NORTON

SAINT-GOBAIN

ABRASIVE TECHNOLOGICAL EXCELLENCE

Jimi
VELKOOBCHOD

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VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

- Worldwide market leader
- Product innovations
- Cutting edge technologies
- Complete range of stock products
- Widest spectrum of product quality
- Made-to-order solutions

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ABRASIVE TECHNOLOGICAL EXCELLENCE

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THE WORLD'S PREMIUM ABRASIVE BRAND

Norton, the world's premium abrasive brand, offers a complete range of high performance products designed to perform in any abrasive application in all industrial markets.

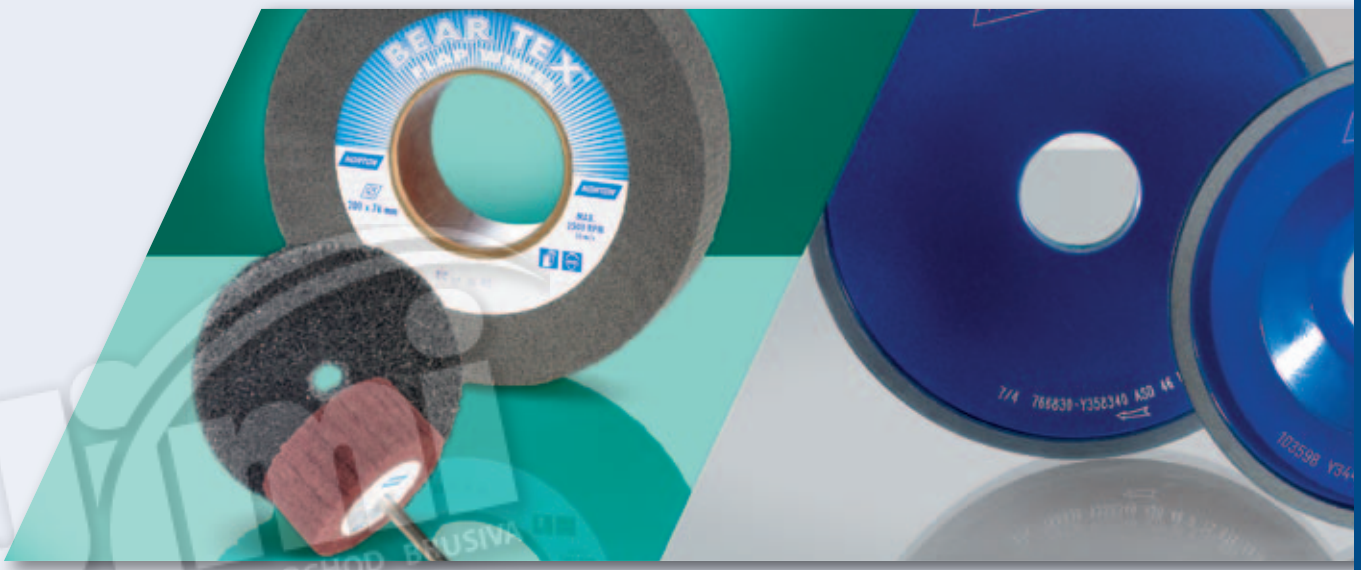
As the technology leader, Norton sits at the forefront of the industry offering highly engineered value-adding abrasive solutions. Each year, Norton makes substantial investments in R&D helping to generate innovative ideas that aim to revolutionise abrasives. This strong commitment to innovation ensures that exciting new products are continuously introduced, offering substantial benefits to customers by helping to improve process productivity.

As well as New Product Development, Norton is committed to utilising technology breakthroughs in all its existing products. Both the Norton stock range and made-to-order solutions are continually reviewed to ensure that the product offer remains fresh and conforms to the most recent market trends. This approach ensures that all Norton products benefit from state-of-the art technology, and that the Norton brand has continued sustainable market growth.

Norton reinforces its position as market and innovation leader by constantly analysing the market to ensure it continuously fulfils customer needs. Norton looks to acquire and hold extensive knowledge about its customers' business activities and product priorities. This market orientated approach enables Norton to better anticipate customer requests and to have an improved understanding of market developments.

Norton's technical expertise ensures not only are the most appropriate products used in all abrasives applications but also they are used in an effective and safe manner, maximising performance. Through this Norton looks to establish valuable working partnerships with its customers of all sizes and stature. These working partnerships are reinforced through extensive marketing activities that support its complete and innovative product range.

Norton is much more than the world's leading manufacturer of abrasive products, it's a brand that has become and remains number one in the minds of its customers. Norton is committed to the long-term development of abrasives and is part of a company that looks to assist customers in all their abrasive needs.



THE WORLD'S PREMIUM ABRASIVE BRAND

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ABRASIVE TECHNOLOGICAL EXCELLENCE

Since Norton's first breakthrough, in 1885, research efforts have continued to produce industry-leading results. At the start of the 20th Century Norton's first innovation was the invention of Norton's trademark Alundum abrasive grain, an alumium oxide grain that could be manufactured to meet precise grinding requirements. Throughout the 20th and early 21st Centuries Norton has increased its research efforts by developing innovative products made with new grains including, aluminium oxide, zirconium oxide (Norzon®), Seeded Gel (SG®) and IPA (Vortex™).

Today, Norton's relentless commitment to Delivering Technological Excellence is reinforced through its "Centres of Excellence". Positioned across the globe, each centre concentrates on the development of exciting new products and grains for all applications found within one type of abrasives.

Centre of Excellence

BONDED ABRASIVES

Opened in 1993, the World Grinding Technology Centre in Worcester, Massachusetts, USA, is Norton's premier research centre for Bonded Abrasives products. In 1998, the centre was renamed as the Higgins Grinding Technology Centre, in honour of the late Milton P. Higgins, a member of one of the founding families of Norton.

The centre is dedicated to the advancement of grinding technology and abrasive product performance, using structured R&D that focuses on grinding system solutions, coolant system solutions, and process diagnostics and optimisation.

The centre conducts regular training sessions promoting a systems orientated education focusing on new process development, and increasing the awareness of new product technology. The centre enables Norton to set the standard for Bonded Abrasive product performance throughout the worldwide abrasives industry.

SUPER ABRASIVES

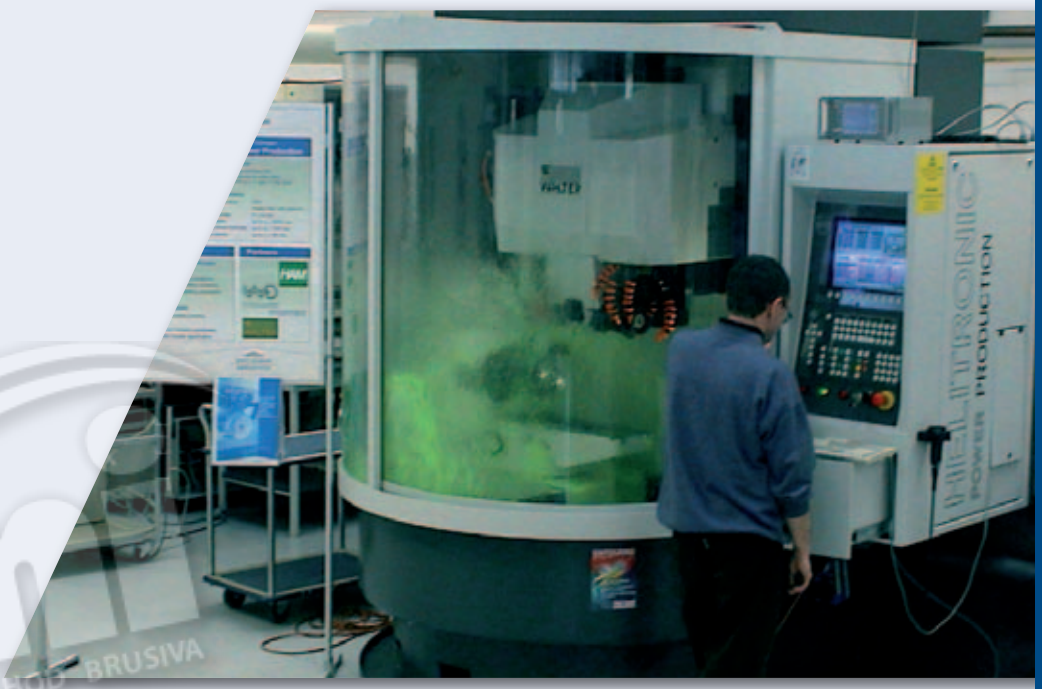
The Norderstedt Technology Centre (NTC), founded in 2001, is located at the Saint-Gobain Abrasives Diamantwerkzeuge production plant in Noderstedt, Germany. Since opening, the NTC has played a key role in new grinding wheel and process technology development for Super Abrasive products.

The centre brings together the expertise of Super Abrasive specialists who have a profound understanding of the complex grinding system, with innovative measurement and analysis tools which enables detailed investigation of grinding wheel performance and complex tool-workpiece interactions.

The NTC conducts short-term customer application projects in close collaboration with the Saint-Gobain Abrasives application engineering teams, who have a strong European presence. As well as this, long-term projects targeting more complex tasks are frequently performed by the centre. The centre allows research teams, consisting of end-users, grinding wheel manufacturers and machine manufacturers, to meet in one place. This enables fast, sustainable and economical solutions for all Super Abrasive applications.

The NTC possesses a number of modern CNC grinding and consignment machine tools to deal with the different applications found in a global market.

The attitude at the centre is highlighted by the numerous seminars and training sessions conducted each year, for both Saint-Gobain Abrasives employees and Norton customers from across the globe.



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CUTTING-OFF & GRINDING WHEELS

The Saint-Gobain Abrasives Centre of Excellence in Eibergen, Netherlands has outstanding experience in testing Cutting-off and Grinding wheels. The highly sophisticated test centre has advanced training facilities with a range of carefully selected, up-to-date machines enabling tests to be carried out on the most common application materials. It is possible to test all wheels in the Norton range from diameter 76mm to 406mm, analysing cutting performance, grinding performance, and wheel safety.

The test centre also contains a state-of-the-art robot, which, when used by the centre's expertly trained operators, enables highly reliable test figures to be produced in clear test reports. This not only helps Norton sales teams sell products but also supports Research and Development efforts.

Regular training sessions are also conducted for employees and customers which cover both the theoretic and practical aspects of our products and their application. Regular presentations and demonstrations are given by our product and application specialists.

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COATED ABRASIVES

For more than 80 years our manufacturing plant, in Wesseling near Cologne, Germany, has been well-known for the development of Coated Abrasive products. Computerised production processes, high performance product specifications formulations and a long-standing quality management system give the required assurance for the high performance of all Wesseling manufactured products.

This long standing expertise has allowed Norton product and application engineers to have a superb understanding of the technical issues encountered during coated abrasive applications.

The Wesseling Technology Centre, due to be officially opened as a Centre of Excellence in 2007, features a state-of-the-art Automotive Aftermarket training centre including a spray booth that replicates the real life working environment of Body and Paint Shops.

The Technology Centre is also equipped with a high tech back stand grinder, down draft tables and selected hand tools, that allow focused application tests to take place. This gives Norton engineers the fullest and most accurate knowledge of applications using basic products to more high-tech engineered abrasives, such as NORaX®.

The forward thinking approach adopted at Wesseling is passed to sales staff through regular training sessions, giving them a greater understanding of our products to pass on to our customers.

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DIAMOND BLADES

Norton's facilities in Bascharage, Luxembourg, host the Norton Diamond products state-of-the-art Centre of Excellence.

Ideally located in the centre of Europe, the facilities are used to offer regular training sessions to both staff and customers. Visitors to the centre can learn about the best use for the different types of diamond blades, compare the different Norton ranges in the demonstration area, and learn about effective and safe methods of use. Using products and seeing them being used by experts not only helps provide a more memorable experience, but also helps people develop a greater understanding.

The showroom at Bascharage also gives visitors the opportunity to see the whole range of Norton Diamond Blades as well as every type of Clipper machine.

The centre is also a key resource for product development and testing. All new products are subjected to strenuous tests to gather accurate application and performance statistics. This not only ensures product safety, it also ensures accurate information is gathered meaning products can be sold with confidence by our sales personnel. The test area is of-course equipped with a wide range of up-to-date equipment, to help measure and control product tests.

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DELIVERING INNOVATIVE EXCELLENCE

INNOVATION

Investing in R&D, stimulating the generation of new ideas, and increasing the speed at which cutting-edge science is turned into market-ready products, are identified as key factors that determine business success and are some of Norton's main business priorities.

Norton also takes an innovative approach to its business operations, and is committed to the continuous improvement processes and services, creating, evaluating and exploiting new ideas to help continuously add value to its customer relations.

Recently a number of product innovations have been introduced. These are clearly highlighted throughout this catalogue.

Norton's innovative abrasive solutions offer outstanding productivity and versatility, and help reinforce its position as the world's leading manufacturer of abrasives.

NEW TECHNOLOGY

NORAX

NORaX® is an engineered three-dimensional coated abrasive product that uses an innovative structure to help give high performance in cut, finish and consistency. Using special pattern technology, the product can be adapted to work better in different situations, increasing productivity, quality and repeatability, whilst reducing cost, scrap, and inventory.

VORTEX technology

Vortex™ technology is an innovative new grinding concept that combines high metal removal rates with minimum heat generation. Cycle times can be reduced by up to 50% and productivity is greatly improved, with 2 to 3 times the number of pieces ground per wheel, compared to more standard solutions.

THE WORLD'S PREMIUM ABRASIVE BRAND

NORTON QUANTUM

Norton Quantum is the new generation of ceramic grain with innovative organic and vitrified bonds specially developed to enhance grain performance. Cutting edge innovation makes Norton Quantum Grinding Wheels last 50% to 100% longer - designed for maximum performance and cost savings. With unrivalled precision, Norton Quantum Wheels provide the fastest and finest grinding in the industry. Norton Quantum wheels use a new alumina grain chemistry and shape developed from the Norton's patented Seeded-Gel Technology. This revolutionary ceramic grain multiplies the cutting efficiency by controlling the grain breakdown at the micrometric level. Norton Quantum is a versatile technology that is ideal for low, medium and high force applicationson materials ranging from cast iron to stainless steel as well as hard to-grind inconel and titanium.

NEW ABRASIVE GRAINS

SG BLAZE R980 + VIKING R996

R980 and R996 use a new generation ceramic SG® abrasive for Coated Abrasive belts, flap discs, and SpeedLok® discs. It cuts faster and has significantly longer product life compared to all other standard abrasive solutions. This cool cutting abrasive generally lasts between 50% and 200% longer than standard products.

Red Dragon FX 21

Introducing the New Generation of SG Ceramic Fibre Discs engineered for high material removal and fast cut rate and performance. This new revolutionary product is a polyvalent product, replacing the Greenlyte Plus. It offers increased productivity versus competitor products, a more aggressive cut rate combined with a very high quality of surface finish. It is ideal for metal removal, weld grinding & blending & light deburring & finishing, so is ideal for use in a range of markets including car manufacture & repair, metal fabrication, & welding & foundries.

NEW PRODUCT CONCEPTS

NORTON QUANTUM

Norton Quantum is a new generation of ultra thin wheels specially developed using the new and revolutionary Patent Pending Bond Technology in combination with the new NorZon Plus grain - a unique combination that significantly increases grain performance.

- 0,8mm thickness for fast and precise cutting
- 1,0mm thickness for fastest cut rate and minimum material loss
- 1,3mm thickness specially developed to cut tubes and profiles
- 1,6mm thickness for demanding applications
- 7,5mm thickness

  This grinding wheel is optimized for safe use on high power machines and rough applications. Extreme stability and performance.

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Cutting, light grinding and polishing! All with one single product. Impossible? Not anymore! The new Norton 1-2-3 wheel makes it possible! The unique 3 layered reinforcement structure in combination with the selected abrasive materials contribute to this innovative new product. So, finally there's no need to be continually switching wheels. The new Norton 1-2-3 can save you valuable time.

OCTOPUS

The Norton Octopus® grinding and polishing wheel allows you to see the workpiece through the wheel whilst it is being worked on. This means work is more precise and it does away with the need to continually keep pulling away from the workpiece to check results. This improves productivity by reducing the time spent on each operation.

MULTI AIR

Multi-Air® combines the excellence of Norton No-Fil® technology with a revolutionary dust extraction system that provides users with an optimal sanding solution. The dust extraction system gives a 30% increase in dust extraction, meaning clogging is virtually eliminated, the working environment automatically becomes cleaner and the cutting surface of the disc remains cleaner with less clogging. This gives a 35% increase in productivity when compared to traditional vacuum systems. All Multi-Air® discs should be used with the corresponding back-up pad that forms part of the revolutionary dust extraction system.

4x4 Explorer

"4x4 Explorer" is the revolutionary laser-welded diamond blade from Norton, for petrol handheld saws, floor saws and masonry saws.

It is designed for cutting the widest variety of building materials from reinforced concrete and granite, to asphalt, scaffold poles and barriers.

"4x4 Explorer" also introduces the innovative patent-pending "cut depth indicator", the perfect device to optimise cutting speed and blade life in step-cutting.

Personal Protection Equipment

From Norton, the world's leading abrasive brand, comes a new range of personal protection equipment designed to provide the highest standard of protection in the workplace. Through understanding our customers needs and requirements for a safer working environment, we are able to deliver a valuable, effective solution for applications in multiple industries.

SAFETY AND QUALITY IS OUR PRIORITY

The range comprises a selection of Respiratory Masks with filters providing varying levels of protection against chemicals, as well as Glasses, Gloves and Overalls.

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THE WORLD'S PREMIUM ABRASIVE BRAND

DELIVERING MADE-TO-ORDER SOLUTIONS

NORTON IS A UNIQUE SOLUTION PROVIDER

Whatever the industrial sector, Norton is dedicated to providing the most appropriate and effective abrasive solution for any application including cutting, grinding and polishing.

In addition to the thousands of stock products available in Coated, Bonded, Thin Wheels, Diamond Blades and Super Abrasives, Norton offers a large number of made-to-order products designed to meet any technical requirement.

Made-to-order solutions represent a significant amount of the complete Norton product offering. When complex application environments have to be analysed, when cutting-edge technology is necessary to optimise product performances, our leading brand offers the premium solution.

Many Norton customers benefit from our technical support – facilitating the choice of abrasive and combining insight from both sides to run appropriate tests and improve processes.

Sharing views and experiences, Norton represents your preferred partner to increase productivity and reduce overall cost.

WHY SELECT NORTON?

BECAUSE:

- Our Centres of Excellence enable product testing under real conditions
- We have highly skilled, knowledgeable and experienced personnel devoted to delivering high performance solutions to fulfil customer needs
- We allocate time and resource to product testing/customer case studies
- We have acquired invaluable experience over our long history
- We establish client partnerships to ensure we are aware of the most up-to-date technology with regard to processes, machines and coolants

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OUR MANTRA IS CLEAR:

Help customers select the right abrasive from our huge product offering and deliver highly engineered solutions that not only meet but exceed very specific and technical requirements, in all market segments.

CASE STUDY EXAMPLE 1 BONDED ABRASIVES

	Vitrified	Vitrified	Organic
Market	Aerospace	Gearing industry	Steel mill
Application	Creep Feed grinding	Gear grinding	Large cut-off operation
Workpiece	Turbine blade for power generator	Gear	Bars
Material	Inconel 738	Cemented treated steel	Stainless steel
Coolant	Water soluble oil	Emulsion 2%	n/a
Dresser	Diamond roll	Diamond roll	n/a
Norton Wheel	Altos TGX80D13VCF5	Vortex™ IPA60ME29VTX	Toros ZUA20XBF2
Shape	.01	.01F	.01
Dimension (mm)	508x40x127	450x20x127	1250x13,5x200
Benefit	Increase wheel life by a factor of 3,4	Reduce the cost per part by 3%	Improve wheel life time by 30%

CASE STUDY EXAMPLE 2 SUPER ABRASIVES

Market	Tool room	General engineering	General engineering
Application	Peripherical grinding of inserts	OD grinding	Surface grinding
Workpiece	Inserts	Drill bits	Tool
Material	Tungsten carbide	Polycristalline Diamond	HSS
Coolant	Emulsion 2%	Emulsion 2%	Emulsion 2%
Norton Wheel	Norton SD54R100B77	Norton DEH126R125B56	Norton CB126QBB
Shape	12A2	3A1	1A1
Dimension (mm)	350x23x300 W=15 X=9	508x30x203,2 X=6,35	350x30x127 x=4
Benefit	Productivity increased by 25%	Decrease grinding cost by 20%	Reduction on cutting time by 15%

CASE STUDY EXAMPLE 3 COATED ABRASIVES

Market	Aerospace	Chipboard	Automotive industry
Application	Gate grinding	Sanding	Metal blending
Workpiece	Turbine blades	Boards	Body of a car
Material	Inconel	MDF	Metal
Norton Product	R 980	S 482	NORaX® U264 X200 Norgrip® discs
Shape	Belts	Sectional belts	Norgrip® disc
Dimension (mm)	150x3500	2620x3820	150x0
Benefit	Belt life +200%	Higher quality in surface finish reduces downtime (fewer belt changes)	10 times the life time of a standard paper disc with a consistent cut & finish

To learn more about Norton made-to-order capabilities, highly effective engineered solutions, cutting edge technologies that can help you optimise performance and reduce costs, please contact your local Customer Service Department.

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THE WORLD'S PREMIUM ABRASIVE BRAND

HEALTH, SAFETY & ENVIRONMENT

ACTIVITIES

Our responsibility to customers, particularly in the area of safety and comfort, is taken very seriously. Products are designed and produced to the most stringent quality standards to guarantee optimum personal safety and user comfort. Saint-Gobain Abrasives is an active member of both FEPA and oSa.

Norton products comply with all expectations of European health, safety and environmental standards.

FEPA, the Federation of European Producers of Abrasives, is dedicated to the promotion of safety in the use of abrasives and is actively involved in the preparation and implementation of the European (EN) and International Standards (ISO) for Abrasives and Grinding machines.

oSa, the Organisation for Safety of Abrasives pursues in close collaboration with FEPA the objectives of supporting both the currently attained safety standards for abrasive products and their further developments.

The internal testing and certification is based on the following standards:

- Safety requirements for Bonded Abrasive products (EN12413: 1999)
- Safety requirements for Super Abrasive products (EN13236: 2001)
- Safety requirements for Coated Abrasives (EN13743: 2002)
- Safety requirements for Diamond Blades (EN13236: 2001)

Thus the oSa symbol on the abrasive signifies enhanced application safety for the user, a reduced liability risk and excellent brand image for manufacturers, traders and those in marketing.

ISO 9001, certifies Quality Management system is in accordance with requirements of quality standards.

ISO 14001, certifies Environmental Management system is in accordance with requirements of environmental standards.

OHSAS 18001, health and safety at work certification.

DELIVERING ENVIRONMENTAL EXCELLENCE

Norton prides itself on having an environment friendly approach to all its business activities. This approach is actively pursued as caring for the environment is a fundamental part of the corporate culture of Saint-Gobain. Environmental responsibility is both our responsibility as employers and also important for successful business operations.

Saint-Gobain Abrasives actively looks to promote its environmental principles through its widely distributed EHS (Environment, Health and Safety) policy. The Environment Policy Statement is distributed to all employees in Europe, to ensure a clear consistent message is delivered. This is supported by the responsible attitude shown by all our employees towards the use of natural resources, and constant monitoring to ensure that environmentally focused business objectives are met. This is ensured through regular procedural reviews and employee training sessions.

ENVIRONMENT PROTECTION

- Waste management is undertaken to optimise recycling activities of materials including paper, carton, wood, production dust, steel, and batteries
- Zero pollution of air, water and land is defined as a major objective

REDUCTION OF NATURAL RESOURCES CONSUMPTION

- New production processes and procedures are regularly implemented to help minimize the amount of waste created at all manufacturing processes
- Improving process technology and systems is a strong focus to help enhance energy conservation

All Saint-Gobain Abrasives manufacturing facilities implement an Environmental Management System, with most having been certified to the international ISO 14001 standard. The company's objective is to have all the sites certificated with this standard before the end of 2007.

We, at Saint-Gobain Abrasives, seek to achieve environmental excellence in all our business operations.

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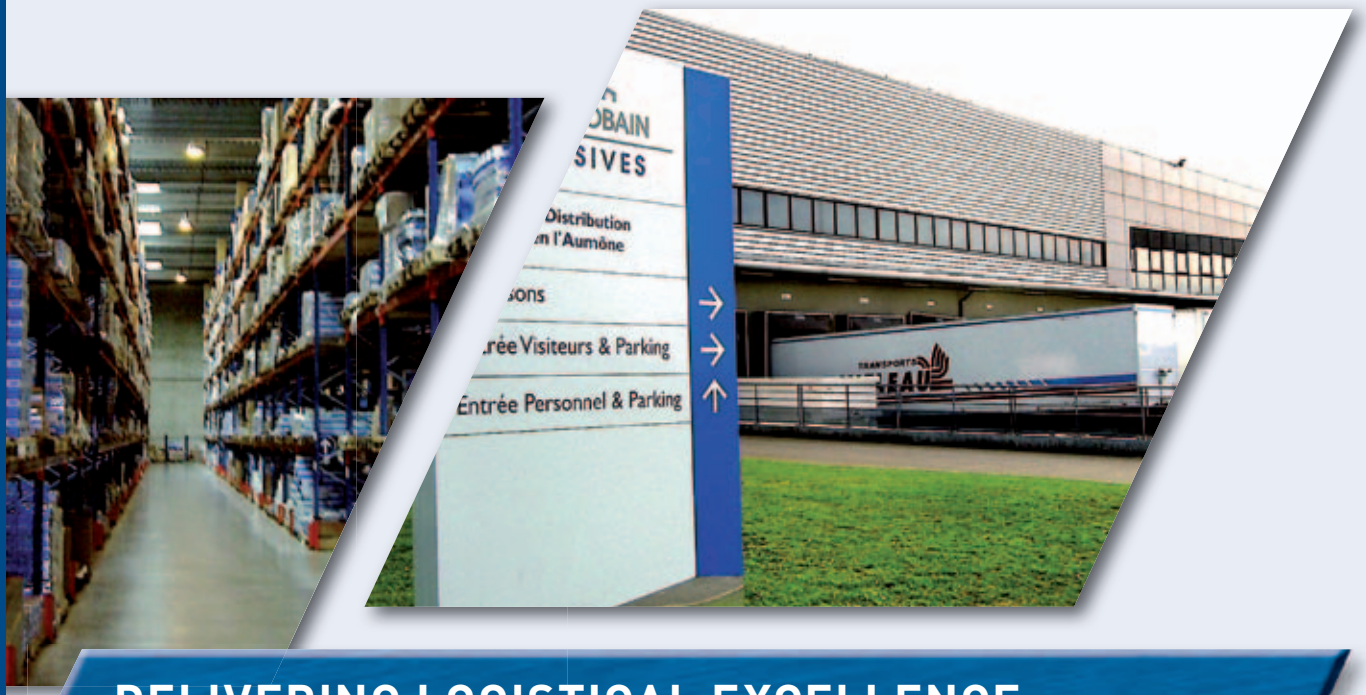

DELIVERING LOGISTICAL EXCELLENCE

In order to confirm Norton's market leading position and support our highly engineered, innovative product solutions, Norton operates a range of ERP and Quality Management systems. This enables continuous improvement of performance at every stage of the logistic chain, through careful effective monitoring of all logistical processes and the subsequent implementation of new technology and best practice procedures.

Today, Norton has a logistics team of 80 specialised people who are dedicated and focused on satisfying customer requirements. Our planning system, integrated directly with our order processing system, is managed and controlled by a team of forecasting experts who look to maintain and improve our service level (over 97% today).

Reviews are continuously undertaken to improve packaging techniques and new packaging technology is regularly considered, and implemented where appropriate. This ensures customers receive all products in excellent condition.

Norton operates the biggest abrasives distribution centre in Europe with 10,000m² used to stock more than 8,000 product lines in one location. We have more products at our fingertips than any other abrasives manufacturer in the world. Shipping over 4,000 product lines every day and working closely with carefully selected partners, gives us the necessary experience and expertise to provide an unrivalled delivery service to our customers.

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A HISTORY OF EXCELLENCE

In the mid 19th Century, a group of ceramists and entrepreneurs in Worcester, Massachusetts, USA, set out with a goal: meet the growing need of the burgeoning U.S. manufacturing industry, which needed an ever-increasing supply of grinding wheels to build and maintain machinery.

By 1876 Norton were manufacturing grinding wheels, and had acquired a patent for vitrified wheels. In 1885 the Norton Emery Wheel Co. was founded to manufacture the first grinding wheel that could be precision made and mass-produced.

Through the latter part of the 19th Century Norton expanded its abrasives range and reached customers throughout the U.S. and Canada. In 1909, Norton built its first European plant in Germany. This was followed by plants in France (1920), UK (1930), and Italy (1935). In the 1930s Norton strengthened its position by expanding into Coated Abrasives. In the same decade Norton developed Diamond and CBN based Super Abrasives.

By 1950 Norton had established itself as the leading world-wide abrasives brand. In 1956, Norton entered South America through an acquisition in Brazil, and followed this with plants in India (1968) and Japan (1972). This steady growth, based upon innovation, technology and responsiveness to customers, has continued and Norton now has a presence in 28 countries around the world.

In 1990, Norton was acquired by Saint-Gobain, a world leader in the manufacture of engineered materials. Saint-Gobain, founded in France in 1665, shares Norton's tradition of commitment to its business and customers, of understanding and responding to the needs of the marketplace and of technical innovation. Saint-Gobain's experience has been a strong addition to the Norton brand.

For over 125 years, Norton has provided innovative solutions for the challenges faced by industries. Our dedication to our business and customers ensures we will continue to be the world's number one abrasive manufacturer supplying a complete range of products that continually add value and efficiency to your operation.

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THE WORLD'S PREMIUM ABRASIVE BRAND

PATENTS & TRADEMARKS

Norton shows its commitment to innovation by filing Patents & Trademarks for its most innovative product solutions.

ALTOS
AZTEC®
BDX™
BEAR-TEX®
BLACK ICE™
BLUE FIRE™
DURATOR®
GOLD RESERVE™
INDIA OIL STONE®
MULTI-AIR PROCESS®
NO-FIL®
NORaX®
NORBIDE®
NORGRIP
NORTON®
NORTON ICE™
NORTON INDUSTRIAL LINE™
NORTON SG®
NORTON SG® BLAZE
NORZON®
OCTOPUS®
ROTOLO® FOAM
SOFT-TOUCH®
SPEEDLOK®
SPEEDOFLEX
SUPER BLEUE 2™
TOROS™
VORTEX™

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NOTES

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A CORPORATE PERSPECTIVE

Norton, the world's leading abrasives brand, is the key ingredient in an effective portfolio of brands from Saint-Gobain Abrasives. The mission is to deliver a portfolio of highly recognised brands, each with unique value, fulfilling the complete spectrum of customer needs.

Saint-Gobain Abrasives takes time to understand and fulfil its evolving customer needs which is reflected in its worldwide market leader status. With a strong presence in every continent the Abrasives Division serves its customers through structured units in 27 countries and employs 10700 people. It is the only international manufacturer of abrasives that provides each of the 3 major types of abrasives; Bonded Abrasives (resinoid and vitrified), Coated Abrasives, and Diamond products. This is supported by exceptional technology, complete and innovative product lines, an irrefutable reputation for quality and safety, and experienced, committed, passionate people.

Abrasives forms a key part of the High Performance Materials Division of Saint-Gobain, which is one of 4 key areas of activity in which Saint-Gobain operate.

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ABRASIVES

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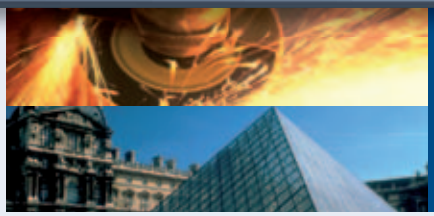
SAINT-GOBAIN BUSINESS SECTORS

INNOVATIVE MATERIALS



High Performance Materials	**No 1** worldwide
Flat Glass	**No 1** in Europe **No 2** worldwide

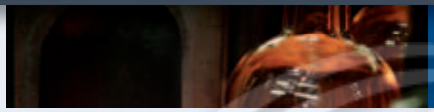
CONSTRUCTION PRODUCTS

Pipelines	**No 1** worldwide in ductile cast iron pipe
Gypsum	**No 1** worldwide in plasterboard and plaster
Insulation	**No 1** worldwide in insulation
Mortars	**No 1** in Europe for wall facings **No 1** worldwide for tile adhesives
Exterior products	**No 1** in the USA in siding

BUILDING DISTRIBUTION

Building Distribution	**No 1** worldwide in tile distribution **No 1** In Europe Building materials distribution network **No 1** in Europe in plumbing, heating and sanitaryware products

PACKAGING VERALLIA

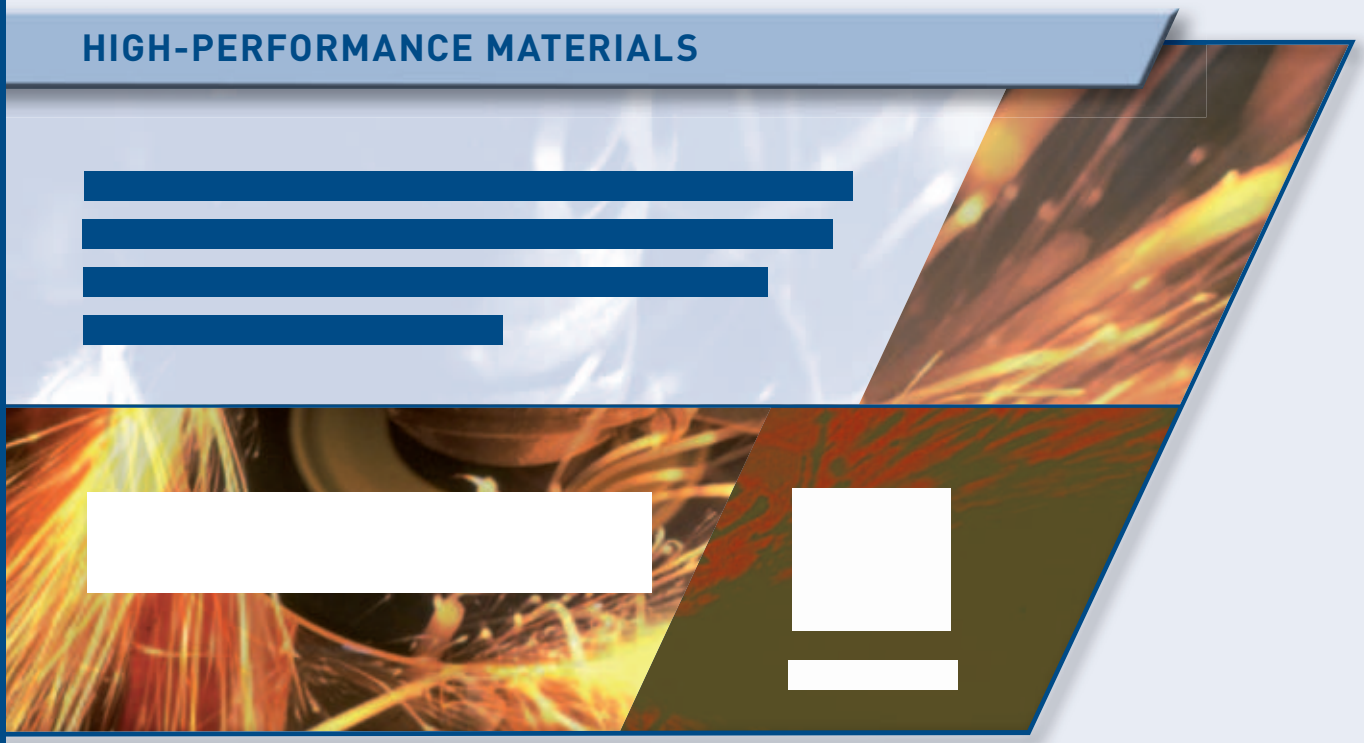


Packaging	**No 2** worldwide bottles and jars

jimi VELKOOBCHOD BRUSIVA

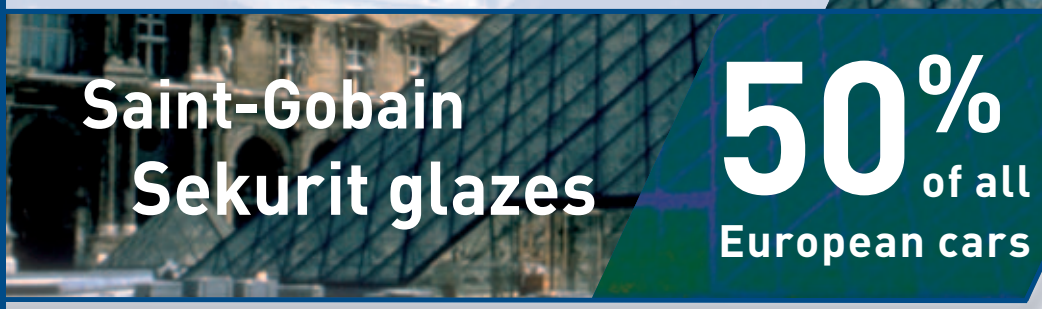
A CORPORATE PERSPECTIVE

HIGH-PERFORMANCE MATERIALS



FLAT GLASS

The Flat Glass business manufactures, processes and sells glass products for three main markets: building, transportation and solar energy.



50% of all European cars

VELKOOBCHOD BRUSIVA

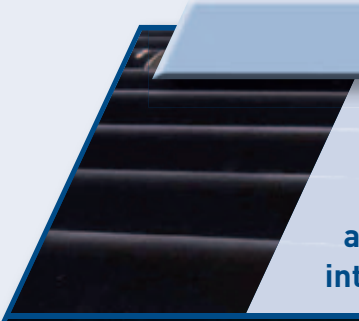
PACKAGING VERALLIA

The Packaging Sector makes glass containers for the food industry.

Makes more than **25** billion bottles and jars a year.

Operations: **13 countries**

CONSTRUCTION PRODUCTS



Saint-Gobain Construction Products markets interior and exterior solutions for all types of building. It offers solutions for all types of projects, from acoustic and thermal insulation and facade coatings to roofing, interior and exterior design products and piping.

Operations: **55 countries**

BUILDING DISTRIBUTION

The Building Distribution Sector serves the newbuilding, renovation and sustainable building markets.

Operations: **26 countries**

ABRASIVE MARKET SEGMENTS

METAL FABRICATION

Norton continues to play a key role in the Metal Fabrication market, delivering hi-tech relevant abrasive solutions for all applications in surface preparation and finishing. Decades of acquired expertise combined with innovative technology allows Norton to offer the most appropriate abrasive solutions for the most common applications, including: ship building, food industry, chemical and oil industries and boiler making.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Cutting sheet metal	Wheels for Angle Grinders	Fast cut operation	**48**
Heavy grinding & deburring	Fibre discs	Agressive cutting	**94**
Welds grinding & blending	Flap discs	Versatility	**100**
Grinding & sanding all kind of metals	Narrow belts	High stock removal	**234**
Light to medium deburring	SpeedLok® discs	Long life	**116**
Light to heavy duty cleaning	BearTex® discs	High resistant	**110,112**
Finishing of Stainless Steel	NORaX® belts	Consistent and predictable surface finish	**241**
Cleaning & finishing	Flap wheels	Consistent finish	**246**
Derusting of Steels, Inox	Wire Brushes	Steady Brushing	**459**

NEW PRODUCTS

COATED ABRASIVES	PAGE	CUTTING-OFF & GRINDING WHEELS	PAGE
F975 & F971 Greenlyte Fibre discs	**95**	1-2-3 wheels	**46**
R828 X-TREME Flap discs	**101**	Octopus® Grinding wheels	**61**
F980 Norton SG Blaze	**118**	0,8mm Ultra-thin Cut-off wheels	**49**
R996 Viking belts	**236**	Norton Quantum ultra thin cut-off wheels	**48**
R207 Flap wheels	**246**		

THE ULTIMATE SOLUTION

NORaX® BELTS — **241**

An incomparably high performance, high quality product designed specifically for finishing

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

GENERAL ENGINEERING

Norton provides technical solutions for applications from surface grinding to sharpening operations on a range of materials from high alloy to stainless steel. In addition Norton offers technical assistance to help provide optimum performance in application precision, quality of finishing and operation productivity. Typical sectors: mechanical, mould industry, tool industry, aerospace subcontractors and medical prosthesis.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Surface grinding	Vitrified wheels	Cool & burn-free cutting	**302**
Truing & dressing a wheel	Dressers	Optimises the cutting action & the finish	**412**
Restoring the cutting edge on tools	India stones	Long lasting cutting edge	**354**
Internal grinding	CBN wheels	Excellent cutting	**384**
Surface grinding & finishing	Narrow belts	Quick metal removal & surface finishing	**234**
Shaping & deburring	Carbide burrs	Long life, reduction of cutting force	**474**
Light deburring	Coated specialties	Conformability to complex surfaces	**140**
Surface finishing	Flap wheels	Consistent wear rate, high quality results	**246**
Polishing of moulds	BearTex® wheels	From preparatory lapping to finest finishing	**252**

NEW PRODUCTS

BONDED ABRASIVES	PAGE	COATED ABRASIVES/BEARTEX®	PAGE
Norton Quantum	**302**	R980 SpeedLok® discs	**118**
Vortex™ Grinding wheels	**303**	BearTex® metal finishing convolute wheels	**252**

THE ULTIMATE SOLUTION

NORTON QUANTUM	**NORTON QUANTUM**	**302**

Engineered ceramic grain shape and chemistry with new bond technology.
A perfect blend between sharpness (free cutting) and toughness (life).

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

ABRASIVE MARKET SEGMENTS

MAINTENANCE & REPAIR OPERATIONS

From the most advanced and critical operation to the simplest task, Norton provides an effective solution. Customers can benefit from the largest stock range of abrasives available anywhere in Europe. On any material Norton can provide you with a range of cost effective solutions for use by hand or machine.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Sharpening HSS tools	Vitrified bench wheels	Free cutting	**324**
Light to heavy duty cleaning	BearTex® sheets	Conformability to complex surfaces	**206**
Light deburring	Handy rolls	Multi-purpose	**216**
Building maintenance	Portable diamond blades	Highly versitile product	**424**
Cutting pipe	Cut-off wheels	Fast cut	**48**
Blending welds	Flap discs	Versatile & long lasting	**100**
Deburring	Mounted points	Precise	**342,378**
Removing imperfections	Specialties	Wide range of items for accessing intricate areas	**140**

NEW PRODUCTS

COATED ABRASIVES/BEARTEX®			PAGE
Convolute wheels	**252**	Sanding Stars	**146**

DIAMOND BLADES/CUTTING-OFF & GRINDING WHEELS			PAGE
4x4 Explorer	**424**	1-2-3 wheels	**46**
		Norton multi-purpose cut-off wheels	**53**

THE ULTIMATE SOLUTION

1-2-3 WHEELS **46**

The most versatile wheel on the market. Cutting, light grinding & polishing, all with one single product. No more lost time due to changing machines or products

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

WOODWORKING

Norton has actively developed new solutions with innovative abrasives products in full co-operation with customers over many years. Whatever the machine type is, Norton is in a position to optimise the sanding process. In addition to abrasives dedicated to sophisticated machines, Norton has created a very effective range of tools, easy to use like sponges or sanding block for manual operations. Furthermore, a huge variety of product shapes are available to fit with any particular application that requires specific abrasive types. Typical sectors: carpentry, furniture manufacturer, parquetry (manufacturer and renovation), boat and marine.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Sanding & finishing of wood	Narrow & wide belts	Long life	**266,270**
Sanding contours	Abrasives sanding sponges	Soft & versatile manual finishing	**208**
	Narrow belts	Very flexible for machine polishing	**242**
Re-sharpening saw blade	Vitrified wheel	No burn & straight cut	**302**
Sanding	Portable belts	Long life	**228**
Hand sanding	Paper sheets	Load resistant	**200**
Bare wood sanding	Cloth rolls	Excellent finish	**272**
Varnished surface sanding	No-Fil® paper discs	Anti-clogging & longer lasting	**164**
Edges sanding	Polyester narrow belts	Sharp & long lasting belts	**290**

NEW PRODUCTS

COATED ABRASIVES/BEARTEX®			PAGE
Norton Ice Discs	**162**	Multi-Air® discs	**155**

THE ULTIMATE SOLUTION

H231	**NARROW & WIDE BELTS**	**242,266**

These high performance aluminium oxide belts are ideal for any sanding applications, from rough sanding to finishing operations

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

ABRASIVE MARKET SEGMENTS

FLOOR SANDING

Norton leads the development of abrasive technology in this market through innovations such as Norton Red Heat R955 with New generation SG® grain which provides the optimum productivity at the lowest cost.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Drum sanders	Sheets & rolls	Easy to use, load resistant	**200**
Belt sanders	Belts	Ideal cost/benefit ratio	**270**
Edger sanders	Discs	Time-saving	**162**
Buffer sanders	Screen-bak® & Double-sided discs	Anti-clogging for a perfect finish	**276**

NEW PRODUCTS

COATED ABRASIVES/BEARTEX®	PAGE
Red Heat R955 belts	**270**

THE ULTIMATE SOLUTION

NORTON SG REDHEAT | **RED HEAT R955 BELTS** | **270**

These polyester backed belts are extremely strong & ideal for floor sanding. There's no need to look for any other product when sanding hard wood

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

FOUNDRY

Norton holds significant expertise in the foundry applications by conducting thorough analysis of the complete abrasive process to help maximize productivity. The products offered are capable of providing incomparable solutions for the most demanding applications in the industry. Typical sectors: aerospace, automotive and medical prosthesis.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Deburring	Grinding wheels	High stock removal rate	**63**
Removing cracks	Resin bond wheel	Fast operation	**374**
Shaping & deburring	Carbide burrs	Fast cutting	**474**
Gate removal	Supersize Narrow belts	Cool cut for heat sensitive metal	**236**
	Resin mounted wheels	High stock removal rate	**342**
Cutting-off	Large Cut-off wheels	Free cutting	**370**

NEW PRODUCTS

COATED ABRASIVES	PAGE	BONDED ABRASIVES	PAGE
R996 Viking belts	**236**	Toros™ non reinforced Cut-off wheels	**370**
Tungsten carbide burrs	**474**		

CUTTING-OFF & GRINDING WHEELS	PAGE
Norzon III Foundry Grinding wheels	**63**

THE ULTIMATE SOLUTION

VIKING | **R996 VIKING BELTS** | **236**

Uses 100% premium SG® abrasive to deliver superior performance both in terms of metal removal rate & product life

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

ABRASIVE MARKET SEGMENTS

RAIL

Rail track is continuously subjected to high stress as a result of the millions of tons of train riding over them each year. Norton makes significant investment in the research and development of all abrasive applications encountered in the rail industry ensuring it continues to offer the most suitable range of abrasive products that focus on providing effective, accurate and safe results. Norton's products for the rail industry are each specifically designed to take into account the hardness of the metal used and the unique shape of rail track.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Cutting rail	Cut-off wheels	White & straight cuts	**74**
Deburring rails	Grinding wheels	Weld preparation	**54**
Grinding rails	Organic cup wheel	Excellent preparation of the rail before welding	**374**
Finishing welds	Organic straight wheel	Fast operation	**374**
Deburring Welds	Carbide Burrs	Faster removal than mounted points	**474**

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

TOOL ROOM

The maintenance and repair of cutting tools is common place in almost every manufacturing plant. Norton has a range of highly effective solutions suitable for tool room cutting and sharpening operations.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Sharpening cemented carbide cutting tools	Diamond wheels	High removal rate could be used wet or dry	**384**
Cutting drill bits	Non-Reinforced Cut-off wheels	Produce minimal burr & burn	**371**
Sharpening HSS cutting tools	CBN wheels	Free cutting	**384**
Sharpening tools	Vitrified cups & dishes	High removal rate & extended product life	**326**

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

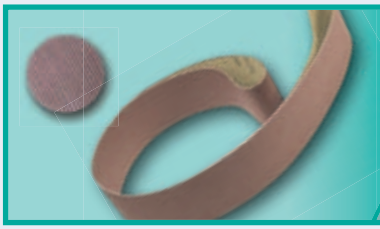
ABRASIVE MARKET SEGMENTS

GLASS

Norton offers innovative technological solutions with coated and non-woven abrasives, and supplies a full range of products to cover the various needs for glass converting and finishing operations. Norton has been successful in adapting and evolving its products to match customer's processes in order to meet the most stringent surface quality standards on any type of machine designed for the Glass market.

