23	ZA 24 R BF	80 m/s	8500	10
180 x 8 x 22.23	ZA 24 R BF	80 m/s	8500	10
180 x 10 x 22.23	ZA 24 R BF	80 m/s	8500	10
230 x 6 x 22.23	ZA 24 R BF	80 m/s	6650	10
230 x 8 x 22.23	ZA 24 R BF	80 m/s	6650	10
230 x 10 x 22.23	ZA 24 R BF	80 m/s	6650	10

- Zirconia aluminium oxide
- Specially designed for foundry applications
- Long life and durable
- Fast grinding
- Excellent performance

# SC Cup Wheels

## Resin Bonded Abrasives



**Application Area:** Used for surface grinding operation of marble, stone and granite materials in the masonry. They are made of silicon carbide abrasive grains.



Flaring Cup Wheel

SC 16 Q 5 BA  
SC 24 Q 5 BA

FORM 11 with (M14)  
Aluminium Bushing - Conical



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
	16	24	
100 x 45 x 14	16	24	4
100 x 50 x 14	16	24	4
130 x 45 x 14	16	24	4



Flat Cup Wheel

SC 16 Q 5 BA  
SC 24 Q 5 BA

FORM 6 with (M14) Aluminium Bushing - Flat



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
	16	24	
100 x 45 x 14	16	24	4
100 x 50 x 14	16	24	4