Typical sectors: safety and special glass, building and furniture glass.

APPLICATIONS	PRODUCT GROUP	MAIN BENEFITS	PAGE
Edge grinding	Narrow belts	High resistant & long life	**290**
	Cross belts	High quality & resistant	**291**
Edge finishing	Cork belts	High finishing quality	**291**
Removal coating after cutting	BearTex® wheels	High performance	**252**



THE ULTIMATE SOLUTION

NORAX | **U366 NORaX® NARROW BELTS** | **Made-to-order**

Gives the ultimate surface finish that can ever be achieved. The grit X5 is ideal for final finishing of glass edges. Made-to-order

For more information about Norton Abrasive Solutions, and to discuss our made-to-order capabilities don't hesitate to contact your local Customer Service Department.

NOTES

VELKOOBCHOD BRUSIVA

HOW TO USE THIS CATALOGUE

THE NORTON PRODUCT TIERING CONCEPT

To help compare and contrast the performance and price level of each Norton product line, the tiering system of Best, Better, Good is used. This is designed to help you choose the right product and to gain the appropriate level of performance for your application.

INNOVATION BEST	Norton's innovative abrasive solutions offer outstanding productivity and versatility. For further information about these products please contact your local Sales Representative.
BETTER	The core lines of Norton. These products provide high performance solutions with high levels of productivity delivering low abrasive costs.
BEST	Norton's high performance, high technology products are designed to add value to abrasive applications, providing exceptional performance. The high performing nature of these products mean they deliver the lowest possible operating costs.
GOOD	For users who are looking for Norton quality products, with consistent above average performance, and competitive prices.

THE CATALOGUE STRUCTURE

The Norton product line is segmented into easy-to-use, colour-coded sections – Cutting-off & Grinding wheels, Coated Abrasives, BearTex® (Non-woven) Abrasives, Bonded Abrasives, Super Abrasives and Diamond Blades. Each of these sections are divided into sub-sections and are categorised by product type, machine type or application.

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The first part of each sub-section is designed to help you find the right product – each product is categorised by Best, Better, Good, and is supported by key features & benefits, applications & markets and selection tables.

The second part of each sub-section comprises of product tables – designed to give quick and easy product reference details. The tables are arranged by product type or application (for Diamond Blades and Cutting-Off and Grinding Wheels). The Best, Better, Good concept is repeated to bring clear product comparison. Dimensions, grit, pack quantity and product codes are clearly displayed. In addition, Product Selection charts serve as a quick reference guide to the range. 'Spec Checks' also give helpful information on specific products or range benefits.

Technical and Safety information for each of the core product types is included in a separate section at the back of the catalogue.

VELKOOBCHOD BRUSIVA

HOW TO USE THIS CATALOGUE

HOW TO ORDER

Please contact your local Customer Service Centre, details can be found on the back page of the catalogue. For countries that are not listed please send your request to our European Headquarters.

When placing an order it helps to have the following information available:

Your name
Your account number
Your order or reference number
Product article number/s
Required quantity
Any special instructions

If you require additional product or technical information then please do not hesitate to contact your local Customer Service or Sales Representative.

For prices and terms of sale please refer to the price list.

jmi VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

42 INTRODUCTION
46 WHEELS FOR ANGLE GRINDERS
65 WHEELS FOR STRAIGHT GRINDERS
68 WHEELS FOR PETROL SAWS
70 WHEELS FOR CHOP SAWS
72 WHEELS FOR STATIONARY MACHINES
74 WHEELS FOR RAIL

JIMI
VELKOOBCHOD BRUSIVA

Cutting-Off & Grinding Wheels

INTRODUCTION

The Norton range of cutting-off and grinding wheels for portable and fixed machines provide superior performance in the most stringent working environment. The product range includes state-of-the-art solutions for cutting-off, grinding, and surface finishing operations on any materials related to industrial fabrication markets.

Norton, the industry's most comprehensive cutting-off and grinding product line.

UNDERSTANDING THE PRODUCT

SHAPE SPECIFICATION SYSTEM

BF 27	BF 29	BF 41	BF 42
Depressed centre grinding wheels. Available in diameters 76-230mm for hand-held machines	Depressed centre grinding wheels. Available in diameters 115mm & 125mm for hand-held machines	Flat cutting-off wheels. Available in diameters 50-400mm for hand-held machines & 250-400mm for stationery machines	Depressed centre cutting-off wheels. Available in diameters 76-230mm for hand-held machines
Application: grinding	Application: grinding	Application: cutting-off	Application: cutting-off

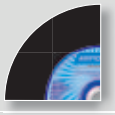
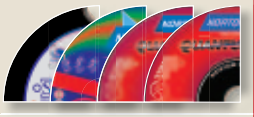
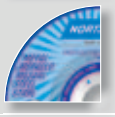
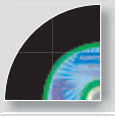
All Norton products are designed to be operator friendly with high safety standards to satisfy the requirements of all professional users.

For further information please go to the Technical Information Section at the back of this catalogue.

DIFFERENTIATION IN THE RANGE

Norton offers the industry's widest selection of cutting-off and grinding wheels designed to meet every customer's requirement. The range is classified into 3 tiers (Best/ Better/ Good) to help you choose the right product for your specific application.

INNOVATION BEST	With unparalleled abrasive technology, Norton provides optimum solutions with innovative products dedicated to industrial applications	BETTER	Norton Industrial Line grinding & cutting-off wheels are extensively used across a range of industries including aerospace, automotive, foundries, fabrication, ship-building & construction. This wide range of products return industry leading price/performance ratios delivering lower costs
BEST	Norton offers premium quality ranges of conventional zirconia (NorZon) & aluminium oxide (X-Treme life) abrasive grinding & cutting-off wheels. These ranges have been developed to meet the demands of the most discerning users. NorZon Quick Cut & X-Treme life ensure outstanding cutting speed & stock removal rates combined with exceptional long life meaning lower operating costs	GOOD	Norton's BDX Line gives above average performance for grinding & cutting-off operations on a wide range of materials, including steel, stainless steel, cast iron & stone

	INNOVATION BEST	BEST	BETTER	GOOD
METAL				
INOX				
METAL INOX				
ALU METAL INOX STONE C.TILES PVC				
ALU				
STONE				
STONE TILES				
RAIL				
CAST IRON METAL INOX				
CAST IRON METAL				

VELKOOBCHOD BRUSIVA

PRODUCT SELECTION CUTTING-OFF WHEELS FOR ANGLE GRINDERS

USAGE KEY

- Highly recommended
- Recommended

	Norton 1-2-3	Norton Quantum ZA 60 ZZ	Multi-Purpose C46T	Multi-Purpose C60T	NorZon Quick Cut	X-Treme Life	NorZon III Foundry	Industrial Line Metal-Inox	Industrial Line Inox	Industrial Line Non-ferrous	Industrial Line Stone/Tiles	BDX Metal-Inox	BDX Stone/Tiles
	INNOVATION BEST				BEST			BETTER				GOOD	
Steel, construction steel	■	■	■	■	■	■	■	■	◧			■	
Low-allow steel	■	■	■	■	■	■	■	■	◧			■	
High-alloy steel	■	■	■	■	■	◧	■	◧	■			◧	
Thin sheets, plates profiles	■	■	■	■	■	◧	■	■	◧			■	
Stainless steel, Inox	■	■	■	■	■	◧	■	■	■			◧	
Cast iron					■	■	■				◧		◧
Non-ferrous			■	■						■	◧		◧
Titanium			■	■						■	■		■
Stone, concrete			■	■							■		■
Tiles, ceramic			■	■							◧		◧
Glass, plastic, pvc			■	■									

PRODUCT SELECTION GRINDING WHEELS FOR ANGLE GRINDERS

USAGE KEY

- Highly recommended
- Recommended

	Norton Quantum HF	Octopus	NorZon Plus S-Hard	NorZon Q-Soft	NorZon Quick Cut S-Hard	NorZon Quick Cut R-Medium	NorZon Quick Cut Q-Soft	NorZon III Foundry S-Hard	NorZon III Foundry R-Medium	NorZon III Foundry Q-Soft	Industrial Line Metal-Inox Medium	Industrial Line Metal-Inox Soft	Industrial Line Inox	Industrial Line Non-ferrous	Industrial Line Stone/Tiles	BDX Metal-Inox	BDX Stone
	INNOVATION BEST			BEST							BETTER					GOOD	
Steel, construction steel	■	■	■	■	■	■	■	■	■	■	■	■	◧			■	
Low-alloy steel	■	■	■	■	■	■	■	■	■	■	■	■	◧			■	
High-alloy steel	■	■	◧	■	◧	■	■	◧	■	■	◧	■	■			■	
Stainless steel, Inox	■	■	■		■	■	■	■	■	■	◧	◧	■			◧	
Cast iron	■			■	■	■	■	■	■	■					◧		◧
Non-ferrous			■											■			
Titanium														◧	■		■
Stone, concrete															■		■

VELKOOBCHOD BRUSIVA

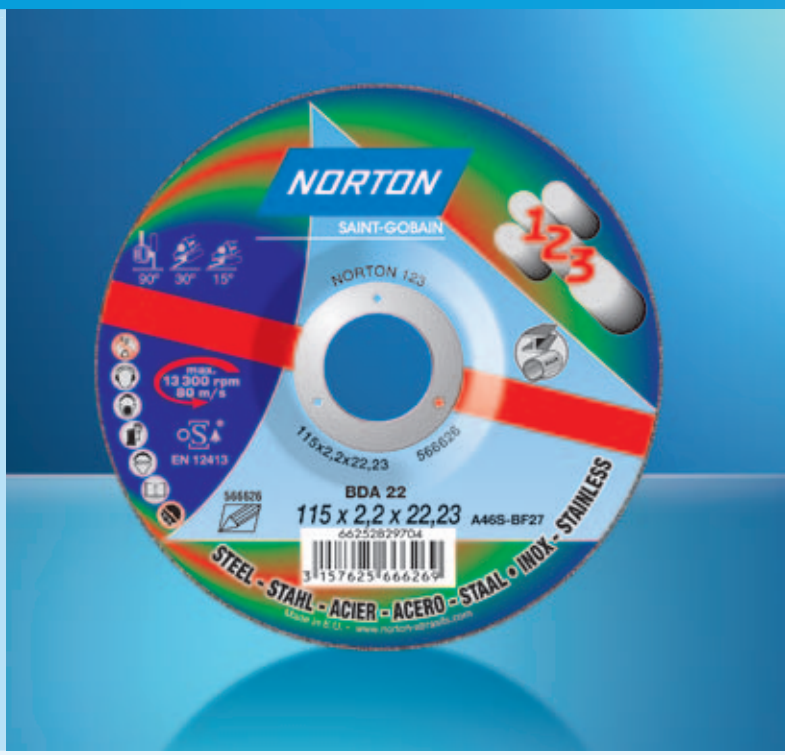
WHEELS FOR ANGLE GRINDERS

1 Cutting, 2 Grinding, 3 Polishing

Cutting, light grinding and polishing, all with one single product?
The new Norton 1-2-3 makes it possible!
No more lost time due to machine or product changing.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building



NORTON 1-2-3 THE ALL IN ONE SOLUTION

INNOVATION BEST

FEATURES	BENEFITS
Cutting, light grinding & polishing with one single product	No more lost time due to machine or product changing
Fine grit	Excellent & uniform finishing result
Low vibration	Comfortable working Operator friendly
Three layered strong reinforcement	Maximum safety
Free of iron, sulphur & chlorine	No contamination

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	1-2-3 A 46 S-BF27
Type 27	115	2,2x22,23	25	662528**29704**
	125	2,2x22,23	25	662529**21592**

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

NORTON SAINT-GOBAIN

QUANTUM

THE NEW GENERATION ABRASIVE TECHNOLOGY

- Lowest total abrasive costs
- High metal removal rate
- Fast cutting
- High stability
- Low vibration
- Less material loss
- Less noise & dust
- Less energy consumption
- Burr-free cutting
- White and clean cutting
- Extreme precision and straight cutting

No other wheel lasts longer!

jimi VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

Norton Quantum ultra thin cut-off wheels for stainless, alloy and carbon steels provide unrivalled wheel life, highest metal removal rates and fastest cutting action.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

NORTON QUANTUM

INNOVATION BEST

FEATURES	BENEFITS
Premium aggressive NorZon Plus grain	No other wheel lasts longer
Revolutionary Patent Pending Bond Technology	Lowest total abrasive costs High metal removal rate Fast cutting High stability
	Low vibration Less material loss
	Less noise & dust Less energy consumption Burr-free cutting White and clean cutting Extreme precision and straight cutting

APPLICATION BENEFITS

Norton Quantum is a new generation of ultra thin wheels specially developed using the new and revolutionary Patent Pending Bond Technology in combination with the new NorZon Plus grain - a unique combination that significantly increases grain performance.

- 0,8mm thickness for fast and precise cutting
- 1,0mm thickness for fastest cut rate and minimum material loss
- 1,3mm thickness specially developed to cut tubes and profiles
- 1,6mm thickness for demanding applications
- 7,5mm thickness
  This grinding wheel is optimized for safe use on high power machines and rough applications. Extreme stability and performance.

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	115	1,0x22,23	25	66252836338
		1,3x22,23	25	66252836897
		1,6x22,23	25	66252836339
	125	1,0x22,23	25	66252836340
		1,3x22,23	25	66252836898
		1,6x22,23	25	66252836341
	180	1,6x22,23	25	66252837989
	230	1,9x22,23	25	66252837990
Type 42	115	0,8x22,23	25	66252840228
	125	0,8x22,23	25	66252838243

METAL/INOX/CAST IRON

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27 HF	230	7,0x22,23	10	66252840382*

* Optimized for use on high power machines

JIMI VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

The Industrial Line offers good levels of performance & quality consistent with Norton's rich heritage.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
Advanced grain & bond system	Longer product life & faster material removal
Suitable for steel, stainless steel, aluminium, stone and tile applications	No more time loss due to machine or product changing
Unique grain & bond system optimised for non-ferrous	Counteracts loading & wheelglazing when cutting non-ferrous
Sharp silicon carbide grains	Longer product life & quicker cutting Optimised to cut stone, bricks, concrete & asphalt

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	MEDIUM	SOFT
Type 27	100	7,0x16,0	25	66252829953	
	115	4,6x22,23	25	66252829939	
		7,0x22,23	25	66252829483	66252829484
	125	4,6x22,23	25	66252829937	
		7,0x22,23	25	66252829485	66252829922
	150	7,0x22,23	25	66252829954	
	180	7,0x22,23	25	66252829486	66252829487
	230	7,0x22,23	25	66252829489	66252829490
		8,0x22,23	20	66252830004	

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	100	1,6x16,0	25	66252829945
		2,0x16,0	25	66252950985
	115	1,0x22,23	25	66252829482
		1,6x22,23	25	66252829764
		2,0x22,23	25	66252829927
	125	1,0x22,23	25	66252829925
		1,6x22,23	25	66252829572
		2,0x22,23	20	66252829928
	150	2,5x22,23	25	66252829923
	180	1,6x22,23	25	66252829946
		2,0x22,23	25	66252829929
		2,5x22,23	25	66252829932
	230	1,9x22,23	25	66252829926
		2,0x22,23	25	66252829488
		2,5x22,23	25	66252829934
Type 42	100	3,2x16,0	25	66252829950
	115	2,5x22,23	25	66252829930
		3,2x22,23	25	66252829769
	125	2,5x22,23	25	66252829931
		3,2x22,23	25	66252829936
	150	3,2x22,23	25	66252829951
	180	2,5x22,23	25	66252829933
		3,2x22,23	25	66252829770
	230	2,5x22,23	25	66252829935
		3,2x22,23	25	66252829771

Jimi VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	115	7,0x22,23	25	66252829480
	125	7,0x22,23	25	66252829978
	180	7,0x22,23	25	66252829571
	230	7,0x22,23	25	66252829481
Type 41	115	1,0x22,23	25	66252829964
		1,6x22,23	25	66252829966
	125	1,0x22,23	25	66252829965
		1,6x22,23	25	66252829967
Type 42	115	3,2x22,23	25	66252829768
	125	3,2x22,23	25	66252829757
	180	3,2x22,23	25	66252829974
	230	3,2x22,23	25	66252829437

ALUMINIUM

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	125	7,0x22,23	25	66252829988
	180	7,0x22,23	25	66252829989
	230	7,0x22,23	25	66252829990
Type 41	115	1,6x22,23	25	66252829984
	125	1,6x22,23	25	66252829985
	180	2,5x22,23	25	66252829983
	230	1,9x22,23	25	66252829986
		2,5x22,23	25	66252829987

STONE/TILES

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	180	7,0x22,23	25	66252829905
	230	7,0x22,23	25	66252829906
Type 41	115	2,5x22,23	25	66252829891
	125	2,5x22,23	25	66252829892
	180	2,5x22,23	25	66252829893
	230	2,5x22,23	25	66252829894

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

Norton's wide range of cutting wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

MULTI-PURPOSE

INNOVATION BEST

FEATURES	BENEFITS
Cuts all materials	No more time loss due to machine or product changing Quicker cutting
Ultra thin	Less noise, less dust, less material loss Extremely precise straight cuts with burr-free results Reduced energy consumption
Low vibration	Comfortable working
Unique construction	Counteracts loading & wheelglazing when cutting non-ferrous or plastics
Free of iron	No contamination

MULTI-PURPOSE

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	C 46 T-BF41	C 60 T-BF41
Type 41	115	1,0x22,23	25		66252833258
		1,6x22,23	25	66252828951	
	125	1,0x22,23	25		66252918924
		1,6x22,23	25	66252828952	
	180	1,6x22,23	25	66252926730	
	230	1,9x22,23	25	66252918925	

VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

Norton's wide range of cutting wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

NORZON QUICK CUT

BEST

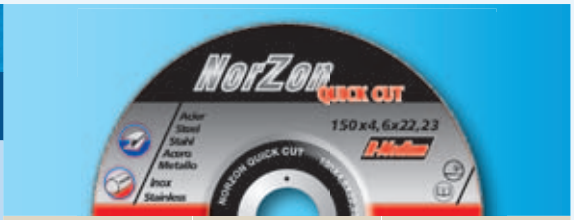
FEATURES	BENEFITS
■ Premium combination of zirconia grain and advanced bond system ■ Suitable for stainless steel, hardened steel and cast iron applications	■ Superior performance compared to standard aluminum oxide wheels ■ Highest productivity means lowest operating cost ■ Easy & comfortable grinding ■ Optimised for thick applications ■ High stability for easy & comfortable cutting
■ Q-Soft	■ Fast material removal
■ R-Medium	■ Optimised for universal applications
■ S-Hard	■ Long product life
■ Free of iron, sulphur & chlorine	■ No contamination

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	S-HARD	R-MEDIUM	Q-SOFT
Type 27	100	4,6x16,0	25		66252833116	
		7,0x16,0	25		66252831403	
	115	4,6x22,23	25		66252832729	
		7,0x22,23	25	66252831413	66252831412	
	125	4,0x22,23	25	66252832684	66252950962	
		4,6x22,23	25		66252829673	
		7,0x22,23	25	66252831422	66252831421	66252832747

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX



PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	S-HARD	R-MEDIUM	Q-SOFT
Type 27	150	4,6x22,23	25		66252832732	
		7,0x22,23	25		66252833119	
	180	4,0x22,23	25	66252832871	66252950963	
		4,6x22,23	25		66252831429	
		7,0x22,23	25	66252831434	66252831433	66252832745
	230	4,0x22,23	25	66252832685	66252950964	
		4,6x22,23	25		66252831438	
		7,0x22,23	25		66252831446	
		7,0x22,23	25	66252831447		66252832746

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	115	1,0x22,23	25	66252829663
		1,6x22,23	25	66252829496
		2,0x22,23	25	66252831458
	125	1,0x22,23	25	66252832682
		1,6x22,23	25	66252829577
		2,0x22,23	25	66252831463
		2,5x22,23	25	66252833117
	150	2,0x22,23	25	66252833118
	180	1,6x22,23	25	66252832870
		2,0x22,23	25	66252831469
		2,5x22,23	25	66252832734
	230	1,9x22,23	25	66252832683
		2,0x22,23	25	66252831478
		2,5x22,23	25	66252831474
Type 42	100	3,2x16,0	25	66252831502
	115	2,5x22,23	25	66252831506
		3,2x22,23	25	66252831510
	125	2,5x22,23	25	66252831516
		3,2x22,23	25	66252831519
	150	3,2x22,23	25	66252832731
	180	2,5x22,23	25	66252831524
		3,2x22,23	25	66252831527
	230	2,5x22,23	25	66252831529
		3,2x22,23	25	66252831532

VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

Norton's wide range of cutting wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

X-TREME LIFE

BEST

FEATURES	BENEFITS
Premium aluminium oxide grain in combination with an advanced bond system	Ultra long product life & extremely quick cutting Optimised for powerful machines Easy to use
Free of iron, sulphur & chlorine	No contamination

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	115	1,0x22,23	25	662529**19427**
		1,6x22,23	25	662529**20339**
		2,0x22,23	25	662529**20340**
		2,5x22,23	25	662529**21564**
	125	1,0x22,23	25	662529**20341**
		1,6x22,23	25	662529**20342**
		2,0x22,23	25	662529**20343**
		2,5x22,23	25	662529**20350**
	150	1,6x22,23	25	662529**20344**
	180	1,6x22,23	25	662529**20345**
		2,0x22,23	25	662529**20346**
		2,5x22,23	25	662529**20347**
	230	1,9x22,23	25	662529**20348**
		2,0x22,23	25	662529**20351**
		2,5x22,23	25	662529**20349**

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 42	115	2,5x22,23	25	662529**21567**
		3,2x22,23	25	662529**21568**
	125	2,5x22,23	25	662529**18816**
		3,2x22,23	25	662529**18819**
	180	2,5x22,23	25	662529**18817**
		3,2x22,23	25	662529**18820**
	230	2,5x22,23	25	662529**18818**
		3,2x22,23	25	662529**18821**

jimi VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

Norton's wide range of cutting wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

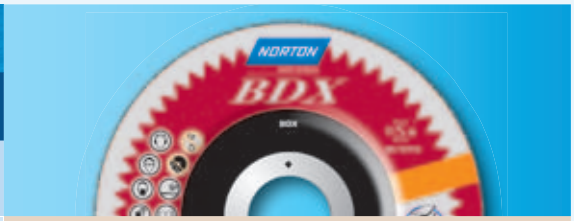
- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

BDX

GOOD

FEATURES	BENEFITS
The BDX range features a broad selection for steel/stainless steel and stone applications	No more time loss due to machine or product changing
Free of iron, sulphur & chlorine	No contamination
Sharp silicon carbide grains	Suitable for cutting stone, bricks, concrete & asphalt

METAL INOX



PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	100	4,0x16,0	25	66252831398
		6,5x16,0	10	66252831400
	115	4,0x22,23	25	66252831406
		6,5x22,23	10	66252831408
	125	4,0x22,23	25	66252829766
		6,5x22,23	10	66252831415
	150	6,5x22,23	10	66252832633
	180	4,0x22,23	25	66252829477
		6,5x22,23	10	66252831431
	230	4,0x22,23	25	66252831439
		6,5x22,23	10	66252831440

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	115	1,0x22,23	25	66252831452
		1,6x22,23	25	66252831451
		2,0x22,23	25	66252831456
		2,5x22,23	25	66252831454
	125	1,0x22,23	25	66252831541
		1,6x22,23	25	66252831460
		2,0x22,23	25	66252831462
		2,5x22,23	25	66252831461
	150	2,0x22,23	25	66252832741
	180	1,6x22,23	25	66252832631
		2,0x22,23	25	66252831468
		2,5x22,23	25	66252831466
	230	1,9x22,23	25	66252832686
		2,0x22,23	25	66252831476
		2,5x22,23	25	66252831471
Type 42	100	2,5x16,0	25	66252831497
	115	2,5x22,23	25	66252831504
		3,2x22,23	25	66252831508
	125	2,5x22,23	25	66252831513
		3,2x22,23	25	66252831517
	150	3,2x22,23	25	66252832632
	180	2,5x22,23	25	66252831522
		3,2x22,23	25	66252831525
	230	2,5x22,23	25	66252831494
		3,2x22,23	25	66252829430

STONE/TILES

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	115	2,5x22,23	25	66252832941
	125	2,5x22,23	25	66252832942
	180	2,5x22,23	25	66252832945
	230	2,5x22,23	25	66252832848
Type 42	100	3,2x16,0	25	66252831501
	115	3,2x22,23	25	66252831509
	125	3,2x22,23	25	66252831518
	180	3,2x22,23	25	66252831526
	230	3,2x22,23	25	66252831496

VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

STONE

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	115	6,5x22,23	10	66252831409
	125	6,5x22,23	10	66252831416
	180	6,5x22,23	10	66252831432
	230	6,5x22,23	10	66252831441

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

Norton's wide range of grinding wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

OCTOPUS

INNOVATION BEST

FEATURES	BENEFITS
Unique patterned face	Prevents loading Cooler operation
Viewable surface	Gives complete vision of the grinding zone More effective as less rework needed Reduces heat on the workpiece
Grinding & polishing with one product	No more lost time due to machine or product changing
2 grit sizes	36 grit for stock removal 60 grit for polishing
Low vibration	Comfortable working
No backing pad needed	Easy mounting

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	A 36 T-BF29	A 60 T-BF29
Type 29	115	4,0x22,23	20	66252829991	66252829992
	125	4,0x22,23	20	66252829993	66252829994

Jimi VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

Norton's wide range of NorZon PLUS cutting & grinding wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Fabrication
- Foundry

NORZON PLUS

INNOVATION BEST

FEATURES	BENEFITS
■ Premium combination of zirconia grain & an advanced bond system	■ Quality optimised for professionals ■ Superior performance compared to standard aluminum oxide wheels ■ Highest productivity & lowest cost per cut ■ Easy & comfortable grinding ■ Designed for steel, stainless steel, casts & white, grey & nodular cast iron applications
■ R-Medium grade	■ Fast material removal
■ S-Hard grade	■ Long wheel life
■ Free of iron, sulphur & chlorine	■ No contamination

CAST IRON/METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	S-HARD	R-MEDIUM
Type 27	115	7,0x22,23	25	66252832968	66252832967
	125	7,0x22,23	25	66252832970	66252832969
	180	7,0x22,23	25	66252832972	66252832971
	230	7,0x22,23	25	66252832974	66252832973

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

Norton's wide range of Foundry cutting & grinding wheels for angle grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Fabrication
- Foundry

NORZON III FOUNDRY

BEST

FEATURES	BENEFITS
■ Premium combination of zirconia grain and advanced bond system	■ Superior performance compared to standard aluminum oxide wheels ■ Highest productivity & lowest cost per cut ■ Designed for steel, stainless steel, casts & white, grey & nodular cast iron applications
■ Q-Soft grade	■ For comfortable working
■ R-Medium grade	■ Fast material removal
■ S-Hard grade	■ Long wheel life

CAST IRON/METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 42	115	3,2x22,23	25	66252833137
	125	3,2x22,23	25	66252829555
	180	3,2x22,23	25	66252833144
	230	3,2x22,23	25	66252831531

Jimi VELKOOBCHOD BRUSIVA

WHEELS FOR ANGLE GRINDERS

CAST IRON/METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	S-HARD	R-MEDIUM	Q-SOFT
Type 27	100	7,0x16,0	25	66252831405	66252829765	
	115	7,0x22,23	25	66252832712	66252832956	
	125	4,0x22,23	25		66252833139	
		4,6x22,23	25		66252833140	
		7,0x22,23	25	66252829391	66252833036	66252833224
	150	7,0x22,23	25	66252832724	66252832723	
	180	4,0x22,23	25		66252833223	
		4,6x22,23	25		66252832716	
		7,0x22,23	25	66252831435	66252832717	66252832692
	230	4,0x22,23	25		66252833147	
		4,6x22,23	25		66252833037	
		7,0x22,23	25	66252831448	66252829493	66252832693

METAL/CAST IRON

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 27	115	7,0x22,23	25	66252840240
	125	7,0x22,23	25	66252840237
	150	7,0x22,23	25	66252840241
	180	7,0x22,23	25	66252840242
	230	7,0x22,23	25	66252838276

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

Norton's wide range of cutting and grinding wheels for straight grinders provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Aerospace
- Automotive
- Construction
- Fabrication
- Foundry
- Rail industry
- Ship-building

NORTON QUANTUM

INNOVATION BEST

FEATURES	BENEFITS
■ Premium aggressive NorZon Plus grain	■ No other wheel lasts longer
■ Revolutionary Patent Pending Bond Technology	■ Lowest total abrasive costs ■ High metal removal rate ■ Fast cutting ■ High stability
	■ Low vibration ■ Less material loss
	■ Less noise & dust ■ Less energy consumption ■ Burr-free cutting ■ White and clean cutting ■ Extreme precision and straight cutting

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	76	1,0x10,0	5/50	66252840231

APPLICATION BENEFITS

■ 1,0mm thickness for fastest cut rate and minimum material loss

These new 76mm wheels are packed in a environmentally friendly PET pack. The wheels are packed 5 pieces per pack. The overbox contains 50 wheels (10 packs). **No wheel lasts longer!**

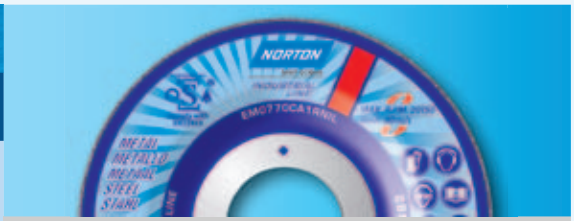
WHEELS FOR STRAIGHT GRINDERS

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
■ Advanced grain & bond system	■ Longer product life & quicker cutting & grinding
■ Suitable for steel & stainless steel applications	■ No more lost time due to machine or product changing
■ 2 external full reinforcements	■ Maximum safety ■ High stability for straight cuts
■ Free of iron, sulphur & chlorine	■ No contamination
■ 6mm ultra thick type 41 wheels available	■ Can be used for cutting & grinding

METAL INOX



PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	MEDIUM
Type 27	76	7,0x10,0	10	662528**29952**

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

METAL INOX

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	HARD	MEDIUM
	50	1,0x6,35	50	6624357**8272**	
		1,6x6,35	25		6624357**8274**
		6,0x6,35	10		6625282**9875**
	63	1,0x6,35	50	6625282**9956**	
		1,6x6,35	25		6625282**9876**
		2,5x6,35	25		6625292**5546**
		6,0x6,35	10		6625282**9877**
		1,0x10,0	50	6625282**9878**	
		1,6x10,0	25		6625283**1132**
		2,5x10,0	25		6625282**9879**
		6,0x10,0	10		6625282**9880**
Type 41	76	1,0x6,35	50	6625282**9941**	
		1,6x6,35	25		6625282**9943**
		2,5x6,35	25		6625282**9881**
		6,0x6,35	10		6625282**9882**
		1,0x8,0	50	6625282**9883**	
		1,6x8,0	25		6625282**9884**
		2,5x8,0	25		6625282**9885**
		6,0x8,0	10		6625282**9886**
		1,0x10,0	50	6625282**9957**	
		1,6x10,0	25		6625282**9944**
		2,5x10,0	25		6625283**0429**
		3,2x10,0	25		6625282**9949**
		6,0x10,0	10		6625282**9887**
	100	1,0x10,0	25	6625282**9888**	
		1,6x10,0	25		6625282**9767**
Type 42	76	2,5x10,0	25		6625282**9947**

jimi VELKOOBCHOD BRUSIVA

WHEELS FOR PETROL SAWS

Norton's wide range of cutting wheels for petrol saws provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Construction
- Fabrication
- Foundry
- Rail industry

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
■ Advanced grain & bond system	■ Longer product life ■ Quick & free cutting
■ Sharp silicon carbide grains	■ Optimised to cut stone, bricks, concrete & asphalt ■ Longer product life & quicker cutting
■ 2 external full reinforcements	■ Maximum safety ■ High stability for straight cuts
■ 80m/s for 300mm ■ 100m/s for 350mm	■ Designed for petrol & electrical saws

METAL

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	300	3,8x20,0	10	66252829491
		3,8x22,23	10	66252829914
		3,8x25,4	10	66252829753
	350	3,8x20,0	10	66252829915
		3,8x22,23	10	66252829916

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

JIMI BRUSIVA VELKOOBCHOD

STONE

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	300	3,8x20,0	10	662528**29900**
		3,8x22,23	10	662528**29901**
	350	3,8x20,0	10	662528**29903**
		3,8x22,23	10	662528**29904**

VELKOOBCHOD BRUSIVA

WHEELS FOR CHOP SAWS

Norton's wide range of cutting wheels for chop saws provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Construction
- Fabrication
- Foundry
- Maintenance

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
■ Advanced grain & bond system	■ Longer product life ■ Quick & free cutting
■ Internally reinforced	■ Burn & burr-free cutting ■ Maximum safety ■ High stability for straight cuts
■ 80m/s	■ Designed for small electrical table & fixed machines

METAL

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	MEDIUM
Type 41	300	2,8x25,4	10	66252829909
	350	3,0x25,4	10	66252829910
	400	3,0x25,4	10	66252829918

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

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NOTES

VELKOOBCHOD BRUSIVA

WHEELS FOR STATIONARY MACHINES

Norton's wide range of cutting wheels for stationary machines provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Construction
- Fabrication
- Foundry

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
■ Advanced grain & bond system	■ Longer product life ■ Quick & free cutting ■ Burn & burr-free cutting
■ Sharp silicon carbide grains	■ Optimised to cut stone, bricks & concrete ■ Long product life ■ Quick & free cutting
■ Strong reinforcements ■ 2 external full reinforcements	■ Maximum safety ■ High stability for straight cuts
■ 80m/s	■ Designed for stationary machines

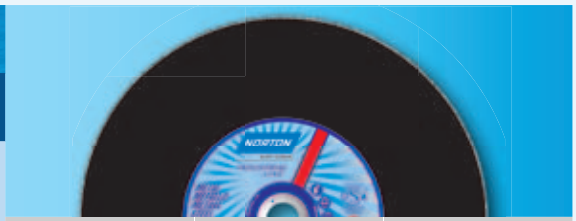
STONE

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	
Type 41	300	3,0x25,4	10	66252829895
	350	3,5x25,4	10	66252829899
	400	4,0x25,4	10	66252829908

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

jmi VELKOOBCHOD BRUSIVA

METAL



PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	HARD	MEDIUM	SOFT
Type 41	250	3,5x25,4	10		66252829919	
	300	3,5x22,23	10	66252829960	66252829911	
		3,5x25,4	10	66252829961	66252829912	
		3,5x30,0	10		66252919096	
		3,5x32,0	10		66252829913	
	350	4,0x25,4	10	66252829962		
		4,5x25,4	10		66252829917	
	400	4,0x25,4	10	66252829963		
		4,5x25,4	10		66252829920	66252920502
		4,5x32,0	10		66252829921	

Jimi VELKOOBCHOD BRUSIVA

WHEELS FOR RAIL

Norton's wide range of cutting wheels for rail industry machines provide high value and high performance industrial solutions.

APPLICATIONS & MARKETS

- Rail industry

INDUSTRIAL LINE

BETTER

FEATURES	BENEFITS
■ Premium grain & bond system	■ White & straight cuts ■ Quick & free cutting ■ High stability
■ 3 specifications Soft-Medium-Hard	■ Complete range for all rail machines, horsepower & applications
■ 80m/s for 300mm ■ 100m/s for 350mm	■ Designed for petrol & electrical railcut machines with clamping device ■ Maximum safety

RAIL METAL

PRODUCT TYPE	DIA (mm)	TxB (mm)	PK QTY	HARD	MEDIUM	SOFT
Type 41	300	3,5x20,0	10		66252829589	
		3,5x22,23	10		66252829585	66252833257
	350	4,0x20,0	10		66252829586	
		4,0x22,23	10		66252829587	66252951091
		4,0x25,4	10	66252832744	66252829588	66252828620
	400	4,0x25,4	10			66252919130

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

NORTON
SAINT-GOBAIN

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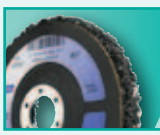
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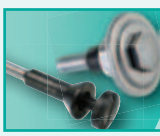
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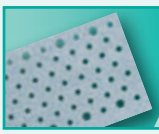
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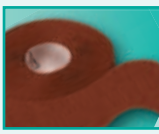
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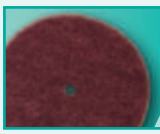
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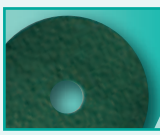
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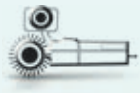

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JMI VELKOOBCHOD BRUSIVA

INTRODUCTION

The Norton coated abrasive and Beartex product offering encompasses a complete range of belts, discs, rolls, sheets and flap wheels for all your polishing, welding, maintenance and repair operations needs. This extensive product range includes products designed for all types of application, including heavy stock removal, dimensioning, grinding, deburring, cleaning, blending, polishing and finishing operations.

UNDERSTANDING THE PRODUCT

COATED ABRASIVES

R	9	2	9
BACKING	**PRINCIPAL ABRASIVE**	**COATED**	**RANDOM**
A - Light Paper	1 - Aluminium Oxide	Odd Number - Openkote	Differentiates different products within the same product group
F - Fibre	2 - Aluminium Oxide	**Even number - Closekote**	
G - Heavy Paper	3 - Aluminium Oxide		
H - Heavy Paper	4 - Silicon Carbide		
K - Cloth	6 - Emery		
Q - Various (e.g. Screen-bak & Film)	7 - Flint		
R - Cloth	8 - Zirconia Alumina		
S - Combination	**9 - SG® - Ceramic Aluminium Oxide**		
T - Waterproof Paper			
U - Norax®			
W - Special (Cork)			

BEARTEX

Flat stock
Aluminium oxide
Very fine

F	2	5	04
MARKETING CAP CODE FAMILY / **TYPE OF MATERIAL**	**GRAIN**	**GRADE**	**INTERNAL DIFFERENTIATION**
Flat stock / **F**	0 - No grain	0 - No grit	Consecutive numbers used for internal differentiation
Utitized/Unified / U	1 - A/O white	1 - Extra coarse	
Rapid strip / R	**2 - A/O brown**	2 - Coarse	
Surface conditioning/ Blending / S	4 - S/C	3 - Medium	
Convolute / C	5 - Garnet	4 - Fine	
Floor maintenance / JF		**5 - Very fine**	
		6 - Ultra fine	
		7 - Super fine	
		8 - Micro fine	

VELKOOBCHOD BRUSIVA

BACKING TYPES

Whether paper, cloth, vulcanised fibre or polyester film, the backing must be smooth enough for uniform adhesive coating, stong enough to withstand grinding pressures and flexible enough to conform to contours if necessary.

ABRASIVE BONDS

There are two main types of adhesives in use, one based on animal glue, and the more common based on synthetic heat hardenable resins. The adhesive is applied with a minimum of two bonding applications. The first, or maker, coat adheres the abrasive grain to the backing ensuring proper anchoring and orientation. After drying, or curing, the second, or sizer, coat is applied. The sizer adhesive, united with the maker bond, provides final grain anchoring and the proper total adhesive level for the finished product.

ABRASIVE TYPES

The ideal abrasive grain offers maximum resistance to point wear, yet fractures before serious dulling occurs, thereby satisfying both stock removal and finishing requirements.

SYNTHETIC ABRASIVES

- Aluminium oxide is tough and well adapted to grinding high tensile materials, such as carbon steel, alloy steels, tough bronze and hard woods. Wherever toughness (ability to resist fracturing) is the main consideration, aluminium oxide out performs all other coated abrasive grains
- Silicon carbide is the hardest and sharpest of the minerals used in coated abrasives. Its hardness and sharpness make it the ideal abrasive for sanding non-ferrous metals (aluminium, brass, bronze, magnesium, titanium, etc.), rubber, glass, plastics, fibrous woods, enamel and other relatively soft materials. Silicon carbide is superior to any other abrasive in its ability to penetrate and cut faster under light pressure
- Zirconia alumina has a unique self-sharpening characteristic which gives it long life on rugged stock removal operations. Zirconia alumina is well suited for heavy grinding of metals and planing of wood, because the controlled fracturing of the grain continuously produces sharp, new abrading points
- Ceramic aluminium oxide is a long-lasting, tough, dense abrasive due to its micro structure. The extremely small micron size particles break off during grinding, producing multiple new cutting edges. As it stays sharp, especially when used in medium and high pressure operations, it cuts at a higher rate than other abrasives. Recommended for use on forged and carbon steels, high nickel and cobalt alloys

NATURAL ABRASIVES

- Emery is a natural composite of corundum and iron oxide. The particles are blocky in shape and tend to cut slowly, thereby producing a polishing action on the material being abraded. Used for general maintenance and polishing of metals and in very fine grits for highly technical polishing, such as preparing metallurgical specimens requiring very close tolerances. Emery products are black in colour

Jimi VELKOOBCHOD BRUSIVA

INTRODUCTION

BearTex consists of a backing in “non-woven” nylon fibers evenly impregnated with abrasive granules through the binding action of synthetic resins. This structure forms a “three-dimensional” abrasive material. Since this product was created as a finishing tool for operations where no material need be removed, it is particularly suitable for buffing-up purposes or to reduce the roughness of a surface: BearTex begins to act when other abrasive tools have terminated their work. In all those situations where a buffing, cleaning or finishing operation is required, the BearTex product is decidedly a must.

USED WET OR DRY, BEARTEX® PRODUCTS OFFER THE FOLLOWING ADVANTAGES:

- A predictably consistent, uniform finish.
- Minimum smearing and discolouration of the work-piece as heat is dissipated through the open mesh of the product.
- Increased productivity through savings in time.
- Ability to automate operations.
- Reduced operator training.
- Less maintenance required.
- Greater safety than other methods.
- Conformability to irregular surfaces.

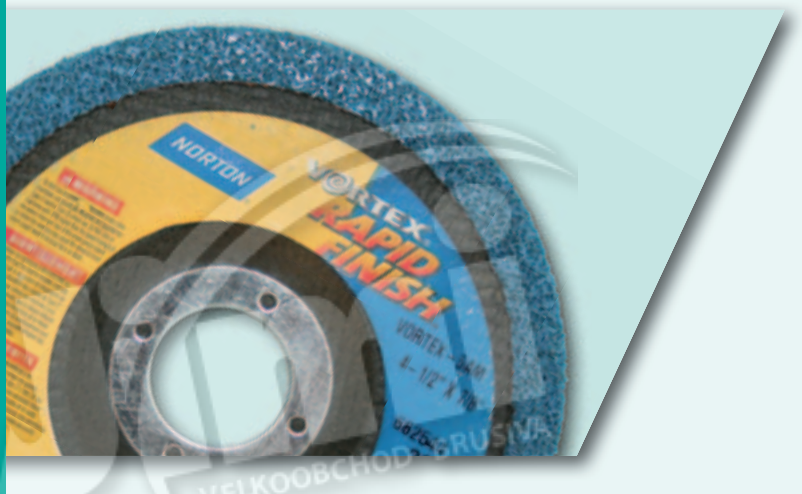
These advantages make BearTex® products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds, and steel wool. Operators quickly learn the techniques of using BearTex® products to produce eye catching finishes.

BEARTEX® PRODUCTS CAN BE USED ON A WIDE VARIETY OF SURFACES -

- Aluminium
- Brass
- Copper
- Nickel
- Chromium
- Stainless Steel
- Zinc
- Titanium
- Tantalum
- Ceramics
- Glass
- Plastic
- Fibreglass
- Wood
- Plywood

APPLICATIONS INCLUDE

- Deburring
- Cleaning
- Scrubbing
- Scouring
- Blending
- Polishing
- Highlighting
- Deflashing plastics
- Defuzzing plywood
- Dulling laminates
- Imparting satin
- Removing raised wood fibres
- Decorative finishes



ABRASIVE TYPES

BEARTEX® products are manufactured utilising either silicon carbide or aluminium oxide abrasive grain.
These are the same high quality abrasives used in Norton's world famous coated abrasive products.

SILICON CARBIDE is a hard, sharp, brittle abrasive grain which tends to break down under pressure. Therefore silicon carbide items are sharper, tend to cut faster and produce finer scratch patterns on most surfaces.

ALUMINIUM OXIDE is a tough, blocky abrasive which does not tend to break down. Aluminium oxide is more durable than silicon carbide and tends to last longer, produce less discolouration on aluminium, and be more aggressive on certain applications such as hardened steel parts.

GRIT SIZE

The 'grit' refers to the particle size of the abrasive grain that is impregnated into the nylon web during manufacture.
Use of large particles result in a BearTex® product that acts more aggressively and produces a coarse surface finish. Small size particles result in a BearTex® product that produces fine surface finishes.

DENSITY

The 'density' refers to the number of fibres which have been compressed onto the nylon web material. Most BearTex® products are made in a single density designed to meet the requirements of the intended application. However, several wheel items offer two densities to provide a broader range of finishing results.

Under identical conditions, 'Hard' density wheels cut faster, last longer and produce finer finishes than medium density wheels. 'Medium' density wheels offer greater conformability and less tendency to load the workface.

BOND TYPES

Waterproof resins are used throughout the manufacture of BearTex® web material to bond the nylon fibres together and to firmly anchor the abrasive grains throughout the web.

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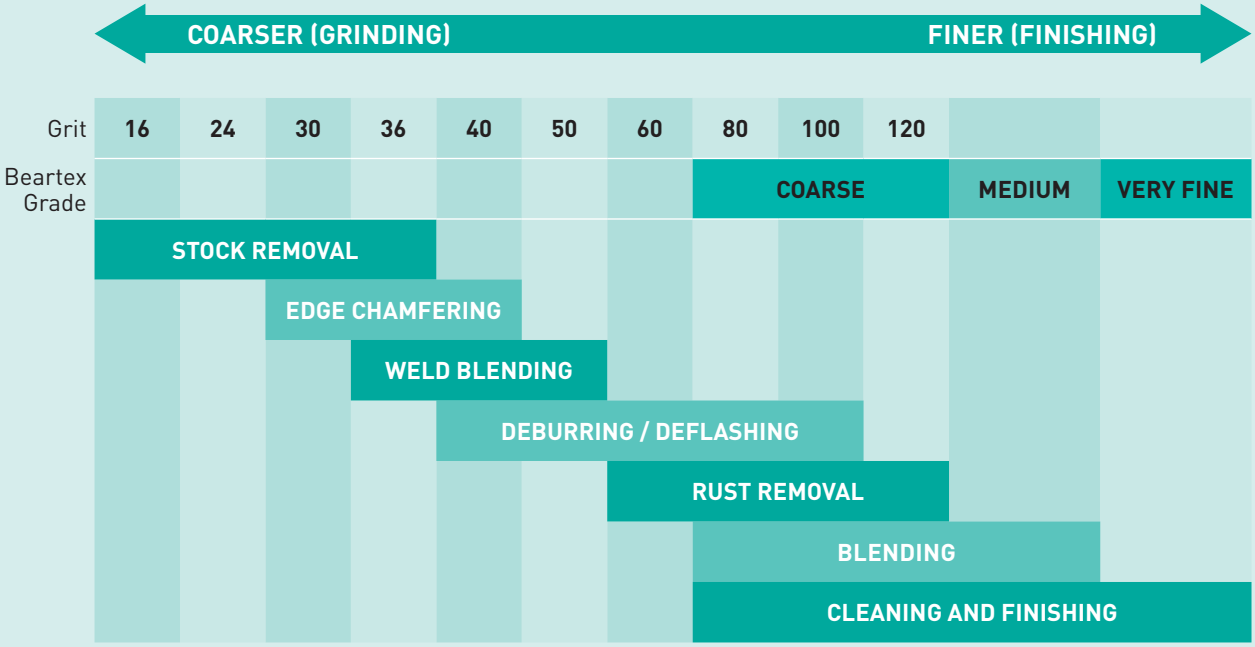
APPLICATION / GRIT RECOMMENDATION

APPLICATION / GRIT RECOMMENDATION



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DIFFERENTIATION IN THE RANGE

Norton offers the industry's widest selection of coated abrasives to meet every customer requirement. The wide range of abrasive types used in the range are classified into 3 tiers by product shape (Best/ Better/ Good) to help you choose the right product for your specific application.

INNOVATION BEST	Using unparalleled abrasive technology, and extremely high performance abrasive grains, Norton provides innovative product solutions dedicated to improving productivity in all industrial applications
BETTER	The core of the Norton Coated Abrasive offering. These products are designed to give superior performance solutions in all abrasive applications, giving high productivity levels and low total abrasive costs
BEST	These technologically advanced products meet the demands of the most discerning user giving the highest productivity and the longest product life for the lowest operating costs
GOOD	Standard Norton products that give highly durable solutions with good performance levels

PRODUCT SELECTION GUIDE

Norton offers a diverse range of products that are suitable for all commonly encountered industrial applications. To enable more effective product selection an overview of appropriate products for the main applications is given in the following pages. Pictograms and colours are used to represent the applications and these are repeated with the product details in the main section.

For further information please go to the Technical Information Section at the back of this catalogue.

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PRODUCT AVAILABILITY TABLE

KEY: GRIT AVAILABILITY

- Standard Norton products
- Generic backprint
- • Cancelled - stock will not be replenished
- \+ Planned
- N Available also in Norgrip
- S Soft-Touch

KEY: SHAPE AVAILABILITY

- Standard availability
- BSG P600 Stock — Specific availability (BSG only, P600 only, stock only)
- No BFL — Restricted availability (no BFL)
- FW — Available only in full jumbo width

A,B,C WEIGHT PAPER PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320
A213	B/C	AO	Beige	UF/UF	P36 to P80 with C-wt	Sheets										•				
A255	B	AO	Brown	UF/UF	Non stearate No Fil															N
A275	B/C	AO	Brown	UF/UF	No Fil, P80 to P120 in C-wt	1400					S		S	N/S	N/S	N/S	N/S	N/S	N/S	N/S
A975	B/C	SG/AO	Blue	UF/UF	No Fil, P80 to P120 in C-wt	1400								N		N	N/S		N/S	
A726	C	Flint	Beige	G/G	Special flint grading	Stock sheets														
A296	B	AO	Yellow	UF/UF	No Fil	1400														

WATERPROOF PAPER PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							4,000	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320	
T221	C	AO	Black	PF/PF		Stock sheets														
T489	B/C	SiC	Black	PF/PF	P60 to P150 in C-wt	Stock sheets														
T417	B/C	SiC	Black	PF/PF	P60 to P150 in C-wt	Stock sheets														
T401	A	SiC	Black	V/PF		Stock only														
T402	A	SiC	Black	V/PF		Stock only			•	•	•									
L41PC	C	SiC	Black		C-wt	482														

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280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
	■	■	■		■	■	■	■	•	■	•					A213				Stock		FW
																A255						
N/S	N/S	N/S	N	N	N	N	N									A275			N/S	Stock	N	FW/Rotolo
N	N	N	N	N	N		N									A975			N/S		N	FW
				3/0	2/0	0	1 2	3	4	5	6					A726				Stock		
	■	■	■				■									A296			Stock			Rotolo

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
	■	■	■												T221				Stock		FW
■	■	■	■	■	■	■	■	■							T489				Stock		FW
■	■	■	■	■	■	■	■	■							T417				Stock		
															T401				Stock		
															T402				Stock		
															L41PC						FW

Jimi VELKOOBCHOD BRUSIVA

PRODUCT AVAILABILITY TABLE

E AND F WEIGHT PAPER PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE												
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320
G156	E*	AO	Green	UF/UF		1400													
A277	E*	AO	Salmon	UF/UF	No Fil	1400													
G131	E*	AO	Yellow	UF/G		1400													
H216	E*	AO	Brown	UF/G		1400													N
H259	F	AO	Maroon	PF/PF	Open coat	1420													
H231	F+	AO	Maroon	PF/PF	Antistatic, open coat	1420													N
H230	F+	AO	Maroon	PF/PF	Antistatic, open coat	1420													
H425	E,F	SiC	Black	UF, PF 240+f 220+C PF	Open coat	1420								N	N		N		N
H835 Blue Fire	F	NZ/AO	Blue	PF/PF	Open coat	1420													
H822	F+	NZ	Blue	PF/PF	Closed coat	1420													

E* = 185gr F+ = 270gr

FILM PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE												
							1µ	1,5µ	3µ	5µ	6µ	7µ	8µ	9µ	12µ-1500	15µ-1200	18µ-1000	20µ-800	30µ
Q132	3mil film	AO white	White	UV	No backcoat	400													
Q151	5mil film	AO white	White	UV	With backcoat	325													
Q152	5mil film	AO white	White	UV	No backcoat	400													
Q153	5mil film	AO white	White	UV	With backcoat	325													
Q260 Dry Ice	3mil film	AO white	White	UV	No-Fil	Stock only									N	N	N	+	
L61F3	3mil film	Diamond	Clear		No backcoat, lapping, source from US	330													
L67F3	3mil film	Diamond	Clear		No backcoat, superfinishing, source from US	330													
L12F3	3mil film	AO white	White		No back coat and source from US	330													
L41F3	3mil film	SiC			No back coat and source from US	330													

JIMI VELKOOBCHOD BRUSIVA

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
					N		N	N								G156						
																A277		BWD				FW
			N		N		N			N	N					G131						FW
	N		N	N	N	N	N	N	N	N	N					H216						
																H259		BWD				
	N		N	N	N	N	N	N	N	N	N					H231						Norgrip in FW
																H230						FW
		N	N	•	N	N	N	N	N	N	N		N			H425		BWD				FW
					N	N	N	N		N						H835 Blue Fire						FW
																H822						FW

40µ	45µ	50µ	60µ	75µ	80µ	100µ	200µ	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
								Q132						
		•	•					Q151						
								Q152						
						•		Q153						
								Q260 Dry Ice						
								L61F3						Rolls 101 & 203mm
								L67F3						Rolls 101 & 203mm
								L12F3						
								L61F3						Rolls 101 & 203mm

Jimi VELKOOBCHOD BRUSIVA

PRODUCT AVAILABILITY TABLE

FIBRE AND SCREENBAK PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320	
F228	0,6/0,8	AO	Maroon	PF/PF	P24 to P36 in 0,8															
F293	0,8	AO	Maroon	PF/PF																
F425	0,8	SiC	Black	PF/PF																
F827	0,8	NZ/AO	Blue	PF/PF																
F861	0,8	NZ/AO	Red	PF/PF	Supersize															
F975	0,8	SG 100%	Green	PF/PF																
FX21 Red Dragon	0,8	SG 100%	Red	PF/PF	Supersize															
Q421	Grid	SiC	Black	PF/PF	Screenbak	1150														
Q263	Grid (fine)	AO	Green	PF/PF	Screenbak									■						

COTTON CLOTH PRODUCTS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320	
K625	J light	Emery	Black	G/G	'Emery cloth'	Stock sheets														
Q222	NW	AO	Maroon	PF/PF	Non woven backing	960														
R212	J cotton	AO	Black	UF	Handy rolls	1400											■		■	
R222	J cotton	AO	Maroon	PF/PF	Handy rolls	1150									■		■		■	
R230	X cotton	AO	Maroon	PF/PF		1500														
R265	X cotton	AO	Maroon	PF/PF		1500											■		■	
R207	X cotton	AO	Maroon	PF/PF	Flap wheel only	1500											■		■	
R287	J cotton	AO	Maroon	PF/PF		1500											■		■	
R380	J cotton	AO	Maroon	PF/PF	GEN	1400											■		■	
R296	JJ cotton	SG/AO	Green	PF/PF	Supersize	1200											•		■	
R376	JJ cotton	AO	Green	PF/PF	Special stainless steel	1400											+		+	
R235	JJ cotton	AO	Maroon	PF/PF	GEN	1400														
R309	JJ cotton	AO	Red/Brown	PF/PF		1400											■		■	
R427	X cotton	SiC	Black	PF/PF		1400														
R822	X cotton	NZ/AO	Blue	PF/PF		1500														
R82A	X cotton	AO/NZ	Blue	PF/PF	Belt/Flap disc	1500														
R82B	X cotton	AO/NZ	Blue	PF/PF	Flap Disc	1400														
R828	X polycotton	NZ/AO	Blue	PF/PF	Rolls/Flap disc	1500														
R926	X cotton	SG/AO	Red	PF/PF	Supersize	1500														
RX22	X cotton	Delta/AO	Green	PF/PF		1500														
U242	J cotton	A/O	Grey	UV	NORaX fine tri-helical	600		X4				X16		X22			X30		X45	
U234	XF cotton	A/O	Grey	UV	NORaX quad	600														
U254	XF cotton	A/O	Grey	UV	NORaX pyramid	600		X5				X16		X22			X30		X45	
U264	XF cotton	A/O	Grey	UV	NORaX tri-helical	600		X5				X16		X22			X30		X45	
U464	XF cotton	SiC	Green	UV	NORaX tri-helical	600														

NORTON SAINT-GOBAIN

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
					■	■	■	■	■		■		■			F228						
					■	■	■	■	■		■		■		■	F293						
			■													F425						
					■	■	■	■	■		■		■			F827						
					■	•	■	■	■	•	■					F861						
							■	■	■		■					F975						
					+		■	■	■		■					FX21 Red Dragon						
		■	■	■	■	■	■	■								Q421				Stock		FW
																Q263						

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
		Very Fine			Fine		Medium		Coarse	Very Coarse						K625				Stock		
		•	•	•	•	•	•	•		•						Q222				Stock		
																R212				Stock		FW
■	■	■	■	■	■	■	■	■	■	■	■					R222	P600			Stock		FW
			■	■	■	■	■	■	■	■	■		■			R230		BWD				
	■	■	■	■	■	■	■	■	■	■	+					R265		BWD				
																R207						FW
■	■	■	■	■	■	■	■	■								R287						
																R380						FW
•	■	■	■	■	■	■	■	■								R296						
	+	+	+	+	+		+	+								R376						
																R235						FW
■	■	■	■	■	■	■	■	■								R309						
	■		■	■	■	■	■	■	■	■	■		■			R427		BWD				
				■	■	■	■	■	■	■	■		■			R822		BWD				FW
					■		■		■		■					R82A	DIY					
																R82B						
					■											R828						FW
					■	■	■	■	■	■	■					R926						
					■	•	■	■	•	■						RX22						FW
	X65															U242						
	X65		X80		X100											U234						
	X65		X80		X100											U254						
	X65		X80		X100											U264						
	X70		X90		X110											U464						

VELKOOBCHOD BRUSIVA

PRODUCT AVAILABILITY TABLE

POLYESTER CLOTH PRODUCTS (EXCEPT CHIPBOARD)

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320	
R293	X/Y poly	AO	Maroon	PF/PF	P24 to P60 with 10% SG	1500											■		■	
R270	Y poly	Aggreg AO	Maroon	PF/PF	Closed coat	1400											■		■	
R275	Y poly	Aggreg AO	Maroon	PF/PF	Open coat	1400											■		■	
R445	X/Y poly	SiC	Black	PF/PF		1400											■		■	
R473	Y poly	Aggreg SiC	Maroon	PF/PF		1400									■					
R817	Y poly	NZ	Blue	PF/PF	Open coat	1500														
R823	X poly	NZ/AO	Blue	PF/PF		1500														
R847	Y poly	NZ/AO	Blue	PF/PF		1500														
R872	Y/X Poly	New NZ	Blue	PF/PF	Blue Force - Open coat	1500														
R874	YY/Y Poly	New NZ	Blue	PF/PF	Blue Force	1500														
R876	YY/Y Poly	New NZ	Blue	PF/PF	Blue Force - Supersize	1500														
R929	X poly	New SG/AO	Green	PF/PF		1500														
R984	Y poly	SG/AO	Maroon	PF/PF		1500														
RX84	Y poly	Delta/AO	Green	PF/PF		1500														
R976 Red-X	Y poly	SG/AO	Red	PF/PF	Supersize	1500														
RX66	Y poly	Delta/AO	Green	PF/PF	Supersize	1500														
R996 Viking	YY/Y Poly	New SG	Red	PF/PF	Supersize	1500														
U366	X poly	AO	Grey	UV	NORaX	600		X5				X16		X22			X30		X45	
U936	Y poly	SG	Grey	UV	NORaX	600						+					+		+	
W441	X cotton	SiC/Cork	Black	PF/PF	Waterproof	1400							+	■	■		■		■	
W445	Y poly	Cork	Beige	PF/PF	Cork polishing	1320	■													

PRODUCTS FOR CHIPBOARD AND OTHER COMBINATIONS

PRODUCT CODE	BACKING	ABRASIVE	PRODUCT COLOUR	BOND	COMMENTS	USEABLE WIDTH (mm)	GRIT SIZE													
							NO GRIT	5µ-3000	8µ-2500	10µ-2000	12µ-1500	16µ-1200	1000	800	600	500	400	360	320	
R490	YY poly	SiC	Black	PF/PF	Antistatic	1440														
S88XL	YY poly	SiC	Black	PF/PF		1400														
S413	Light combi	SiC	Black	PF/G	Open coat	1430														
S422	Light combi	SiC	Black	PF/G	Closed coat	1430														
S490	Heavy combi	SiC	Black	PF/PF	Antistatic	1440														
H490	400g paper	SiC	Black	PF/PF	Antistatic	1440														

VELKOOBCHOD BRUSIVA

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
■	■	■	■	■	■	■	■	■	■	■	■		■			R293						
	■		■		■		■	■								R270						FW
	■		■	•	■	■	■	■								R275						FW
	■	■	■	■	■	■	■	■							■	R445						
	■		■		■	■	■	■								R473						FW
					■	■	■	■	■	■	■		■			R817						
		■	■	■	■	■	■	■								R823						
								■	■	■	■		■			R847						
		■	■	■	■	■	■	■	■	■	■		■			R872						
					■	■	■	■	■	■	■		■			R874						
								■	■	■	■		■			R876						
					■	■	■	■	■	■	■					R929						
					■	■	■	■	■	■	■		■			R984						
					•	•	■	■	■	■	■					RX84						
					■	■	■	■	■	■	■					R976 Red-X						
					■	■	■	■	■	■	■					RX66						
							■	■	■	■	■					R996 Viking	No BFL					
	•		•		X100											U366		BWD				
	X65				X100		X200									U936						
		+		+												W441						
																W445						

280	240	220	180	150	120	100	80	60	50	40	36	30	24	20	16	PRODUCT CODE	SHAPE AVAILABILITY: BELTS W≤ 400MM	BELTS W> 400MM	DISCS	STD SHEETS	OTHER SHEETS	ROLLS
			■	■	■	■	■	■	■	■	■	■				R490		BSG				FW
					■	■	■	■	■	■	■	■	■			S88XL		BWD				FW
												■	N		N	S413		BSG				Norgrip in FW
						■	■	■	■	■	■	■	■			S422		BWD				
				■	■	■	■	■	■	■	■					S490		BSG				FW
			■	■	■	■	■									H490						FW

VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

94 FIBRE DISCS
99 FLAP DISCS
106 SEMI FLEXIBLE DISCS
108 BEARTEX SURFACE BLENDING DISCS
110 BEARTEX RAPID FINISH DISCS DEPRESSED CENTRE
112 BEARTEX RAPID STRIP DISCS DEPRESSED CENTRE

The table below demonstrates our complementary range of Coated and Beartex products to assist you throughout the application spectrum, from aggressive stock removal to fine finishing for two operations:

Welding

Application	Grind & Blend		Weld Prep and Cleaning
Product	Flap Discs →	Fiber Discs →	Wire Brushes
			Non-Woven RapidStrip

General Metal Fabrication

Application	Grind & Blend		Deburring
Product	Flap Discs →	Fiber Discs →	Non-Woven RapidFinish Vortex

For Extra Conformability:	Surface Conditioning (Preparation before Coating)
Non-Woven RapidPrep High Strength	Non-Woven RapidFinish SF
	Non-Woven SBM Discs

FIBRE DISCS

From rapid weld grinding to blending and finishing, Norton has a complete range of high performance fibre discs available in premium performance Norton SG® ceramic aluminium oxide, zirconia alumina, and aluminium oxide abrasives. All fibre discs in the Norton range feature a full resin bond system with heavy duty fibre backing for increased strength, durability and tear resistance.

APPLICATIONS & MARKETS

- Material removal
- Weld grinding & blending
- Light deburring & finishing
- Car manufacturing
- Metal fabrication
- Welding & foundry markets
- Transport markets

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	FX21	F861	F293
Carbon Steel/Weld/Ferrous metal	F975	F827	F293
Non-Ferrous Metal/Brass/Aluminium		F827	F228
Stone		F425	F228

INNOVATION BEST

FX21 RED DRAGON

Red Dragon

FERR. & NON-FERR.

FEATURES	BENEFITS
New SG® Ceramic Abrasives	Exceptionally high performance
Extremely high density of abrasive	High material removal even at low pressure Generates an excellent surface finish
0,8mm fibre backing	Exceptionally long life
Supersize with a high % of active fillers	Resists loading & has low heat generation

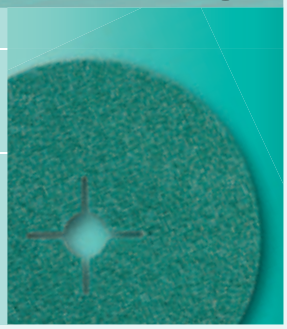
Jimi VELKOOBCHOD BRUSIVA

BEST

F975 GREENLYTE

FERR. & NON-FERR.

FEATURES	BENEFITS
■ SG® ceramic abrasive	■ Fastest cut rate ■ Suitable for metal grinding, shaping, blending, edge breaking & weld removal
■ 0,8mm high strength fibre backing	■ Resistant to high pressure ■ Cool cut

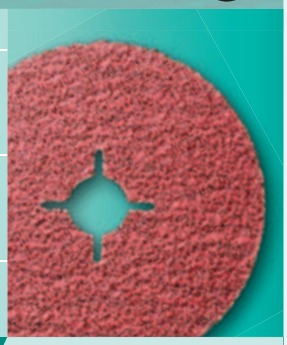


BETTER

F861 NORZON® PLUS

FERR. & NON-FERR.

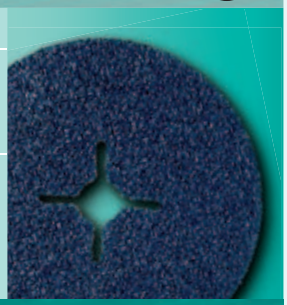
FEATURES	BENEFITS
■ NorZon® abrasive	■ Excellent cut rate ■ Ideal for metal grinding, shaping, blending & weld removal
■ 0,8mm fibre backing	■ Cool cut ■ Ideal for heavy construction work & stainless steel grinding
■ Third layer Supersize with active filler	■ Resistant to loading ■ Ideal for sensitive metal grinding



F827 NORZON®

FERR. & NON-FERR.

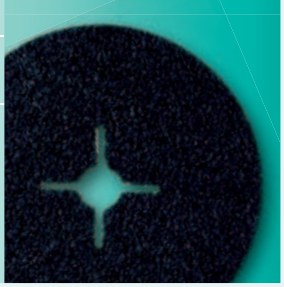
FEATURES	BENEFITS
■ NorZon® abrasive	■ General purpose ■ Ideal for grinding, shaping, blending, edge breaking & weld
■ 0,8mm fibre backing	■ High & regular cut rate ■ Good for high metal removal in short time ■ Excellent price-performance ratio



F425

NON-FERR. STONE

FEATURES	BENEFITS
■ High performance silicon carbide abrasive	■ Very good cut rate with low pressure
■ 0,8mm fibre backing	■ Self-sharpening ■ Recommended for use on angle grinders



VELKOOBCHOD BRUSIVA

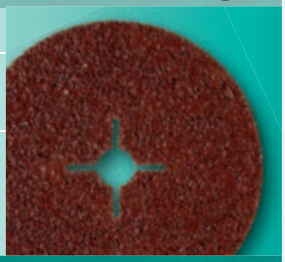
FIBRE DISCS

GOOD

F293

FERR. & NON-FERR.

FEATURES	BENEFITS
■ Aluminium oxide abrasive	■ General purpose ■ General metal grinding, shaping & polishing
■ 0,8mm fibre backing	■ Good cut rate ■ Weld removal



F228

FERR. & NON-FERR.

FEATURES	BENEFITS
■ Tough versatile aluminium oxide abrasive	■ Fast initial cut
■ 0,8mm fibre backing	■ Ideal for general purpose metal applications

MAXIMUM OPERATING SPEED

DIA (mm)	MOS (m/s)	MAX RPM
100	80	5300
115	80	13300
125	80	12300
150	80	10200
180	80	8600

■ The maximum peripheral operating speed of a fibre disc is 80m/s. This is communicated on the box label

See other product lines from our From Start To Finish range

■ page 44 - Cutting & Grinding Wheels

■ page 100 - Flap Discs

jimi
VELKOOBCHOD BRUSIVA

STANDARD

DIM DIAxH(mm)	GRIT	PK QTY	Red Dragon INNOVATION BEST FX21	GREENLYTE BEST F975	NORZON PLUS BETTER F861	NORZON BETTER F827	BETTER F425	GOOD F293	GOOD F228
115x22	24	25				69957**360048**	63642**545163***	63642**547861**	07660**707354**
	36	25		63642**568819**	69957**395190***	63642**539615**	63642**537161***	63642**535056**	07660**707355**
	36	100	66261**083245**						
	50	25		63642**568820***		69957**360053**		07660**705216**	07660**707356**
	50	100	66261**083247**						
	60	25		63642**568821**	69957**395192***	63642**539616**	63642**537239***	63642**536900**	07660**707357**
	60	100	66261**083252**						
	80	25		63642**568822**	69957**395193***	63642**539617**	63642**548543***	07660**705214**	07660**707358**
	80	100	66261**083254**						
	100	25				69957**360063***		07660**705213**	07660**707359**
	120	25			69957**395194**	63642**533055**	63642**512988***	07660**705212**	07660**707360**
	220	25					63642**512989***		
125x22	24	25				63642**539619**	63642**508423***	63642**547907**	07660**707366**
	36	25		63642**568823**	69957**395195**	63642**536483**	63642**546187***	63642**547906**	07660**707361**
	36	100	66261**083256**						
	50	25		63642**568824**		63642**539620**		63642**547905**	07660**707362**
	50	100	66261**083257**						
	60	25		63642**568825**	69957**395198**	69957**360057**	63642**551570***	63642**547904**	07660**707363**
	60	100	66261**083258**						
	80	25		63642**568826**	69957**395199**	63642**539622**	63642**507453***	63642**547903**	07660**707364**
	80	100	66261**083259**						
	100	25				63642**536484**		63642**547902**	66261**153113***
	120	25			69957**395200**	63642**533056**	63642**507454***	63642**547901**	07660**707365***
	220	25					63642**547695***		
180x22	16	25						63642**533109**	
	24	25				63642**533062**	63642**534249***	63642**533108**	07660**707367**
	36	25		63642**568827**	69957**395201***	63642**533063**	69957**360039**	63642**533107**	07660**707368**
	36	100	66261**083260**						
	50	25		63642**568828**	69957**395202**	63642**533064**		63642**535057**	07660**707369**
	50	100	66261**083261**						
	60	25		63642**568830**	69957**395204**	63642**533065**	69957**360040**	63642**533105**	07660**707370**
	60	100	66261**083262**						
	80	25		63642**568831**	69957**395206**	63642**533066**	69957**360041**	63642**533104**	07660**707371**
	80	100	66261**083263**						
	100	25				63642**533067***		63642**533103**	07660**707372**
	120	25			69957**395207***	63642**533068**	63642**536718**	63642**533102**	07660**707373**
	220	25					69957**360044***		

* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

JIMI VELKOOBCHOD BRUSIVA

FIBRE DISCS

MOULDED

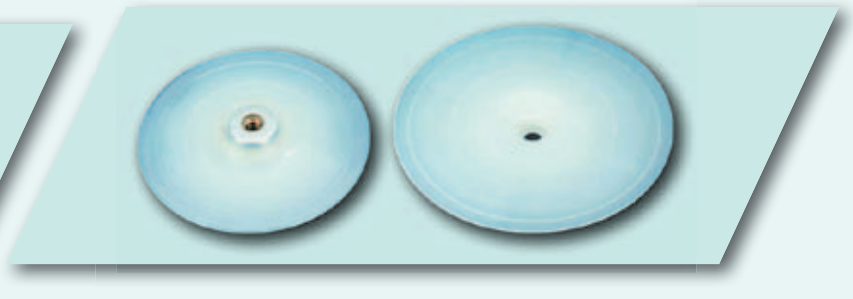
DIM DIAxH(mm)	GRIT	PK QTY	Red Dragon INNOVATION BEST FX21	GREENLYTE BEST F975	NORZON PLUS BETTER F861
180x22	36	100	6626108**3264**	6364256**8832**	6995739**5209***
	50	100	6626108**3266**	6364256**8833**	
	60	100	6626108**3267**	6364256**8834**	6995739**5212***
	80	100	6626108**3268**	6364256**8835**	6995739**5213***
	120	100			6995739**5214***

* Made-to-order

BACK-UP PADS

AIRCOOL					NYLON				
DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.	DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
115	Hard	M14	1	6995738**2821**	115	Hard	M14	5	6995738**2828**
	Medium	M14	1	6995738**9797**		Medium	M14	5	6995738**2825**
125	Hard	M14	1	6995738**2823**	125	Hard	M14	5	6995738**2829**
	Medium	5/8	1	6364258**8240**		Medium	5/8	5	6364258**8341***
	Medium	M14	1	6995738**9803**		Medium	M14	5	6995738**2826**
178	Hard	M14	1	6995738**2824**	178	Hard	M14	5	6995738**2830**
	Medium	5/8	1	6364258**8243**		Medium	5/8	5	6364258**8345**
	Medium	M14	1	6995738**9804**		Medium	M14	5	6995738**2827**

* Made-to-order



Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

Superior cut and longer life

NORTON
SAINT-GOBAIN

X-TREME

ABRASIVE TECHNOLOGICAL EXCELLENCE

Jimi
VELKOOBCHOD

FLAP DISCS

Norton flap discs are engineered for multiple applications including light stock removal, blending and finishing, meaning they can help reduce processing times and lower costs. Flap discs have a fast cut and provide a better finish than fibre while having the added benefit of a longer life.

APPLICATIONS & MARKETS

- Stock removal
- Edge chamfering
- Deburring
- Rust/paint removal
- Cleaning & finishing
- Grinding & blending welds

PRODUCT SELECTION GUIDE

MATERIAL	INNOVATION	BEST	BETTER	GOOD
Heat sensitive Alloys / High strength steel / Hard to grind metals	Quantum	Norstar / Twinstar	Xtreme	
Stainless steel	Quantum	Norstar / Twinstar	Xtreme / Norfiber	
Carbon steel		Norstar / Twinstar	Xtreme / Norfiber	BDX / Nortech
Aluminium / Cast iron / Bronze / Copper / Composite			Norfiber	BDX / Nortech
Wood / Paint				BDX / Nortech
THIN WHEEL EQUIVALENT QUALITY	Quantum	Extreme	Industrial line	BDX
MACHINE	High power (more than 1000 Watts)		Low power (less than 1000 Watts)	

INNOVATION BEST

QUANTUM NEW SG® CERAMIC R996 WITH VIKING TECHNOLOGY

FERR. & NON-FERR.

FEATURES	BENEFITS
High Performance new SG Ceramic Grain	Very aggressive and consistent cut rate
Y-weight polyester backing	High and fast stock removal
New resin system for high grain retention	Maximum and lost lasting performance
3rd layer supersize treatment	Advanced cooling system

SHAPE KEY Flat Conical

VELKOOBCHOD BRUSIVA

BEST

RX22/R822 TWINSTAR

FERR. & NON-FERR.

FEATURES	BENEFITS
Premium SG® ceramic aluminium oxide & Norzon® zirconia alumina abrasive blend	Aggressive stock removal with less pressure, giving a cooler cut
Heavy cotton cloth	
High density disc with extra-large flaps	Achieves a much longer life due to the high density of flaps
Reinforced plastic backing	

RX22/R822 NORSTAR

FERR. & NON-FERR.

FEATURES	BENEFITS
Premium SG® ceramic aluminium oxide & NorZon® zirconia alumina abrasive blend	Aggressive stock removal with less pressure
Heavy cotton cloth	
High content of active filler	
Fiberglass backing	

INNOVATION
BETTER

R828 X-TREME

FERR. & NON-FERR.

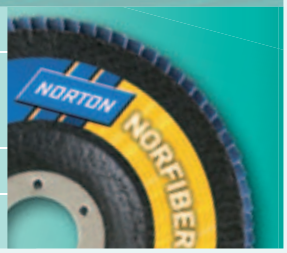
FEATURES	BENEFITS
100% High performance Norton® zirconia alumina abrasive grain	Fast and consistent cut
Specifically engineered heavy cloth optimized for controlled wear characteristics	Best for mid/heavy duty application
Durable innovative bond system	Increased life time and cut renewal
	Low vibrations

BETTER

R822 NORFIBER

FERR. & NON-FERR.

FEATURES	BENEFITS
High performance NorZon® zirconia alumina abrasive grain	Good stock removal
Heavy cotton cloth	
Fibreglass backing	



VELKOOBCHOD BRUSIVA

FLAP DISCS

BETTER

FLEXI DISCS

NORZON

FERR. & NON FERR.

FEATURES	BENEFITS
■ Premium NorZon® grain	■ Remove material quickly & effectively
■ Flexible cloth backing	■ Adapt to contours & improved finish
■ Angular flap disc construction	■ Increased flexibility in use
■ Available in grit range 40, 60, 80	

GOOD

R822 NORTECH

FERR.

FEATURES	BENEFITS
■ NorZon® zirconia alumina abrasive grain	■ Aggressive cut
■ Heavy cotton cloth	
■ Double flap disc construction	
■ Plastic backing	

R822 BDX

BDX

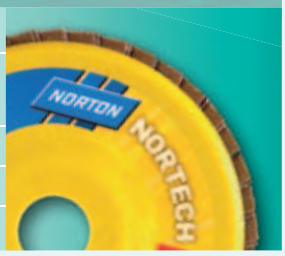
FERR.

FEATURES	BENEFITS
■ High performance NorZon® zirconia alumina abrasive grain	■ Good stock removal
■ Heavy cotton cloth	
■ Fibreglass backing	

R265 NORTECH

FERR.

FEATURES	BENEFITS
■ Durable aluminum oxide abrasive grain	■ Fast initial cut rate especially on carbon steel
■ Heavy cotton cloth	
■ Double flap disc construction	
■ Plastic backing	



Jimi VELKOOBCHOD BRUSIVA

FIBREGLASS BACKED

DIM DIAxH(mm)	GRIT	PK QTY	NORTON QUANTUM INNOVATION / BEST R996	NORSTAR BEST RX22/R822	X-TREME INNOVATION / BETTER R828	NORFIBER BETTER R822	BDX GOOD R822
Conical							
115x22	16	10				6364253074*	
	36	10		6364234666			
	40	10	6625446**1027**	6364234667	6626199026	6364253075	
	40	200**					6364215039
	50	10		6364214933			6626141593
	60	10	6625446**1029**	6364234668	6626199030	6364253076	
	60	200**					6364215040
	80	10	6625446**1031**	6364234669	6626199034	6364253077	
	80	200**					6364249442
	120	10		6364234670	6626198800	6995787295	
	120	200**					6364215041
125x22	16	10				6364253078*	
	36	10		6364214934			
	40	10	6625445878	6364263571	6626199037	6364253079	
	40	160**					6364250311
	50	10		6364250473			
	60	10	6625445879	6364268611	6626199038	6364253080	
	60	160**					6364250312
	80	10	6625446**1033**	6364249404	6626199039	6364253081	
	80	160**					6364215042
	120	10		6364250474	6626199035	6995787300	
	120	160**					6364215043
180x22	36	10		6364234671			
	40	10	6625446**1038**	6995736664	6626199045	6995787302	
	40	60**					6626179318
	60	10	6625446**1036**	6364249405	6626199046	6995787303	
	60	60**					6626179319
	80	10	6625446**1040**	6364249406	6626199047	6995787304*	
	80	60**					6626179320
	120	10		6995753208*	6626199044*	6364294667*	6995753178*

** Also available shrink-wrapped in 10

* Made-to-order

SPEC CHECK

- Conical flap discs are designed to be used at an angle of 15-25°
- For an equivalent finish, always use a flap disc one grit size coarser than with a fibre disc

MOQ for MTO
- 115mm - 1200 pcs
- 125mm - 960 pcs
- 180mm - 360 pcs

SHAPE KEY Flat Conical

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

FLAP DISCS

FIBREGLASS BACKED

DIM DIAxH(mm)	GRIT	PK QTY	NORSTAR BEST RX22/R822	X-TREME INNOVATION BETTER R828	BDX GOOD R822
Flat					
115x22	40	10	63642514923		
	40	10	63642514924		
	40	200**			63642527334
	60	10	63642514926		
	60	200**			63642527336
	80	10	63642569159		
	80	200**			63642527337
	120	10	63642514928		
	120	200**			69957353557
125x22	36	10	63642514929		
	40	10	63642550472	66261099052	
	40	160**			63642527341
	60	10	63642549401	66261099056	
	60	160**			63642527343
	80	10	63642549402	66261099057	
	80	160**			63642527347
	120	10		66261099051	69957353180
180x22	36	10	63642514930		
	40	10	63642564417		
	40	60**			69957353181
	60	10	63642565986		
	60	60**			69957353182
	80	10	63642549403		69957353183*
	120	10			69957353184*

** Also available shrink-wrapped in 10

* Made-to-order

FLEXI DISCS FLD FXSF

DIM DIAxH(mm)	GRIT	PK QTY	NORZON BETTER R822
115x22	40	10	63642544276
	60	10	63642544277
	80	10	63642544278
125x22	40	10	66261177415
	60	10	66261177416
	80	10	66261177417

VELKOOBCHOD BRUSIVA

PLASTIC BACKED

DIM DIAxH(mm)	GRIT	PK QTY	TWINSTAR BEST RX22/R822	X-TREME INNOVATION BETTER R828	NORTECH GOOD R822	NORTECH GOOD R265
		Flat				
115x22	36	10	63642545567		66261039424	
	40	10	63642545568	66261099060		
	40	200**			66261039431	66261039427
	50	10	63642545569		66261039441	66261039435
	60	10	63642545570	66261099061		
	60	200**			66261039449	66261039445
	80	10	63642545571	66261099062		
	80	200**			66261039457	66261039453
	100	10	63642545572*		66261039463	66261039460
	120	10	63642545573	66261099059		
	120	200**			66261039469	66261039467
125x22	40	10		66261099533		
	40	160**			63642588032	
	60	10		66261099534		
	60	160**			63642588033	
	80	10		66261099535		
	80	160**			63642588031	
	120	10		66261099532	69957353205	
180x22	36	10	63642545574		66261039472	
	40	10	63642545575			
	40	60**			66261039476	66261039474
	50	10	63642513943			
	60	10	63642545576			
	60	60**			63642514335	66261039481
	80	10	63642545577			
	80	60**			63642514336	66261039485*
	120	10			69957353207*	69957353888*

** Also available shrink-wrapped in 10

* Made-to-order

SPEC CHECK

- For an equivalent finish, always use a flap disc one grit size coarser than with a fibre disc
- Flat flap discs are designed to be used at an angle less than

MAXIMUM OPERATING SPEED

DIA (mm)	MOS (m/s)	MAX RPM
115x22	80	13300
125x22	80	12200
180x22	80	8500

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

SEMI-FLEXIBLE DISCS

Semi-flexible discs are made by coating heavy duty fibre with multiple layers of a special resin bonded abrasive. They can be used in a wide range of applications instead of depressed centre grinding wheels.

APPLICATIONS & MARKETS

- Grinding welds
- Derusting large surfaces
- Cleaning hulls of ships & boats
- Cleaning cows' hooves

PRODUCT SELECTION GUIDE

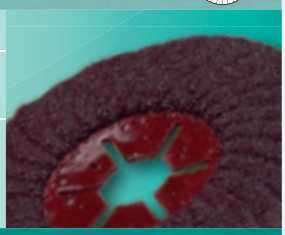
MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	Q200		
Carbon Steel/Weld/Ferrous metal	Q200		
Non-Ferrous Metal/Brass/Aluminium	Q200		
Stone	Q400	CPFLEX	

BEST

Q200

FERR.

FEATURES	BENEFITS
High concentration of aluminium oxide abrasive	For use on stainless steel, aluminium & most other metals
Unique disc pattern	Resists loading Cooler work area



Q400

STONE

FEATURES	BENEFITS
High concentration of sharp silicon carbide abrasive	For use on marble, granite, concrete, fibreglass & cast iron Suitable for heavy duty industrial applications Longer lasting
Unique disc pattern	Resists loading Cooler work area

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

BETTER

CP FLEX

STONE

FEATURES	BENEFITS
■ Sharp silicon carbide abrasive grain	■ For use on marble, granite, concrete, fibreglass & cast iron ■ Ideal for use in construction markets ■ Longer lasting
■ Unique disc pattern	■ Resists loading ■ Cooler work area

SPEC CHECK

■ Semi-flexible discs should be used on an angle grinder with a hard density back-up pad which has the same diameter as the disc. All semi-flexible discs have a maximum operating speed of 80m/s

CPA DISCS ALUMINIUM OXIDE

DIM DIAxH(mm)	GRIT	PK QTY	Q200 BEST CONVEX
127x22	24	25	07660717653
	36	25	07660717654
	60	25	07660717655
	80	25	07660717656*
180x22	24	25	07660717647
	36	25	07660717648
	60	25	07660717650
	80	25	07660717651

* Made-to-order

CPS DISCS SILICON CARBIDE

DIM DIAxH (mm)	GRIT	PK QTY	Q400 BEST MOULDED/CONVEX	Q400 BEST FLAT	CP FLEX BETTER FLAT
127x22	16	25		07660707935	66261083476
	24	25	07660705207	07660707937	07660719292
	36	25	07660707946	07660707454	07660719293
	60	25	07660718494		07660719294
	80	25	07660707948		07660719295
180x22	16	25	07660705202	07660717646	66261083479
	24	25	07660705203	07660707931	07660719296
	36	25	07660705204	07660707933	07660719297
	60	25	07660705205	07660707934	07660719298
	80	25	07660705206		07660719299
	120	25	07660707943		

BACK-UP PADS

DIA (mm)	DENSITY	ATTACHMENT	PK QTY	NYLON
125	Hard	M14	5	69957382829
180	Hard	M14	5	69957382830

VELKOOBCHOD BRUSIVA

BEARTEX SURFACE BLENDING DISCS (SBM)

Surface Blending products are reinforced with a special nylon fibre net backing (scrim) to increase the resistance to tearing. They provide a unique combination of aggressive performance, long life and improved finish.

APPLICATIONS & MARKETS

- Removing surface defects
- Removing light edge burrs, parting lines or flashing
- Removing rust, oxides, corrosion, paints & scale
- Cleaning moulds
- Blending mill marks, tool marks, uneven edges & coated abrasive finish

PRODUCT SELECTION

WHICH GRADE SHOULD I CHOOSE?

GRADE	FEATURES & BENEFITS
Extra Coarse	Provides longest cutting life & highest aggressiveness to quickly achieve an even surface ready for finer finishing.
	Ideal for descaling & removing heavy rust & oxides, Ideal for deburring, aluminium & Excellent performance on hard materials
Coarse	Ideal where a less coarse finish or increased flexibility is required & an aggressive cut is necessary
	Removes 60-120 grit grindlines - for light deburring
Medium	Removes 120-180 grit grindlines - for cleaning & rust removal
Very Fine	Provides an excellent & uniform finish, ideal choice for fine finishing & pre-coat finishing
	Removes 180-320 grit grindlines - for finishing, polishing & paint preparation
Super Fine	The finest & most flexible surface conditioning for decorative finishes & excellent surfaces on soft & hard metals, ideal for pre-polishing

SPEC CHECK

Surface Blending discs should always be run at lower speeds than Coated abrasives.
This extends life and improves the finish.