Flaring Cup Wheel

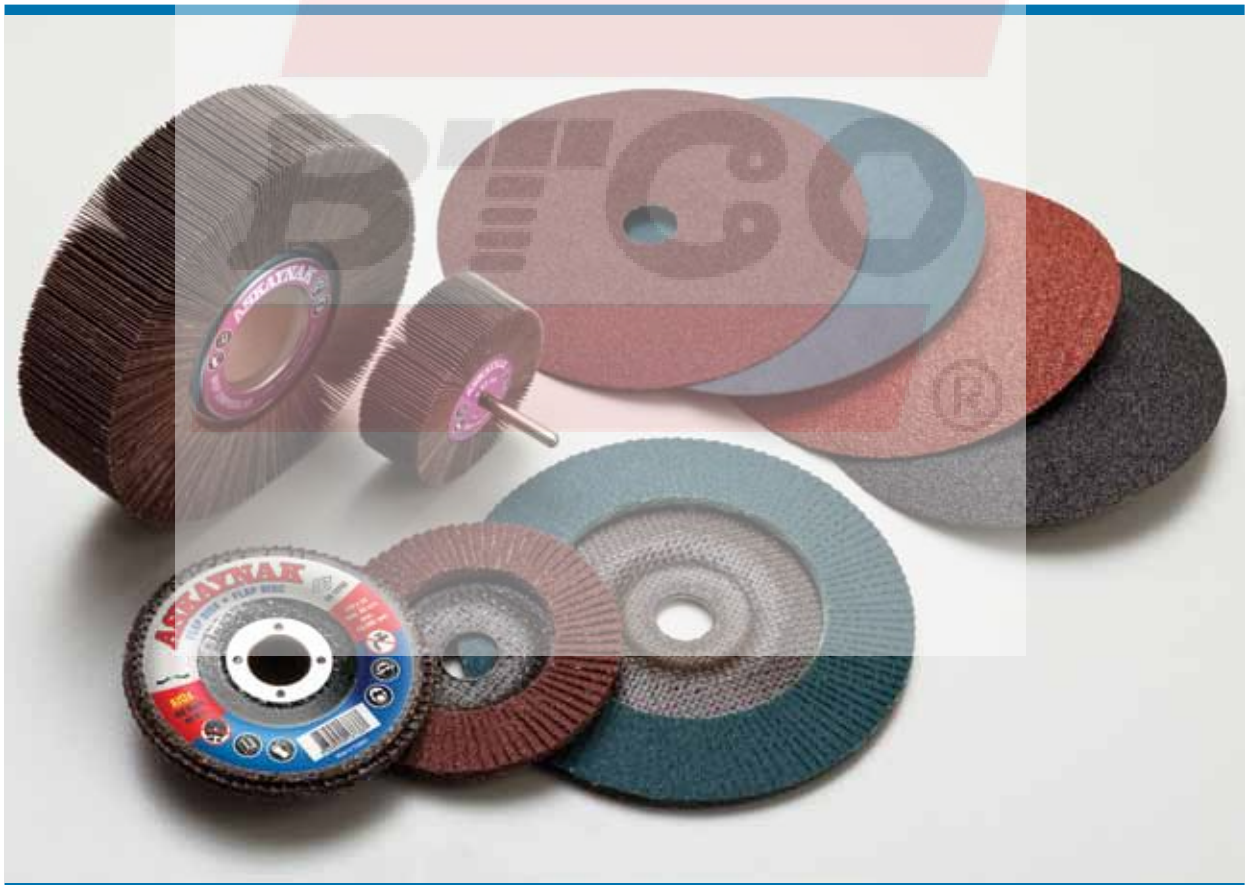
SC 16 Q 5 BA  
SC 24 Q 5 BA

SPECIAL FORM



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
	16	24	
110 x 58 x 22	16	24	4

# COATED ABRASIVES



# Flap Discs

## Coated Abrasives

Flap Discs have the advantage of finishing and grinding operations with a longer life. These discs provide more uniform grinding than resin fiber discs, and also remove welds and blends in one fast operation. The discs are available in two designs, flat and conical shape. The flat form is mainly used for face and plain surface grinding. The conical shape is used for applications on curved and more difficult accessible areas as well as for face and surface grinding. Different grain types, fibre and plastic backing alternatives and also several flap specifications gives the opportunity to choose the best disc for every special need. High density flap discs are ideal for grinding and finishing contoured shapes.

### Aluminium Oxide Flap Discs

**Application Area:** Used for grinding operation of iron, steel and metals at moderate hardness.



#### CONICAL



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

#### FLAT



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

#### CONICAL



HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

#### FLAT

HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10



# Flap Discs

## Coated Abrasives

### Zirconium Flap Discs

**Application areas:** An addition to application areas of aluminium oxide flap discs, zirconia is used for inox materials with cool cutting, high performance and long life.



#### CONICAL



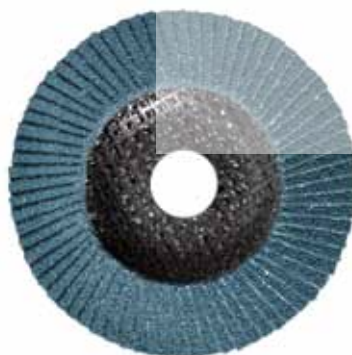
STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

#### FLAT



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

#### CONICAL



HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

#### FLAT

HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

# Fibre Discs

## Coated Abrasives

### Aluminium Oxide Fibre Discs

**Application Areas:** Used for grinding and surface cleaning operation of iron, steel and inox materials at moderate hardness.



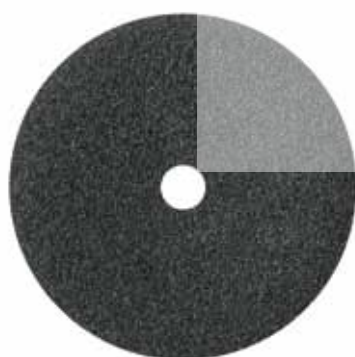
FLAT

GRAIN SIZE	DIMENSIONS (mm)				BOX UNITS
	100 x 16	115 x 22	125 x 22	180 x 22	
16	100 x 16	115 x 22	125 x 22	180 x 22	50
24	100 x 16	115 x 22	125 x 22	180 x 22	50
36	100 x 16	115 x 22	125 x 22	180 x 22	100
40	100 x 16	115 x 22	125 x 22	180 x 22	100
50	100 x 16	115 x 22	125 x 22	180 x 22	100
60	100 x 16	115 x 22	125 x 22	180 x 22	100
80	100 x 16	115 x 22	125 x 22	180 x 22	100
100	100 x 16	115 x 22	125 x 22	180 x 22	100
120	100 x 16	115 x 22	125 x 22	180 x 22	100

- Aluminium oxide
- Used for steel and inox
- High performance and long life
- Cool grinding

### Silicon Carbide Fibre Discs

**Application Areas:** Used for rough and fine grinding operation of marble and stone materials in masonry and construction industry.