MAXIMUM OPERATING SPEED

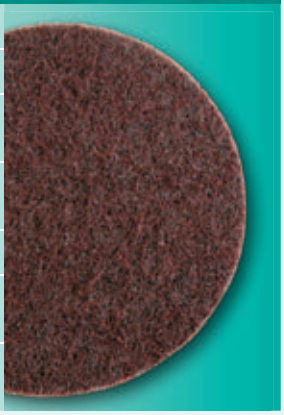
DIA (mm)	RPM
115	13.000
125	10.000
150	8.000
178	6.000

*Maximum operation speed is 33m/s

Jimi VELKOOBCHOD BRUSIVA

BEARTEX SURFACE BLENDING DISCS

FEATURES	BENEFITS
Durable fibre construction	Long lasting and cool running
Very sharp abrasive grain	High, continuous cut rate, resistant to loading and clogging
Rigid, low stretch backing	Excellent performance on hard materials including steels, nickel, alloys etc.
Controlled cut and comfortable to use	Consistent finish
Remove and attach quickly (Use with Norgrip back-up pads)	Ideal for sequential finishing using consecutively finer grades
Extra Coarse grade for de-burring Aluminium	Reduced clogging or loading



SURFACE BLENDING DISCS

DIA (mm)	CAP CODE	GRADE	TYPE	PK QTY	ART. NO.
115	S2112	Extra Coarse	DSB	20	636425**57509**
	S2211	Coarse FB*	DSB	20	636425**57510**
	S2211	Coarse	DSB	20	636425**57511**
	S2311	Medium	DSB	20	636425**57717**
	S2513	Very Fine	DSJ	20	636425**57718**
	S4713	Super Fine	DSJ	20	636425**57719***
125	S2112	Extra Coarse	DSB	20	636425**57720**
	S2211	Coarse FB*	DSB	20	636425**57721**
	S2211	Coarse	DSB	20	636425**57722**
	S2311	Medium	DSB	20	636425**57723**
	S2513	Very Fine	DSJ	20	636425**57724**
	S4713	Super Fine	DSJ	20	636425**57725***
150	S2211	Coarse FB*	DSB	10	636425**57727**
	S2211	Coarse	DSB	10	636425**57728**
178	S2112	Extra Coarse	DSB	10	636425**57732**
	S2211	Coarse FB*	DSB	10	636425**57733**
	S2211	Coarse	DSB	10	636425**57734**
	S2311	Medium	DSB	10	636425**57735**
	S2513	Very Fine	DSJ	10	636425**57736***

FB* = Fibre backed and with 22mm hole (for a stiffer, higher performing disc)

* Made-to-order

BACK-UP PADS

NORGRIP for BEARTEX

DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
115	Medium	M14	1	699573**82846**
	Medium	5/8	1	636425**95937**
125	Medium	M14	1	699573**82841**
	Medium	5/8	1	636425**95938**
178	Medium	M14	1	699573**82844**
	Medium	5/8	1	636425**95940**

VELKOOBCHOD BRUSIVA

BEARTEX RAPID FINISH DISCS DEPRESSED CENTRE

Unique design offers material removal while imparting a final smear free finish. Ideal for deburring, edge breaking, blending, cleaning, and polishing. Durable construction for fast, economical surface preparation using a right angle grinder. Can be used in sequence with, fibre and flap discs, to clean, polish and impart great finishes in one or two operations.

APPLICATIONS & MARKETS

- Conditioning grindlines
- Blending surface defects
- Deburring and radiusing edges
- Removing corrosion and oxide and Light scale removal
- Preparing surfaces for coatings

RAPID FINISH DPC DISCS

FEATURES	BENEFITS
Fits 115mm Angle grinders	Eliminates steps by replacing other 115mm coated abrasive products
Wide range of solutions for finishing ferrous and non-ferrous materials	Longer life and more parts per disc. resists loading
No need to change Power tools	Can be used in place of, or in sequence with, fibre and flap discs for improved part quality
Undersized backing plate	Longer usable diameter

RAPID FINISH DPC DISCS

DIM DIAxH(mm)	CAP CODE	PK QTY	MAX RPM	GRADE	APPLICATION	ART. NO.
115x22	U4401	10	12000	NEX2SF	Blend & Finish	662610**20546**
115x22	U4401	10	12000	NEX3SF	Blend & Finish +	662544**61726**
115x22	U2401	10	12000	NEX2AF	Multi-purpose	662610**20547**
115x22	U2301	10	12000	NEX2AM	Most aggressive	662610**20548**
115x22	F2303	10	12000	RAPIDPREP HSMA	Most conformable	662610**20549**
125x22	F2303	10	12000	RAPIDPREP HSMA	Blend & Finish	662544**96320**

SPEC CHECK

Where can a Rapid Finish Disc be used?

They can be used in conjunction with Flap Discs. In some cases, the Unitized Discs can replace a Flap Disc.

The Flap Disc leaves scratches on the workpiece. The Rapid Finish Disc will remove the coated abrasive scratches, providing a smoother, burr-free finish.

They provide a clean bright surface finish on Stainless Steel.

Revolutionary Grain Technology combined with a new manufacturing process, produces up to twice the stock removal rates of conventional unitised discs while imparting a final finish. Best solution for deburring, edge breaking, blending and finishing. Extremely versatile and top performer!

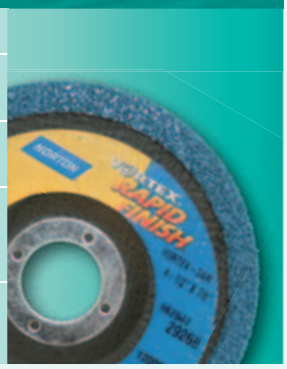
APPLICATIONS & MARKETS

- Conditioning grindlines, light TIG weld and splatter removal
- Blending surface defects and weld discolouration
- Deburring and radiusing edges
- Preparing surfaces for coatings

INNOVATION BEST

RAPID FINISH VORTEX DPC DISCS

FEATURES	BENEFITS
High-performance engineered grain	Aggressive, fast stock removal, reduced cycle times and increased part quality
Thick Nylon web	Longer life and more parts per disc. resists loading
No need to change Power tools	Can be used in place of, or in sequence with, fibre and flap discs for improved part quality
Undersized backing plate	Longer usable diameter



RAPID FINISH VORTEX DPC DISCS

DIM DIAxH(mm)	CAP CODE	PK QTY	MAX RPM	GRADE	APPLICATION	INNOVATION BEST
115x22	U2305	10	12000	VORTEX 5AM	Tig Weld removal	662544**29268**
125x22	U2305	10	12000	VORTEX 5AM	Tig Weld removal	662544**96323**

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

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BEARTEX RAPID STRIP DISCS DEPRESSED CENTRE

The BearTex® rapid strip disc is constructed with thick, strong, synthetic fibres and extra-coarse silicon carbide abrasive. The open web construction of the disc provides fast cutting action with very little loading. Safer than wire bristle tools, Rapid Strip is suitable for use in many industries.

APPLICATIONS & MARKETS

- Removal of surface rust & residue, corrosion, light weld splatter, dirt, mill scale & other similar surface contaminants
- Paint & epoxy coating removal
- Surface preparation before coatings are applied
- Surface preparation before welding
- Cleaning & conditioning after welding

RAPID STRIP DISCS DEPRESSED CENTRE TYPE 27

FEATURES	BENEFITS
Open web construction	Fast cutting action with very little loading
Conformable	Easy cleaning of uneven surfaces
Thick, strong, synthetic fibres & extra coarse grit	Quick cleaning & conditioning of surfaces
Used with portable tools NEW R4101 H with harder density	Easy & safe to use especially in difficult to reach areas Longer Life

BLAZE RAPID STRIP DISCS DEPRESSED CENTRE TYPE 27 NEW!

FEATURES	BENEFITS
Heavy coating of Norton SG Blaze ceramic alumina long-lasting grain and advanced resin bond	2x as substantial as competitive discs so last 2x (plus) as long as competitive products Will not shed on rust-encrusted pieces
Extremely versatile; use one disc for multiple operations	Lighter pressure will finish similar to a medium grit surface conditioning disc; additional pressure will remove material (strip and clean) Stiff enough to stand abuse but soft enough to prevent gouging and rework Fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap
Open structure	Will not load on sticky coatings, adhesives and soft metals (e.g. aluminum)

Dimensions Key: DIA = Diameter, B = Bore

NORTON SAINT-GOBAIN

RAPID STRIP DISCS DEPRESSED CENTRE TYPE 27

DIAxB (mm)	CAP CODE	PK QTY	MAX RPM	STRIPPA	RAPID STRIP
115x22	R4101S	5	11000	63642585732	
115x22	R4101H	10	12000		66261009649 NEW!
125x22	R4101S	5	8500	63642585749	
178x22	R4101S	5	6500	63642585750	

BLAZE RAPID STRIP DISCS DEPRESSED CENTRE TYPE 27 NEW!

DIAxB (mm)	CAP CODE	PK QTY	MAX RPM	ART. NO.
115x22	R9101	10	12000	66623303783
125x22	R9101	10	11000	66623303916
178x22	R9101	10	8000	66623303920

SPEC CHECK

Perfect product for rust, paint and corrosion removal

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NOTES

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NORTON

SAINT-GOBAIN

116 SPEEDLOK COATED DISCS
124 SPEEDLOK BEARTEX DISCS

Min

SPEEDLOK® DISCS

The tool-free fastening systems make fast work of disc changes to maximise productivity and minimise downtime. They can be used on contours as well as flat surfaces in general purpose and specialised grinding.

APPLICATIONS & MARKETS

- Weld blending
- Light deburring & finishing
- Blending
- Aggressive Stock removal
- 2 button attachment systems
- Cleaning & corrosion removal

FEATURES	BENEFITS
SpeedLok® fastener	Quick, tool-free disc changes allow for more grinding time
Twist on & twist off in 2-1/2 turns	Disc locks securely to back-up pad, but is easily removed
25mm to 75mm TS discs – all metal fasteners	Mount to the Norton SpeedLok® TS or standard abrasives' quick-change back-up pads
25mm to 75mm TR discs – rubber threaded hubs	Mount to Norton SpeedLok TR or 3M Roloc back-up pads
Small disc sizes	Discs can access restricted corners & contours

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	R980	R822	RV71
Carbon Steel/Weld/Ferrous metal	R980	R822	RV71
Non-Ferrous Metal/Brass/Aluminium	R422		

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal - using SBM	S2211	S2313	S2313
All metal - using Unitised	U2305 Vortex	U4401	U4401
All metal with minimal or no stock removal	F2303 HS	R4101	F2300

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PRODUCT SELECTION

OPTIMUM TOOL SPEED TABLE (for maximum disc cut rate & life)*

DIA(mm)	STAINLESS	ALUMINIUM	MID STEEL	TITANIUM	GLASS	COMPOSITES
38	20000	20000	30000	9000	9000	15000
50	15000	15000	20000	7000	7000	10000
75	10000	10000	15000	4500	4500	8000

ATTACHMENTS/BACK-UP PADS

TS – Type 2 – SL2

Turn on/turn off system using a metal to metal fixing on pad (TS) with spindle

TR – Type 3 – SL3

Roll-on/roll off system using a nylon threaded button on pad (TR) with spindle

*Please note: The operational speed is governed by application & product size

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INNOVATION BEST

F980 NORTON SG BLAZE

NEW!

SG BLAZE

FERR.

FEATURES	BENEFITS
Patented, new generation ceramic SG® grain	Significant cut rate and life over competitive blended/low-ratio ceramic alumina disc
Self-lubricating, advanced supersize treatment	Reduced heat, loading and glazing on stainless, titanium and super alloys
Improved resin system	Improved grain retention for longer life
Heaviest Fibre backing (blue)	Longer Life and aggression for tough applications

R980 X-TREME LIFE BLAZE

SG BLAZE

FERR.

FEATURES	BENEFITS
100% premium SG® abrasive	High metal removal rate, even at medium pressure Cool cutting
3rd layer Supersize with active filler	Best part cut & finish on stainless steel, inconels, chromium cobalt or titanium
3 ply polyester backing (yellow backing) Also with new single ply laminate (black backing)	Exceptionally longer life, durability & aggressiveness More conformable and very flexible for contours

BEST

MINI FLAP DISCS

FERR. & NON FERR.

FEATURES	BENEFITS
R822 NorZon® cloth	High stock removal Fast cutting capacity Long life
50mm/75mm nylon backing	Ideal for working on small, difficult to access areas
Incorporated quick change system (TR)	Quick & easy to change
Available in grit range 40 to 80	Blending & finishing in one operation

Jimi VELKOOBCHOD BRUSIVA

BEST

MINI-FLEXI FLAP DISCS

FERR. & NON FERR.

FEATURES	BENEFITS
R822 NorZon® flexible cloth	Longer life with excellent finish
50mm nylon backing	Ideal for working on small, difficult to access & contoured surfaces
Incorporated quick change system (TR)	Quick & easy to change
Available in grit range 40 to 80	Blending & finishing in one operation

BETTER

NORZON® PLUS

NORZON PLUS

FERR. & NON FERR.

FEATURES	BENEFITS
Zirconia alumina abrasive with grinding aid	High stock removal with a cool cutting action
Heavyweight backing	Extended durability

R822 NORZON®

NORZON

FERR. & NON FERR.

FEATURES	BENEFITS
NorZon® abrasive	Long lasting cutting edges especially on stainless steel
Heavy cotton cloth	Durable & hardwearing

GOOD

RV71

FERR. & NON FERR.

FEATURES	BENEFITS
High performance aluminium oxide	Multi-purpose Economy product ideal for general purpose applications
Strong cotton laminated backing	Durability for edge wear & fray resistance
Open-coat grain distribution	Reduced clogging

VELKOOBCHOD BRUSIVA

SPEEDLOK® DISCS TR ATTACHMENT (Type 3 – SL3)

DIA (mm)	GRIT	PK QTY	SG BLAZE INNOVATION BEST F980	SG BLAZE INNOVATION BEST R980 Triple Ply	SG BLAZE INNOVATION BEST R980 Single Ply	NORZON PLUS BETTER PLUS	NORZON BETTER R822	ALOX GOOD RV71	SiC GOOD R422
25	36	100		66261094895					
	50	100		66254402096					
	60	100		66261038811					
	120	100		66261038810					
38	36	50		63642597033			63642560879*	63642586622*	
	36	100			63642595465*				
	50	50		63642597034				63642586626*	
	50	100			63642595467*				
	60	50		63642597037			63642560880*	63642586628*	08834163863*
	60	100			63642595468*				
	80	50		63642597038				63642586629*	69957391364*
	80	100			63642595469*				
	120	50						63642586631*	69957391366*
	120	100		66261043380	66261043417*				
	180	50						63642586633	
50	36	25	66261058704		63642595470*				
	36	50		63642597039		63642556405	63642560882	63642586683*	
	50	25	66261058705		63642595472*				
	50	50		63642597045		63642587202	69957389455	63642586685*	
	60	25	66261058706		63642595476				
	60	50		63642597050		63642556407	63642556396	69957389332*	08834164163*
	80	25	66261058707		63642595478				
	80	50		63642597052		63642587207	63642560884	63642586687*	08834166155*
	100	25		66261043383	66261043419				
	120	25		66261043386	66261043421				
	120	50				63642587208	63642560885	63642586689	08834164837*
	180	50						63642586691	
	240	50						63642586694	
	320	50						63642586695	
75	36	25	66261058708		63642595479*				
	36	50		63642597053		63642587245	63642560886	63642586723*	
	50	25	66261058709		63642595480*				
	50	50		63642597057		63642587246	69957389465	63642586728*	
	60	25	66261058711		63642595481				
	60	50		63642597060		63642556411*	63642560887	63642586731*	08834164850*
	80	25	66261058712		63642595493				
	80	50		63642597062		63642587247	63642560888	63642586733*	08834166159*
	120	25			66261043425				
	120	50		66261043392		63642587248		63642586735	08834166160*
	180	50						63642586738	

* Made-to-order

Dimensions Key: DIA = Diameter

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SPEEDLOK® SPECIALIST DISCS TR ATTACHMENT (Type 3 – SL3)

DIA (mm)	GRADE	PK QTY	BEST	
			MINI FLEXI-FLAP DISCS	MINI FLAP DISC
50	40	10	662611**80889**	662611**80892**
	60	10	662611**80890**	662611**80893**
	80	10	662611**80891**	662611**80894**
75	40	10		636425**27476**
	60	10		662611**80904**
	80	10		636425**27482**

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SPEEDLOK® DISCS TS ATTACHMENT (Type 2 – SL2)

			SG BLAZE			NORZON PLUS	NORZON	ALOX	SiC
			INNOVATION			BETTER		GOOD	
DIA (mm)	GRIT	PK QTY	BEST						
			F980	R980 Triple Ply	R980 Single Ply	PLUS	R822	RV71	R422
15	36	100		08834**63315***					
	60	100		08834**63318***					
	120	100		08834**63320***					
25	36	100		66254**02097**					
	60	100		66254**02098**					
	120	100		66261**94680**					08834**60894***
38	36	50					63642**49604**	63642**86583***	08834**60895***
	36	100		66254**02099**	63642**95401***				
	50	50		69957**90693**			66261**38622**	63642**86587***	08834**60685***
	50	100			63642**95446***				
	60	50		69957**90694**			63642**49607**	63642**86596***	
	60	100			63642**95447***				
	80	50		69957**90695**		63642**87383**	63642**49606**	63642**86607***	
	80	100			63642**95450***				
	120	50		69957**90696**		63642**87416***		63642**86608***	
	120	100			66261**43416***				
	180	50						63642**86609***	08834**65254***
	180	100		66261**43379**					
	240	50						63642**86611**	08834**65255***
	320	50						63642**86617***	08834**65257***
50	36	25	66254**70490**		63642**95452***				
	36	50		69957**90698**		63642**56399**	63642**49747**	63642**86651***	
	50	25			63642**95456***				
	50	50		69957**90699**		63642**87194**	69957**60306**	63642**86654***	
	60	25			63642**95458**				
	60	50		69957**90700**		63642**56403**	63642**49748**	63642**86656***	
	80	25			63642**95459**				
	80	50		69957**90701**		63642**87203**	63642**49749**	63642**86660***	
	120	25			66261**43420**				
	120	50		66261**43384**		63642**87204**	66261**15917**	63642**86671**	
	180	50						63642**86675**	08834**65269***
	240	50						63642**86680**	08834**65270***
	320	50						63642**86681**	08834**65272***

* Made-to-order

Dimensions Key: DIA = Diameter

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SPEEDLOK® DISCS TS ATTACHMENT (Type 2 – SL2)

DIA (mm)	GRIT	PK QTY	SG BLAZE			NORZON PLUS	NORZON	ALOX	SiC
			INNOVATION			BETTER		GOOD	
			BEST						
			F980	R980 Triple Ply	R980 Single Ply	PLUS	R822	RV71	R422
75	36	25			6364295460*				
	36	50	6626109356	6995739070		6364287209	6364249605	6364224390*	
	50	25			6364295462*				
	50	50		6995739070		6364287210	6995760307	6364286697*	
	60	25			6364295463				
	60	50		6995739070		6364256408*	6364239858	6364286699*	
	80	25			6364295464				
	80	50		6995739070		6364287214	6995760313	6364286705*	
	120	25			6626104342				
	120	50				6364287217		6364286708	
	180	50						6364286712*	
	240	50						6364286715	
	320	50						6364286718	

* Made-to-order

SPEEDLOK® SPECIALIST DISCS TS ATTACHMENT (Type 2 – SL2)

DIA (mm)	GRADE	PK QTY	BEST
			MINI FLEXI-FLAP DISCS
50	60	10	6364244254
	80	10	6364244255

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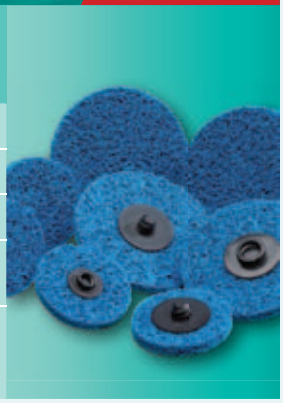
VORTEX RAPID BLEND

NEW!

This state-of-the-art product is made of a very open web structure of nylon fibers impregnated with patented grain technology and an advanced resin system. With amazing durability it can work on different deburring, blending and finishing applications.

FEATURES	BENEFITS
Advanced Grain technology	Controlled cut rate with consistent finish
Longer Life (5 to 8 times of competitors)	Less disc changes and downtime, improved costs
Blend in 3D	Face, Edge and Backside of the disc can be used, operator friendly and no smearing!
Open web structure	Avoid premature loading - especially good on soft metals e.g. Aluminium, Brass etc.



VORTEX RAPID BLEND

NEW!

DIA (mm)	CAP CODE	GRADE	PK QTY	TR	TS
25	U2311	Medium	100	662544**97806**	
38	U2311	Medium	80	662544**97807**	
50	U2311	Medium	25	662544**97067**	662544**97070***
75	U2311	Medium	25	662544**97068**	662544**97069***

* Made-to-order

Dimensions Key: DIA = Diameter

INNOVATION

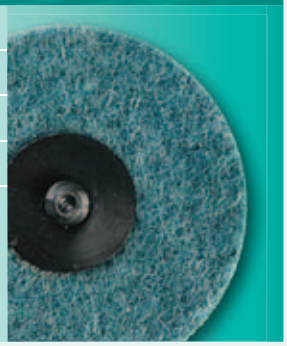
VORTEX UNITIZED

NEW!

Revolutionary Grain Technology: Taking Deburring to a Whole New Level
Patented grain, combined with a new manufacturing process, produces up to twice the stock removal rates of conventional unitised wheels. Aggressive cut and a new advanced resin bond system result in longest wheel life and up to two times the number of pieces finished per wheel.

FEATURES	BENEFITS
■ High-performance engineered grain and improved resin bond system	■ Aggressive, fast stock removal, reduced cycle times and increased part quality
■ Thick nylon web	■ 2x longer life and faster finishing – with minimal shedding
■ Porous	■ Cool cutting and improved cut rate
■ New curing process and bond technology	■ Consistent performance from first contact to stub size, improved part quality, with no chemical odour or smearing
■ Excellent form holding	■ Will not break down under heavy deburring conditions
■ Preformable	■ Can be used on a variety of shapes and contours
■ Up to 2x the number of pieces finished	■ Less downtime for changes; maximum productivity per wheel over other unitised wheels
	■ Unique blue colour for easy identification

SURFACE BLENDING DSJ / DSB



FEATURES	BENEFITS
■ Open structure	■ Resists loading on softer materials
■ High abrasive content	■ Fast initial cut rate
■ Flexible backing	■ Conforms to surface contours
■ General Purpose	■ Very versatile

UNITIZED

Unitized discs are used widely in the preparation of metal surfaces.
Excellent for light deburring of flashing & threads, blending alloys, polishing & finishing

FEATURES	BENEFITS
■ Easily preformed	■ Usable on a wide variety of shapes/contours
■ Hold shape well	■ No undercutting or gouging of the work peice
■ New light density formulation in 2SF and 3SF	■ Optimum combination of Cut, Life and Finish with smear resistant properties

Jimi VELKOOBCHOD BRUSIVA

SPEEDLOK® DISCS

HIGH STRENGTH

Provides an excellent finish and flexibility with greater tear resistance.

FEATURES	BENEFITS
■ Premium aluminium oxide grain	■ Clean cutting & long lasting
■ Firm, durable web	■ High resistance to tearing on burrs & sharp edges
■ Strong resin binders	■ Highly smear-resistant
■ Smear-proof	■ Produces light satin finishes

RAPID STRIP

First choice for rapid corrosion or paint removal.

FEATURES	BENEFITS
■ Open web construction	■ Fast cutting & long lasting
■ Conformable	■ Follow difficult part profiles ■ Easy cleaning of uneven surfaces
■ Thick, strong, synthetic fibres & extra coarse grit	■ Quick cleaning & conditioning of surfaces with aggressive corrosion removal
■ New 100mm TR+ discs available	■ Quick-change replacement; can be used on face & edge
■ Strippa version also available	■ Less dense & more flexible than rapid strip

BLAZE RAPID STRIP SPEEDLOK DISCS

NEW!

FEATURES	BENEFITS
■ Heavy coating of Norton SG Blaze ceramic alumina long-lasting grain and advanced resin bond	■ 2x as substantial as competitive discs so last 2x (plus) as long as competitive products ■ Will not shed on rust-encrusted pieces
■ Extremely versatile; use one disc for multiple operations	■ Lighter pressure will finish similar to a medium grit surface conditioning disc; additional pressure will remove material (strip and clean) ■ Stiff enough to stand abuse but soft enough to prevent gouging and rework ■ Fewer safety, ergonomic, and environmental issues due to fewer change-outs, less downtime, and less production waste/landfill scrap
■ Open structure	■ Will not load on sticky coatings, adhesives and soft metals (e.g. aluminum)

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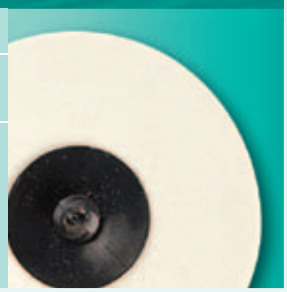
BUFFING

FEATURES	BENEFITS
■ Laminated to Lamtuck backing	■ Extra strength
■ Made from soft, flexible material	■ Conforms to shapes & contours, providing a uniform finish ■ Ideal for preparing awkward shaped parts for lacquer coating or polishing ■ Removes light oxidation

WHITE FELT

FEATURES	BENEFITS
■ Ideal for use with polishing compounds to give final finish	■ Achieves spectacular results on a variety of metals such as stainless steel & aluminium
■ 50mm & 75mm diameter size available	■ Excellent for polishing small areas achieving a good cosmetic finish



BEARTEX HIGH-STRENGTH CROSS BUFFS

FEATURES	BENEFITS
■ Unique design with a durable non-woven construction	■ Longer life and cool running
■ Removing oxidation and preparing surfaces prior to coating aircraft parts	■ ID grinding and finishing

APPLICATION GUIDE

INDUSTRY	APPLICATION	PRODUCTS
Aerospace maintenance	■ Removing coatings ■ Cleaning weld lines in awkward areas ■ Maintenance work on fuselage & wings	Surface blending discs
Marine	■ Cleaning hulls, finishing aluminium casings	Rapid Strip & coarse surface blending discs
Automotive	■ Accessing hard to reach areas such as under the bonnet & door frames ideal for removing stone chips	Rapid Strip & coarse surface blending discs
Composites	■ Removal of squeezed excessive glue	Unitized & surface blending discs
Wood	■ Removal of old paint & coatings	Rapid Strip & surface blending discs
Food processing	■ Surface finishing	Surface blending discs
Architectural steelwork	■ Cleaning & finishing weld joints ■ Achieving decorative finishes	Unitized & surface blending discs

VELKOOBCHOD BRUSIVA

SPEEDLOK® DISCS

VORTEX SPEEDLOK UNITIZED DISCS

NEW!

DIAxT (mm)	CAP CODE	GRADE	PK QTY	TR
50x6	U2305	3AM	60	66254428237
75x3	U2305	5AM	40	66261093556
	U2305	7AM	40	66261090909
75x6	U2305	3AM	40	66254428238
	U2305	5AM	40	66254413661
	U2305	7AM	40	66254406395

DSJ / DSB SURFACE BLENDING DISCS

DIA (mm)	CAP CODE	GRADE	PK QTY	TR	TS
50	S2112	Extra Coarse	25	63642586817	
	S2211	Coarse	25	63642556609	63642556608
	S2313	Medium	25	63642556580	63642556559
	S2513	Very Fine	25	63642556575	69957360378
	S4713	Super Fine	25	63642585626*	63642585670*
75	S2112	Extra Coarse	25	63642586830	63642586820
	S2211	Coarse	25	66261009194	63642519572
	S2313	Medium	25	63642556601	
	S2513	Very Fine	25	63642556599	
	S4713	Super Fine	25	63642585649*	

* Made-to-order

UNITIZED WHEELS

DIA (mm)	CAP CODE	GRADE	PK QTY	TR
50	U2301	2 A Medium	10	63642585684
	U2301	6 A Medium	10	63642585725
	U4401	2 S Fine	10	63642585677
	U4401	3 S Fine	10	66254473613
	U2401	4 A Fine	10	63642585679
75	U2301	2 A Medium	10	63642585697
	U2301	6 A Medium	10	63642585726
	U4401	3 S Fine	10	66254473614
	U4401	2 S Fine	10	63642585691
	U2401	4 A Fine	10	63642585695

Dimensions Key: DIA = Diameter, T = Thickness

HIGH STRENGTH DISC

DIA (mm)	CAP CODE	GRADE	PK QTY	TR
50	F2303	Medium A	50	63642**85924**
	F2506	Very Fine A	50	08834**163987**
75	F2303	Medium A	50	08834**164065**
	F2304	Very Fine A	50	63642**85932**

RAPID STRIP

DIA (mm)	CAP CODE	GRADE	PK QTY	TR RAPID STRIP	TR STRIPPA	TR+ RAPID STRIP
50	R4101	X Coarse S	10	63642**88173**	63642**56605**	
75	R4101	X Coarse S	10	63642**88175**	63642**56624**	
100	R4101	X Coarse S	5			63642**85751**

BLAZE RAPID STRIP SPEEDLOK DISCS NEW!

DIA (mm)	CAP CODE	GRADE	PK QTY	TR
75	R9101	X Coarse SG	10	662610**96557**

BUFFING DISCS

DIA (mm)	GRADE	PK QTY	TR	TS
50	Coarse A	25		63642**87177**
	Medium A	25		63642**87176**
	Fine A	25		63642**87175**
	Very Fine A	25	08834**163987**	63642**87171**

WHITE FELT DISCS

DIA (mm)	GRADE	PK QTY	TR
50	Felt	25	63642**87165**
75	Felt	25	63642**87167**

Jimi VELKOOBCHOD BRUSIVA

SPEEDLOK® KIT TR ATTACHMENT (Type 3 – SL3)

TYPE	DIA (mm)	GRIT/GRADE DENSITY	PK QTY
GREENLYTE PLUS F986	50	36	2
	50	60	2
SG® CERAMIC R981	50	36	2
	50	60	2
NORZON® PLUS	50	36	2
	50	60	2
NORZON® R822	50	36	2
	50	60	2
	50	80	2
R230	50	36	2
	50	60	2
	50	80	2
	50	120	2
ALOX RV81	50	36	2
	50	60	2
SURFACE BLENDING BEARTEX®	50	Coarse	2
	50	Fine	2
	50	Very Fine	2
UNITIZED	50	Fine	1
STRIPPA	50	Coarse	1
RUBBER BACK-UP PAD	50	Medium	1

SPEEDLOK® KIT TS ATTACHMENT (Type 2 – SL2)

TYPE	DIA (mm)	GRIT/GRADE DENSITY	PK QTY
GREENLYTE PLUS F986	50	36	2
	50	50	2
SG® CERAMIC R981	50	36	2
	50	50	2
NORZON® PLUS	50	36	2
	50	50	2
	50	80	2
	50	120	2
ALOX PLUS RV81	50	36	2
	50	60	2
ALOX RV71	50	36	2
	50	60	2
	50	80	2
	50	120	2
SURFACE BLENDING BEARTEX®	50	Coarse	2
	50	Medium	2
	50	Very Fine	2
RUBBER BACK-UP PAD	50	Medium	1

Dimensions Key: DIA = Diameter

BACK-UP PADS TR ATTACHMENT (Type 3 – SL3)

DIA (mm)	DENSITY	PK QTY	RUBBER WITH SPINDLE	PLASTIC HOLDER M14	RUBBER HOLDER M14	ADAPTOR
25	Medium	1	63642**56628**			
38	Medium	1	63642**56629**			
50	Medium	1	07660**17817**			
	Hard	1	63642**86931**			
75	Medium	1	63642**56631**		63642**87305**	
	Hard	1	66254**01460**			
	Blue	1		63642**57133**		
1/4-M14		1				63642**87997**

BACK-UP PADS TS ATTACHMENT (Type 2 – SL2)

DIA (mm)	DENSITY	PK QTY	RUBBER WITH SPINDLE
15	Medium	1	66254**01994**
25	Medium	1	07660**18963**
38	Medium	1	07660**07032**
50	Medium	1	63642**01157**
	Hard	1	63642**86926**
75	Medium	1	07660**07384**
	Hard	1	63642**86932**

HOLDERS ATTACHMENT (TR+ – SL4)

TR+

S (mm)	DENSITY	PK QTY	ART. NO.
6	Medium	1	63642**86196**

CROSS BUFFS

DIAxW (mm)	GRADE	PK QTY	ART. NO.
38x13	Medium	100	08834**89308***
38x13	Very fine	100	08834**89307***
Mandrel MM32-4**		1	63642**87136***

** Use Mandrel MM32-4 to mount 38mm Cross Buffs

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

134 SPINDLE MOUNTED FLAP WHEELS
140 SPECIALTIES
148 UNITISED WHEELS
152 ACCESSORIES FOR DIE GRINDER

Die

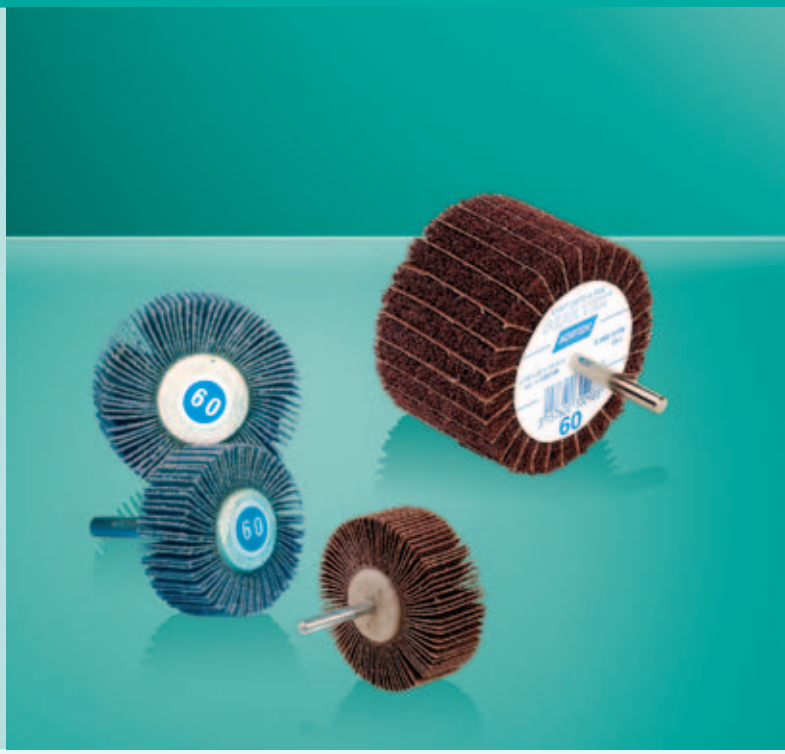
JMI VELKOOBCHOD BRUSIVA

SPINDLE MOUNTED FLAP WHEELS

Designed to deliver a consistent finish with a uniform rate of cut, flap wheels have a continual rate of wear which exposes new abrasive. Their construction also makes them ideal for sanding contours and uneven surfaces.

APPLICATIONS & MARKETS

- Metal fabrication
- Blending welds
- Deburring
- Cleaning & finishing



PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	R822	R207	
Carbon Steel/Weld/Ferrous metal	R207	R265	

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
Metal	F2302	F2401	F4300/F2501
Wood	F2300	F2401	F2501

BETTER

R822 NORZON®

NORZON

FERR. & NON FERR.

FEATURES	BENEFITS
NorZon® abrasive	Long lasting cutting edges of NorZon®
Heavy cotton cloth	

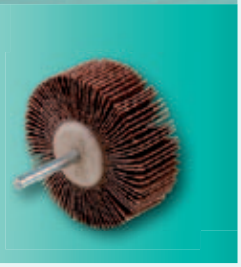
Jimi VELKOOBCHOD BRUSIVA

GOOD

R207

FERR. & NON FERR.

FEATURES	BENEFITS
■ Aluminium oxide abrasive	■ Unique manufacture technique provides low dust generation
■ Highly resistant backing	■ Consistent cut rate with ability to leave a very good finish ■ Good life & cut rate in comparison to competition



BEARTEX FLAP WHEELS

FEATURES	BENEFITS
■ Cushioning action	■ The most conformable of all BearTex® wheel products. Ideal for use on contoured surfaces & parts with awkward geometry
■ Constructed using layers of BearTex® with a smear resistant formula	■ Achieves a consistent & uniform finish with no risk of gouging
■ Available in a wide range of sizes & grades ■ Ventilated flap arrangement	■ Suitable for a wide range of applications including corrosion removal, cleaning & surface finishing ■ Smooth running vibration free product that gives a constant finish without smearing or component discolouration

SPINDLE MOUNTED RECOMMENDED OPERATING SPEED

DIM DIAxWxS(mm)	RECOMMENDED MINIMUM RPM	RECOMMENDED OPTIMUM RPM	RECOMMENDED MAXIMUM RPM
30x15x6	12000	16500	25500
30x20x6	12000	16500	25500
40x20x6	9600	12500	19100
50x20x6	7000	10000	15300
50x30x6	7000	10000	15300
60x15x6	6300	8300	12700
60x30x6	6300	8300	12700
60x40x6	6300	8300	12700
80x50x6	4800	6200	9600

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, B = Bore, S = Spindle

Jimi VELKOOBCHOD BRUSIVA

BEARTEX SPINDLE MOUNTED FLAP WHEELS

FLAP WHEEL TYPES

Beartex Non Woven Flap wheels

Mounted on a 6mm diameter spindle, designed to be used on straight line die grinders for removal of oxidation, paint, corrosion and generating grain finishes.

Ideal for finishing large and awkward components.

Can be used for metals, wood, composite and plastics.

Less aggressive than conventional coated abrasive flapwheels.

Beartex Interleaved Flap Wheels

Interleaved version gives the benefits of aggressiveness by alternatively arranging coated abrasive cloth with the finishing qualities of Non wovens.

They are soft and aggressive, creating a “firmer” wheel that provides a higher rate of cut.

The ratio of Cloth flaps to non woven flaps can be altered to suit particular applications

Ideal for deburring and grain finishing on stainless steel

VELKOOBCHOD BRUSIVA

SPINDLE MOUNTED

DIM DIAxWxS (mm)	GRIT	PK QTY	NORZON BETTER R822	GOOD R207
22x10x3	80	10		63642539934
	120	10		63642539935
	150	10		63642533081
30x10x6	60	10		63642545207
	80	10		63642537371
	100	10		63642513147
	120	10		63642552728
	150	10		63642512892
	240	10		63642545208
30x15x6	60	10	63642578174	63642513148
	80	10		63642561466
	100	10		63642547339
	120	10		63642551593
	150	10		63642547340
	240	10		63642547341
	320	10		63642513149
40x15x6	40	10		63642539937
	60	10		63642533099
	80	10		63642533098
	100	10		63642533095
	120	10		63642533094
	150	10		63642533092
	240	10		69957360895
40x20x6	40	10	63642578194	63642539938
	60	10	63642578195	63642546771
	80	10	63642578196	63642546768
	120	10		63642546760
	150	10		63642533091
	240	10		63642539939
	320	10		63642539940
50x20x6	40	10		63642546774
	60	10		63642531870
	80	10		63642533097
	120	10		63642546759

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, B = Bore, S = Spindle

JIMI VELKOOBCHOD BRUSIVA

SPINDLE MOUNTED (CONTINUED)

DIM DIAxWxS (mm)	GRIT	PK QTY	BETTER R822	GOOD R207
50x30x6	40	10		63642539943
	60	10		63642534251
	80	10		63642561879
	100	10		63642546765
	120	10		63642531863
	150	10		63642531860
	320	10		63642546725
60x15x6	40	10		63642546773
	60	10		69957360901
	80	10		63642546767
	100	10		63642546764
	120	10		63642546758
	150	10		69957360902
	240	10		69957360903
	320	10		63642539945
60x20x6	40	10		63642536738
	60	10		63642531869
	80	10		63642531866
	100	10		63642546763
	120	10		63642531862
	150	10		63642559975
	240	10		63642539770
60x30x6	40	10	63642539952	63642536737
	60	10	63642536547	63642531868
	80	10	63642539953	63642531865
	100	10		63642546762
	120	10		63642531861
	150	10		63642560343
	240	10		63642546694
	320	10		63642546727
80x30x6	40	10	63642539954	69957360911
	60	10	63642539955	63642531867
	80	10	63642536548	63642533096
	100	10		69957364103
	120	10		63642534250
	150	10		63642562580
80x50x6	40	10	63642578252	69957360914
	60	10	63642578253	63642559718
	80	10	63642578254	69957360916
	120	10		69957360917
	150	10		63642539947
	240	10		63642539948

Other sizes and grits available upon request

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, S = Spindle, D = Diameter

BEARTEX SPINDLE MOUNTED FLAP WHEELS

DIM DxWxS(mm)	GRADE	INTERLEAVED CLOTH GRIT	CAP CODE	PK QTY	ART. NO.
30x20x6	Medium A		F2300	10	66261032155
	Fine A		F2401	10	66261032160
40x20x6	Medium A		F2300	10	66261032156
	Fine A		F2401	10	66261032161
	Very Fine A		F2501	10	66261032165
60x30x6	Fine A Interleaved	60	F2401	10	63642549639
	Fine A Interleaved	100	F2401	10	63642549640
	Fine A Interleaved	150	F2401	10	63642549641
	Coarse/Extra Cut		F2302	10	66261032167
	Medium A		F2300	10	66261032157
	Medium S		F4300	10	66261053048
	Fine A		F2401	10	63642549650
	Fine S		F4401	10	63642515902
	Very Fine A		F2501	10	63642515905
80x50x6	Fine A Interleaved	60	F2401	10	07660705179
	Fine A Interleaved	100	F2401	10	63642515544
	Fine A Interleaved	150	F2401	10	63642515545
	Coarse/Extra Cut		F2302	10	63642586113
	Medium S		F4300	10	66261053053
	Fine A		F2401	10	63642515583
	Fine S		F4401	10	63642515614
	Very Fine A		F2501	10	63642515628
100x50x6	Fine A Interleaved	60	F2401	10	63642515907
	Fine A Interleaved	100	F2401	10	63642515908
	Fine A Interleaved	150	F2401	10	63642515909
	Fine A		F2401	10	63642515903
	Fine S		F4401	10	63642515904
	Very Fine A		F2501	10	63642515906

The catalogue includes details of all stock products but other options are available using Norton's made to order facility.
Please contact your local sales or customer service representative for more information.

jimi VELKOOBCHOD BRUSIVA

SPECIALTIES

Boasting an outstanding selection of shapes, sizes and grains, the new coated 'Specialties' range can be used in general purpose applications as well as more specific problematic applications. They are ideal for grinding and blending intricately shaped and contoured components, or for high speed, accurate grinding.

APPLICATIONS & MARKETS

- Metal
- Wood
- Recesses
- Contours
- Corners
- Angles

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	R980	R822	R230
Carbon Steel/Weld/Ferrous metal	R822	R230	
Non-Ferrous Metal/Brass/Aluminium	R422		
Wood	VK53		
Paint/Varnish	VK53		
Leather / Shoe	K229		

GOOD

CARTRIDGE ROLLS

FERR. & NON FERR.

FEATURES

- Available in straight or tapered shapes

BENEFITS

- Straight rolls wear to the shape required
- Tapered shape is especially suited for use on contoured parts
- For sanding & polishing channels, fillets, recesses, radii, small contours & the bottom of dead-end holes

Dimensions Key: DIM = Dimensions, BS = Base, L = Length, B = Bore

NORTON SPECIALTIES KIT

To help introduce you to the correct product, this kit contains a small range of our SpeedLok and Specialties ranges

INNOVATION
BEST
66254476957*

* Made-to-order

KITS

To help you select the correct product, the cartridge roll kit contains 122 pieces of the most popular shapes, sizes & grits

SG BLAZE	ALOX
INNOVATION	GOOD
BEST	
R980	R230
66261071558	63642557136

CARTRIDGE ROLLS STRAIGHT ZPE

				SG BLAZE	ALOX	SiC
DIM BSxLxB(mm)	GRIT	MANDREL CODE	PK QTY	INNOVATION BEST	GOOD	
				R980	R230	R422
6x38x3,2	60	CRM5	100	66261194384		08834183274*
	80	CRM5	100	66261194394		08834182359*
	120	CRM5	100	66261194397		08834189131*
10x25x3,2	80	CRM4	100		63642556812	
10x38x3,2	60	CRM5	100		63642556687	
	120	CRM5	100		63642556691*	
13x38x3,2	60	CRM5	100	66261194393	66261181251	08834189233*
	80	CRM5	100	66261194396	63642556694	08834180712*
	120	CRM5	100	66261194399	63642556696*	66261086969*
19x50x4,8	60	CRM8	100		69957386966	

* Made-to-order

See other complementary products: page 342 - Bonded Mounted Points page 474 - Carbide Burrs

JIMO VELKOOBCHOD BRUSIVA

CARTRIDGE ROLLS TAPERED - ZSPI

DIM BSxLxB(mm)	GRIT	MANDREL CODE	PK QTY	SG BLAZE	ALOX	SiC
				INNOVATION BEST	GOOD	
				R980	R230	R422
10x25x3,2	60	CRM4	100		63642556703	
10x38x3,2	60	CRM5	100	66261194481		08834189901*
	80	CRM5	100	66261194490		08834189904*
	120	CRM5	100	66261194491		66261046936*
13x38x3,2	80	CRM5	100		63642556733	
	120	CRM5	100		63642556734	

* Made-to-order

CARTRIDGE ROLLS MANDRELS - ML

DIM BSxL(mm)	MANDREL CODE	PK QTY	ART. NO.
2,4x25	CRM2	1	63642587107*
3,2x13	CRM3	1	63642587120*
3,2x19	CRM4	1	63642556790
3,2x25	CRM5	1	63642556791
4,8x19	CRM6	1	63642556789
4,8x25	CRM7	1	63642556793
4,8x38	CRM8	1	63642556794

* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width

BETTER

SPIRABANDS

FERR. & NON FERR. | PAINT/ VARN. HARD WOOD &SOFT WOOD | GLASS

FEATURES	BENEFITS
Selection of sizes & grades	An excellent blending & deburring tool
Strong construction	Aggressive cut
Use with a rubber holder	Forgiving finish
Easy to fit	Can reduce downtime

SPIRABANDS ZSB

DIM DIAxW(mm)	GRIT	PK QTY	SG BLAZE INNOVATION BEST R980	NORZON BETTER R822	ALOX GOOD R265
10x20	80	100		63642539862	
13x25	50	100		63642528507	
	80	100		63642528508	
15x30	50	100		63642528509	
	80	100		63642528496	
22x20	36	100	66254402665	63642539865	
	50	100		63642528497	
	60	100	66261192992	63642539866	
	80	100		63642539867	
	150	100			63642539868
25x25	36	100		63642528510	
	50	100		63642528511	
	80	100		63642528512	
30x30	36	100		63642566870	
	50	100		63642535053	
	60	100		63642545925	
	80	100		63642545926	
	150	100			63642536540
45x30	36	100	66254402667	63642528498	
	50	100		63642528514	
	60	100	66261031600	63642545928	
	80	100		63642528515	
51x25	80	100		63642528518	
60x30	36	100		63642536541	
	50	100		63642539765	
	80	100		63642539766	

VELKOOBCHOD BRUSIVA

SPIRABAND MANDRELS

DIM DIAxW(mm)	PK QTY	ART. NO.
10x10x6	1	07660**07917**
10x20x6	1	07660**17573**
13x25x6	1	07660**05185**
15x10x6	1	07660**17629**
15x30x6	1	07660**05182**
19x25x6	1	07660**17567**
22x20x6	1	63642**562578**
25x25x6	1	07660**05183**
30x20x6	1	07660**17630**
30x30x6	1	07660**07918**
38x25x6	1	07660**17568**
45x30x6	1	07660**05196**
51x25x6	1	07660**05184**
60x30x6	1	07660**17631**

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, B = Bore, L = Length, DG = Degree

BETTER

CONES

FERR. & NON FERR. SHOE

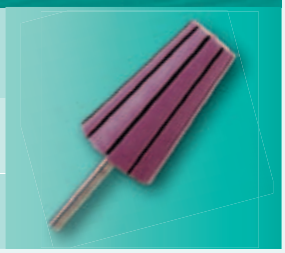
FEATURES	BENEFITS
■ Available in varying heights & diameters	■ Ideal for use on irregular shaped components such as curves, or recesses
■ Mounted on expanded rubber drums	■ Easy fitting
■ Used for grinding, deburring & polishing	■ Useful for repair work in the shoe industry

CONES ZCO

DIM BxLxDG(mm)	GRIT	PK QTY	BETTER R822
20x14x63	36	100	66261176761
	50	100	66261176657
	80	100	66261176656
	120	100	66261176540
29x22x30	50	100	63642513692
36x22x60	36	100	63642520987
	50	100	63642536572
	80	100	63642545922
	120	100	66261176703
50x20x40	40	100	63642536708
64x16x31	40	100	63642547686
82x38x40	40	100	63642546300
85x34x45	40	100	63642546211

CONE HOLDERS ML(ZCO)

DIM BxLxDG(mm)	ART. NO.
20x14x63	07660740439
36x22x63	07660740441



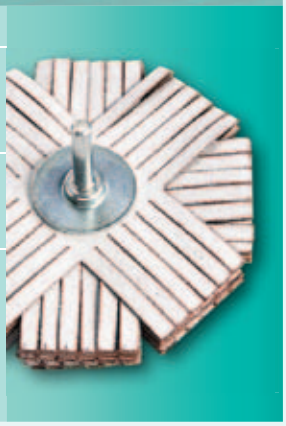
Jimi VELKOOBCHOD BRUSIVA

BEST

SANDING STARS WITH SPINDLE

FERR. & NON FERR.

FEATURES	BENEFITS
■ Flexible	■ Ideal for deburring & polishing difficult to access metal applications
■ Wide selection of aluminium oxide abrasive grits	■ Achieves the desired finish
■ Range of sizes	■ Can be used on small scale as well as large applications



SANDING STARS WITH SPINDLE

DIA (mm)	GRIT	PK QTY	BEST
			VK53
40	80	10	636425**87026**
	120	10	636425**87034***
	240	10	636425**87036***
	320	10	636425**87037***
60	80	10	636425**87038**
	120	10	636425**87040**
	240	10	636425**87042***
	320	10	636425**87046**
80	80	10	636425**87050**
	120	10	636425**87064**
	240	10	636425**87068**
	320	10	636425**87070***
100	80	10	636425**87074**
	120	10	636425**87076**
	240	10	636425**87077**
	320	10	636425**87093***

* Made-to-order

Dimensions Key: DIM = Dimensions, D = Diameter, T = Thickness, W = Width, B = Bore

RAPID STRIP DISCS

FEATURES	BENEFITS
Open web construction	Fast cutting action with very little loading
Conformable	Easy cleaning of uneven surfaces
Thick, strong, synthetic fibres & extra coarse grit	Quick cleaning & conditioning of surfaces
Used with portable tools	Easy & safe to use especially in difficult to reach areas

RAPID STRIP WHEELS STANDARD

DIAxWxB (mm)	CAP CODE	PK QTY	RPM	ART. NO.
100x13x12	R4101	25	8000	636425**85700**
150x13x12	R4101	15	5500	636425**85703**
200x13x12	R4101	5	4500	636425**85704**

MANDRELS

DISCS DIAxWxB(mm)	SPINDLE DIA(mm)	PK QTY	ART. NO.
<150x13x12	6	1	07660**07022**
<200x13x12	8	1	07660**07023**

RAPID STRIP WHEELS SPINDLE MOUNTED

DIM DIAxTxS(mm)	CAP CODE	PK QTY	MAX RPM	STANDARD (1 WHEEL)	LARGE AREA (2 WHEELS GANGED)
75x13x6	R4101	10	10000	636425**57741**	
75x25x6	R4101	5	10000		636425**57744**
100x13x6	R4101	10	8000	636425**57742**	
100x25x6	R4101	5	8000		636425**57745**
150x13x8	R4101	10	6000	636425**57743**	
150x25x8	R4101	5	6000		636425**57746**

SPEC CHECK

Perfect for Rust, corrosion and Paint removal

Jimi VELKOOBCHOD BRUSIVA

BEARTEX UNITIZED WHEELS

BearTex® unitized wheels are made from compressed and bonded layers of non-woven abrasive. Applications include deburring, cleaning composites, and sharp edge removal.

Unitized wheels produce excellent finishes on nearly all surfaces, although are ideally suited for use on harder materials such as titanium or stainless steel.

APPLICATIONS & MARKETS

- Surface preparation, cleaning & finishing
- Turbine blades & aerospace maintenance
- Medical instruments
- Cleaning weld lines & moulds
- Tooling industry

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal	Vortex U2305	U4401	U4401

INNOVATION BEST

VORTEX UNITIZED

NEW!

Revolutionary Grain Technology: Taking Deburring to a Whole New Level
Patented grain, combined with a new manufacturing process, produces up to twice the stock removal rates of conventional unitised wheels. Aggressive cut and a new advanced resin bond system result in longest wheel life and up to two times the number of pieces finished per wheel.

FEATURES

- High-performance engineered grain and improved resin bond system
- Thick nylon web
- Porous
- New curing process and bond technology
- Excellent form holding
- Preformable
- Up to 2x the number of pieces finished

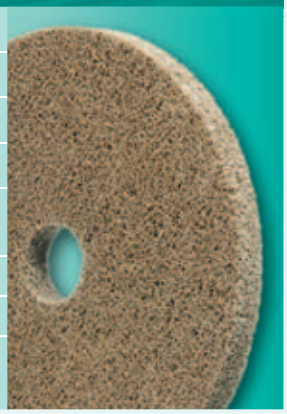
BENEFITS

- 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
- Consistent performance from first contact to stub size, improved part quality, with no chemical odour or smearing
- Will not break down under heavy deburring conditions
- Can be used on a variety of shapes and contours
- Less downtime for changes; maximum productivity per wheel over other unitised wheels
- Unique blue colour for easy identification

VELKOOBCHOD BRUSIVA

NEX UNITISED WHEELS

FEATURES	BENEFITS
Easily preformed	Usable on a wide variety of shapes/contours
Holds shape well	Less wheel dressing, more snag resistant
Non-metallic	No contamination of workpiece
Uniform construction	Extra long life. Maintains part tolerance, prevents cutting or gouging
Smear resistant formula	Excellent smear free finish
Small wheel/disc sizes available	Ideal for reaching awkward corners
New light density formulation in 2SF and 3SF	Optimum combination of Cut, Life and Finish with smear resistant properties



UNITIZED WHEEL NAMING SCHEME

NEX - 8AC

Name of product line: NEX

Naming scheme: similar to convolute wheels

Product Line
NEX

Density
2 3 4 5 6 7 8 9
Soft ↕ Hard

Abrasive Type
A = Aluminium Oxide
S = Silicon Carbide

Grit Size
F = Fine
M = Medium
C = Coarse
XC = Extra Coarse

SPEC CHECK

- For Increased performance see Vortex Unitised

UNITIZED SMALL WHEELS / BOBS

DIM DxTxB(mm)	CAP CODE	GRADE	PK QTY	ART. NO.
25x25x5	U4401	NEX 2SF	50	66261014883
25x25x5	U2301	NEX 6AM	50	66261014908
Use with Threaded Mandrel			1	66261077832

Dimensions Key: DIM = Dimensions, D = Diameter, T = Thickness, W = Width, B = Bore

UNITIZED WHEELS

DIM DxTxB(mm)	CAP CODE	GRADE	PK QTY	MAX RPM	ART. NO.
50x3x6	U2301	NEX-8AM	20	22100	63642**85828***
50x6x6	U2305	VOR-7AM	60	22100	66261**80270***
	U2301	NEX-2AM	20	18000	63642**85754**
	U4401	NEX-2SF	20	18000	63642**85756**
	U2401	NEX-4AF	20	22100	63642**85755**
	U2401	NEX-6AF	20	22100	63642**85757**
	U2201	NEX-8AC	20	22100	63642**85761**
	U2301	NEX-8AM	20	22100	63642**85758**
75x3x6	U2305	VOR-5AM	40	18000	66261**93448**
	U2305	VOR-7AM	40	18000	66261**91445**
	U2301	NEX-8AM	20	18100	63642**85831**
75x6x6	U2305	VOR-3AM	40	18000	66254**28454**
	U2305	VOR-5AM	40	18000	66254**14832**
	U2305	VOR-7AM	40	18000	66261**99696**
	U2301	NEX-2AM	10	12100	63642**85763**
	U4401	NEX-2SF	10	12100	63642**85768**
	U4401	NEX-3SF	10	12100	63642**71113**
	U2401	NEX-4AF	10	18100	63642**85766**
	U2401	NEX-6AF	10	18100	63642**85771**
	U2301	NEX-6AM	10	18100	66261**81929***
	U2201	NEX-8AC	10	18100	63642**85776**
	U2301	NEX-8AM	10	18100	63642**85774**
75x13x6	U2305	VOR-7AM	20	18000	66261**80267**
125x6x22	U2305	VOR-5AM	20	9000	66254**88602**
	U4401	NEX-2SF	20	6000	66254**88603**
	U4401	NEX-3SF	20	6000	66254**89419**
150x6x13	U2301	NEX-2AM	10	4500	66261**19412**
	U4401	NEX-2SF	10	5000	66261**19416**
	U4401	NEX-3SF	8	5000	66261**16691**
	U2301	NEX-6AM	10	7500	66261**19414**
150x6x25	U2305	VOR-5AM	8	7500	66254**14167**
	U2305	VOR-7AM	8	7500	66254**07225**
	U2301	NEX-6AM	8	7500	66261**89390**
	U4401	NEX-2SF	8	7500	66261**17050**
	U4401	NEX-3SF	8	7500	66254**89421**
150x13x13	U2301	NEX-2AM	5	4500	63642**85818**
	U4401	NEX-2SF	5	5000	63642**85812**
	U4401	NEX-3SF	4	5000	66261**15826**
	U2401	NEX-4AF	5	7500	63642**85815**
	U2301	NEX-8AM	5	7500	63642**85824**
150x25x13	U2301	NEX-2AM	5	4500	69957**50267***
	U4401	NEX-2SF	5	5000	69957**50272**
	U2401	NEX-4AF	5	7500	69957**50269**
150x25x25	U2301	NEX-2AM	5	4500	63642**85789***
	U4401	NEX-2SF	5	5000	63642**85795**
	U2401	NEX-4AF	5	7500	63642**85792**
	U2301	NEX-6AM	8	7500	66261**15989**
200x25x25	U2301	NEX-2AM	5	3500	63642**85796**
	U4401	NEX-2SF	5	4000	63642**85797**

Other sizes, grades & densities available upon request. Metal bushings are also available to reduce the bore size, please refer to the accessories section at the back of this catalogue for more information.

* Made-to-order

Dimensions Key: DIM = Dimensions, D = Diameter, T = Thickness, W = Width, B = Bore

APPLICATIONS

- For all heavy deburring and finishing applications
- Remove grind lines, punched hole burrs and pits or scratches
- Deburring Stainless Steel sinks, tanks and other food equipment
- Thread deburring operations
- Good alternative to spindle-mounted flap wheels and cotton-laminated wheels, which often generate unpleasant odours when grinding

PRODUCT SELECTION

APPLICATION AREA	SPECIFIC APPLICATION	SPECIFICATION
UNITIZED WHEELS		
Cleaning: oxidation removal, coatings, contaminations	■ Welding preparation ■ removal of weld blueing, scale ■ removal, gasket removal ■ removing excessive bonding agents after curing, cleaning steel castings	■ NEX 4AFINE ■ NEX 6AFINE
Deburring: surface, edge, ID_OD & thread deburring	■ Deburring flashings ■ threaded parts ■ stamped parts, turbine blades, machined out parts ■ deburr aluminium extrusions, ■ deburring of pipes in the oil & gas industry	■ NEX 2SFINE ■ NEX 4AFINE ■ Vortex 7AM
Deburring: OD & thread deburring	■ Deburring of pipe threads in oil & gas industry	■ Vortex 7AM
Blending: removal of parting lines, grindline conditioning	■ Parting line removal, blending surface defects & forge marks	■ NEX 8MED ■ NEX 8ACOARSE
Finishing: final finishing, satin finishing	■ Turbine blade edge radius, medical implants (stainless steel & alloys ■ figurines, jewellery, finishing saw blades	■ NEX 6A FINE ■ NEX 8AMED
Polishing: polishing surface defects, preparation before buffing	■ Polishing precision metal pieces, welds etc.	■ NEX 2SFINE ■ NEX 8AFINE

SPEC CHECK

- Unitized wheels can be run in either direction

VELKOOBCHOD BRUSIVA

ACCESSORIES FOR DIE GRINDER

MANDRELS

Accessory	For BearTex® Product type	DIM LxSxW (mm)	For Wheel/ disc dia (mm)	Max usable wheel/disc width (mm)	For wheels/ discs bore hole dia (mm)	ART. NO.
Extra Long Mandrel with dishtooth washer	Plain Discs & Lap Mops	75x6x40	up to 200	38	8 to 10	66261**077806**
Mandrels with Washers	RapidStrip/ Plain Discs	55x6 x40	up to 150	13	10 to 12	07660**07022**
Mandrels with Washers	RapidStrip/ Plain Discs/ Unitised Wheels	55x8x38	up to 200	13	10 to 13	07660**07023**
Mandrels	Unitised Wheels	60x6	up to 75	6	6 & 10	63642**586234**
Mandrels	Unitised Wheels	75x6	up to 75	6 to 12	6 & 10	63642**586236**
Mandrels	Unitised Wheels	85x6	up to 150	12 to 25	6	63642**586239**
Threaded Mandrel	Unitised Wheels/Bobs	25x6	25	25	5	66261**077832**

PORTABLE TOOL ADAPTOR KIT

CONVERTS FLANGE MOUNTED FLAP WHEELS OR CONVOLUTE WHEELS INTO SMALLER DIAMETERS OR TRANSFORMS THEM INTO SPINDLE MOUNTED WHEELS FOR MOUNTING ON PORTABLE MACHINES

Wheel Centre hole (mm)	Size of reduced bore with bushing (mm)	For Wheel Diameter (mm)	For Wheel Width (mm)	Spindle Diameter (mm)	PK QTY	ART. NO.
25 or 50	12,7 (13)	150 to 200	20 to 50	6 or 8	1 Kit	66261**082440**

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NORTON
SAINT-GOBAIN

Coated & BearTex

154 INTRODUCTION
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178 SELF-ADHESIVE DISCS

Disc

JMI VELKOOBCHOD BRUSIVA

PRODUCT SELECTION GUIDE FOR NORTON DISCS

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Metal		Multi-Air Norzon	Multi-Air Plus	
Wood	Coarse Sanding	Multi-Air Norzon	Multi-Air Plus	A275
	Finishing	A975	A275	Gold Reserve A296
Filler	Aluminium/Metal	Multi-Air Norzon/ H835	Multi-Air Plus/ A975	Multi-Air/ A275
	Polyester	Multi-Air Plus/ A975	Multi-Air Norzon/ H835	Multi-Air/ A275
Primer/Paint/Varnish	Coarse Sanding	Multi-Air/A275	Multi-Air/A275	Gold Reserve A296
	Finishing	ICE	Q260	Multi-Air/A275
	Finishing/Spot Repair	ICE	T401	
Composites/Coatings	Epoxy	H835	H231	
	Acrylic	A975	A275	Gold Reserve A296
	Fibre Glass	H835	H231	
	Finishing	A975/ICE	A275 / Q260	
Stone			H425/G422	
Accessories - replacement velcro			Q007	

jimi VELKOOBCHOD BRUSIVA

Norton Multi-Air Process® combines the excellence of a premium Norton Multi-Air® abrasive disc with an innovative dust-extraction Multi-Air® back-up pad.

This revolutionary Multi-Air Process® gives operators the optimal sanding solution to optimise performance, increase productivity and eliminate dust.

APPLICATIONS & MARKETS

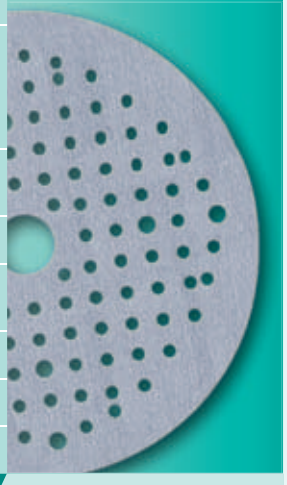
- Automotive
- Furniture
- Paint
- Composites
- Primer
- Marine gel coat
- Non-ferrous metals
- Aerospace

BEST

MULTI-AIR® PLUS SOFT-TOUCH®

NON FERR. | PAINT/ VARN. &SOFT WOOD

FEATURES	BENEFITS
Norton SG® Ceramic abrasive blended with premium heat treated aluminium oxide abrasive	Higher & faster cut rate Consistent & uniform scratch pattern
Unique – blue fibre-reinforced latex paper	Combines flexibility with tear resistance
Water based No-Fil®	Resists clogging during use
No pigment in No-Fil® or bond	No risk of colour transfer
Improved performance	Extended life
Ideal for large surface areas	Less downtime
Available in grits P80-800	



MULTI-AIR® NORZON®

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Latest Norzon® grain design	Self-sharpening grain Improved cut rate for higher productivity Extended product life
High strength paper backing (E-weight)	Reduces curling & edge chipping Tear resistant
Open grain distribution	Prevents premature clogging
Full resin bond system	Strong & improved grain adhesion

VELKOOBCHOD BRUSIVA

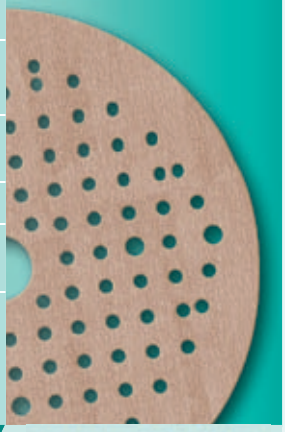
MULTI-AIR® DISCS

BETTER

MULTI-AIR®

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Premium, heat-treated aluminium oxide abrasive	Faster cut rate
Unique fibre-reinforced latex paper	Flexible & tear resistant
Water based No-Fil®	Improved load resistance
No pigment in No-Fil® or bond	No risk of colour transfer
Available in grits P80-800	

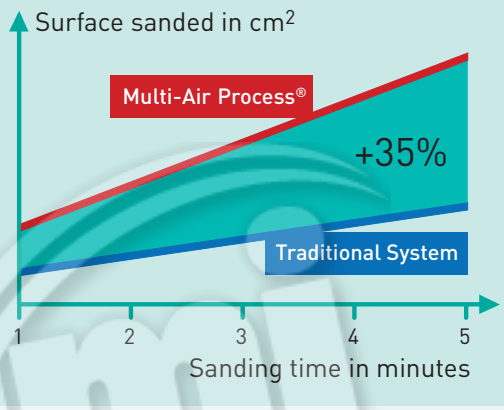


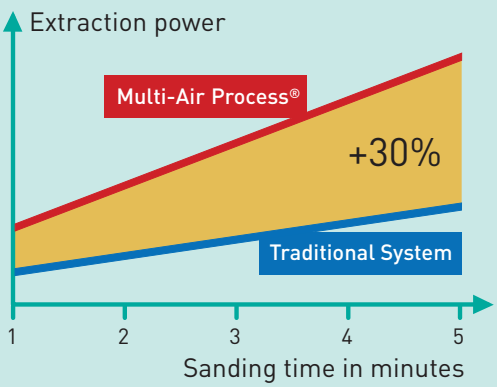
MULTI-AIR® SOFT-TOUCH®

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Premium, heat treated aluminium oxide abrasive	Faster cut rate Improved performance
Unique fibre-reinforced latex paper	Flexible & tear resistant
Water based No-Fil®	Improved load resistance
No pigment in No-Fil® or bond system	No risk of colour transfer
Flexible foam backing with coloured Norgrip®	Allows contour sanding without cutting through coating layer
Multi-Air® hole configuration	Maximum dust extraction for a clean work surface & longer life
Colour coded discs	For easy recognition of grit size
Available in grits P320-1500	Also available in Multi-Air® Plus

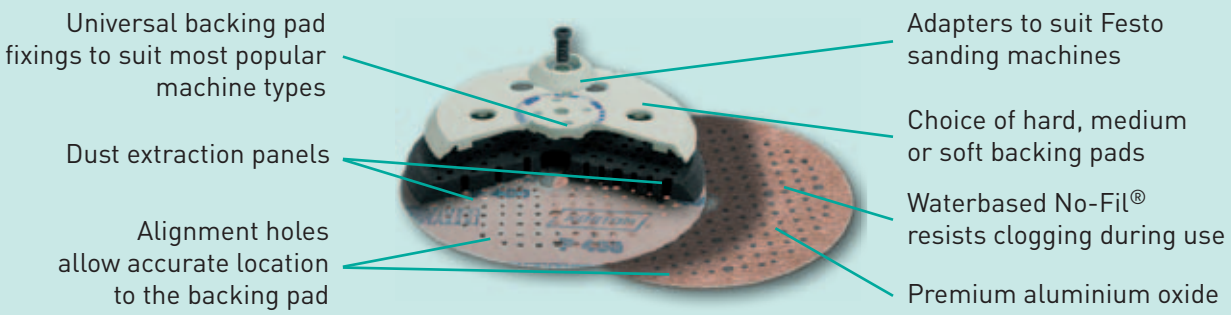
ADVANTAGES OF MULTI-AIR PROCESS®



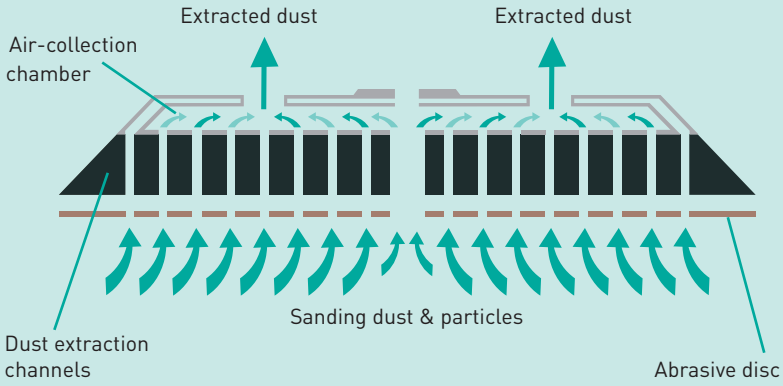


VELKOOBCHOD BRUSIVA

NORTON MULTI-AIR PROCESS®



Dust Extraction System



EXTRACTION HOLES

- 181 holes maximise dust removal for 150mm
- 125 holes maximise dust removal for 125mm

The overall abrasive area is similar to that of conventional discs with traditional 6, 7 or 9 holes dust extraction

MULTI AIR

FEATURES	BENEFITS
■ Revolutionary design for maximum vacuum assistance	■ 30% increase in dust extraction; clogging is virtually eliminated ■ Cleaner working environment; less dust & contamination
■ Cutting surface of disc remains clean	■ 35% increase in productivity versus traditional vacuum systems ■ No clogging; consistent cut throughout the life of the disc
■ Highly-engineered back-up pad	■ Patented design for maximum dust extraction

MULTI-AIR® PLUS KIT

DIA (mm)	GRIT	TYPE	PK QTY	BEST
150	80	Multi-Air® Plus	5	69957**95370**
	120	Multi-Air® Plus	5	
	240	Multi-Air® Plus	5	
	320	Multi-Air® Plus	5	
		Multi-Air® Plus Soft-Touch®	3	
	400	Multi-Air® Plus	5	
		Multi-Air® Plus Soft-Touch®	3	
		Medium Multi-Air® Back-up Pad	1	

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

MULTI-AIR® DISCS

MULTI-AIR®

DIM DIAxH(mm)	GRIT	PK QTY	MULTI-AIR PLUS	MULTI-AIR NORZON	MULTI-AIR
			BEST		BETTER
125x18	80	100	63642563535		63642563513
	120	100	63642563536		63642563514
	150	100	63642563537		63642563515
	180	100	63642563538		63642563516
	240	100	63642563540		63642563518
	320	100	63642563542		63642563520
	400	100	63642563543		63642563522
	500	100	66254477930		63642563523
	600	100			63642563524
	800	100	66254477934		63642563525
150x18	40	50		66261086898	
	60	50		66261086903	
	80	50		66261181412	
	80	100	63642565916		63642560561
	120	100	63642523429	66261086905	63642560562
	150	100	63642523430		63642560563
	180	100	63642565920		63642560564
	220	100	63642523434		63642560565
	240	100	63642523435		63642560566
	280	100	63642523436		63642560567
	320	100	63642523437		63642560568
	360	100			63642560569
	400	100	63642565925		63642560570
	500	100	66254477924		63642560571
	600	100			63642560572
	800	100	66254477926		63642560573

MULTI-AIR® KIT

DIA (mm)	GRIT	TYPE	PK QTY	BETTER
150	80	Medium Multi-Air® NorZon®	5	63642587576
	120	Multi-Air®	5	
	240	Multi-Air®	5	
	320	Multi-Air®	5	
	400	Multi-Air®	5	
		Multi-Air® Soft-Touch®	3	
	500	Multi-Air® Soft-Touch®	3	
	800	Multi-Air® Soft-Touch®	3	
		Medium Multi-Air® Back-up Pad	1	

VELKOOBCHOD BRUSIVA

SOFT-TOUCH® MULTI-AIR®

DIM DIAxH(mm)	GRIT	COLOUR	PK QTY	MULTI AIR PLUS BEST	MULTI AIR BETTER
125x18	500	Dark Blue	20	662544**77935***	
	800	Turquoise	20	662544**77952***	
	1000	White	20		636425**63531**
150x18	320	Salmon	20		636425**60574**
	400	Yellow	20		636425**60575**
	500	Dark Blue	20	662544**77927**	636425**60576**
	800	Turquoise	20	662544**77932**	636425**60577**
	1000	White	20		636425**60578**
	1500	Green	20		636425**60579**

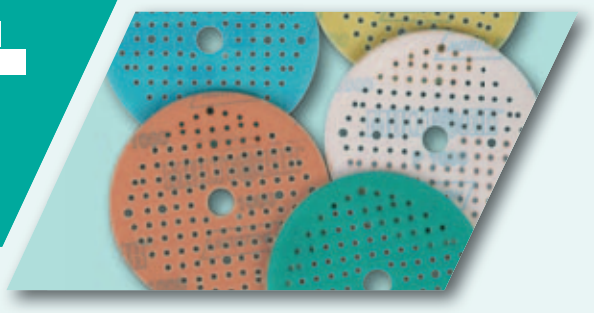
* Made-to-order

PRODUCT SELECTION

APPLICATION	GRIT	COLOUR
SOFT-TOUCH DISCS®		
Sanding cataphoretic coats & primer	320	Salmon
Sanding polyurethane primer	400	Yellow
	500	Dark Blue
Cutting back lacquer before a flush joint	800	Turquoise
Retouching clear coat	1000	White
Before polishing & buffing	1500	Green

SPEC CHECK

- Multi-Air® Soft-Touch® discs are made with a specific soft foam backing with high performance & exceptional long li directly attached to the abrasive paper
- The foam layer absorbs easily any difference in surface, maintaining an excellent cutting action with a very homogenous, high level finish



Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

Jimi VELKOOBCHOD BRUSIVA

MULTI-AIR® DISCS

BACK-UP PADS MULTI-AIR PROCESS®

DIM (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
125	Medium	5/16 & M8	1	63642563533
	Soft	5/16 & M8	1	63642563534
	Medium HT*	5/16 Fixed Screw	1	66261067436
150	Hard	5/16 & M8	1	07660719198
	Medium HT	5/16 & M8	1	63642585872
	Medium HT*	5/16 Fixed Screw	1	63642582245
	Soft	5/16 & M8	1	63642560605
	Rupes Adapter	M5	1	63642526648

* Designed for Hutchins. Also compatible for most common brands such as Dynabrade, Rupes. Except festool.

5/16 Fixed screw backup pad includes a molded screw for greater pad resistance and stability. All other Multi-Air Process® back-up pads are packed in individual boxes with Festo adapter M8 & 5/16 bolts & three fibre ring spaces.

FOAM INTERFACE PADS MULTI-AIR PROCESS®

DIM (mm)	PK QTY	ART. NO.
125	16	63642585864
150	12	07660719359

PRODUCT SELECTION

APPLICATION	DENSITY
BACK-UP PADS	
Heavy duty sanding, best for flattening surfaces or dimensioning	Hard
Scuffing, shaping, sanding & finishing	Medium
For use on filler, primer, paint, clear coat, wood, plaster, composites & metal	
Final sanding, to obtain the best finishes	Soft

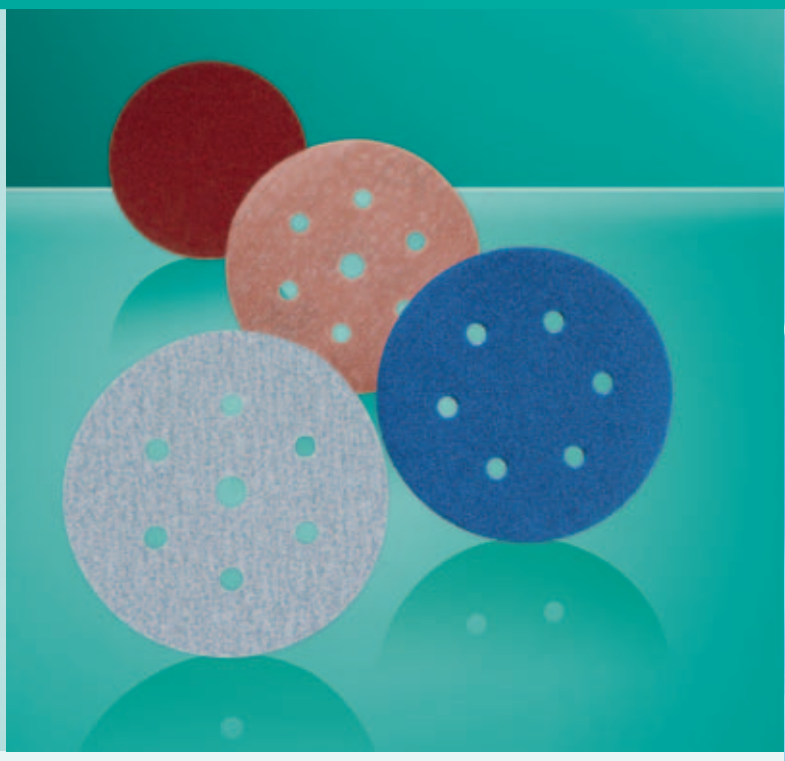
VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORGRIP® & SOFT-TOUCH® DISCS

Norgrip® and Soft-Touch® discs have a quick release backing that allows quick and easy disc changing, increasing performance by minimising downtime. Soft-Touch® discs also include a foam backing that improves product performance and gives an even longer product life. The foam layer absorbs unevenness in the surface, helping to maintain an excellent cutting action providing a very homogenous, high quality finish.



APPLICATIONS & MARKETS

- Preparing primed & painted surfaces
- Stripping primer & paint
- Sanding plastic & fibreglass
- Light weld blending & deburring
- Sanding bare wood

INNOVATION BEST

NORTON ICE

NEW!

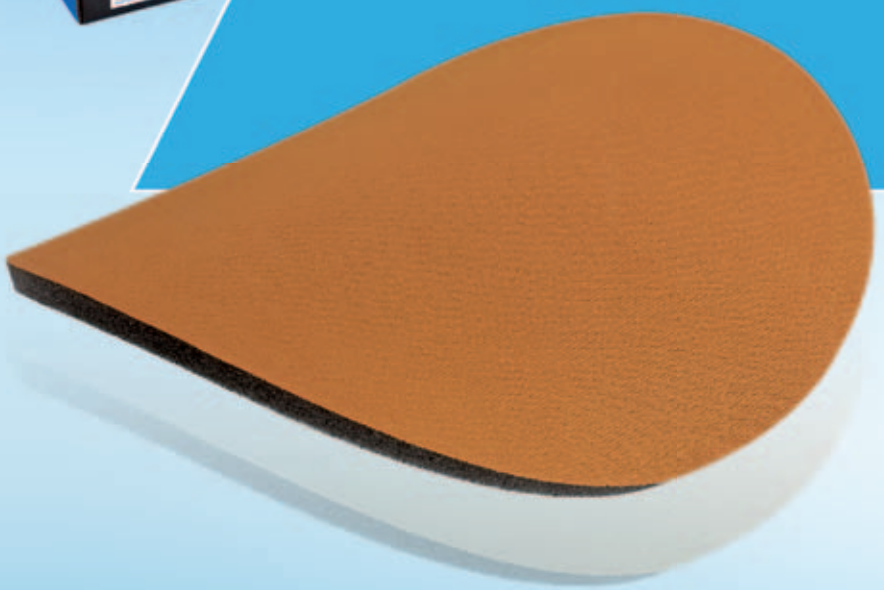
Norton ice

PAINT/ VARN. & HARD WOOD

FEATURES	BENEFITS
Ultra fine grits 1500, 2000 & 3000	Foam backing absorbs water and moulds to the surface for equal pressure distribution
Uniformed cut throughout product life span	Smooth finish and lower scratch depth Requires less effort during the application
Washable and waterproof	High quality finish

jimi VELKOOBCHOD BRUSIVA

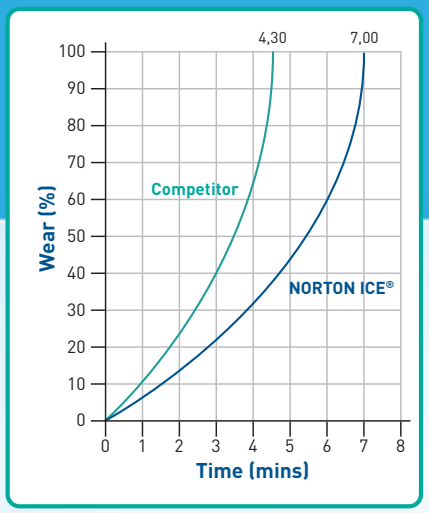
Norton ice™
ACHIEVE THE PERFECT FINISH



NORTON ICE

- Ultra fine grits 1500, 2000, 3000
- Foam backing absorbs water and moulds to the surface for equal pressure distribution
- Uniformed cut throughout product life span
- Smooth finish and lower scratch depth
- Requires less effort during the application
- Washable and waterproof
- Reuseable
- High quality finish

Test on 2K Clearcoat
P1500 / P2000

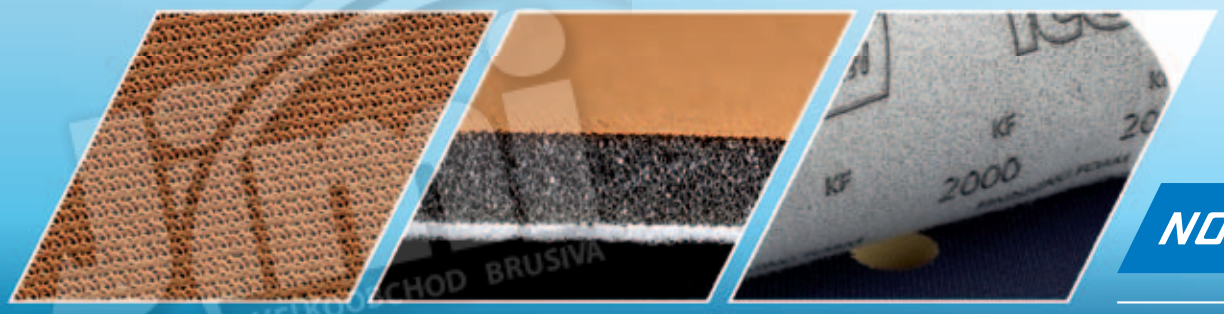


Faster polishing process
after using Norton Ice®

Aluminium oxide cloth backed abrasive

Foam backed disc

Norgrip® fixing

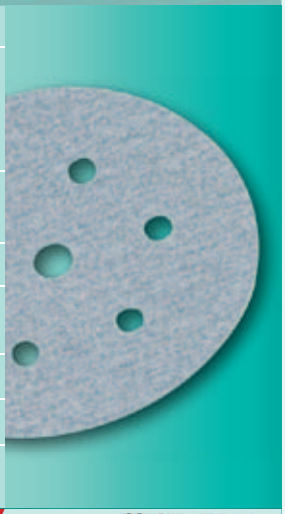


NORTON SAINT-GOBAIN

A975 NORTON PRO PLUS SOFT-TOUCH®

NON FERR. | PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ Norton SG® ceramic abrasive blended with premium heat-treated aluminium oxide abrasive	■ Higher & faster cut rate ■ Ideal for large surfaces ■ Consistent & uniform scratch pattern
■ Unique blue fibre-reinforced latex paper	■ Combines flexibility with tear resistance
■ Water based No-Fil®	■ Resists clogging during use
■ No pigment in No-Fil® or bond	■ No risk of colour transfer
■ Improved performance	■ Extended life
■ Ideal for large surface areas	■ Less downtime
■ Available in grits P80-800	



BEST

Q260 DRY ICE FILM

NEW!

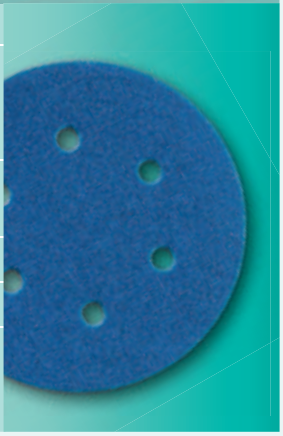
PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ Anti-loading agent	■ Eliminates pig tails and costly re-work
■ Consistent finish	■ Quick and easy to buff out
■ Fast Cut	■ Increase productivity
■ Smooth Film backing	■ Consistent finish that buffs out faster
■ Long Life	■ Less downtime switching discs ■ Reduce material and labor costs

H835 BLUE FIRE®

FERR. & NON FERR. | PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ Latest NorZon® grain design	■ Self-sharpening grain ■ Improved cut rate ■ Extended product life
■ High strength paper backing (E-weight)	■ Reduces curling & edge chipping ■ Tear resistant
■ Open grain distribution	■ Prevents premature clogging
■ Full resin bond system	■ Strong grain adhesion
■ Available in grits 40-120	



VELKOOBCHOD BRUSIVA

BETTER

A275 NORTON PRO

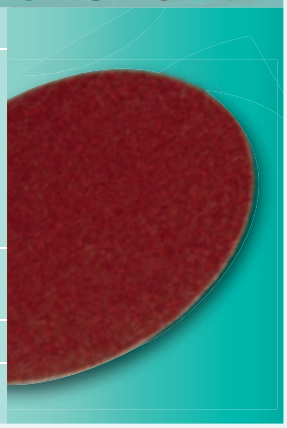
NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Premium, heat-treated high performance aluminium oxide abrasive	■ Faster cut rate ■ Improved performance ■ More consistent uniform scratch pattern
■ Unique fibre-reinforced latex paper	■ Flexible & tear resistant
■ Water based No-Fil®	■ Improved load resistance
■ No pigment in No-Fil® or bond	■ No risk of colour transfer
■ Available in Soft-Touch® discs with flexible foam backing & coloured Norgrip® ■ Available in Norgrip® grits P80-1500 & Soft-Touch® Norgrip® grits P220-1500	■ Allows contour sanding without cutting through coating layer & easy grit identification

H231

FERR. & NON FERR. | HARD WOOD

FEATURES	BENEFITS
■ High performance aluminium oxide abrasive	■ Ideal for roughing, intermediate sanding & finishing of solid wood ■ Ideal for floor & furniture applications ■ Finer grits ideal for polishing metal, plastics & leathers, smoothing fillers, sanding primers, within vehicle repair markets
■ Semi-open / open coat (depending on grit size)	■ Resists clogging
■ Very strong, F-weight paper	■ High performance
■ Anti-static properties	■ Excellent surface quality



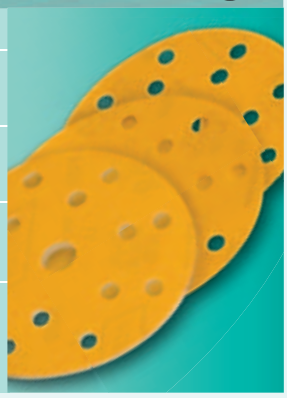
GOOD

A296 GOLD RESERVE

NEW!