FLAT

GRAIN SIZE	DIMENSIONS (mm)				BOX UNITS
	100 x 16	115 x 22	125 x 22	180 x 22	
16	100 x 16	115 x 22	125 x 22	180 x 22	50
24	100 x 16	115 x 22	125 x 22	180 x 22	50
36	100 x 16	115 x 22	125 x 22	180 x 22	100
40	100 x 16	115 x 22	125 x 22	180 x 22	100
50	100 x 16	115 x 22	125 x 22	180 x 22	100
60	100 x 16	115 x 22	125 x 22	180 x 22	100
80	100 x 16	115 x 22	125 x 22	180 x 22	100
100	100 x 16	115 x 22	125 x 22	180 x 22	100
200	100 x 16	115 x 22	125 x 22	180 x 22	100

- Silicon carbide
- Used for marble and non-ferrous
- High performance
- Long life
- Specially developed for construction industry

# Flap Wheels

## Coated Abrasives

A flap wheel is an abrasive wheel made from abrasive strips (flaps) radiating from a center hub. Flap wheels come in many different shapes and sizes. They give high stock removal performance, long work life and perfect surface quality in shaft mounted and unmounted types.

### Shaft Mounted Flap Wheels

**Application Areas:** Used for finishing, cleaning, deburring and preparing for final treatment (e.g. varnishing), especially for steel and stainless steel materials. Particularly suitable for surfaces that are difficult to clean.



DIMENSIONS (mm)	GRAIN SIZE					BOX UNITS
	40	60	80	120	150	
30 x 10	40	60	80	120	150	25
30 x 15	40	60	80	120	150	25
30 x 20	40	60	80	120	150	25
40 x 10	40	60	80	120	150	25
40 x 15	40	60	80	120	150	25
40 x 20	40	60	80	120	150	25
40 x 30	40	60	80	120	150	25
50 x 10	40	60	80	120	150	25
50 x 15	40	60	80	120	150	25
50 x 20	40	60	80	120	150	25
50 x 30	40	60	80	120	150	25
50 x 40	40	60	80	120	150	25
60 x 15	40	60	80	120	150	25
60 x 20	40	60	80	120	150	25
60 x 30	40	60	80	120	150	25
60 x 40	40	60	80	120	150	25
80 x 20	40	60	80	120	150	25
80 x 30	40	60	80	120	150	25
80 x 40	40	60	80	120	150	25
80 x 50	40	60	80	120	150	25

### Flap Wheels with Bore

**Application Areas:** Used for finishing operation of steel, inox and non-ferrous materials, suitable for portable machines and bench grinding machines.



DIMENSIONS (mm)	GRAIN SIZE			
	60	80	100	120
165 x 30 x 54	60	80	100	120
165 x 50 x 54	60	80	100	120
200 x 50 x 54	60	80	100	120
250 x 50 x 54	60	80	100	120

## VITRIFIED BONDED ABRASIVES



# NK Bench Grinding Wheels

## Vitrified Bonded Abrasives

**Application Area:** Used for the grinding operation of tungsten carbide tools, glass, marbles and all non-ferrous metals at bench grinding machines.



FORM 1 



**NK 24 Q 6 V130**  
**NK 36 P 6 V130**  
**NK 46 O 6 V130**  
**NK 60 M 6 V130**

DIMENSIONS (mm)	GRAIN SIZE				BOX UNITS
	24	36	46	60	
75 x 13 x 10	24	36	46	60	10
100 x 13 x 10	24	36	46	60	10
100 x 16 x 20	24	36	46	60	10
100 x 20 x 20	24	36	46	60	10
125 x 16 x 16	24	36	46	60	10
125 x 20 x 20	24	36	46	60	10
150 x 20 x 20	24	36	46	60	10
150 x 25 x 20	24	36	46	60	5
175 x 20 x 20	24	36	46	60	5
175 x 25 x 20	24	36	46	60	5
200 x 20 x 20	24	36	46	60	5
200 x 25 x 20	24	36	46	60	5
200 x 30 x 20	24	36	46	60	4
200 x 32 x 20	24	36	46	60	4
250 x 25 x 25	24	36	46	60	5
250 x 30 x 25	24	36	46	60	4
250 x 32 x 25	24	36	46	60	3
250 x 40 x 25	24	36	46	60	2
300 x 30 x 30	24	36	46	60	2
300 x 32 x 30	24	36	46	60	2
300 x 40 x 32	24	36	46	60	2
350 x 32 x 40	24	36	46	60	2
350 x 40 x 40	24	36	46	60	2
400 x 40 x 40	24	36	46	60	1

# SCG Bench Grinding Wheels

## Vitrified Bonded Abrasives

**Application Area:** Used for the grinding operation of tungsten carbide tools, glass, marbles and all non-ferrous metals at bench grinding machines.



**SCG 80 M 7 V140**

FORM 1 

DIMENSIONS (mm)	GRAIN SIZE	BOX UNITS
125 x 20 x 20	60	10
150 x 20 x 20	60	10
150 x 25 x 20	60	5
175 x 20 x 20	60	5
175 x 25 x 20	60	5
200 x 20 x 20	60	5
200 x 25 x 20	60	5
200 x 32 x 20	60	4
250 x 25 x 25	60	5
250 x 32 x 25	60	4
250 x 40 x 25	60	2
300 x 30 x 30	60	2
300 x 32 x 30	60	2
300 x 40 x 32	60	2
350 x 32 x 40	60	1
350 x 40 x 40	60	1
400 x 40 x 40	60	1

# Saw Sharpening Wheels, Cylindrical and Face Grinding Wheels

## Vitrified Bonded Abrasives

### Saw Sharpening Wheels

**Application Area:** Used for the sharpening different types of sawtooths.



NK 60 O 4 V130  
NEK 60 O 4 V130  
EKR 60 O 4 V130

FORM C

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE			BOX UNITS
	NK 60	NEK 60	EKR 60	
150 x 6 x 20	NK 60	NEK 60	EKR 60	10
150 x 8 x 20	NK 60	NEK 60	EKR 60	10
150 x 10 x 20	NK 60	NEK 60	EKR 60	10
175 x 8 x 20	NK 60	NEK 60	EKR 60	10
175 x 10 x 20	NK 60	NEK 60	EKR 60	10
200 x 8 x 20	NK 60	NEK 60	EKR 60	10
200 x 10 x 20	NK 60	NEK 60	EKR 60	10
250 x 10 x 25	NK 60	NEK 60	EKR 60	10

### Cylindrical and Surface Grinding Wheels

**Application Area:** Used for cylindrical and surface grinding of alloyed steels, high speed steels and tool steels.

FORM 1



EKR 46 K 6 V130  
EKR 60 K 6 V130  
EKW 46 K 6 V130  
EKW 60 K 6 V130

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE			
	EKR 46	EKR 60	EKW 46	EKW 60
100 x 20 x 20	EKR 46	EKR 60	EKW 46	EKW 60
125 x 20 x 20	EKR 46	EKR 60	EKW 46	EKW 60
150 x 20 x 20	EKR 46	EKR 60	EKW 46	EKW 60
150 x 25 x 20	EKR 46	EKR 60	EKW 46	EKW 60
175 x 20 x 20	EKR 46	EKR 60	EKW 46	EKW 60
175 x 25 x 20	EKR 46	EKR 60	EKW 46	EKW 60
200 x 20 x 20	EKR 46	EKR 60	EKW 46	EKW 60
200 x 25 x 20	EKR 46	EKR 60	EKW 46	EKW 60
250 x 25 x 76	EKR 46	EKR 60	EKW 46	EKW 60
250 x 25 x 25	EKR 46	EKR 60	EKW 46	EKW 60
250 x 30 x 76	EKR 46	EKR 60	EKW 46	EKW 60
250 x 32 x 76	EKR 46	EKR 60	EKW 46	EKW 60
250 x 40 x 76	EKR 46	EKR 60	EKW 46	EKW 60
300 x 30 x 127	EKR 46	EKR 60	EKW 46	EKW 60
300 x 30 x 30	EKR 46	EKR 60	EKW 46	EKW 60
300 x 32 x 30	EKR 46	EKR 60	EKW 46	EKW 60
300 x 40 x 127	EKR 46	EKR 60	EKW 46	EKW 60
300 x 40 x 76	EKR 46	EKR 60	EKW 46	EKW 60
350 x 40 x 127	EKR 46	EKR 60	EKW 46	EKW 60
350 x 40 x 40	EKR 46	EKR 60	EKW 46	EKW 60
350 x 50 x 127	EKR 46	EKR 60	EKW 46	EKW 60
400 x 40 x 127	EKR 46	EKR 60	EKW 46	EKW 60
400 x 50 x 127	EKR 46	EKR 60	EKW 46	EKW 60