FERR. & NON FERR. | PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ "P" graded premium aluminium oxide grain	■ Produces a quick, cool cut ■ Produces a more consistent scratch pattern
■ Strong B weight latex/paper backing	■ Resists tearing ■ Conformable and flexible
■ Water-based, non-loading stearate	■ Resists loading ■ Increases productivity
■ Available in Norgrip® grits P80-P800 & Soft-Touch® Norgrip® grits P220-P800	



VELKOOBCHOD BRUSIVA

NORGRIP® DISCS

DIM DIAxH(mm)	GRIT	PK QTY	NORTON ICE INNOVATION BEST	BLUE FIRE BEST	Norton DRYice Q260 NEW! BEST	NORTON PRO BETTER	
				H835	Q260	A275	H231
76	80	50				6364285133	
	120	50				6364285145	
	150	50				6364285148	
	180	50				6364285150	
	220	50				6364285153	
	240	50				6364285156	
	280	50				6364285161	
	320	50				6364269699	
	360	50				6364285165	
	400	50				6364285169	
	500	50				6995791303	
	600	50				6995789052	
	800	50			6662303900	6364285172	
	1000	50			6625405679	6364285180	
	1200	50			6662300930		
	1500	50			6625405681		
76x3	800	50			6662303902		
	1000	50			6625405686		
	1200	50			6662300933		
	1500	50			6625405684		
80	1500	6	6364206213				
	2000	6	6364206212				
	3000	6	6364206211				
125	36	100					6626117734
	40	25		6995750908			
	60	100					6364216174
	60	25		6995750915			
	80	100					6364216175
	80	50		6995750916			
	120	100					6364216176
	120	50		6995750919			
	180	100					6364237389
	240	100					6995760184
	320	100					6364237390
125x8	80	100				6995751501	
	100	100				6995751503	
	120	100				6995751506	
	150	100				6995751508	
	180	100				6995751509	
	240	100				6995751510	
	320	100				6995751882	
	400	100				6364291163	
	600	100				6995751511*	

* Made-to-order

VELKOOBCHOD BRUSIVA

NORGRIP® DISCS (CONTINUED)

DIM DIAxH(mm)	GRIT	PK QTY	NORTON ICE INNOVATION BEST	BLUE FIRE BEST	Norton DRYice Q260 NEW! BEST	NORTON PRO BETTER	
				H835	Q260	A275	H231
150	36	50					63642551458
	40	100					63642531875
	40	25		69957390933			
	50	100					69957360119
	60	100					63642519158
	60	25		69957390940			
	80	100				63642585184	63642546787
	80	50		69957391248			
	100	100				63642585186	63642531872
	120	100				63642569701	63642531871
	120	50		69957391249			
	150	100				63642569702	69957360170
	180	100				63642585190	63642536755
	220	100				63642585194	
	240	100				63642585197	63642546797
	280	100				63642585199	
	320	100				63642569704	63642536677
	360	100				63642585205	
	400	100				63642585214	
	500	100				63642585217	
	600	100				63642585220	
	800	100				63642585223	
	1000	50			662544**05675***		
	1500	50			662544**05677***		
	1500	15	636425**06209**				
	2000	15	636425**06208**				
	3000	15	636425**06207**				

* 150mm x 18 Multi-Air

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

NORGRIP® DISCS (CONTINUED)

DIM DIAxH(mm)	GRIT	PK QTY	BLUE FIRE (BEST) H835	NORTON PRO PLUS (BEST) A975	Norton DRYice Q260 NEW! BEST Q260	NORTON PRO (BETTER) A275	BETTER H231
150x14	36	100					6995735**1529***
	40	100					6626102**6066**
	40	25	6995739**1250**				
	60	100					6995738**2764**
	60	25	6995739**1255**				
	80	100		6364252**7655**		6364255**7950**	6626102**6069**
	80	50	6995739**1256**				
	100	100				6364258**6135**	6626102**6070**
	120	100		6364252**7659**		6364255**7954**	6626102**6071**
	120	50	6995739**1257**				
	150	100		6364252**7657**		6364258**6141**	6626102**6072**
	180	100		6364252**7661**		6364258**6142**	6995735**1530**
	220	100		6364252**7662**		6364258**6143**	
	240	100		6364252**7666**		6364255**7955**	6995735**1531**
	280	100		6364252**7667**		6364258**6144**	
	320	100		6364252**7669**		6364255**7959**	6995735**1532**
	360	100				6364258**6148**	
	400	100		6364252**7670**		6364255**7962**	
	500	100		6625476**6604**		6364258**6150**	
	600	100				6364255**7964**	
	800	100		6625476**6617**		6364258**4990**	
	800	50			6662330**3904**		
	1000	50			6626107**2192**		
	1200	50			6625440**3620**		
	1500	50			6626107**2193**		
150x18	40	100					6364255**0341**
	40	25	6995739**1258**				
	60	100					6364253**6740**
	60	25	6995739**1260**				
	80	100		6364252**7612**		6364255**7968**	6364253**6741**
	80	50	6995739**1261**				
	100	100				6364258**5059**	6364256**8763**
	120	100		6364256**5918**		6364255**7969**	6364254**6779**
	120	50	6995739**1262**				
	150	100		6364256**5919**		6364255**7970**	6364254**6781**
	180	100		6364252**7633**		6364258**5064**	6364254**6834**
	220	100		6364256**5921**		6364258**5065**	
	240	100		6364256**5922**		6364258**5067**	6364256**8766***
	280	100		6364256**5923**		6364258**5069**	
	320	100		6364256**5924**		6364255**7973**	
	360	100				6364258**5078**	
	400	100		6364252**7647**		6364255**7974**	
	500	100		6625477**7132**		6364255**7975**	
	600	100				6364258**5073**	
	800	100		6625477**7133**		6364258**5074**	
	800	50			6662330**3896**		
	1000	50			6626107**2195**		
	1200	50			6662330**0928**		
	1500	50			6626107**2196**		

* Made-to-order

VELKOOBCHOD BRUSIVA

NORGRIP® DISCS (CONTINUED)

DIM DIAxH(mm)	GRIT	PK QTY	BLUE FIRE NEW! BEST H835	NORTON PRO PLUS NEW! BEST A975	Norton DRYice Q260 NEW! BEST Q260	NORTON PRO NEW! BETTER A275	GOLD RESERVE NEW! GOOD A296
150x18	40	50	66254**44904**				
	60	50	66254**44905**				
	80	100		66254**77881**		66254**05540**	66261**97523**
	80	50	66254**44908**				
	100	100				66254**05542**	66261**97526**
	120	100		66254**77879**		66254**05528**	66261**97529**
	120	50	66254**44909**				
	150	100		66254**77882**		66254**05530**	66261**97531**
	180	100		66254**77883**		66254**05546**	66261**97532**
	220	100		66254**77884**		66254**05548**	66261**97533**
	240	100		66254**77885**		66254**05549**	66261**97534**
	280	100		66254**77886**		66254**05550**	66261**97537**
	320	100		66254**77887**		66254**05539**	66261**97538**
	360	100				66254**05551**	
	400	100		66254**77888**		66254**05552**	66261**97539**
	500	100		66254**76601**		66254**05553**	66261**97540**
	600	100				66254**05554**	66261**97542**
	800	100		66254**79091**		66254**05555**	66261**97543**
	800	50			66623**05249***		
	1000	50			66623**11271***		
	1200	50			66623**11275***		
	1500	50			66623**11277***		
203	40	25	69957**91263**				
	60	25	69957**91268**				
	80	100				63642**85236**	
	80	50	69957**91269**				
	100	100				63642**85242**	
	120	100				63642**85243**	
	120	50	69957**91272**				
	150	100				63642**85244**	
	180	100				63642**85245**	
	220	100				63642**85246**	
	240	100				63642**85248**	
	280	100				63642**85249**	
	320	100				63642**85250**	
	360	100				63642**85251**	
	400	100				63642**85252**	
203x18	60	100	66254**25281**				
	80	100	66254**25282**	66254**79251**		66254**79260**	
	100	100				66254**79261**	
	120	100		66254**25291**		66254**33333**	
	150	100		66254**25292**		66254**33335**	
	180	100		66254**79253**		66254**79262**	
	220	100				66254**79263**	
	240	100		66254**25293**		66254**33336**	
	280	100		66254**79255**		66254**79264**	
	320	100		66254**25294**		66254**33337**	
	360	100				66254**79265**	
	400	100		66254**25295**		66254**33338**	
	500	100		66254**79257**			
	800	100		66254**79258**			

* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

VELKOOBCHOD BRUSIVA

BEARTEX CLEAN & FINISH DISCS

FEATURES	BENEFITS
■ Flexible	■ Conforms to work surface & provides a uniform finish
■ Gentle action	■ Easily removes burrs without affecting the dimension of the workpiece
■ Non-loading and ideal for finishing solid surface materials	■ Continual supply of new cutting edges
■ Non-rusting	■ No contamination of the workpiece
■ Resilient construction	■ Long life, waterproof & solvent resistant

BEARTEX NORGRIP DISCS

DIA (mm)	CAP CODE	GRADE	PK QTY	ART. NO.
150	F2520	Very Fine A	10	69957**383151**
150	F4804	Ultra Fine S	10	69957**383158**
150	F2801	Micro Fine A	10	69957**383162**

BACK-UP PADS NORGRIP

DIA (mm)	DENSITY	PK QTY	ART. NO.
150	Hard	3	63642**584830**
150	Medium	3	63642**584832**
150	Soft	3	63642**584834**

SPEC CHECK

Norton has the capability to convert Jumbo rolls into a wide variety of shapes & sizes for your individual application.

Please contact your local Norton Sales Representative for further information.

jimi VELKOOBCHOD BRUSIVA

PRODUCT SELECTION

APPLICATION	GRIT	COLOUR
SOFT-TOUCH DISCS®		
Sanding of filler before primer	220	Red
	240	Electric Blue
Sanding of cataphoretic primer	280	Grey
	320	Salmon
Sanding of polyurethane primer	360	Pink
	400	Yellow
	500	Dark Blue
	600	Fuchsia
Cutting back lacquer before a flush joint	800	Turquoise
Retouching clear coat	1000	White
Before polishing & buffing	1500	Green

Dimensions Key: DIM = Diameter, DIA = Diameter, H = Hole

SOFT-TOUCH® DISCS

DIM DIAxH(mm)	GRIT	COLOUR	PK QTY	NORTON PRO BETTER A275	GOLD RESERVE NEW! GOOD A296
150x14	220	Red	20	63642**57535***	
	280	Grey	20	63642**57541**	
	320	Salmon	20	63642**57543***	
	360	Pink	20	63642**57545**	
	400	Yellow	20	63642**57546***	
	500	Dark Blue	20	63642**57548**	
	600	Fuchsia	20	63642**57550**	
	800	Turquoise	20	63642**57551**	
	1000	White	20	63642**57556**	
	1500	Green	20	63642**57559**	
150x18	220	Red	20	63642**57561**	
	240	Electric Blue	20	63642**57563***	
	360	Pink	20	63642**57567**	
	400	Yellow	20	63642**57569**	
	500	Dark Blue	20	63642**57570**	
	600	Fuchsia	20	63642**57572**	
	800	Turquoise	20	63642**57571**	
	1000	White	20	63642**57573**	
	1500	Green	20	63642**57574**	
150x18	220	White	20		66261**97548**
	320	White	20		66261**97551**
	400	White	20		66261**97554**
	500	White	20		66261**97556**
	800	White	20		66261**97557**

* Made-to-order

SPEC CHECK

- Norton Pro Soft-Touch® discs are made with a specific soft backing with high performance & exceptional long life, directly attached to the abrasive paper
- The foam layer absorbs easily any difference in surface, maintaining an excellent cutting action with a very homogenous, high quality finish

jimi VELKOOBCHOD BRUSIVA

PRODUCT SELECTION

ATTACHMENT TYPE	MACHINE
BACK-UP PADS	
M14	Electrical angle grinder
5/8	Electrical & pneumatic grinders (US tools)
M8	Festo orbital sander
5/16	Other orbital sanders
M6	Mirka or CP orbital sander
M5	Rupes orbital sander

FEATURES	BENEFITS
■ Different densities, available in most popular perforations/dust hole patterns	■ Applies to a full range of applications with optimal dust extraction
■ New back plate technology	■ Heavy duty design ■ Long life
■ Attachments for different tools	■ Adapts to all common orbital sanders
■ Easy-peel technology	■ Longer life of gripping layer
■ Colour coding of foam layer	■ Easy & quick hardness identification

BACK-UP PADS

DENSITY	COLOUR	APPLICATION	
Hard	Black	Heavy duty sanding, best for flattening surfaces or dimensioning	
Medium	Blue	Scruffing, shaping, sanding & finishing. For use on filler, primer, paint, clear coat, wood, plaster, composites & metal	
Soft	Light Blue	Final sanding, to obtain the best finishes	

Packed in clear individual display box including: safety recommendations, product information, mounting instructions, versatile attachment system (FESTO M8 and standard 5/16) and allen wrench

Dimensions Key: DIM = Diameter, DIA = Diameter, H = Hole

Jimi VELKOOBCHOD BRUSIVA

NORGRIP® & SOFT-TOUCH® DISCS

BACK-UP PADS NORGRIP®

DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
76	Medium	M6	6	69957**350736***
115	Medium	M14	3	69957**350743**
125	Medium	5/16	3	69957**350739**
125	Medium	M14	3	69957**350744**
150	Medium	M14	3	63642**567812**
150	Medium	5/16 & M8	3	63642**584885**
150	Hard	5/16 & M8	3	63642**584830**
	Medium	5/16 & M8	3	63642**584832**
	Soft	5/16 & M8	3	63642**584834**
150	Hard	5/16 & M8	3	63642**584883**
	Medium	5/16 & M8	3	63642**584884**
	Soft	5/16 & M8	3	63642**584835**
150	Medium	5/16 & M8	3	63642**584842**
203	Medium	M5	1	69957**371442**
203x18	Medium	5/16	10	66254**425341**

* Made-to-order

WHAT IS NORGRIP® DUO?

- A universal attachment system for both Norgrip® & self-adhesive discs provides the maximum flexibility of use & the optimal results during finishing
- The Norgrip® Duo combines an innovative design of gripping structures in the shape of flat-top mushrooms which provide a very uniform finish, while allowing both self-adhesive & Norgrip® discs to be used on this unique system

BACK-UP PADS NORGRIP® DUO

DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
33	Medium	5/16	6	63642**567811***
76	Medium	5/16	6	63642**567810**

* Made-to-order

VELKOOBCHOD BRUSIVA

HAND PAD NORGRIP®

DIA (mm)	DENSITY	PK QTY	ART. NO.
150	Medium	10	63642596414*
	Soft	6	6364259641**6**

* Made-to-order

FOAM INTERFACE BACK-UP PADS NORGRIP®

DIA (mm)	PK QTY	ART. NO.
76	10	6995739458**9***
150	10	0766060738**3**
150	10	6995739459**0**
150	10	0766071936**0**
203x18	10	6625442533**9**

* Made-to-order

SPEC CHECK

- Specially designed to give optimal results with very fine grit abrasives, the Norton foam interfaces easily conforms to contours. These are specifically developed for the finishing operation to reduce any risk of scratching
- Norgrip® discs can be used with the Norgrip® hand pad for manual application

Dimensions Key: DIA = Diameter

CONVERSION INTERFACES

DIA (mm)	PK QTY	NORGRIP® TO NORGRIP® DUO
150	12	6364256**7842**
150	12	6364256**7848**
150	12	6364256**7850**

SPEC CHECK

- Convert a standard Norgrip® back-up pad into a Norgrip® Duo & reduce the time needed for back-up pad changes. Norgrip® Duo back-up pads can be used with both Norgrip® & Self-adhesive discs. They can be used with all types of Norton abrasives

Dimensions Key: DIA = Diameter

NOTES

VELKOOBCHOD BRUSIVA

SELF-ADHESIVE DISCS

Norton Premium quality self-adhesive discs can be securely fixed onto suitable back-up pads. The Norton Pro A275 self-adhesive discs are supplied as convenient dispenser rolls of 100 discs.

APPLICATIONS & MARKETS

- Preparing primed & painted surfaces
- Stripping primer & paint
- Sanding plastic & fibre-glass
- Light weld blending & deburring
- Finishing metal

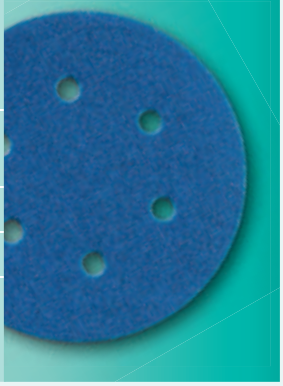
BEST

H835 BLUE FIRE®

FERR. & NON FERR.

PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
Latest NorZon® grain design	Self-sharpening grain Improved cut rate Extended product life
High strength paper backing (E-weight)	Reduces curling & edge chipping Tear resistant
Open grain distribution	Prevents premature clogging
Full resin bond system	Strong grain adhesion
Available in grits 60-80	

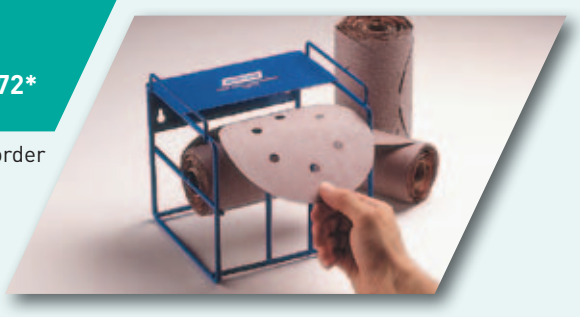


SPEC CHECK

- Dispenser for convenient & easy storage of A275 self-adhesive disc rolls

63642542772*

* Made-to-order



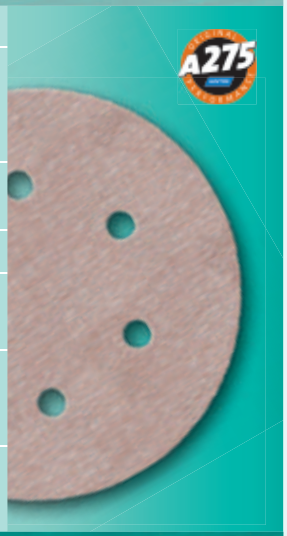
JMI VELKOOBCHOD BRUSIVA

BETTER

A275 NORTON PRO

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ New premium, heat-treated high performance aluminium oxide abrasive	■ Faster cut rate ■ Improved performance ■ More consistent uniform search pattern
■ New unique fibre-reinforced latex paper	■ Flexible & tear resistant
■ Water based No-Fil®	■ Improved load resistance
■ No pigment in No-Fil® or bond	■ No risk of colour transfer
■ Supplied in roll form with 100 discs per roll & 6 rolls in a dispenser box	■ Convenient, easy to store & merchandise
■ Available in grits 80-800	



H231

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ High performance aluminium oxide abrasive	■ Ideal for roughing, intermediate sanding & finishing of solid wood ■ Ideal for floor & furniture applications ■ Finer grits ideal for polishing metal, plastics & leathers, smoothing fillers, sanding primers, within vehicle repair markets
■ Semi-open / open coat (depending on grit size)	■ Resists clogging
■ Very strong, F-weight paper	■ High performance
■ Anti-static properties	■ Excellent surface quality

T401 BLACK ICE

FERR. | PAINT/ VARN.

FEATURES	BENEFITS
■ Premium, ultra fine silicon carbide abrasive	■ Best finish in wet clear-coat repair applications
■ Advanced resin bond system	■ Longer life in wet applications ■ Waterproof
■ Advanced, A-Weight waterproof paper backing design	■ Ultimate flexibility & waterproof performance
■ Supplied in rolls of 400 discs	■ Convenient & easy to store

VELKOOBCHOD BRUSIVA

SELF-ADHESIVE DISCS

SELF-ADHESIVE DISCS

DIA (mm)	GRIT	PK QTY	NORTON PRO	BLACKICE
			BETTER	
			A275	T401
38	1500	400		6364253**4470**
	2000	400		6995736**0371**
	2500	400		6364256**1155**
125	80	6x100	6626113**1464***	
	100	6x100	6626113**1463***	
	120	6x100	6626113**1462***	
	180	6x100	6626113**1460***	
	220	6x100	6626113**1459***	
	240	6x100	6626113**1458***	
	280	6x100	6626113**1457***	
	320	6x100	6626113**1456***	
	400	6x100	6626113**1454**	
	500	6x100	6626113**1453***	
	800	6x100	6626113**1451**	
125	80	6x100	6626113**1498***	
	100	6x100	6626113**1497***	
	120	6x100	6626113**1496***	
	150	6x100	6626113**1495***	
	180	6x100	6626113**1494***	
	220	6x100	6626113**1493***	
	240	6x100	6626113**1492***	
	280	6x100	6626113**1491***	
	320	6x100	6626113**1490***	
	500	6x100	6626113**1487***	
	600	6x100	6626113**1486***	
	800	6x100	6626113**1485***	

* Made-to-order

VELKOOBCHOD BRUSIVA

SELF ADHESIVE DISCS (CONTINUED)

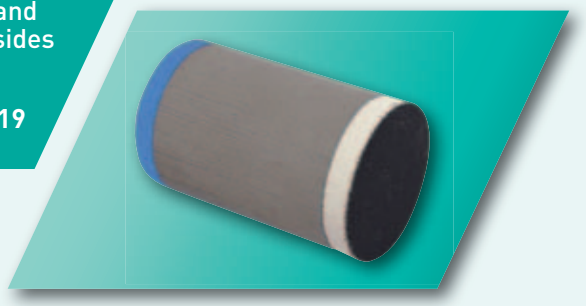
DIA (mm)	GRIT	PK QTY	BLUE FIRE BEST H835	NORTON PRO BETTER A275	BETTER H231
150	40	100			69957**60111**
	60	100			63642**536719**
	80	100			63642**528522**
	80	6x100		66261**131481**	
	100	100			63642**536724**
	100	6x100		66261**131480**	
	120	100			63642**536725**
	120	6x100		66261**131479**	
	150	6x100		66261**131478***	
	180	6x100		66261**131477**	
	220	6x100		66261**131476**	
	240	6x100		66261**131475***	
	280	6x100		66261**131474***	
	320	6x100		66261**131473***	
	400	6x100		66261**131471**	
	500	6x100		66261**131468***	
	600	6x100		66261**131469***	
	800	6x100		66261**131470***	
150	60	50	66261**023410***		
	80	50	66261**023408**		
	80	6x100		66261**131515**	
	100	6x100		66261**131514***	
	120	6x100		66261**131513**	
	150	6x100		66261**131512**	
	180	6x100		66261**131511**	
	220	6x100		66261**131510***	
	240	6x100		66261**131509**	
	280	6x100		66261**131508***	
	320	6x100		66261**131507**	
	400	6x100		66261**131505**	
	500	6x100		66261**131504***	
	600	6x100		66261**131503***	
	800	6x100		66261**131502***	

* Made-to-order

SPEC CHECK

- Designed to be used by hand with the maximum flexibility and versatility, the 33mm double-sided sanding block has two sides with different hardness: one for cutting, one for finishing

Pack quantity 12 63642**567819**



Dimensions Key: DIA = Diameter

SELF-ADHESIVE DISCS

BACK-UP PADS SELF-ADHESIVE DISCS

DIA (mm)	DENSITY	ATTACHMENT	PK QTY	ART. NO.
150	Medium	5/16 & M8	3	636425**94551**
150	Medium	5/16 & M8	3	636425**94552**

CONVERSION INTERFACES

DIA (mm)	PK QTY	SELF-ADHESIVE TO NORGRIP® DUO
150	6	636425**67849**
150	6	636425**67851**

SPEC CHECK

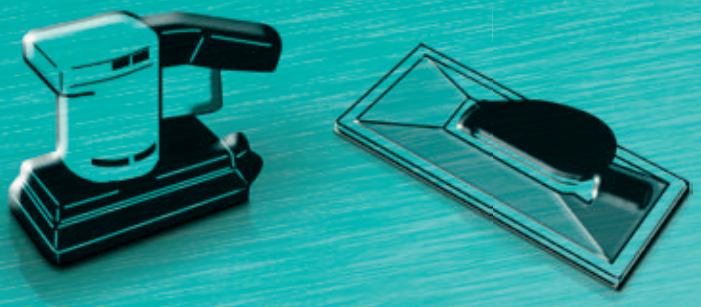
- Convert a self-adhesive back-up pad into a Norgrip® Duo & reduce the time needed for back-up pad changes. Norgrip® Duo back-up pads can be used with both Norgrip® & Self-adhesive discs. They can be used with all types of Norton abrasives

Dimensions Key: DIA = Diameter

NORTON
SAINT-GOBAIN

Coated & BearTex

184 CUT SHEETS
196 NORGRIP PAPER ROLLS
198 BEARTEX ROLLS



Orb heet Sander/Sanding Block

CUT SHEETS

Norton offers a full range of cut sheets for hand and machine use, providing a range of efficient, user-friendly abrasive solutions. The extended range of dimensions and grits complies with all commonly encountered applications.

APPLICATIONS & MARKETS

- Flatten sharp edges & large surface areas
- Deburring
- Removing sanding scratches

PRODUCT SELECTION GUIDE

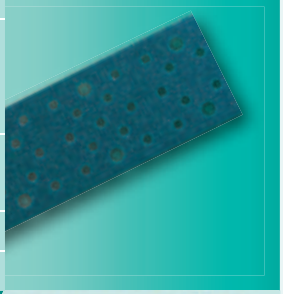
MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Metal	H835	H231	A275
Wood	H231	A275	G131
Filler	H835	A975	A275
Primer/Paint/Varnish	A975	A275	
Composites/Coatings	H835	A975	A275

jimi VELKOOBCHOD BRUSIVA

INNOVATION BEST

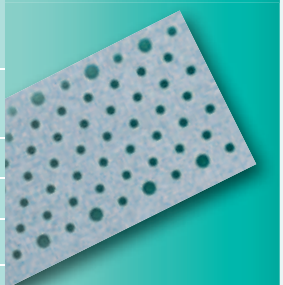
MULTI-AIR® NORZON®

FEATURES	BENEFITS
■ Latest Norzon® grain design	■ Self-sharpening grain ■ Improved cut rate for higher productivity ■ Extended product life
■ High strength paper backing (E-weight)	■ Reduces curling & edge chipping ■ Tear resistant
■ Open grain distribution	■ Prevents premature clogging
■ Full resin bond system	■ Strong & improved grain adhesion



MULTI-AIR® PLUS

FEATURES	BENEFITS
■ Norton SG® Ceramic abrasive blended with premium heat-treated aluminium oxide	■ Higher & faster cut rate ■ Consistent & uniform scratch pattern
■ Unique blue fibre reinforced latex paper	■ Combines flexibility with tear resistance
■ Water based No-fil®	■ Resists clogging during use
■ No pigment in No-Fil® or bond	■ No risk of colour transfer
■ Improved performance	■ Extended life
■ Ideal for large surface area	■ Less downtime
■ Available in grits P80-400	

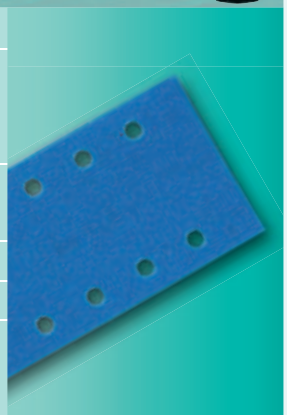


BEST

H835 BLUE FIRE®

FERR. & NON FERR. PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ Latest Norzon® grain design	■ Self-sharpening grain ■ Improved cut rate ■ Extended product life
■ High strength paper backing (E-weight)	■ Reduces curling & edge chipping ■ Tear resistant
■ Open grain distribution	■ Prevents premature clogging
■ Full resin bond system	■ Strong grain adhesion
■ Available in grits 40-120	



jimi VELKOOBCHOD BRUSIVA

BETTER

A275 NORTON PRO

NON FERR.

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Premium, heat-treated high performance aluminium oxide abrasive	Faster cut rate Improved performance More consistent uniform scratch pattern
Unique fibre-reinforced latex paper	Flexible & tear resistant
Water based No-Fil®	Improved load resistance
No pigment in No-Fil® or bond	No risk of colour transfer
Available in grits 80-1000	

GOOD

G131

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Aluminium oxide abrasive	Good performance
E-weight paper backing	Economy product

Jimi VELKOOBCHOD BRUSIVA

PAPER SHEETS

DIM WxL(mm)	GRIT	PK QTY	NORTON PRO BETTER A275	GOOD G131
115x280	80	50	636425**88214**	
	100	50	636425**88216**	
	120	50	636425**88217**	
	150	50	636425**88218**	
	180	50	636425**88221**	
	220	50	636425**88222**	
	240	50	636425**88223**	
	280	50	636425**88224**	
	320	50	636425**88225**	
	400	50	636425**88226**	
	500	50	636425**88227**	
	600	50	636425**88228**	
115x280	40	50		699573**52139***
	60	50		699573**51278**
	80	50		699573**52140**
	100	50		699573**52141**
	120	50		699573**52146**

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

jimi VELKOOBCHOD BRUSIVA

MULTI-AIR® CUT SHEETS

DIM WxL(mm)	GRIT	PK QTY	MULTI AIR NORZON	MULTI AIR PLUS
			INNOVATION	
			BEST	
70x125	40	50	69957394449	
	60	50	69957394350	
	80	50	69957394355	69957394456
	120	50	69957394357	69957394457
	150	50		69957394458
	180	50		69957394459
	220	50		69957396408
	240	50		69957394460
	280	50		69957396409
	320	50		69957394461
	400	50		69957394462
70x198	40	50	69957394363	
	60	50	69957394367	
	80	50	69957394369	69957394470
	120	50	69957394451	69957394472
	150	50		69957394473
	180	50		69957394474
	220	50		69957396410
	240	50		69957394475
	280	50		69957396411
	320	50		69957394477
	400	50		69957394478
70x420	40	50	69957394450	
	60	50	69957394358	
	80	50	69957394360	69957394463
	120	50	69957394361	69957394464
	150	50		69957394465
	180	50		69957394466
	220	50		69957396406
	240	50		69957394467
	280	50		69957396407
	320	50		69957394468
	400	50		69957394469

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MULTI-AIR® CUT SHEETS (CONTINUED)

DIM WxL(mm)	GRIT	PK QTY	MULTI-AIR NORZON	MULTI-AIR PLUS
			INNOVATION	
			BEST	
115x230	40	50	699573**94452**	
	60	50	699573**94453**	
	80	50	699573**94454**	699573**94479**
	120	50	699573**94455**	699573**94481**
	150	50		699573**94482**
	180	50		699573**94483**
	220	50		699573**96414**
	240	50		699573**94484**
	280	50		699573**96415**
	320	50		699573**94485**
	400	50		699573**94486**
115x405	40	50	662610**66780**	
	60	50	662610**66782**	
	80	50	662610**66783**	662610**66786**
	120	50	662610**66784**	662610**66788**
	150	50		662610**66791**
	180	50		662610**66792**
	220	50		662610**66796**
	240	50		662610**66793**
	280	50		662610**66800***
	320	50		662610**66794**
	400	50		662610**66795**

* Made-to-order

Multi-Air® cut sheets have similar positioning holes locations as standard perforated sheets that makes them easy to position

Dimensions Key: DIM = Dimensions, W = Width, L = Length

Jimi VELKOOBCHOD BRUSIVA

NORGRIP® CUT SHEETS

DIM WxL(mm)	GRIT	PK QTY	BLUE FIRE BEST H835	NORTON PRO BETTER A275
70x125	80	100		6364258002
	100	100		6364285263
	120	100		6364285272
	150	100		6364258005
	180	100		6364285274
	220	100		6364285281
	240	100		6364285284
	280	100		6364285286
	320	100		6364258006
	360	100		6364285291
	400	100		6364285294
	500	100		6364269777
	600	100		6364269669
	800	100		6364269670
70x198	40	25	6995739**0890***	
	60	25	6995739**0892***	
	80	50	6995739**0896***	
	80	100		6364285468
	100	100		6364285475*
	120	50	6995739**0901***	
	120	100		6364285477
	150	100		6364285479
	180	100		6364285481
	220	100		6364285492*
	240	100		6364285493
	280	100		6364285494
	320	100		6364285495
	360	100		6364285496*
	400	100		6364285497*
	500	100		6364285498*
70x420	40	25	6995739**0902***	
	60	25	6995739**0905***	
	80	50	6995739**0909**	
	80	100		6364285549
	100	100		6364285551*
	120	50	6995739**0910***	
	120	100		6364285555
	150	100		6364285558
	180	100		6364285561
	220	100		6364285566
	240	100		6364285568
	320	100		6364285576
	400	100		6364285579

* Made-to-order

VELKOOBCHOD BRUSIVA

NORGRIP® CUT SHEETS (CONTINUED)

DIM WxL(mm)	GRIT	PK QTY	BLUE FIRE BEST H835	NORTON PRO BETTER A275
80x133	40	25	699573**90920***	
	60	25	699573**90922***	
	80	50	699573**90923***	
	80	100		63642**85306**
	100	100		63642**85317**
	120	50	699573**90925***	
	120	100		63642**85319**
	150	100		63642**85322**
	180	100		63642**85323**
	220	100		63642**85326**
	240	100		63642**85328**
	280	100		63642**85329***
	320	100		63642**85331**
	400	100		63642**85345**
81x153	40	25	699573**90884***	
	60	25	699573**90886***	
	80	100		63642**85372**
	100	100		63642**85376***
	120	50	699573**90873***	
	120	100		63642**85377**
	150	100		63642**85378**
	180	100		63642**85383**
	220	100		63642**85384***
	240	100		63642**85399**
	280	100		63642**85400***
	320	100		63642**85402**
	400	100		63642**85406***
	500	100		63642**85407***
93x180	40	25	699573**90927***	
	60	25	699573**90930***	
	80	50	699573**90931***	
	80	100		63642**85409**
	100	100		63642**85412***
	120	50	699573**90932***	
	120	100		63642**85422**
	150	100		63642**85424**
	180	100		63642**85428**
	220	100		63642**85431***
	240	100		63642**85438**
	280	100		63642**85442***
	320	100		63642**85446**
	400	100		63642**85458**
	500	100		63642**85461***

Dimensions Key: DIM = Dimensions, W = Width, L = Length

* Made-to-order

NORGRIP® CUT SHEETS (CONTINUED)

DIM WxL(mm)	GRIT	PK QTY	BLUE FIRE BEST H835	NORTON PRO BETTER A275
100x150	40	25	6995739**1019**	
	60	25	6995739**1020**	
	80	50	6995739**1023***	
	80	100		6995739**1028**
	120	50	6995739**1025***	
	120	100		6995739**1030**
	150	100		6995739**1033**
	180	100		6995739**1034**
	220	100		6995739**1037**
	240	100		6364257**6688***
	320	100		6995735**1544**
	400	100		6995735**1546***
115x230	40	25	6995739**0911***	
	60	25	6995739**0915***	
	80	50	6995739**0917***	
	80	100		6364258**5506**
	100	100		6364258**5507**
	120	50	6995739**0918***	
	120	100		6364258**8012**
	150	100		6364258**5508**
	180	100		6364258**8013**
	220	100		6364258**5511**
	240	100		6364258**8014**
	280	100		6364258**5517**
	320	100		6364258**5533**
	360	100		6364258**5536***
	400	100		6364258**5538**
	500	100		6364258**5543***

* Made-to-order

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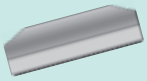
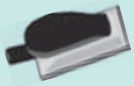
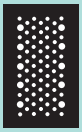
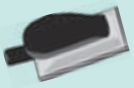
PLAIN SANDING BLOCK NORGRIP®

	DIM WxL(mm)	PK QTY		
	70x125	15	07660705180	

PERFORATED SANDING BLOCKS NORGRIP®

	DIM WxL(mm)	PK QTY	BETTER
	70x125	1	6995739664**5**
	70x198	1	6995739664**6**
	70x400	1	6995739664**8**
	115x230 	1	6995739664**4**
	81x153	1	0766071928**4**

Dimensions Key: DIM = Dimensions, W = Width, L = Length

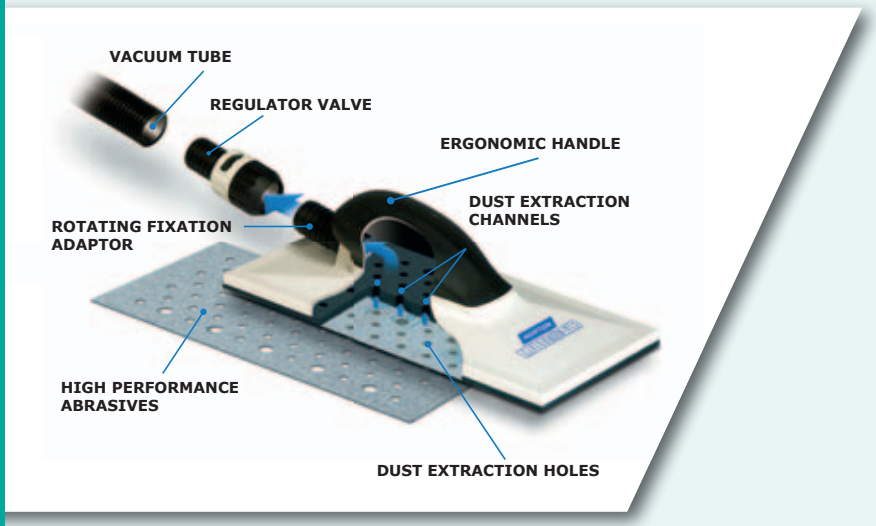
Jimi VELKOOBCHOD BRUSIVA

PERFORATED SANDING BLOCK ACCESSORIES

	PK QTY	BETTER
Flexible 4 Metre Pipe	1	07660767979

PERFORATED SANDING BLOCK KIT NORGRIP®

	PK QTY	BETTER
Sanding Block Kit	1	6995739664 9



VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORGRIP PAPER ROLLS

Coated abrasive rolls are ideal for fast easy sanding of various materials. They can be torn to exact lengths as needed.

APPLICATIONS & MARKETS

- Light deburring
- Removing rust & scale
- Sanding & polishing
- Bare wood sanding
- Hand sanding
- Machine sanding on eccentric sanders
- Paint & plaster sanding
- Floor sanding

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Metal	H231	A275	
Wood	H231	A275	G131
Primer/Paint/Varnish	H231	A275	G131

BEST

H231

FERR. & NON FERR.

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES

- Very strong F-weight paper
- High performance aluminium oxide abrasive
- Open grain distribution
- Anti-static properties

BENEFITS

- Ideal for sanding flat wooden or painted surfaces
- Suitable for metal surface finishing
- Reduces clogging
- Helps minimise dust when used with an appropriate extraction system

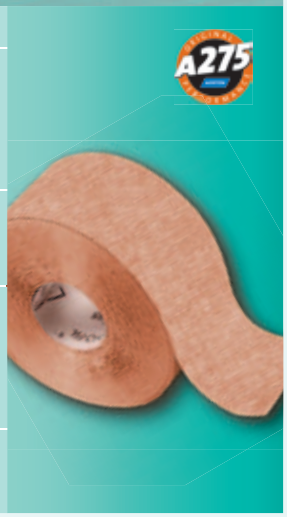
Jimi VELKOOBCHOD BRUSIVA

BETTER

A275 NORTON PRO

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Fibre-reinforced latex, B-weight paper	■ Tear resistant ■ Can be used wet ■ Suitable for use on primer, paint filler & coating sanding (for automotive & transport applications)
■ Premium heat-treated aluminium oxide abrasive blend	■ Long lasting, fast cut rate
■ Water based No-Fil® anti-loading third layer	■ Good finish ■ Resists loading & extends life ■ Can be used for composite & gel coat sanding (for marine market, etc.)
■ No pigments in No-Fil® or bonding system	■ No risk of colour transfer ■ Wooden furniture preparation



NORGRIP® ROLLS

DIM WxL	GRIT	PK QTY	BEST H231	BETTER A275
75mmx25M	40	2	699573**91104***	
	60	2	699573**91106***	
	80	2	699573**91112***	
	120	2		699573**91149**
	150	2		699573**91151***
	180	2		699573**91152**
	220	2		699573**91153***
	240	2		699573**91155**
	280	2		699573**91156**
	320	2		699573**91157**
	400	2		699573**91159**
115mmx25M	40	2	699573**91121**	
	60	2	699573**91123**	
	80	2	699573**91133**	
	120	2		699573**91218**
	150	2		699573**91219**
	180	2		699573**91220**
	220	2		699573**91221**
	240	2		699573**91222**
	280	2		699573**91223***
	320	2		699573**91224**
	400	2		699573**91225**

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

BEARTEX ROLLS

BEARTEX SLIT ROLLS

FEATURES	BENEFITS
■ High quality aluminium oxide or silicon carbide grain	■ Long product life
■ Uniform web construction	■ Controlled aggressiveness
■ Can be cut to exact sizes needed	■ Economical; minimal waste
■ Flexible for hand and machine use	■ Conforms to contours of work surface & provides a uniform finish
■ Non-loading	■ Continual supply of new cutting edges
■ Non-rusting	■ No contamination of the workpiece
■ Resilient construction	■ Long life ■ Waterproof & solvent resistant

BEARTEX SLIT ROLLS

DIM WxL	GRADE	CAP CODE	PK QTY	ART. NO.
100mmx10M	Medium A	F2300	2	63642557499
	Fine A	F2401	2	66261018300
	Very Fine A	F2520	2	63642557738
	Very Fine A Long Life	F2504	2	66261018301
	Micro Fine A	F2801	2	63642557500
	Ultra Fine S	F4804	2	63642557501
115mmx10M	Very Fine A	F2520	2	63642557739
	Very Fine A Long Life	F2504	2	63642587694
	Ultra Fine S	F4804	2	63642557503
120mmx10M	General Purpose	F2523	2	63642515571
125mm x10M	Medium A	F2300	2	63642557504
	Fine A	F2401	2	66261018307
	Very Fine A	F2520	2	63642557740
	Very Fine A Long Life	F2504	2	66261018308
	Micro Fine A	F2801	2	63642557505*
	Ultra Fine S	F4804	2	63642557506
150mmx10M	Medium A	F2300	2	63642557507
	Very Fine A	F2504	2	66261018312
	Ultra Fine S	F4804	2	63642557508*

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

jimi VELKOOBCHOD BRUSIVA

NORTON

SAINT-GOBAIN

200 SHEETS & HAND PADS

208 ABRASIVE SPONGES

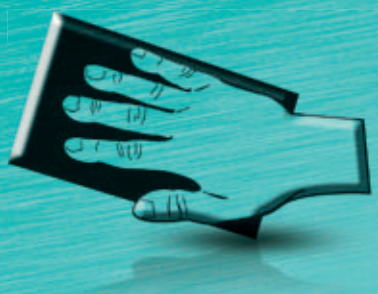
210 ROLLS

214 CLOTH ROLLS

216 HANDY ROLLS

218 ROTOLO FOAM ROLLS

220 BEARTEX ROLLS



JIMI VELKOOBCHOD BRUSIVA

SHEETS & HAND PADS

Norton offers a wide range of paper, cloth & waterproof sheets for use in all commonly encountered industrial applications.

APPLICATIONS & MARKETS

- Metal sanding
- Bare wood sanding
- Sanding between coats
- Scale & rust removal
- Scouring & light deburring

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Metal		R222/T417/T402	R202/T489	
Wood	Paper	H835	A275	A213
	Cloth	R222	R202	
Primer/Paint/Varnish	Wet Sanding - Waterproof	T417/T401	T489	T221
	Dry Sanding - No-Fil	A275		

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
Metal	F2302	F2504	F4300/F4804
Wood	F2504		F4804
Primer/Paint/Varnish		F2504	F4807/F2802

jimi VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

BEARTEX PAD PRODUCT SELECTION

CAP CODE	OLD REF	GRADE	MINERAL	TARGET SUBSTRATE	APPLICATION	FEATURES / BENEFITS
HAND PADS (IN ORDER OF DECREASING AGGRESSIVENESS)						
F2302	D305	Extra Cut	Aluminium Oxide	Stainless Steel	▪ Rust Removal ▪ Blending ▪ Deburring ▪ Bluing removal	▪ Aggressive & Durable ▪ Long life ▪ Ideal replacement for coated abrasive steel wool & wire brushes
F2300	D155	Medium	Aluminium Oxide	Metals & ceramics	▪ Cleaning, Deburring ▪ Rust removal ▪ Coating removal	▪ Strong & Open construction ▪ Resists loading ▪ Long life ▪ Ideal for achieving a matt satin finish
F2401	D97	Fine	Aluminium Oxide	Wood & plastics	▪ Cleaning & Intermediate finishing of ferrous & non-ferrous metals ▪ Defuzzing wood, denibbing laquers, paints & plastic	▪ Coarser & Stiffer than very fine ▪ Ideal for achieving a matt satin finish
F2520/ F2529	D915	Very Fine	Aluminium Oxide	General Purpose	▪ Rust removal ▪ Automotive primer keying, ▪ Defuzzing wood, denibbing plastic	▪ Conforms well to contoured surfaces ▪ Excellent finish on a wide variety of surfaces
F2504	D28	Very Fine (Long Life)	Aluminium Oxide	General Purpose	▪ Rust removal ▪ Automotive primer keying, ▪ Defuzzing wood, denibbing plastic, light sanding of old paint and new primers	▪ Moderate flexibility ▪ Fast initial cut ▪ Long life than standard products ▪ Gives no colour blend when used with solvents
F2510	D63	Gen.purpose Clean & Scour	Alumina Silicate	Metals & Plastics	▪ General Purpose Cleaning, Surface preperation prior to painting ▪ Removal of light stains & oxide marks on metal surfaces	▪ Low cost pad ▪ Gives good performance at an economical price
F4300	D125	Medium (SIC)	Silicon Carbide	Stainless Steel	▪ Satin finishing aluminium, cleaning glass moulds ▪ Grain finishing, removal of weld bluing on stainless steel	▪ Resiliant ▪ Conforms well to surface contours
F4804 / F4807/ F4605	D985 (D26)	Ultra Fine	Silicon Carbide	General Purpose	▪ Keying clear coat, finishing metal, deburring plastics, finishing aluminium ▪ Doors & window frames, blending paint, scuffing varnishes & keying acrylic coatings	▪ Can be used wet or dry with prepping compounds
F2801/ F2829	D995	Micro Fine	Calcined Alumina	Precious Metals, Varnished Wood, Car Body Work	▪ Keying clear coat ▪ Polishing	▪ Produces an extremely high quality surface finish ▪ Ideal for cleaning precious metals and finishing varnished wood
F0001	D84	White Cleaning	None	All substrates	▪ Light cleaning, polishing, ▪ Rubbing down primer & highlighting wood	▪ Highly Conformable ▪ Tear resistant ▪ Ideal for use with liquid detergent

VELKOOBCHOD BRUSIVA

SHEETS & HAND PADS

BEST

H835 BLUE FIRE®

FERR. & NON FERR.

PAINT/ VARN. & HARD WOOD

FEATURES	BENEFITS
■ Latest Norzon® grain design	■ Self-sharpening grain ■ Improved cut rate ■ Extended product life
■ High strength paper backing (E-weight)	■ Reduces curling & edge chipping ■ Tear resistant
■ Open grain distribution	■ Prevents premature clogging
■ Full resin bond system	■ Strong grain adhesion
■ Available in grits 60 and 80	

T401/T417 BLACK ICE®

FERR.

PAINT/ VARN.

FEATURES	BENEFITS
■ Premium, ultra fine silicon carbide abrasive	■ Best finish in wet clear-coat repair applications
■ Advanced resin bond system	■ Waterproof ■ Longer life in wet applications
■ Advanced, A-weight waterproof paper backing design	■ Ultimate flexibility & waterproof performance

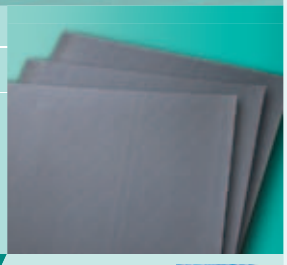
jimi VELKOOBCHOD BRUSIVA

BETTER

T489

FERR. PAINT/VARN.

FEATURES	BENEFITS
■ Silicon carbide abrasive	■ Advanced product
■ Waterproof paper backing	■ Flexible



A275 NORTON PRO

NON FERR. PAINT/VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Premium heat-treated aluminium oxide abrasive blend	■ Long lasting, fast cut rate
■ Fibre-reinforced latex, B-weight paper	■ Tear resistant ■ Can be used wet ■ Suitable for use on primer, paint filler & coating sanding (for automotive & transport applications)
■ Water based No-Fil® anti-loading third layer	■ Good finish ■ Resists loading & extends life ■ Can be used for composite & gel coat sanding (for marine market, etc.)
■ No pigments in No-Fil® or bonding system	■ No risk of colour transfer ■ Ideal for wooden furniture preparation

R222

FERR. & NON FERR. PAINT/VARN. HARD WOOD &SOFT WOOD

FEATURES	BENEFITS
■ Aluminium oxide abrasive	
■ J-weight cloth backing	■ Flexible product

R202

FERR. & NON FERR. PAINT/VARN. HARD WOOD &SOFT WOOD

FEATURES	BENEFITS
■ Aluminium oxide abrasive	■ Waterproof
■ Flexible J-weight cotton	■ Polyvalent product

VELKOOBCHOD BRUSIVA

GOOD

A213

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Aluminium oxide abrasive	■ Aggressive cutting action for all dry sanding applications
■ C-weight paper backing	■ Designed for heavy & light duty hand sanding

T221

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Aluminium Oxide ■ Waterproof paper backing	■ Multi-purpose product

WATERPROOF SHEETS

DIM WxL(mm)	GRIT	PK QTY	BLACKICE BEST T401/T417	BETTER T489	GOOD T221
230x280	60	50		63642532956	
	80	50	66261021180	63642532988	
	100	50		63642532989	
	120	50	66261021183	63642532990	
	150	50		63642532991	
	180	50	66261021185	63642532957	63642536402
	220	50	66261021186	63642532992	63642536401
	240	50	66261021187	63642532993	63642536400
	280	50	66261021188	63642532994	63642536399
	320	50	66261021189	63642532995	63642535049
	360	50	66261021190	63642532996	63642534013
	400	50	66261021191	63642532997	63642536397
	500	50	66261021192	63642532998	63642536403
	600	50	66261021193	63642532999	63642536396
	800	50	66261021195	63642533000	63642536414
	1000	50	66261021196	63642533001	63642561379
	1200	50	66261021197	63642533002	63642536578
	1500	50	63642534713		
	2000	50	63642534719		
	2500	50	63642565497		

VELKOOBCHOD BRUSIVA

PAPER SHEETS

DIM WxL(mm)	GRIT	PK QTY	BLUE FIRE BEST H835	NORTON PRO BETTER A275	GOOD A213
230x280	40	25			63642536385
	60	50	66261029949		63642536387
	80	50	66261029946		69957360388
	80	100		63642558015	
	100	100		63642585256	69957360389
	120	100		63642558016	69957360390
	150	100		63642586145	69957360391
	180	100		63642558017	63642531774
	220	100		63642586139	63642536411
	240	100		63642558018	69957360394
	280	100		63642585742	
	320	100		63642586132	69957360396
	360	100		63642586133	
	400	100		63642586134	63642539112
	500	100		63642586136	
	600	100		63642586137	
	800	100		63642586138	
	1000	100			
	1200	100			

CLOTH SHEETS

DIM WxL(mm)	GRIT SIZE	PK QTY	BETTER R222	BETTER R202
230x280	36	25	63642531775	
	40	25	63642531776	69957360506
	50	25	63642531777	
	60	25	63642531778	63642536405
	80	50	63642531779	63642536407
	100	50	63642531780	63642536408
	120	50	63642531781	63642536410
	150	50	63642531782	63642536413
	180	50	63642531783	63642531773
	220	50	63642531785	63642563323
	240	50	63642531786	
	280	50	63642531788	
	320	50	63642531789	
	400	50	63642531790	
	600	50	63642534613	

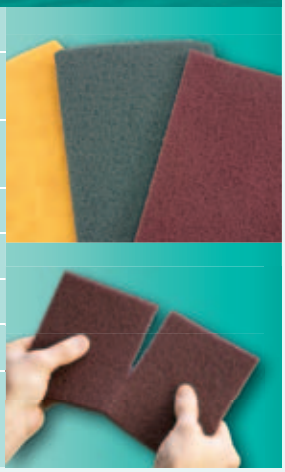
Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

BEARTEX SHEETS & HAND PADS

BEARTEX HAND PADS

FEATURES	BENEFITS
Flexible	Conforms to contours of work surface & provides a uniform finish
Gentle action	Easily removes burrs without affecting the dimension of the workpiece
Non-loading	Continual supply of new cutting edges
Non-rusting	No contamination of the workpiece
Resilient construction	Long life, waterproof & solvent resistant
Easy to cut to desired size	Can be folded to suit hand / shape
Perforated pads for clean and easy tearing also available	Perforations allow for smooth, shred free split to create 2 smaller easy to use 115mm x 150mm pads



HAND PADS

DIM WxH(mm)	GRADE	CAP CODE	PK QTY	*PERFOR. HAND PADS*	*HAND PADS*
150x230	Extra Cut A	F2302	40**		636425**57491**
	Medium A	F2300	60**		636425**57493**
	Fine A	F2401	60*		662610**18286**
	Very Fine A Long Life	F2504	60*	662610**18293**	
		F2504	60*		662610**18287**
	Gen. Purpose Clean & Scour A	F2510	60*		662610**18288**
	Medium S	F4300	60**		662610**39806**
	Ultra Fine S	F4807	60*	662610**18294**	
		F4804	60**		636425**57494**
	Micro Fine A	F2801	60**		636425**57277**
	White Cleaning (Non Abrasive)	F0001	60*		662610**18283**
230x280	Very Fine A Long Life	F2504	35		662610**18291**
	Ultra Fine S	F4807	35		662610**18292**

*Supplied in packs of 20 **Supplied in packs of 10

HAND PADS - THINFLEX

DIM WxH(mm)	GRADE	CAP CODE	PK QTY	ART. NO.
115x230	Very Fine A Long Life	F2543	4x25	636425**57495**
	Ultra Fine S	F4614	4x25	636425**57496**

Dimensions Key: DIM = Dimensions, W = Width, H = Height

jimi VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

ABRASIVE SPONGES

Abrasive sanding sponges are designed for use on a wide variety of materials including wood, paint and metal. Their flexible nature means they can be used on curved, contoured and flat surfaces.

APPLICATIONS & MARKETS

- Light stock removal
- Sanding contours & intricate shapes
- Finishing
- Removing minor defects
- Clear coat sanding
- Base coat sanding
- Scuffing primer
- Shaping filler

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
All Workpiece Materials	Rough	#60		
	Semi-finishing	#100		
	Finishing	#180		

BETTER

SPONGES

FERR. & NON FERR. | PAINT/ VARN. HARD WOOD &SOFT WOOD | GLASS

FEATURES	BENEFITS
Multi-purpose	Can be used wet or dry
Flexible	Conform to surface shapes & contours, providing a uniform finish Can reach areas inaccessible to sandpaper sheets
Washable	Can be reused, giving added product life

jimi VELKOOBCHOD BRUSIVA

SOFT-TOUCH CONTOUR PADS 1 SIDED

DIM LxWxH(mm)	GRIT	FINISH GENERATED*	PK QTY	BETTER
140x115x6	60	180/120	20	636425**50599**
	100	400/320	20	636425**50601**
	180	600/500	20	636425**50602**
	220	1000/800	20	636425**50603**
	280	1500/1200	20	636425**50604**

*Generates a finer finish than conventional coated abrasive products

FLEXIBLE FINISHING PADS 2 SIDED

DIM LxWxH(mm)	GRIT	PK QTY	BETTER
123x98x12,5	60	60	07660**717578**
	60	250	07660**719341**
	100	60	07660**705187**
	100	250	07660**719342**
	180	60	07660**705188**
	180	250	07660**719343**

FLEXIBLE SANDING SPONGES 4 SIDED

DIM LxWxH(mm)	GRIT	PK QTY	BETTER
100x66x26	60	60	07660**717579**
	60	250	07660**719344***
	100	60	07660**705189**
	100	250	07660**719345**
	180	60	07660**705190**
	180	250	07660**719346**

* Made-to-order

Dimensions Key: DIM = Dimensions, L = Length, W = Width, H = Height

Jimi VELKOOBCHOD BRUSIVA

ROLLS

Coated abrasive rolls are ideal for fast easy sanding of various materials. They can be torn to exact lengths as needed.

APPLICATIONS & MARKETS

- Light deburring
- Removing rust & scale
- Sanding & polishing
- Bare wood sanding
- Hand sanding
- Machine sanding on eccentric sanders
- Paint & plaster sanding
- Floor sanding

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Metal	R309	R222	R212
Wood	H231	A275	G131
Primer/Paint/Varnish		A275	
MATERIALS / APPLICATIONS	**DEBURRING**	**CLEANING**	**BLEND/FINISH**
Metal	F2300	F2504/F2523	F4804
Wood	F2504		F4804
Primer/Paint/Varnish		F2504	F2801/F4804

jimi VELKOOBCHOD BRUSIVA

BEST

H231

FERR. & NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Very strong F-weight paper	■ Ideal for sanding flat wooden or painted surfaces
■ High performance aluminium oxide abrasive	■ Suitable for metal surface finishing
■ Open grain distribution	■ Reduces clogging
■ Anti-static properties	■ Helps minimise dust when used with an appropriate extraction system

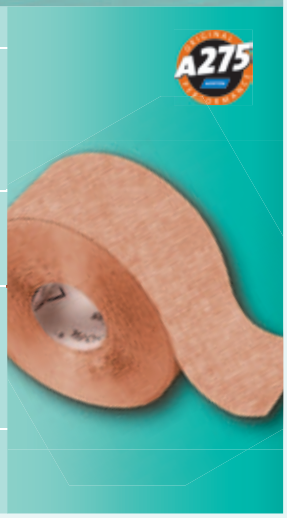
BETTER

A275 NORTON PRO

NORTON PRO

NON FERR. | PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Fibre-reinforced latex, B-weight paper	■ Tear resistant ■ Can be used wet ■ Suitable for use on primer, paint filler & coating sanding (for automotive & transport applications)
■ Premium heat-treated aluminium oxide abrasive blend	■ Long lasting, fast cut rate
■ Water based No-Fil® anti-loading third layer	■ Good finish ■ Resists loading & extends life ■ Can be used for composite & gel coat sanding (for marine market, etc.)
■ No pigments in No-Fil® or bonding system	■ No risk of colour transfer ■ Wooden furniture preparation



GOOD

G131

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ E-weight backing	■ Economy product for sanding wood, paint & plaster
■ Aluminium oxide abrasive	■ Good performance

JMI VELKOOBCHOD BRUSIVA

PAPER & NORGRIP ROLLS

PAPER ROLLS

DIM WxL	GRIT	PK QTY	BEST H231	NORTON PRO BETTER A275	GOOD G131
70mmx50M	120	2		6995738**0784**	
	150	2		6995738**0785**	
	180	2		6995738**0788**	
	220	2		6995738**0790**	
	240	2		6995738**0792**	
	320	2		6995738**0795**	
	400	2		6995738**0797**	
	500	2		6995739**6694***	
93mmx50M	40	2			662610**20827**
	60	2			662610**20828**
	80	2			662610**20829**
	100	2			662610**20830**
	120	2			662610**20831**
100mmx50M	40	2			662610**20775**
	60	2	6995736**1732**		662610**20817**
	80	2	6995736**1771**	6364259**1122**	662610**20818**
	100	2	6364253**6968**		662610**20819**
	120	2	6364253**7413**	6364259**1123**	662610**20820**
	150	2		6995739**1073**	
	180	2		6364259**1124**	
	220	2		6364259**0924**	
	240	2		6364259**0927**	
	280	2		6364259**1648**	
	320	2		6364259**1649**	
	400	2		6995739**1077**	
	500	2		6995739**6695***	
115mmx25M	40	2			6995739**1083**
	60	2			6995739**1087**
	80	2			6995739**1093**
115mmx50M	40	2			662610**20832**
	60	2			636425**28366**
	80	2			662610**20766**
	100	2			662610**20833**
	120	2		6995738**0761**	662610**20825**
	150	2		6995738**0765**	
	180	2		6995738**0767**	662610**20861**
	220	2		6995738**0769**	662610**20849**
	240	2		6995738**0777**	
	280	2		6995738**0778**	
	320	2		6995738**0779**	
	400	2		6995738**0781**	
	500	2		6995739**6696**	

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

PAPER ROLLS (CONTINUED)

DIM WxL	GRIT	PK QTY	BEST H231	BETTER A275	GOOD G131
120mmx50M	40	2			66261**020822**
	60	2	63642**539189**		66261**020823**
	80	2	63642**539187**		66261**020834**
	100	2	63642**539185**		66261**020821**
	120	2	63642**539183**		66261**020824**
	150	2	63642**539181**		
	180	2	63642**546049**		66261**020865**
150mmx50M	60	1	63642**546050**		
	80	1	69957**361785**		
	100	1	63642**546054**		
	120	1	69957**361838**		
	150	1	63642**546058**		

NORGRIP® ROLLS

DIM WxL	GRIT	PK QTY	BEST H231	BETTER A275
75mmx25M	40	2	699573**91104***	
	60	2	699573**91106***	
	80	2	699573**91112***	
	120	2		699573**91149**
	150	2		699573**91151***
	180	2		699573**91152**
	220	2		699573**91153***
	240	2		699573**91155**
	280	2		699573**91156**
	320	2		699573**91157**
	400	2		699573**91159**
115mmx25M	40	2	699573**91121**	
	60	2	699573**91123**	
	80	2	699573**91133**	
	120	2		699573**91218**
	150	2		699573**91219**
	180	2		699573**91220**
	220	2		699573**91221**
	240	2		699573**91222**
	280	2		699573**91223***
	320	2		699573**91224**
	400	2		699573**91225**

* Made-to-order

VELKOOBCHOD BRUSIVA

CLOTH ROLLS

BETTER

R309

FERR. & NON FERR. | HARD WOOD

FEATURES	BENEFITS
Super flexible cotton cloth	Ideal for contour & profile sanding
Premium aluminium oxide abrasive	Long life in wood & metal applications
Semi-open grain distribution	For reduced clogging in wood applications

R222

FERR. & NON FERR. | PAINT/ VARN. HARD WOOD &SOFT WOOD

FEATURES	BENEFITS
J-weight cotton cloth	Flexible product
Aluminium oxide abrasive	General purpose product for hand sanding of wood & metal

R202

FERR. & NON FERR. | HARD WOOD &SOFT WOOD

FEATURES	BENEFITS
Flexible J-weight cotton	Flexible & tear resistant
Aluminium oxide abrasive	Ideal for manual sanding

jimi VELKOOBCHOD BRUSIVA

CLOTH ROLLS

DIM WxL	GRIT	PK QTY	BETTER		
			R309	R222	R202
50mmx50M	40	5		63642**512909**	
	60	5		63642**540086**	
	80	5		63642**539135**	
	100	5		63642**539136**	
	120	5		63642**559727**	
	150	5		63642**539208**	
	180	5		63642**539137**	
	220	5		63642**512916**	
	240	5		63642**512917**	
	320	5		63642**512918**	
	400	5		63642**512919**	
100mmx50M	36	1		63642**536826***	
	40	1		63642**536559**	
	50	1		63642**540090**	
	60	1	699573**85334**	63642**560979**	
	80	1	63642**55261**	63642**531852**	63642**546066**
	100	1	699573**85335**	63642**531854**	63642**546067**
	120	1	699573**85336**	63642**531855**	63642**546068**
	150	1	699573**84617**	63642**545861**	63642**546069**
	180	1	699573**85337**	63642**531856**	
	240	1		63642**531857**	
	320	1		63642**545865**	
	400	1		63642**545867**	
118mmx50M	60	1			63642**536712**
	80	1			63642**536713**
	100	1			63642**546337**
	120	1			63642**546338**
	150	1			63642**546339**
	180	1			63642**539178**
120mmx50M	60	1	699573**85339**		
	80	1	63642**55659**		
	100	1	699573**85340**		
	120	1	63642**55601**		
	150	1	699573**85341**		
	180	1	699573**88153**		
430mmx50M	50	1		63642**539141**	
	60	1		63642**539142**	
	80	1		63642**539143**	
	100	1		63642**539144**	
	120	1		63642**539145**	
	150	1		63642**539146**	
	180	1		63642**539147**	
	240	1		63642**539148**	

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

HANDY ROLLS

BETTER

HANDY ROLLS R222

FERR. & NON FERR. | HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ J-weight cloth backing	■ Ideal for sanding profiled surfaces & round steel parts ■ Can be torn into strips
■ Aluminium oxide abrasive	■ For general purpose maintenance applications ■ Ideal for deburring & derusting metal
■ Dispenser unit	■ For easy storage ■ Protects product ■ Eliminates waste

GOOD

HANDY ROLLS R212

FERR. & NON FERR.

FEATURES	BENEFITS
■ J-weight cloth backing	■ Flexible product
■ Aluminium oxide abrasive	■ For general purpose maintenance applications
■ Dispenser unit	■ For easy storage ■ Protects product ■ Eliminates waste

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
General Purpose (metal, wood, etc.)	R222	R202	R212

SPEC CHECK

- R222 handy rolls are designed for manual applicati
  The high flexibility of the cloth in combination with
  wide grit range, from coarse to fine, provides an ex
  tool for a variety of applications including deburrin
  rust removal & finishing metal
- Handy rolls are packaged in a protective, convenien
  dispenser which eliminates costly waste & permits
  neat, easy storage

Jmi VELKOOBCHOD BRUSIVA

HANDY ROLLS

DIM WxL	GRIT	PK QTY	BETTER R222	GOOD R212
25mmx25M	40	1	63642531849	
	50	1	63642531850	
	60	1	63642531823	69957351243*
	80	1	63642531820	69957351244*
	100	1	63642531815	69957351246*
	120	1	63642531811	69957351247*
	150	1	63642531808	69957351248*
	180	1	63642531805	69957351249*
	220	1	63642531802	69957351250*
	240	1	63642531799	69957351251*
	280	1	63642540084	
	320	1	63642531796	69957351252*
	400	1	63642531793	69957351253*
	600	1	63642560206	
38mmx25M	36	1	63642536432	
	40	1	63642531828	
	50	1	63642531826	
	60	1	63642531824	69957350654
	80	1	63642531821	69957350657
	100	1	63642531817	69957350658
	120	1	63642531812	69957350659
	150	1	63642531809	69957350660
	180	1	63642531806	69957350661
	220	1	63642531803	69957350662
	240	1	63642531800	69957350663
	280	1	63642536425	
	320	1	63642531797	69957350664
	400	1	63642531794	69957350665
	600	1	63642539150	
50mmx25M	40	1	63642531829	
	50	1	63642531827	
	60	1	63642531825	69957351254
	80	1	63642534758	69957351255
	100	1	63642531818	69957351256
	120	1	63642531814	69957351259
	150	1	63642531810	69957351260*
	180	1	63642531807	69957351265
	220	1	63642531804	69957351266*
	240	1	63642531801	69957351267
	280	1	63642536426	
	320	1	63642531798	69957351270*
	400	1	63642531795	69957351272
	600	1	63642534757	

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

ROTOLO FOAM ROLLS

BETTER

ROTOLO FOAM® ROLLS A275

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ A275 Norton Pro premium abrasive paper	■ Excellent for fine sanding with high finishing level
■ Special No-Fil® coating	■ Reduces clogging
■ Flexible foam backing	■ Ideal for use on round edges, contours & curves without breaking through the paint surface. Easy gripping
■ Water-resistant	■ Washable
■ 25m long roll of pre-cut sheets	■ Easy to use & economical ■ New Easy cut upgraded
■ Packed in innovative dispenser box	■ Easy to handle, protected against dust

GOOD

A296 GOLD RESERVE SOFT-TOUCH®

NEW!

FERR. & NON FERR.

PAINT/ VARN. &HARD WOOD

FEATURES	BENEFITS
■ "P" graded premium aluminium oxide grain	■ Produces a quick, cool cut ■ Produces a more consistent scratch pattern
■ Strong B weight latex/paper backing	■ Resists tearing ■ Conformable and flexible
■ Water-based, non-loading stearate	■ Resists loading ■ Increases productivity

PRODUCT SELECTION

APPLICATION	GRIT	COLOUR
ROTOLO® FOAM ROLLS		
Sanding of body filler	120	Apple Green
	150	Orange
	180	Purple
Sanding of finishing filler	220	Red
	240	Electric Blue
Sanding cataphoretic coats & primer	280	Grey
	320	Salmon
Sanding polyurethane primer	360	Pink
	400	Yellow
	500	Dark Blue
	600	Fuchsia
Cutting back lacquer before a flush joint	800	Turquoise
Retouching clear coat	1000	White
Before polishing & buffing	1500	Green

VELKOOBCHOD BRUSH

ROTOLO® FOAM ROLLS

DIM WxL	GRIT	PK QTY	COLOUR	NORTON PRO BETTER A275	GOLD RESERVE NEW! GOOD A296
115mmx25M	120	2	Apple Green	63642535316	
	150	2	Orange	63642557584	
	180	2	Purple	63642557599	
	220	2	Red	63642557600	
	240	2	Electric Blue	63642557602	
	240	2	White		66261097596
	280	2	Grey	63642557604	
	280	2	White		66261097597
	320	2	Salmon	63642557606	
	320	2	White		66261097598
	360	2	Pink	63642557607	
	400	2	Yellow	63642557608	
	400	2	White		66261097599
	500	2	Dark Blue	63642557611	
	500	2	White		66261097600
	600	2	Fuchsia	63642557612	
	600	2	White		66261097601
	800	2	Turquoise	63642557613	
	800	2	White		66261097602
	1000	2	White	63642557616	
	1500	2	Green	63642557617	

SPEC CHECK

- Rotolo® Foam pre-cut sheets, conveniently packaged in a roll form, are ideal for fine sanding on round edges, contours & curves, providing an outstanding finish on primers & top coats. The secret of Rotolo® Foam lies in the combination of Norton Pro A275 sanding paper & the special foam backing
- To ease product recognition, box labels are colour-coded to a specific grit size. The colour-coding follows the Norton Pro grit colour-coding system

Dimensions Key: DIM = Dimensions, W = Width, L = Length

Jimi VELKOOBCHOD BRUSIVA

BEARTEX SLIT ROLLS

FEATURES	BENEFITS
■ High quality aluminium oxide or silicon carbide grain	■ Long product life
■ Uniform web construction	■ Controlled aggressiveness
■ Can be cut to exact sizes needed	■ Economical; minimal waste
■ Flexible for hand and machine use	■ Conforms to contours of work surface & provides a uniform finish
■ Non-loading	■ Continual supply of new cutting edges
■ Non-rusting	■ No contamination of the workpiece
■ Resilient construction	■ Long life ■ Waterproof & solvent resistant

BEARTEX SLIT ROLLS

DIM WxL	GRADE	CAP CODE	PK QTY	ART. NO.
100mmx10M	Medium A	F2300	2	63642557499
	Fine A	F2401	2	66261018300
	Very Fine A	F2520	2	63642557738
	Very Fine A Long Life	F2504	2	66261018301
	Micro Fine A	F2801	2	63642557500
	Ultra Fine S	F4804	2	63642557501
115mmx10M	Very Fine A	F2520	2	63642557739
	Very Fine A Long Life	F2504	2	63642587694
	Ultra Fine S	F4804	2	63642557503
120mmx10M	General Purpose	F2523	2	63642515571
125mm x10M	Medium A	F2300	2	63642557504
	Fine A	F2401	2	66261018307
	Very Fine A	F2520	2	63642557740
	Very Fine A Long Life	F2504	2	66261018308
	Micro Fine A	F2801	2	63642557505*
	Ultra Fine S	F4804	2	63642557506
150mmx10M	Medium A	F2300	2	63642557507
	Very Fine A	F2504	2	66261018312
	Ultra Fine S	F4804	2	63642557508*

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

Dimensions Key: DIM = Dimensions, W = Width, H = Height

NORTON
SAINT-GOBAIN

Coated & BearTex

222 FILE BELTS

File Belt Machine

FILE BELTS

Norton offers a range of file belts designed to perform on intricate shapes and contours.

APPLICATIONS & MARKETS

- Light deburring & blending
- Spot repairs
- General clean-up & finishing

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	R929		
Carbon Steel/Weld/Ferrous metal	R929		
Non-Ferrous Metal/Brass/Aluminium	R929		
Wood		R230	
Stone		R427	
Glass		R427	

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal	S2218	S2318	S2318

INNOVATION BEST

R929 SG®

SG

FERR. & NON FERR.

FEATURES

- X-weight polyester cloth
- Premium SG® abrasive
- High content of active filler

BENEFITS

- Extremely durable even on aggressive applications
- Excellent at low & medium pressure
- Cool cut
- Ideal for heat sensitive metals

mi VELKOOBCHOD BRUSIVA

GOOD

R230

FERR. & NON FERR. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
X-weight cotton cloth	Multi-purpose product for metal & wood
Aluminium oxide abrasive	Good cutting rate
Open grain distribution	Reduced clogging

R427

NON FERR. GLASS STONE

FEATURES	BENEFITS
X-weight cotton cloth	For dry grinding of glass & stone
Silicon carbide abrasive	

JIM VELKOOBCHOD BRUSIVA

FILE BELTS

DIM WxL(mm)	GRIT	PK QTY	SG INNOVATION BEST	NORZON GOOD	
			R929	R230	R427
10x330	40	50	6625448**1835**		
	50	50	6626102**3613**		
	60	50	6625448**1836**		
	80	50	6626102**3614**		
	120	50	6626102**3615**		
13x305	60	50	6626102**3616**		
	80	50	6626102**3617**		
	120	50	6626102**3618**		
13x454	40	50		6364253**9671**	
	60	50		6364253**9672**	
	80	50		6364255**3323**	
	100	50		6364253**9674**	
	120	50		6364255**3324**	
13x457	40	50	6995735**0639**		
	60	50	6995735**0640**		
	80	50	6995735**0642**		
	120	50	6995735**0643**		
13x610	60	50	6995735**0646**		
	80	50	6995735**0647**		
	120	50	6995735**0648**		
15x330	40	50	6625448**1832**		
	60	50	6625448**1833**		
	80	50	6625448**1834**		
	120	50	6625448**1853**		
15x475	50	50	6626104**6549**		
	60	50	6625448**1837**		
	80	50	6625448**1838**		
16x480	50	50	6626102**3641***		
	80	50	6626102**4190***		
19x457	80	50	6625448**1839**		
	120	50	6625448**1840**		
20x480	40	50	6995735**0650**		
	60	50	6995735**0651**		
	80	50	6995735**0652**		
	120	50	6995735**0653**		
20x520	50	50	6626102**3643**		
	80	50	6626102**3645**		
	120	50	6626102**3651**		
30x533	40	20		6364254**6483**	
	60	20	6625448**1841**	6364254**6477**	6364253**8954**
	80	20	6625448**1842**	6364254**6478**	6364254**5903**
	120	20	6625448**1843**		6364253**8955**
	180	20			6364253**8957**
30x540	50	20	6626102**3658**		
	80	20	6626102**3659**		
	120	20	6626102**3660**		

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

BEARTEX SURFACE BLENDING FILE BELTS

FEATURES	BENEFITS
■ Durable fibre construction	■ Long lasting
■ Very sharp abrasive grain	■ High, continuous cut rate
■ Flexible backing	■ Excellent performance on hard materials (steels, nickel, alloys etc.)
■ Highly resistant to clogging & loading	■ Controlled Cut ■ Gives a consistent finish
■ Various sizes available	■ Ideal for belt file machines or backstand linishers
■ User friendly	■ Reduced risk of workpiece damage

DSJ/DSX SURFACE BLENDING BELTS

DIM WxL(mm)	CAP CODE	GRADE	TYPE	PK QTY	ART. NO.
13x305	S2213	A Coarse	DSJ	10	662611**98671***
	S2313	A Medium	DSJ	10	662610**16180***
	S2513	A Very Fine	DSJ	10	662611**98642***
13x457	S2218	A Coarse	DSX	10	662610**54219**
	S2318	A Medium	DSX	10	662610**54250**
	S2518	A Very Fine	DSX	10	662610**54286**
13x520	S2313	A Medium	DSJ	10	662611**98659***
13x610	S2218	A Coarse	DSX	10	662610**54220**
	S2318	A Medium	DSX	10	662610**54251**
	S2518	A Very Fine	DSX	10	662610**54287**
20x457	S2218	A Coarse	DSX	20	662610**54222***
20x520	S2313	A Medium	DSJ	10	662611**98660***
25x610	S2213	A Coarse	DSJ	10	662611**98667***
	S2313	A Medium	DSJ	10	662611**98662***
	S2513	A Very Fine	DSJ	10	662611**98649***
30x533	S2213	A Coarse	DSJ	10	636425**93016**
	S2313	A Medium	DSJ	10	662611**98664**
	S2513	A Very Fine	DSJ	10	699573**87893**

More sizes available on a Made-To-Order basis.

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

Portable Belt Sander

PORTABLE BELTS

Norton offers portable belts in a variety of sizes, designed to fit the most common types of machine. Portable belts are designed for all metal and wood working applications.

All Norton belts are supplied with butt joints for easy mounting and smoother work.

APPLICATIONS & MARKETS

- Surface grinding & finishing of all metals
- Blending welds
- Sanding & finishing wood
- Floor sanding

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Wood		R230	
Stone		W445/R427	
Glass		W445/R427	

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal	S2216/S2211	S2316	S2516

BETTER

W445

GLASS

FEATURES

- Polyester cloth
- Cork grain

BENEFITS

- To be used wet or dry
- Ideal for final finishing of glass edges

Jimi VELKOOBCHOD BRUSIVA

GOOD

R427

NON FERR. | STONE | GLASS

FEATURES	BENEFITS
X-weight cotton cloth	Can be used for dry applications only
Silicon carbide abrasive	Ideal for grinding glass & stone

R230

NON FERR. | HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Strong cloth backing	Multi-purpose product ideal for sanding wood & grinding metal
Aluminium oxide abrasive	Good cutting rate
Open grain distribution	Reduced clogging on loading material such as wood & aluminium

PORTABLE BELTS

DIM WxL(mm)	GRIT	PK QTY	BETTER	GOOD	
			W445	R427	R230
75x457	40	20			63642538877
	60	20			63642539426
	80	20			63642539422
	120	20			63642539415
75x533	36	20			63642546461
	40	20			63642546289
	50	20			63642546278
	60	20			63642546257
	80	20			63642534248
	100	20			63642546273
	120	20			63642530701
75x604	60	20		63642539437	
	80	20		63642539436	
	120	20		63642539434	
	180	20		63642545905	
	320	20		63642539433	
	CORK	20	63642539439		

Dimensions Key: DIM = Dimensions, W = Width, L = Length

PORTABLE BELTS (CONTINUED)

DIM WxL(mm)	GRIT	PK QTY	BETTER	GOOD	
			W445	R427	R230
75x610	40	20			63642546472
	60	20			63642546473
	80	20			63642567329
	120	20			63642546476
100x560	40	20			63642546292
	60	20			63642546262
	80	20			63642546250
	100	20			63642549847
	120	20			63642546235
100x610	36	20			63642529801
	40	20			63642546295
	50	20			63642546283
	60	20			63642560145
	80	20			63642529798
	100	20			63642546242
	120	20			63642529797
	150	20			63642539412
100x620	40	20			63642546457
	50	20			63642546285
	60	20			63642534465
	80	20			63642529799
	100	20			63642534770
	120	20			63642546452
110x620	40	20			63642530702
	50	20			63642546288
	60	20			63642530700
	80	20			63642530699
	100	20			63642546245
	120	20			63642546238
100x690	40	20			63642537627
	60	20			63642537544
	80	20			63642537546
	100	20			63642537548
	120	20			63642537632
100x915	40	20			63642545871
	60	20			63642545873
	80	20			63642545875
	120	20			63642534768

SPEC CHECK

- All Norton belts are supplied with butt joints for easy mounting & smoother work

Dimensions Key: DIM = Dimensions, W = Width, L = Length

BEARTEX SURFACE BLENDING BELTS

FEATURES	BENEFITS
■ Durable fibre construction	■ Long lasting
■ Very sharp abrasive grain	■ High, continuous cut rate
■ Rigid, low stretch backing	■ Excellent performance on hard materials (steels, nickel, alloys etc.)
■ Highly resistant to clogging & loading	■ Controlled Cut ■ Gives a consistent finish
■ Various sizes available	■ Ideal for belt file machines or backstand linishers
■ User friendly	■ Reduced risk of workpiece damage

DSJ SURFACE BLENDING BELTS

DIM WxL(mm)	CAP CODE	GRADE	TYPE	PK QTY	ART. NO.
50x450	S2112	Extra Coarse	DSJ	10	662610**21114***
	S2213	A Coarse	DSJ	10	636425**94874***
	S2313	A Medium	DSJ	10	662610**21099***
	S2513	A Very Fine	DSJ	10	662611**98652***
50x800	S2313	A Medium	DSJ	10	662610**21101***

More sizes available on a Made-To-Order basis.

* Made-to-order

Jimi VELKOOBCHOD BRUSIVA

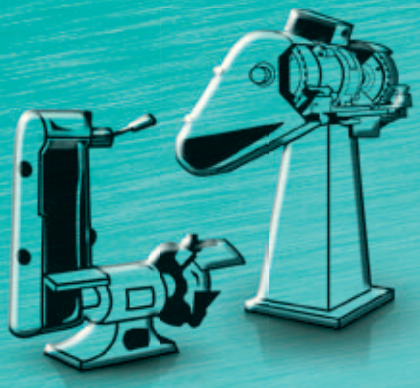
NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

Coated & BearTex

234 NARROW BELTS
243 SURFACE BLENDING BELTS



Backstand

NARROW BELTS

A wide selection of sizes and grits for most dimensioning, intermediate grinding and polishing applications.

APPLICATIONS & MARKETS

- Grinding & deburring
- Heavy stock removal
- Blending, dimensioning & shaping
- Finishing
- Polishing

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stainless Steel/Heat Sentitive Alloys	Stock Removal	R996*	R976*	R929
	Finishing	NORaX*		
Carbon Steel/Weld/Ferrous metal		R929	R822	R293/R265
Non-Ferrous Metal/Brass/Aluminium		R929	R822	R293/R265
Wood			H231/R309	

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal	S2216/S2211	S2316	S2516

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

Performs in the toughest environments

R996 belts are made-to-order

Please contact your local Sales or Customer Service Representative for more information

NORTON
SAINT-GOBAIN

VIKING

THE NEW GENERATION ABRASIVE TECHNOLOGY

VELKOOBCHOD BRUSIVA

NARROW BELTS FOR METAL

INNOVATION BEST

R996 VIKING

VIKING

FERR. & NON FERR.

FEATURES	BENEFITS
■ New generation SG® ceramic grain	■ Longer belt life ■ High stock removal
■ New formulation of Supersize layer	■ Advanced cooling system ■ Less off hand pressure required to cut ■ Reduced heat generation
■ High performance resin system	■ Maximum performance
■ YY polyester backing for coarse grits (36-50)	■ Fast and consistent cut rate
■ Available in grits 36, 40, 50, 60	■ Cost reduction per part

R976 RED-X

RED-X

FERR. & NON FERR.

FEATURES	BENEFITS
■ Strong polyester cloth	■ Excellent belt performance on medium to hard contact wheels
■ New friable ceramic SG® grain	■ Good consistent cut rate even at low and medium pressure
■ High performance phenolic resin	■ Low heat generation reduces risk of burn
■ Third layer: a new high performance formulation of supersize	■ Excellent on various material types; from Stainless Steel to Inconel to Titanium
■ Grit availability: 36 to 120	■ Reduce your cost per part

R929 SG®

SG

FERR. & NON FERR.

FEATURES	BENEFITS
■ Polyester cloth	■ Stiff backing for demanding operations
■ Premium SG® abrasive	■ Excellent cut rate at low & medium pressure
■ High content of active filler	■ Cooler cut

VELKOOBCHOD BRUSIVA

BETTER

R822 NORZON®

NORZON

FERR. & NON FERR.

FEATURES	BENEFITS
X-weight cotton cloth	Stiff backing for backstand grinding
NorZon® abrasive	Long lasting

GOOD

R293

FERR. & NON FERR. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Heavy polyester cloth	Good performance
Premium aluminium oxide	Improved grain adhesion For use on metal & wood edgings
Contains a small amount of SG® abrasive	For extended product life
Active filler	Improved life on metal applications

R265

FERR. & NON FERR.

FEATURES	BENEFITS
Heavy cotton cloth	For semi-finishing operations
Premium aluminium oxide abrasive	Standard general purpose cloth for metal application

Jimi VELKOOBCHOD BRUSIVA

NARROW BELTS FOR METAL

MADE-TO-ORDER CLOTH BELTS FOR METAL

DIM WxL(mm)	GRIT	PK QTY	VIKING INNOVATION BEST R996	RED-X R976
50x2000	36	10	66254403822*	66254402572*
	40	10	66254403847*	66254436882*
	60	10	66254411262*	66254401458*
	80	10		66254436883*
50x2500	36	10	66254403848*	66254410572*
	40	10	66254408229*	66261051186*
	60	10	66254416129*	66261063897*
	80	10		66254401374*
50x3500	36	10	66254404039*	66254409222*
	40	10	66254404041	66261071967
	60	10	66254436885	66261071965
	80	10	66254456931*	66254436884*
50x4000	36	10	66254404064*	66261055060*
	40	10	66254404065*	66261092227*
	60	10	66254405015*	66261054920*
	80	10		66254401290*
75x2000	36	10	66254410065*	66261059564*
	40	10	66254407955*	66261067686*
	60	10	66254407954*	66261060879*
	80	10		66254403117*
75x2500	36	10	66254403849*	66261066499*
	40	10	66254403887*	66254402279*
	60	10	66254403891*	66254433345*
	80	10		66254407537*
75x3500	36	10	66254408009*	66254403849*
	40	10	66254420733*	66254402318*
	60	10	66254436900*	66254436897*
	80	10		66254436898*

* Made-to-order

CLOTH BELTS FOR METAL

DIM WxL(mm)	GRIT	PK QTY	SG INNOVATION BEST R929	NORZON BETTER R822	GOOD R293 & R265
50x800	60	20	66261**023832**		
	80	20	66261**023833**		
	120	20	66261**023834**		
50x1500	60	10	66261**023839**		
	80	10	66261**023840**		
	120	10	66261**023842**		
50x1600	36	10	66261**023878***		
	40	10	66261**023879**		
	50	10	66261**023880**		
	60	10	66261**023881**		
	80	10	66261**023882**		
	120	10	66261**023883**		
50x2000	24	10			63642**548478***
	36	10	69957**350787**	63642**546222**	63642**546943**
	40	10	69957**350790**	63642**547270**	63642**551489**
	50	10	69957**350792**	63642**546218**	63642**551490**
	60	10	69957**350793**	63642**546210**	63642**546878**
	80	10	69957**350794**	63642**546212**	63642**539456****
	100	10			63642**539445****
	120	10	69957**350795**	63642**516010**	
	180	10			63642**539459*** **
	240	10			63642**539460****
50x2500	36	10			63642**540012**
	40	10			63642**540013***
	50	10			63642**540014**
	60	10			63642**540015**
	80	10			63642**547985**
75x1000	50	10	66261**023919**		
	60	10	66261**023920**		
	80	10	66261**023921**		
	120	10	66261**023922**		
75x2000	24	10		63642**539088**	
	36	10	69957**350796**	63642**539386**	63642**547942**
	40	10	69957**350797**	63642**539388**	63642**564728**
	50	10	69957**350798**	63642**538998**	63642**548110**
	60	10	69957**350799**	63642**539389**	63642**548528**
	80	10	69957**350800**	63642**538999**	63642**548275**
	100	10	66261**024222**		
	120	10	69957**350801**	63642**539002**	
	180	10			63642**545883*** **
	240	10			63642**520882****
75x2250	36	10	66261**023968**		
	40	10	66261**023969**		
	50	10	66261**023970**		
	60	10	66261**023971**		
	80	10	66261**023972**		

Dimensions Key: DIM = Dimensions, W = Width, L = Length

* Made-to-order
** R265 product

CLOTH BELTS FOR METAL (CONTINUED)

DIM WxL(mm)	GRIT	PK QTY	SG INNOVATION BEST R929	NORZON BETTER R822	GOOD R293 & R265
75x2500	36	10	6995735**0882**	6364254**6092**	6364254**6130**
	40	10	6995735**0883**	6364254**6094**	6364254**6874**
	50	10	6995735**0884***		
	60	10	6995735**0888**	6364254**6097**	6364255**1507**
	80	10	6995735**0898**	6364254**6099**	
	120	10	6626102**3977**	6364253**9026**	
75x3000	36	10		6364254**6224***	6364255**1509**
	40	10		6364254**6221***	
	50	10		6364254**6220***	
	60	10		6364253**9324***	6364254**6202**
	80	10		6364253**9320***	
100x920	36	10			6364255**1335**
	40	10		6364253**9330**	6364254**8306**
	50	10		6364253**9328**	
	60	10		6364254**6216**	6364254**8307**
	80	10		6364254**6214**	6364255**1544**
	100	10		6364253**9383**	6364255**1546**
	120	10			6364255**1547**
	180	10			6364255**1549**
100x1000	40	10	6995735**0903**	6364254**7284**	6364252**1817**
	50	10	6995735**0904***	6364253**8971**	
	60	10	6995735**0905**	6364253**8973**	6364255**1375**
	80	10	6995735**0906**	6364253**8975**	6364255**1553**
	100	10		6364253**8977**	
	120	10	6995735**0907**	6364253**6388**	
100x1500	50	10	6626102**3978**		
	80	10	6626102**3979**		
	120	10	6626102**3980**		
100x2000	36	10	6995735**0802**		
	40	10	6995735**0804**		
	60	10	6995735**0805**		
	80	10	6995735**0806**		
	120	10	6995735**0807**		
100x3000	40	10			6364255**1511**
	50	10			6364255**1512**
	60	10			6364254**8447**
150x2000	36	10	6995735**0809**	6364253**9008**	
	40	10	6995735**0812**	6364253**9010**	
	50	10	6626102**3983***		
	60	10	6995735**0813**	6364253**9014**	
	80	10	6995735**0815**	6364253**9016**	
150x2500	40	10	6626102**3984**		
	60	10	6626102**3992**		
	80	10	6626102**3993**		

* Made-to-order

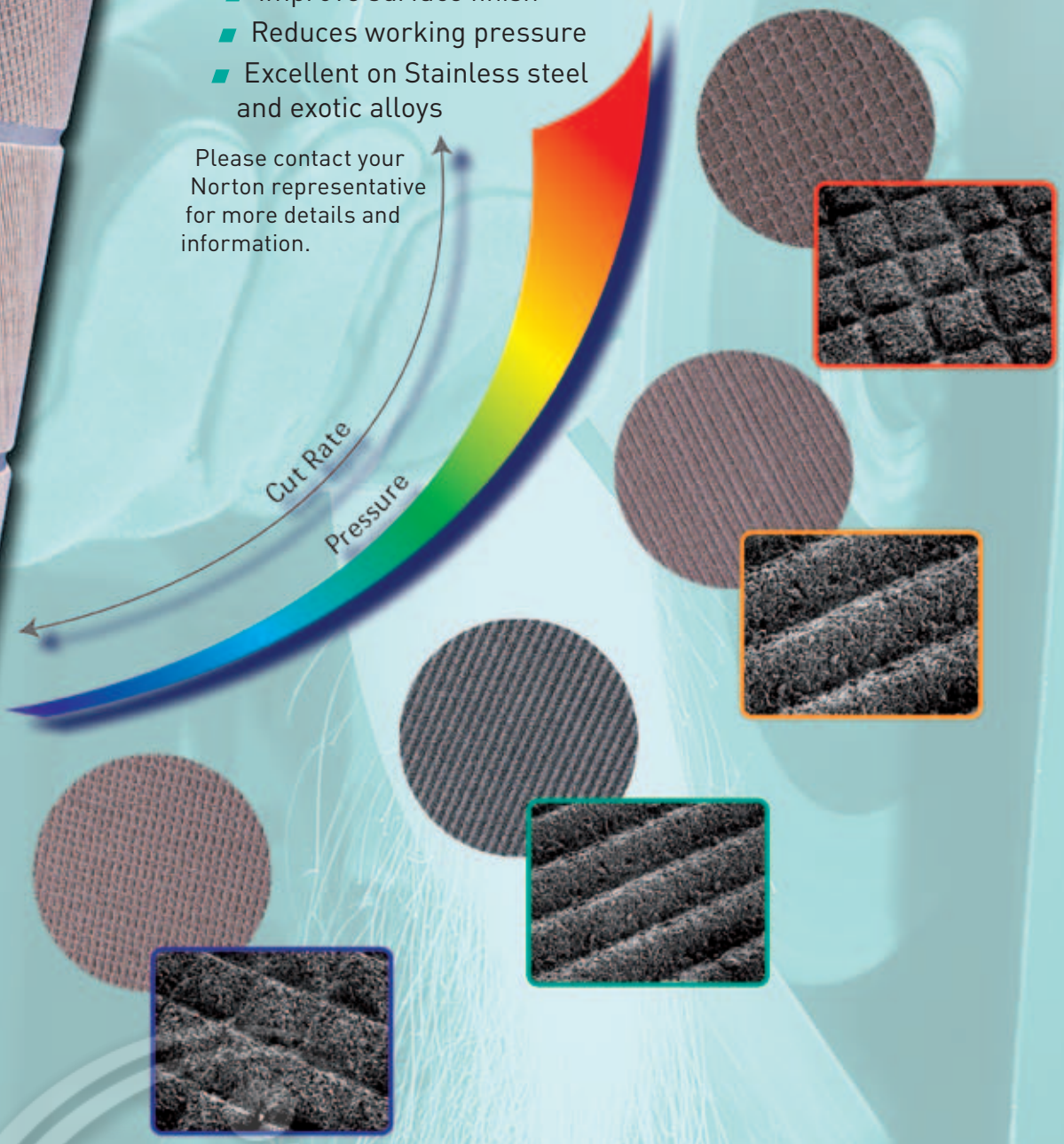
Dimensions Key: DIM = Dimensions, W = Width, L = Length

NORaX
ENGINEERED ABRASIVES

NORaX - a 3D multi-layer coated abrasive.

- Increase productivity by up to 5 times vs. conventional coated
- Increase belt life time
- Improve surface finish
- Reduces working pressure
- Excellent on Stainless steel and exotic alloys

Please contact your Norton representative for more details and information.



ENGINEERED ABRASIVES

VELKOOBCHOD BRUSIVA

NARROW BELTS FOR WOOD

BEST

H231

FERR. & NON FERR.