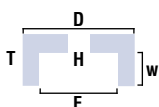
# EKR / EKW Cup Wheels

## Vitrified Bonded Abrasives

**Application Areas:** Used for the grinding operation of cutting tools.



### Form 6 - Flat Cup

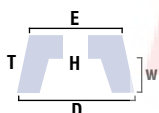


EKR 46 K 6 V130  
EKR 60 K 6 V130  
EKW 46 K 6 V130  
EKW 60 K 6 V130

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE				BOX UNITS
	EKR 46	EKR 60	EKW 46	EKW 60	
D-50	EKR 46	EKR 60	EKW 46	EKW 60	10
D-75	EKR 46	EKR 60	EKW 46	EKW 60	10
D-100	EKR 46	EKR 60	EKW 46	EKW 60	10
D-125	EKR 46	EKR 60	EKW 46	EKW 60	4
D-150	EKR 46	EKR 60	EKW 46	EKW 60	3

DIMENSIONS				
D	T	E	W	H
50	32	40	21	13
75	40	66	29	20
100	50	81	36	20
125	63	102	42	20
150	80	124	57	20

### Form 11 - Conical Cup



EKR 46 K 6 V130  
EKR 60 K 6 V130  
EKW 46 K 6 V130  
EKW 60 K 6 V130

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE				BOX UNITS
	EKR 46	EKR 60	EKW 46	EKW 60	
E-50	EKR 46	EKR 60	EKW 46	EKW 60	10
E-75	EKR 46	EKR 60	EKW 46	EKW 60	10
E-100	EKR 46	EKR 60	EKW 46	EKW 60	10
E-125	EKR 46	EKR 60	EKW 46	EKW 60	4
E-150	EKR 46	EKR 60	EKW 46	EKW 60	3

DIMENSIONS				
E	T	D	W	H
50	25	32	19	13
75	30	53	22	20
100	35	75	25	20
125	45	92	33	20
150	50	114	38	20

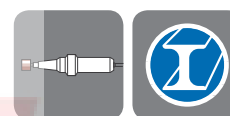


# Mounted Points

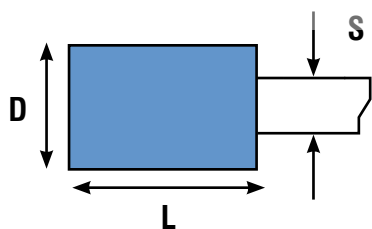
## Vitrified Bonded Abrasives



**Application Areas:** Mounted points are used in toolrooms for manufacturing of various tools and for snagging of castings and forgings. Use A (shaped mounted point wheels with 6mm shank) shapes for medium- to heavy-duty blending.



### Form B

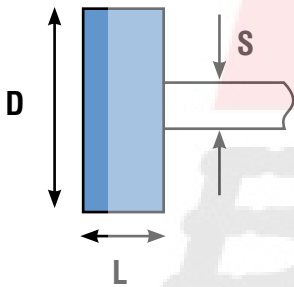


DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 15 x 6	40A 46 P 4 VL	20
15 x 20 x 6	40A 46 P 4 VL	20
15 x 25 x 6	40A 46 P 4 VL	20
15 x 30 x 6	40A 46 P 4 VL	20
15 x 35 x 6	40A 46 P 4 VL	20
15 x 40 x 6	40A 46 P 4 VL	20
20 x 20 x 6	40A 46 P 4 VL	20
20 x 25 x 6	40A 46 P 4 VL	20
20 x 30 x 6	40A 46 P 4 VL	20
20 x 35 x 6	40A 46 P 4 VL	20
20 x 40 x 6	40A 46 P 4 VL	20
25 x 25 x 6	40A 46 P 4 VL	5
25 x 30 x 6	40A 46 P 4 VL	5
25 x 32 x 6	40A 46 P 4 VL	5
25 x 35 x 6	40A 46 P 4 VL	5
25 x 40 x 6	40A 46 P 4 VL	5
30 x 30 x 6	40A 46 P 4 VL	5
30 x 35 x 6	40A 46 P 4 VL	5
30 x 40 x 6	40A 46 P 4 VL	5
32 x 32 x 6	40A 46 P 4 VL	5
32 x 40 x 6	40A 46 P 4 VL	5
40 x 40 x 6	40A 46 P 4 VL	5

# Mounted Points

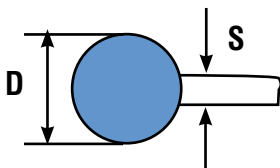
## Vitrified Bonded Abrasives

### Form A



DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 10 x 6	40A 46 P 4 VL	20
20 x 10 x 6	40A 46 P 4 VL	20
20 x 15 x 6	40A 46 P 4 VL	20
25 x 10 x 6	40A 46 P 4 VL	5
25 x 15 x 6	40A 46 P 4 VL	5
25 x 20 x 6	40A 46 P 4 VL	5
30 x 10 x 6	40A 46 P 4 VL	5
30 x 15 x 6	40A 46 P 4 VL	5
30 x 20 x 6	40A 46 P 4 VL	5
30 x 25 x 6	40A 46 P 4 VL	5
32 x 20 x 6	40A 46 P 4 VL	5
40 x 15 x 6	40A 46 P 4 VL	5
40 x 20 x 6	40A 46 P 4 VL	5
40 x 25 x 6	40A 46 P 4 VL	5
40 x 30 x 6	40A 46 P 4 VL	5

### Form H

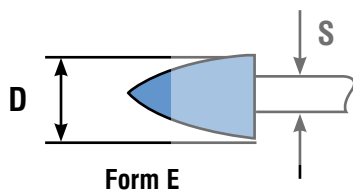
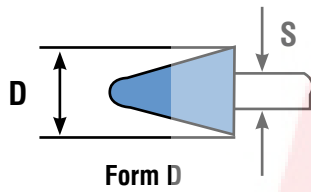


DIMENSIONS (mm) [D x S]	SPECIFICATION	BOX UNITS
15 x 6	40A 46 P 4 VL	20
20 x 6	40A 46 P 4 VL	20
25 x 6	40A 46 P 4 VL	5
30 x 6	40A 46 P 4 VL	5
32 x 6	40A 46 P 4 VL	5

# Mounted Points

## Vitrified Bonded Abrasives

### Form D / Form E

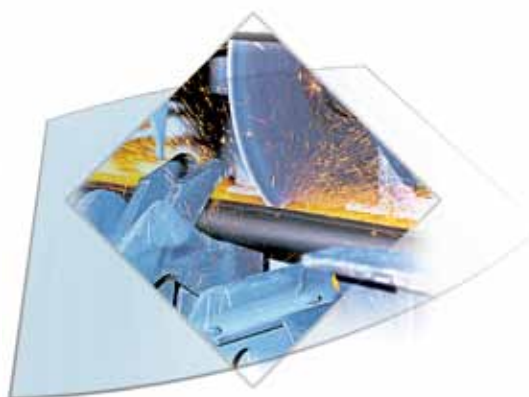
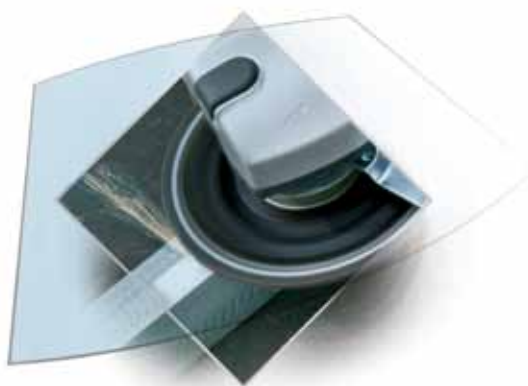


DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 15 x 6	40A 46 P 4 VL	20
15 x 20 x 6	40A 46 P 4 VL	20
15 x 25 x 6	40A 46 P 4 VL	20
15 x 30 x 6	40A 46 P 4 VL	20
15 x 32 x 6	40A 46 P 4 VL	20
15 x 35 x 6	40A 46 P 4 VL	20
15 x 40 x 6	40A 46 P 4 VL	20
20 x 20 x 6	40A 46 P 4 VL	20
20 x 25 x 6	40A 46 P 4 VL	20
20 x 30 x 6	40A 46 P 4 VL	20
20 x 35 x 6	40A 46 P 4 VL	20
20 x 40 x 6	40A 46 P 4 VL	20
25 x 25 x 6	40A 46 P 4 VL	5
25 x 30 x 6	40A 46 P 4 VL	5
25 x 32 x 6	40A 46 P 4 VL	5
25 x 35 x 6	40A 46 P 4 VL	5
25 x 40 x 6	40A 46 P 4 VL	5
30 x 30 x 6	40A 46 P 4 VL	5
30 x 40 x 6	40A 46 P 4 VL	5
32 x 32 x 6	40A 46 P 4 VL	5
32 x 40 x 6	40A 46 P 4 VL	5
35 x 25 x 6	40A 46 P 4 VL	5
40 x 30 x 6	40A 46 P 4 VL	5
40 x 40 x 6	40A 46 P 4 VL	5

# Troubleshooting for Flex Wheels

## Askaynak Abrasives

PROBLEM	CAUSE	REMEDY
<ul style="list-style-type: none"> <li>F27 not grinding</li> </ul>	<ul style="list-style-type: none"> <li>Flat grinding</li> <li>Wheel too hard</li> </ul>	<ul style="list-style-type: none"> <li>Maintain angle 25°-35°</li> <li>Use softer wheel</li> </ul>
<ul style="list-style-type: none"> <li>Wheel not cutting</li> </ul>	<ul style="list-style-type: none"> <li>Wheel glazing</li> </ul>	<ul style="list-style-type: none"> <li>Use softer wheel</li> </ul>
<ul style="list-style-type: none"> <li>Wheel wearing too soon</li> </ul>	<ul style="list-style-type: none"> <li>Wheel too soft</li> </ul>	<ul style="list-style-type: none"> <li>Use harder wheel</li> </ul>
<ul style="list-style-type: none"> <li>Burning</li> </ul>	<ul style="list-style-type: none"> <li>Wheel too hard</li> </ul>	<ul style="list-style-type: none"> <li>Use softer wheel,</li> <li>Use s freer cutting abrasive</li> </ul>
<ul style="list-style-type: none"> <li>Chatter marks</li> </ul>	<ul style="list-style-type: none"> <li>Machine vibration</li> <li>Wheel out of balance</li> <li>Mounting insecure</li> </ul>	<ul style="list-style-type: none"> <li>Check wear in machine bearing</li> <li>Balance the wheel</li> <li>Tighten wheel mounting</li> </ul>
<ul style="list-style-type: none"> <li>Uneven use of the wheel</li> </ul>	<ul style="list-style-type: none"> <li>Unbalance</li> <li>Run out not ok</li> <li>Incorrect mounting</li> </ul>	<ul style="list-style-type: none"> <li>Change the wheel</li> <li>Change the wheel</li> <li>Checking (dirt, flange,...)</li> </ul>
<ul style="list-style-type: none"> <li>Wheel breakage</li> </ul>	<ul style="list-style-type: none"> <li>To high speed</li> <li>To much pressure</li> <li>To much side pressure</li> <li>Cutting wheel used for grinding</li> </ul>	<ul style="list-style-type: none"> <li>Use prescribed speed</li> <li>Don't use force</li> <li>Maintain angle 90 °(F41, F42)</li> <li>Don't grind with cutting wheel</li> </ul>







 Eczacıbaşı

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