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Very strong, F-weight paper	■ High performance & easy to mount
■ High performance aluminium oxide abrasive	■ Ideal for roughing, intermediate sanding & finishing ■ Finer grits are ideal for polishing metal & plastic
■ Semi-open/open grain distribution	■ Resists clogging
■ Anti-static properties	■ Excellent surface quality ■ Less dust generated for an improved working environment

PAPER BELTS FOR WOOD

DIM WxL(mm)	GRIT	PK QTY	BEST H231
120x7000	60	10	6364253**9496**
	80	10	6364253**9497**
	100	10	6364253**9498**
	120	10	6364253**9499**
120x7100	60	10	6364253**9500**
	80	10	6364253**9501**
	100	10	6364253**9502**
	120	10	6364253**9503**
120x7200	60	10	6364253**9543**
	80	10	6364253**9544**
	100	10	6364253**9545**
	120	10	6364253**9546**
120x8000	60	10	6364253**9568**
	80	10	6364253**9567**
	100	10	6364253**9566**
	120	10	6364253**9565**

jimi VELKOOBCHOD BRUSIVA

SURFACE BLENDING BELTS

FEATURES	BENEFITS
■ Durable fibre construction	■ Long lasting
■ Very sharp abrasive grain	■ High, continuous cut rate
■ Rigid, low stretch backing	■ Excellent performance on hard materials (steels, nickel, alloys etc.)
■ Highly resistant to clogging & loading	■ Controlled Cut ■ Gives a consistent finish
■ Various sizes available	■ Ideal for belt file machines or backstand linishers
■ User friendly	■ Reduced risk of workpiece damage

PRODUCT SELECTION

WHICH GRIT SHOULD I CHOOSE?

GRADE	FEATURES & BENEFITS
Extra Coarse	Provides longest cutting life & highest aggressiveness to quickly achieve an even surface ready for finer finishing.
	Ideal for descaling & removing heavy rust & oxides, Ideal for deburring, aluminium & Excellent performance on hard materials
Coarse	Ideal where a less coarse finish or increased flexibility is required & an aggressive cut is necessary
	Removes 60-120 grit grindlines - for light deburring
Medium	Removes 120-180 grit grindlines - for cleaning & rust removal
Very Fine	Provides an excellent & uniform finish, ideal choice for fine finishing & pre-coat finishing
	Removes 180-320 grit grindlines - for finishing, polishing & paint preparation
Super Fine	The finest & most flexible surface conditioning for decorative finishes & excellent surfaces on soft & hard metals, ideal for pre-polishing

BEARTEX SURFACE BLENDING MATERIAL CHOICE

DSB	Coarse grade is excellent for initial aggressive cut for re-finishing work. (Made To Order)
Superflex	Offers the greatest degree of flexibility particularly for Contoured and Flat surfaces. Fast finish. (Made To Order)
DSJ (Low Stretch)	Ideal for long life + edge durability. Low stretch.
DSX	Extremely flexible material for small and file belts.

Dimensions Key: DIM = Dimensions, W = Width, L = Length

jmi VELKOOBCHOD BRUSIVA

SURFACE BLENDING BELTS

DSJ/DSX SURFACE BLENDING BELTS

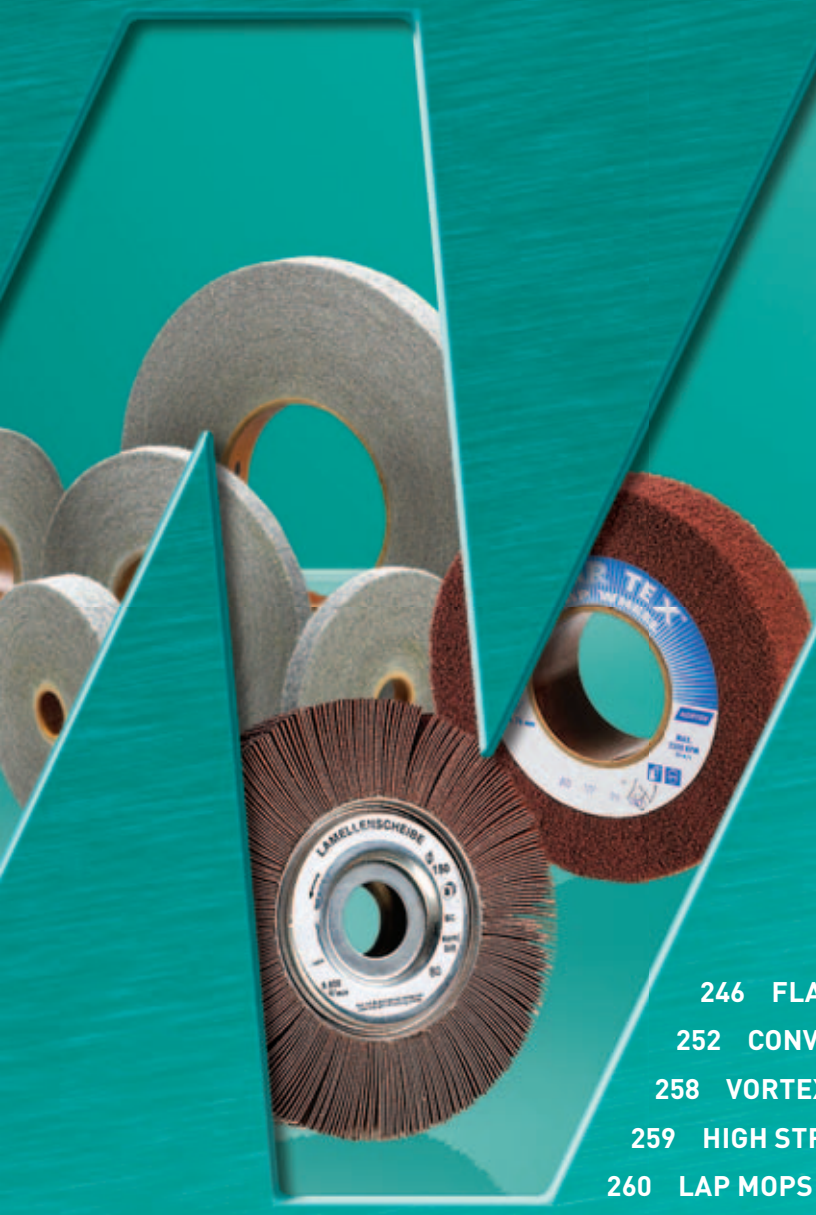
DIM WxL(mm)	CAP CODE	GRADE	TYPE	PK QTY	ART. NO.
50x1500	S2213	A Coarse	DSJ	10	662610**21111***
	S2313	A Medium	DSJ	10	662610**21112***
50x2000	S2213	A Coarse	DSJ	10	662610**21103***
	S2313	A Medium	DSJ	10	662610**21104**
	S2513	A Very Fine	DSJ	10	662610**21107**
50x2500	S2213	A Coarse	DSJ	10	662611**98669***
	S2313	A Medium	DSJ	10	662611**98666***
	S2513	A Very Fine	DSJ	10	662611**98653***
75x2000	S2213	A Coarse	DSJ	10	662610**21108**
	S2313	A Medium	DSJ	10	662610**21109**
	S2513	A Very Fine	DSJ	10	662610**21110**
75x3000	S2213	A Coarse	DSJ	10	662611**98670***
	S2313	A Medium	DSJ	10	662610**21113***
100x2500	S2513	A Very Fine	DSJ	5	662610**21115***
100x3500	S2313	A Medium	DSJ	5	662610**21116***

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN



246 FLANGE MOUNTED FLAP WHEELS
252 CONVOLUTE WHEELS
258 VORTEX CONVOLUTE
259 HIGH STRENGTH DISCS
260 LAP MOPS

Bench/Pede

FLANGE MOUNTED FLAP WHEELS

Designed to deliver a consistent finish with a uniform rate of cut, flap wheels have a continual rate of wear which exposes new abrasive. Their construction also makes them ideal for sanding contours and uneven surfaces.

APPLICATIONS & MARKETS

- Metal fabrication
- Blending welds
- Deburring
- Cleaning & finishing

GOOD

R207

FERR. & NON FERR.

FEATURES	BENEFITS
Aluminium oxide abrasive	Unique manufacture technique provides low dust generation
Highly resistant backing	Consistent cut rate with ability to leave a very good finish Good life & cut rate in comparison to competition

FLANGE MOUNTED MAXIMUM OPERATING SPEED

DIA(mm)	MAX RPM
100	8000
150	5800
165	5500
200	4500
250	3500
300	2800
350	2500
400	2200

Jimi VELKOOBCHOD BRUSIVA

FLANGE MOUNTED

DIM DIAxWxB (mm)	GRIT	PK QTY	GOOD R207
100x25x25	40	1	63642547168*
150x25x25	60	2	63642563719
	80	2	63642546728
	150	2	63642546746
150x50x25	60	1	63642546712
	80	1	63642546729
	100	1	63642546735
165x25x32	40	2	63642547170
	60	2	63642546711
	80	2	63642546730
	100	2	63642546736
	120	2	63642546742
	150	2	63642522957
165x50x32	50	1	63642546716
	60	1	63642561961
	80	1	63642546731
	120	1	63642546743
	150	1	63642545893*
200x25x35	60	2	63642547173
	80	2	63642547175
200x50x35	80	1	63642546732
	100	1	63642546738
250x50x35	80	1	63642546733
	100	1	63642546739*
	120	1	63642546745
	150	1	63642546753
	240	1	63642539771

Other sizes available upon request.

* Made-to-order

Alternative Bore Hole sizes upon request - please also see Accessories section for reduction bushings.

JIMI VELKOOBCHOD BRUSIVA

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, B = Bore

BEARTEX FLANGE MOUNTED FLAP WHEELS

Formed by mounting sheets of BearTex® around a centre core. The tight packed piece forms the spokes of a wheel. This construction makes Flap Wheels the most conformable of all BearTex® Wheel products... providing a cushioning action which is ideal for use on uneven or irregular surfaces, as well as flat areas.

APPLICATIONS & MARKETS

- Cleaning threaded parts
- Removing oxide from printed circuit boards
- De-glossing plastic parts
- Producing uniform finishes on aluminium, brass & stainless steel
- Can be used on automatic & robotic equipment

BEARTEX FLAP WHEELS

FEATURES	BENEFITS
■ Cushioning action	■ The most conformable of all BearTex® wheel products. Ideal for use on contoured surfaces & parts with awkward geometry
■ Constructed using layers of BearTex® with a smear resistant formula	■ Achieves a consistent & uniform finish with no risk of gouging
■ Available in a wide range of sizes & grades ■ Ventilated flap arrangement	■ Suitable for a wide range of applications including corrosion removal, cleaning & surface finishing ■ Smooth running vibration free product that gives a constant finish without smearing or component discolouration

jimi
VELKOOBCHOD BRUSIVA

BEARTEX FLAP WHEEL TYPES

2 types of Flap Wheel are available:

1) 100% Non Woven Flap Wheels (standard for stock)

2) Interleaved Flap wheels (Made to Order)

Both in variable sizes with widths from 10 to 2000mm.

Available in a wide range of abrasive types, grits and densities for Metal and Woodworking.

Interleaved Flap Wheels

Interleaved version gives the benefits of aggressiveness by alternatively arranging coated abrasive cloth with the finishing qualities of Non wovens.

They are soft and aggressive, creating a "firmer" wheel that provides a higher rate of cut.

The ratio of Cloth flaps to non woven flaps can be altered to suit particular applications.

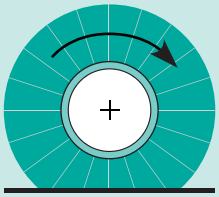
Ideal for deburring and grain finishing on stainless steel.

Available in both Spindle and Flange mounted versions.

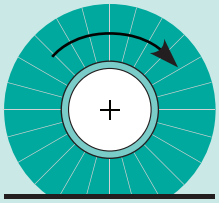
Flange mounted Interleaved wheels can be shaped to match the profile, e.g a wood moulding.

Densities

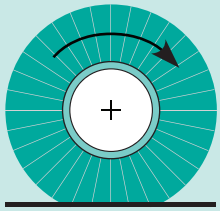
The different densities facilitate a versatility ranging from soft cushioning pads to hard cleaning and finishing tools.
The density of a wheel can be increased (hardened) by adding more flaps, as shown below:



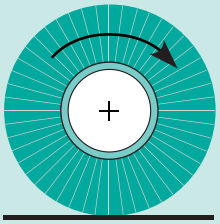
SD, Soft density



MD, Medium density



HD, Hard density



HDEX, Extra Hard density

Jimi VELKOOBCHOD BRUSIVA

FLANGE MOUNTED FLAP WHEELS

BEARTEX FLAP WHEEL APPLICATION GUIDE

SGA MCC	GRADE	MD	OLD QUALITY NAME	GRAIN TYPE	APPLICATION
F2212	Coarse A	DAB01	-	Aluminium Oxide	■ Aggressive, very durable, cutting capacity constant Removal of material and corrosion.
F2301 / F2312	Medium A	D0005	D05/DIS	Aluminium Oxide	■ Specially made for Stainless steel and Aluminium. Matt satin finish
F2305	Medium A Heavy Duty	-	-	Aluminium Oxide	■ Faster working and coarser finish than F2301 ■ Higher durability with ability to withstand sharp edges ■ Specially engineered to avoid smearing.
F2401 / F2412	Fine A	D0097	D97	Aluminium Oxide	■ Fine matt satin finish on stainless steel ■ Defuzzing wood, scuffing paints and varnishes
F2402	Fine A	D0002	D02	Aluminium Oxide	■ Use for all metals. ■ Contains special anti-smearing resin
F2501 / F2519	Very Fine A	D0091	D91	Aluminium Oxide	■ Finishing all metals ■ Cleaning and removing oxide on soft metals.
F4301	Medium S	D0054	D54	Silicon Carbide	■ Semi bright satin finish on stainless steel ■ Surface preparation on aluminium before anodising
F4401	Fine S	D0071	D71	Silicon Carbide	■ Special stainless steel, alumium and brass ■ Weld surface preparation ■ Wood - sanding of primer - scuffing paints and varnishes.
F4501	Very Fine S	D0089	D89	Silicon Carbide	■ Semi bright satin finish on aluminium, brass and precious metals. ■ Wood - uniform finish - scuffing varnishes
F4601 / F4612	Ultra Fine S	D0098	D98	Silicon Carbide	■ Light cleaning on metals ■ Light finishing on precious metals, scuffing varnishes.
F4801	Micro Fine S	D0075	D75	Silicon Carbide	■ Super finishing

jimi VELKOOBCHOD BRUSIVA

BEARTEX FLANGE MOUNTED FLAP WHEELS - MEDIUM DENSITY

DIM DxWxB(mm)	GRADE	CAP CODE	PK QTY	ART. NO.
150x20x50	Coarse A	F2212	2	66261083017*
	Med A	F2312	2	66261082056*
	Med A Heavy Duty	F2305	2	66261083029*
	Fine A	F2412	2	66261083077*
	Very Fine A	F2519	2	66261083081*
	Ultra Fine S	F4612	2	66261083083*
150x50x50	Coarse A	F2212	1	66261083026
	Med A	F2312	1	66261082061
	Med A Heavy Duty	F2305	1	66261083074
	Fine A	F2412	1	66261083078
	Very Fine A	F2519	1	66261083082
	Ultra Fine S	F4612	1	66261083084
200x50x76	Coarse A	F2212	1	66261083027
	Medium A	F2301	1	63642588131
	Med A Heavy Duty	F2305	1	66261083075
	Fine A	F2412	1	66261083079
	Very Fine A	F2504	1	63642588137
	Very Fine S	F4501	1	63642588145

Refer to accessories section at the back of this catalogue for information on metal bushings
The catalogue includes details of all stock products but other options are available in various sizes, grades & densities using Norton's made to order facility.
Please contact your local sales or customer service representative for more information.

* Made-to-order

Jimi VELKOOBCHOD BRUSIVA

Dimensions Key: DIM = Dimensions, D = Diameter, W = Width, B = Bore

BEARTEX CONVOLUTE WHEELS

BearTex® Convolute Wheels are formed by wrapping BearTex® web material around a center core and bonding the layers together to create an abrasive wheel. These wheels are available in various diameters, grades and densities.

APPLICATIONS & MARKETS

- Burr & flash removal
- Reducing surface roughness
- Blending welds on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust & oxides
- Applying decorative finishes

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
Stainless Steel, Heat-sensitive alloys	C4407	C4308	C4308
Carbon Steel	C4308	C4308	C4308
Non-Ferrous Metal/Brass/Aluminium	C4308	C4301	C2303

DCS

Fine finish with light pressure

FEATURES	BENEFITS
Open mesh construction,	Good for blending,rust removal,applying decorative contrast finishes and low to moderate speed applications
Silicon Carbide Grain	Not used for deburring
Softest Convolute wheel	

DSS SURFACE FINISHING

Uniform finish with moderate pressure

FEATURES	BENEFITS
Stronger web compared to Clean/Finish wheels	More aggressive cutting action & more durability than Clean/Finish wheels
	Ideal for rust & paint removal, coarse decorative finishes & blending

VELKOOBCHOD BRUSIVA

DMA RED METAL FINISHING

Light deburring, blending & final finishing

FEATURES	BENEFITS
■ Strongest resin binders	■ Resilient long life construction
■ Dense, very durable web	■ Can be used for light deburring applications
■ Premium, medium grit aluminium oxide grain	■ Generates uniform distinct satin & antique finishes
■ Uniform grain dispersion & coating	■ Cleans & conditions without gouging or changing dimensions of workpiece

LIGHT FINISHING

Light deburring, blending & final finishing

FEATURES	BENEFITS
■ Ideal for deburring parts with tight tolerances, without altering geometry	■ Light deburring and finishing of turbine engine and aerospace components
■ Improved conformability and resiliency deliver optimum workability to effectively polish intricate profiles in minimal time	■ Finishing applications demanding superior quality and high consistency

SERIES 1000 LONG LIFE

General deburring, blending & finishing

FEATURES	BENEFITS
■ Improved Smear & heat resistant formula	■ Use dry, wet or with oil
■ Waterproof non-metallic	■ No contamination of workpiece
■ Dense web construction (9 density)	■ Long life & consistent high quality results
■ More open web construction (6 density)	■ Starting point for deburring, blending, polishing & finishing ■ Smear proof & cool cutting on light deburring applications

SERIES 4000

Ideal for heavy deburring applications

FEATURES	BENEFITS
■ Improved resin bond system	■ Free cutting – use both wet & dry
■ High quality synthetic web	■ More consistent finish. Better performance
■ Smear & heat resistant	■ Long life for heavy deburring, edge breaking & removing parting lines on exotic metals
■ Premium abrasive grain	■ The choice for when edge & form holding are of primary importance
■ Waterproof	

VELKOOBCHOD BRUSIVA

CONVOLUTE WHEEL NAMING SCHEME

D 1 - 9 S F

BONDED SYSTEM	DENSITY	ABRASIVE TYPE	GRIT SIZE
1 = Series 1000 Bond	6 = Open / Conformable	A = Aluminium Oxide	F = Fine
2 = Series 2000 Bond	7	S = Silicon Carbide	M = Medium
4 = Series 4000 Bond	8		VF = Very Fine
	9 = Dense / Durable		

Use Series 1000 Long Life as your starting point for selection.

QUICK PRODUCT SELECTION BY APPLICATION

APPLICATION AREA	SPECIFIC APPLICATION	SPECIFICATION	RECOMMENDED SPEEDS
Cleaning	General purpose cleaning, removing rust oxidation, corrosion, discolouration, flashings, pipe threads, machine parts, plastic moulded parts	D16 AM or D18 AM	11-32 ms/ 2,200 - 6,000 SFPM
Deburring	Removing medium to heavy burrs – deburring die cast/smoothing radii on metal parts/ blending coated abrasive scratch pattern	D19 SF	28-41 ms/ 5,500 - 8,000 SFPM
Blending	Smoothing parting lines, polishing welds, machine parts	D1 7 SF	28-41 ms/ 5,500 - 8,000 SFPM
Finishing	Satin finish, cosmetic finish, brush finish	D1 7 SF	2-15 ms/ 500 - 3,000 SFPM

jimi VELKOOBCHOD BRUSIVA

APPLICATION GUIDE

Pressure	■ Light to medium pressure is recommended for most operations ■ Avoid excessive pressure which may result in wheel deformation & damage to the work surface
Feed speed	■ Feed speeds directly affect the number of pieces completed over a given period of time ■ Slow feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern ■ Slow feed speed allows for longer dwell time & 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
Oscillation	■ Oscillation may be used to break up scratch lines ■ Produce a more uniform finish ■ Additionally, an increase in cut may be experienced ■ A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute
Lubricants	■ Lubricants, such as water, water soluble oil & straight oil, will decrease the heat generated while running, improve the luster & improve the surface finish ■ The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced

UNDERSTANDING THE MCC

SPECIFICATION	GRADE	MCC
DCS	VF	C4501
	F	C4401
	M	C4301
DSS	M	C4302
DSA	M	C2302
DMA	M	C2303
LFW S	F	C4411
D1 6 A LL	M	C2308
D1 7 A LL		
D1 8 A LL		
D1 9 A LL		
D1 6 S LL		
D1 7 S LL, D1 8 S LL, D1 9 S LL, D1 9 S LL	F	C4408
	M	C4308
D4 8 A	M	C2306
D4 8 S	F	C4406
D4 9 S	F	C4406

Jimi VELKOOBCHOD BRUSIVA

CONVOLUTE WHEELS

DIM DxWxB (mm)	REF CODE	ABR TYPE	GRADE	DTY	PK QTY	DCS	DSS Surface Finishing	DMA Metal Finishing	LFW Light Finishing	Series 1000 Long Life	Series 4000
150x 10x25	D17	SiC	F	7	4					63642549767	
150x 12x25	D17	SiC	F	7	4					6626118628	
		AlOx	M		4					6626118857	
		SiC			4					6995797880	
	D18	SiC	F	8	4					6626118773	
		AlOx	M		4					6626118789	
	D49	SiC	F	9	4						6626104021
	DBS	SiC	F	n/a	4						
150x 25x25	DMA	AlOx	M	5	3			6626107936			
	D16	AlOx	F	6	3				6625440370 8*	6626155204	
		AlOx	M		3					6626155205*	
		SiC	M		3					6626155202	
	D17	SiC	F	7	3				6625440370 9*	6626155223	
	D18	SiC	F	8	3				6625442157 3	6626118774	
	D19	SiC	F	9	3					6626118632*	
	D19	SiC	M	9	3					6626155371	
	D48	SiC	F	8	3						6626108658
		AlOx	M		3						6626104208
	DBS	SiC	F	n/a	4						
	DSA	AlOx	M	n/a	4		6626105855 0				
	DSS	SiC	CRS		4		6626105855 3				
150x 50x25	DCS	SiC	F	n/a	2	6364254964 5					
	DCS	SiC	M	n/a	2	6626105851 0					
	DSS	SiC	M	n/a	2		6626105856 0				
	DMA	AlOx	M	5	2			6626107957			
	D17	AlOx	F	7	2					6626108897*	
		AlOx	M		3					6626155229*	
200x 20x76	D19	SiC	S	M	3					6626123567	
200x 25x76	DMA	AlOx	M	5	3			6626107831			
	D16	SiC	F	6	3				6626109570 2	6626119693	
			M		3					6626155208	
	D17	AlOx	F	7	3					6995752389	
		SiC	F		3				6625440992 4	6626118639	
		AlOx	M		3					6626155232	
		SiC	M		3					6995794610	
	D18	SiC	F	8	3				6625442157 7*	6626118775	
		AlOx	M		3					6626118855	
		SiC	M		3					6626118673	

* Made-to-order

Dimensions Key: DIM = Dimensions, D = Diameter, W = Width, B = Bore Hole, ABR = Abrasive Type, DTY = Density

CONVOLUTE WHEELS (CONTINUED)

DIM DxWxB (mm)	REF CODE	ABR TYPE	GRADE	DTY	PK QTY	DCS	DSS Surface Finishing	DMA Metal Finishing	Series 1000 Long Life	Series 4000
200x25x76	D19	SiC	F	9	3				66261018641	
		SiC	M		3				66261018997	
	D48	SiC	F	8	3					66261004123
		AlOx	M		3					66261004165
200x50x76	DCS	SiC	F	n/a	2	63642515565				
	DCS	SiC	M	n/a	2	07660705208				
	DMA	AlOx	M	5	2			66261007904		
	D16	SiC	M	6	2				66261055211	
	D17	AlOx	F		2				66261009252*	
		SiC		7	2				66261018877	
		AlOx	M		2				66261055235	
	D18	SiC	F	8	2				66261019629	
	D18	SiC	M	8	2					
	D19	SiC	F	9	2				66261055276	
	DBS	SiC	F	n/a	2				07660705226	
250x12x127	D17	SiC	F	7	4				69957352396*	
	D18	SiC	F	8	4				66261019221*	
		AlOx	M		4				69957352395*	
		SiC			4				66261019005*	
	D19	SiC	F	9	4				66261019222*	
250x25x127	D18	AlOx	M	8	4				69957352402	
300x50x125	DSS	SiC	CRS	n/a	1		66261058574*			

* Made-to-order

Refer to the accessories section at the back of this catalogue for information on metal bushings to reduce the bore size.

BORE HOLE REDUCTION BUSHINGS

WHEEL BORE (mm)	SIZE OF REDUCED BORE WITH BUSHING (mm)	FOR WHEEL DIAMETER (mm)	PK QTY	ART. NO.
25	10	100 to 150	2	66261080522
	13		2	66261080523
	16		2	66261080524
	20		2	66261080525
	22		2	66261080526
50	13	150 to 200	2	66261082442
50	13	150	2	66261080527
	16		2	66261080528
	25		2	66261080529
	32		2	66261080530
76	25	200	2	66261080531
	32		2	66261080532
	44		2	66261080384
	50		2	66261080514
125	32		2	66261080534

VELKOOBCHOD BRUSIVA

VORTEX CONVOLUTE

THE MOST AGGRESSIVE, FORM-HOLDING CONVOLUTE WHEELS

The breakthrough technology in our proprietary Vortex engineered grain and bond gives these new Vortex convolute wheels up to 2x the cut rate and 5x the life of conventional convolute wheels, making them the first choice for deburring and finishing applications, such as:

- Deburring and finishing automotive gears
- Imparting decorative finishes on plumbing fixtures
- Blending and finishing turbine engine components
- Metal finishing and weld blending at fabrication shops
- Alternative to set-up wheels

VORTEX CONVOLUTE

FEATURES	BENEFITS
■ Unequaled, proprietary Vortex aluminum oxide engineered grain and resin bond system	■ Aggressive, fast-cutting stock removal with exceptional form-holding and uniform finish ■ Up to 2x the cut rate and 5x the life of competitive convolute wheels ■ Reduced cycle times ■ Less truing
■ Advanced, porous web structure and design	■ Cooler cutting and improved cut rate ■ Minimal wheel wear ("shedding")

All Vortex convolute wheels are made-to-order

jimi VELKOOBCHOD BRUSIVA

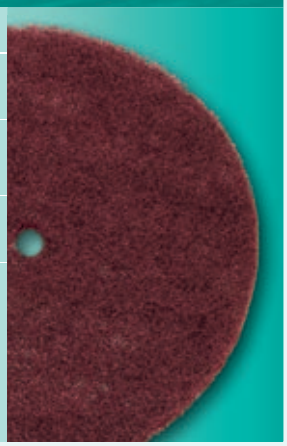
Made of a strong nylon web impregnated with abrasive grain and resin, BearTex® high strength discs are designed for demanding applications on a wide range of substrates. A general purpose product producing light satin finishes.

APPLICATIONS & MARKETS

- Rust/oxide or coating removal
- Satin finishing of stainless steel cutlery
- Root finishing of titanium turbine blades
- Finishing of stainless steel & aluminium components
- Cleaning moulds & castings

HIGH STRENGTH DISCS

FEATURES	BENEFITS
■ Premium Aluminium Oxide grain combined with strong resin	■ Long life and clean cutting. Highly smear resistant!
■ Flexible	■ Follow surface contours ■ Can be used for chamfering
■ Tear resistant	■ Helps avoid gouging or chunking the workpiece
■ Can be ganged together to use as a Wheel or Mop	■ Forms a very flexible but durable wheel for bench or straight grinders



HIGH STRENGTH DISCS

DIM DxB(mm)	CAP CODE	GRADE	PK QTY	ART. NO.
100x8	F2303	Medium	10	662544**29562***
150x12	F2303	Medium	70	636425**85909**
	F2506	Very Fine	70	636425**85912**
200x12	F2303	Medium	50	636425**85915**
	F2506	Very Fine	50	636425**85918**

* Made-to-order

For portable tools - Mount discs on mandrels - See Accessories page.

Dimensions Key: DIM = Dimensions, D = Diameter, B = Bore, DIA = Diameter

BEARTEX LAP MOPS 6 DISC GANGED TOGETHER

DIA (mm)	CAP CODE	GRADE	PK QTY	ART. NO.
150	F2520	Very Fine	5	07660707529*

* Made-to-order

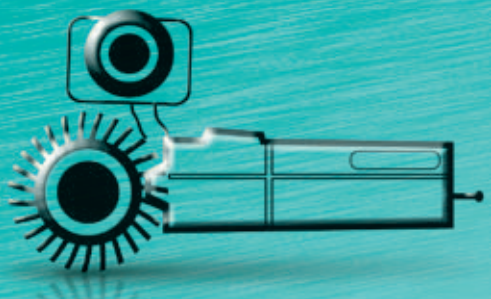
VELKOOBCHOD BRUSIVA

NORTON

SAINT-GOBAIN

Coated & BearTex

262 WHEELS FOR SATINEX MACHINES



Satine

WHEELS FOR SATINEX MACHINES

BearTex Satinex wheels provide a cushioned abrasive action which not only works well on flat areas, but is also ideal for use in finishing operations on uneven surfaces. These versatile wheels are used on portable machines.

APPLICATIONS & MARKETS

- Decorative finishing
- Weld blending & Removing paint
- Removing scales oxide & rust
- For use on wood & stainless steel
- In-line brush finishes on stainless steel and aluminium cookware
- Producing fine scratch pattern prior to cotton buffing/compound polishing

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	DEBURRING	CLEANING	BLEND/FINISH
All metal	F2200	F2300	F2402/F4306

WHEELS SATINEX MACHINES

FEATURES	BENEFITS
Key way fitting	High compatibility with most common systems in the market
Used on portable, variable speed machines	High mobility & flexibility
Wide range of different grades	From rust removal to a satin finish
Advanced flap wheel construction	Ensures perfect linear finish for repair & touch-up jobs

VELKOOBCHOD BRUSIVA

APPLICATION SELECTION

INDUSTRY	APPLICATION	PRODUCTS
Stainless steel fabricators	Grain finishing on sheets, removing of imperfections	Satinex Non Woven A Med
Architectural hardware	Finishing brass aluminium & steel, satin finishing	Satinex Non Woven Fine and Very Fine for bright linear finishes
Metal Working	Cleaning and removing scales, oxide and rust	Satinex RapidStrip
Food Processing	Weld Blending, Satin finishing with extended life	Satinex Polyurethane

WHEELS SATINEX

TYPE	APPLICATION	DIM DxTxB(mm)	CAP CODE	GRADE	PK QTY	ART. NO.
Satinex Cloth AO Abrasive	Grinding/Coarse Graining	110x100x19	R265	P40	6	662611**78710**
			R265	P60	6	636425**56870**
			R265	P80	6	636425**69354**
			R265	P120	6	636425**56744**
Satinex Non Woven	Blending/Satin Finishing	110x100x19	F2200	A Coarse	6	636425**57218**
			F2300	A Medium	6	636425**57404**
			F2400	A Fine	6	636425**57405**
			F2402	A Fine	6	07660**07415**
			F2504	A Very Fine	6	636425**57406**
			F4306	S Med	6	636425**56878**
Satinex Interleaved	Blending/Fine Graining	110x100x19	F2200	A Course + P80	6	636425**57407**
			F2309	A Medium + P80	6	07660**07431**
			F2300	A Medium + P150	6	636425**57408**
			F4402	S Fine + P150	6	636425**56741**
Satinex Polyurethane	Blending/Satin Finishing	110x100x19	P2W01	Coarse	6	636425**57410**
Satinex Rapid Strip	Cleaning/ Corrosion removal	110x100x19	R4101	Extra Coarse (SiC)	6	636425**57184***

* Made-to-order

SATINEX KIT

A Handy portable Kit with everything contained to get you started on the Finish thanks to the speed and precision of the Tool combined with the versatility of the Beartex Wheels.

Contains Satinex Tool and 6 Assorted Wheels.

APPLICATION	ART No.
SATINEX KIT: Satinex tool and assorted wheels	662544**88427**

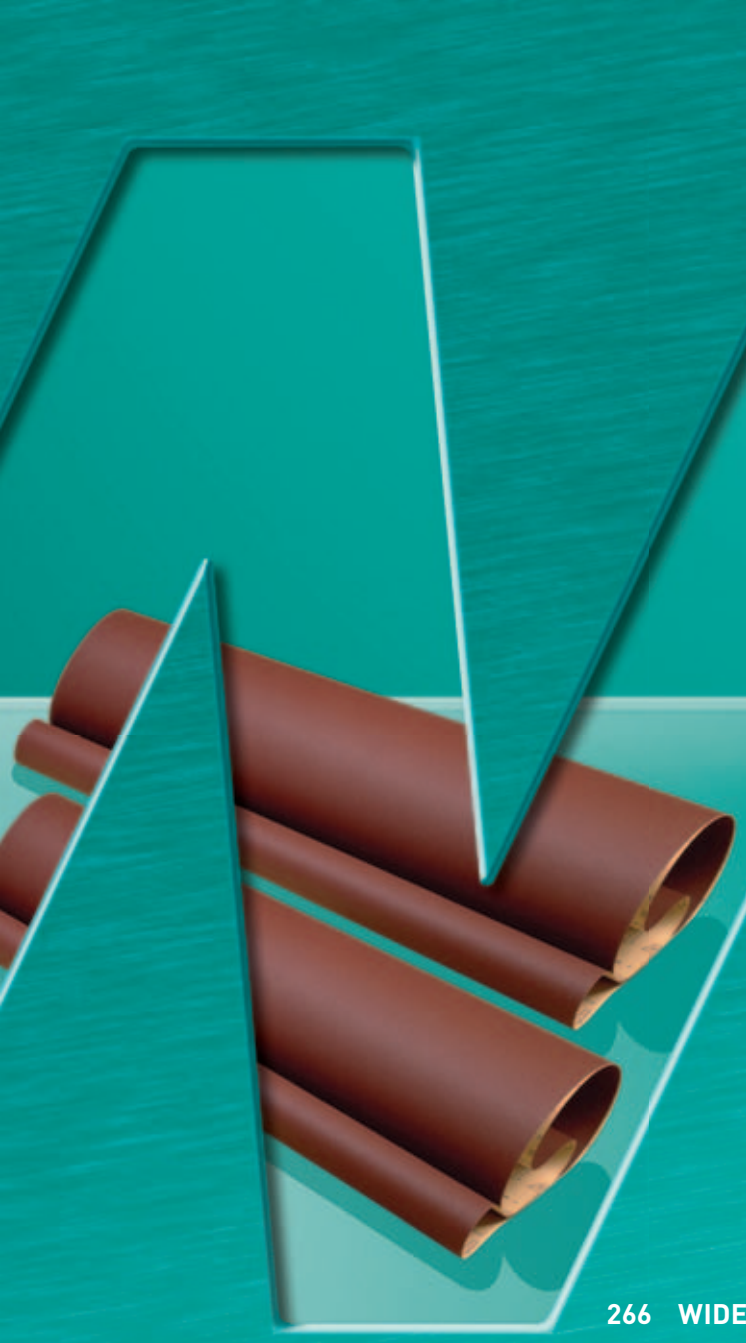
Dimensions Key: DIM = Dimensions, D = Diameter, T = Thickness, B = Bore

NOTES

VELKOOBCHOD BRUSIVA

NORTON

SAINT-GOBAIN



Coated & BearTex

266 WIDE BELTS

JMI VELKOOBCHOD BRUSIVA

WIDE BELTS

Available in a range of sizes, suitable for finishing wood and metal.

APPLICATIONS & MARKETS

Metal Working

- Plate dimensioning
- Slag grinding
- Machining & deburring

Wood Working

- Intermediate sanding
- Planing & dimensioning

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Wood	Heavy Stock removal	R293*	H231	H835*
	Callibration	H231		
	Finishing	H231		
	Between Coats	A277*		

* Made-to-order

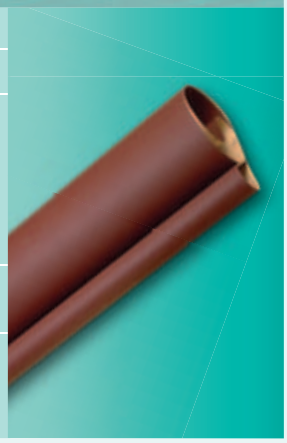
BEST

H231

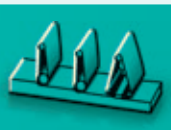
HARD WOOD & SOFT WOOD

FERR. & NON FERR.

FEATURES	BENEFITS
Very strong, F-weight paper	High performance & easy mounting
High performance aluminium oxide abrasive	Ideal for roughing, intermediate sanding & finishing of solid wood Ideal for furniture applications Finer grits ideal for polishing metal, plastics leather & smoothing fillers
Semi-open/open grain distribution	Resists clogging
Anti-static properties	Excellent surface quality Less dust generated for an improved working environment



JMI VELKOOBCHOD BRUSIVA



WIDE BELTS

DIM WxL(mm)	GRIT	PK QTY	BEST H231
930x1525	60	10	699573**37156***
	80	10	699573**37157***
	100	10	699573**37158***
	120	10	699573**37159***
	150	10	699573**37160***
	180	10	699573**37161***
930x1900	60	10	699573**37166***
	80	10	699573**37167***
	100	10	699573**37168***
	120	10	699573**37169***
	150	10	699573**37170***
	180	10	699573**37172***
1120x1900	60	10	699573**72835***
	80	10	699573**37515***
	100	10	699573**37516***
	120	10	699573**37517**
	150	10	699573**37518***
	180	10	699573**37519***
1120x2150	60	10	636425**68246**
	80	10	699573**37538**
	100	10	699573**37539***
	120	10	699573**37540**
	150	10	699573**37541***
	180	10	699573**37542***
1350x2620	60	10	699573**37795***
	80	10	699573**37796***
	100	10	699573**37797***
	120	10	699573**37798**
	150	10	699573**37799**
	180	10	699573**37800***

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

Jimi VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

270 BELTS
272 ROLLS
274 FLOORSANDING SHEETS
276 DOUBLE SIDED DISCS
278 PLAIN DISCS
280 BEARTEX FLOOR PADS

Produ
Floors

VELKOOBCHOD BRUSIVA

BELTS

A wide selection of sizes and grits for most dimensioning, intermediate grinding and polishing applications.

APPLICATIONS & MARKETS

- Grinding & deburring
- Heavy stock removal
- Blending, dimensioning & shaping
- Finishing

INNOVATION BEST

R955 RED HEAT

NORTON SG REDHEAT

HARD WOOD

FEATURES	BENEFITS
Very strong polyester backing	Extra long life & tear resistant Time saving
SG® ceramic abrasive	Unmatched cut rate with optimum resistance to wear, ideal for professional floor sanding
High quality product	Best for use on hard wood & large jobs Less belt changes

BETTER

R817 NORZON®

NORZON

FERR. & NON FERR. HARD WOOD SHOE

FEATURES	BENEFITS
Heavy polyester cloth	Stiff tear resistant backing
100% NorZon® abrasive	Long lasting cutting edges of NorZon® brings long life even at high pressure
Open grain distribution	Recommended for grinding soft materials like aluminium, plastic, rubber or leather Very good performance on hard wood

VELKOOBCHOD BRUSIVA

GOOD

R230

NON FERR. | HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Strong cloth backing	Multi-purpose Economy product ideal for sanding wooden floors & grinding metal
Aluminium oxide abrasive	Good cutting rate
Open grain distribution	Reduced clogging

R427

NON FERR. | HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
X-weight cotton cloth	Can be used for dry applications only
Silicon carbide abrasive	Ideal for grinding glass & stone

CLOTH BELTS FOR FLOOR SANDING

DIM WxL(mm)	GRIT	PK QTY	REDHEAT INNOVATION BEST R955	NORZON BETTER R817	GOOD R230	GOOD R427
200x750	24	5	69957**45034**			
	24	10		66261**82171**	63642**521182**	63642**552608**
	36	5	69957**45033**			
	36	10		66261**82172**	69957**349006**	63642**552610**
	40	5	69957**45032**			
	40	10		66261**82173**	69957**349007**	63642**552612**
	50	5	69957**45031**			
	50	10				63642**552613**
	60	5	69957**45030**			
	60	10		69957**371516**	69957**349010**	63642**552614**
	80	5	69957**45029**			
	80	10		63642**552057**	69957**349014**	63642**552616**
	100	5	69957**45028**			
	100	10		66261**82174**	69957**349394**	63642**552618**
	120	10		69957**371513**	63642**558814**	63642**552620**

Dimensions Key: DIM = Dimensions, W = Width, L = Length

VELKOOBCHOD BRUSIVA

BETTER

S413

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Very strong combination backing	■ High tear resistance
■ Sharp silicon carbide abrasive	■ Very high cutting action for rough floor sanding applications ■ Long life
■ Very open grain distribution	■ Aggressive cut & clog resistant

S422

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Very strong combination backing	■ High tear resistance
■ Sharp silicon carbide abrasive	■ Very high cutting action on hard wood

R817 NORZON®

NORZON

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Heavy polyester cloth	■ High tear resistance
■ 100% NorZon® abrasive	■ Long lasting cutting edges of NorZon® brings long life in floor sanding applications
■ Open grain distribution	■ Reduces clogging

H425

HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
■ Strong E-weight paper	■ Ideal for floor sanding ■ Good tear resistance
■ Silicon carbide abrasive	■ High cut rate

VELKOOBCHOD BRUSIVA

GOOD

R230

FERR. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Strong cloth backing	Multi-purpose product ideal for floor sanding, grinding metal & sanding wood
High performance aluminium oxide abrasive	High cutting rate
Open grain distribution	Reduced clogging

ROLLS

DIM WxL	GRIT	PK QTY	BETTER		NORZON		GOOD
			S413	S422	R817	H425	R230
203mmx50M	16	1	63642512552				
	24	1	63642512551		63642514304		
	30	1	63642539278	63642539283			
	36	1		63642539286	63642514305	63642557681	
	40	1				69957361909	
	50	1		63642539292		69957352812	
	60	1		63642539295	63642514309	63642527466	63642564505*
	80	1		63642539298	63642508570	63642557682	
	100	1		63642539300		63642557683	
	120	1				63642552702	
254mmx50M	24	1			63642514311		
	36	1			63642514312	63642539191	
	40	1			63642514313	63642559644	
	50	1			63642514314	63642539194	
	60	1			63642514315	63642534759	
	80	1				63642539198	
	100	1				63642539200	63642507353
	120	1				63642539203	

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

Jimi VELKOOBCHOD BRUSIVA

FLOORSANDING SHEETS

Norton offers specially designed parallelogram cut sheets for floor sanding machines. These special sheets provide fast cutting with low loading.

APPLICATIONS & MARKETS

- Flatten sharp edges & large surface areas

BETTER

H425

STONE SOFT WOOD

FEATURES	BENEFITS
Silicon carbide abrasive	Self-sharpening and lost lasting
Strong E-weight paper backing	High cut rate
	For dry applications only

PAPER SHEETS

DIM WxL(mm)	GRIT	PK QTY	BETTER H425
203x478	40	25	63642519223*
	60	25	63642519224*
	80	25	63642516181*

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

NORTON SAINT-GOBAIN

NOTES

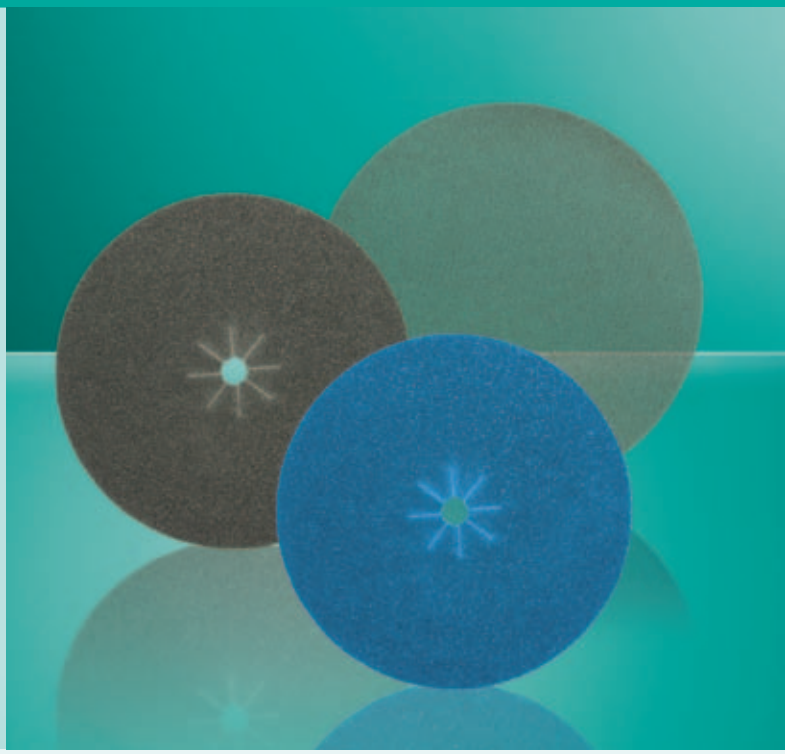
VELKOOBCHOD BRUSIVA

DOUBLE-SIDED DISCS

Norton offers a full range of double-sided discs designed to meet all commonly encountered applications. Double-sided discs have abrasive on both sides.

APPLICATIONS & MARKETS

- Floor sanding



PRODUCT SELECTION GUIDE

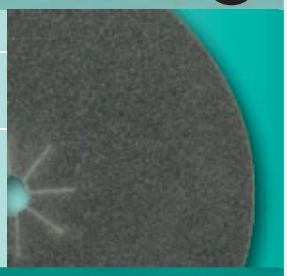
MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Wood - Floor Sanding	Surface Preparation	S413	H425	
	Between Coats	Q421		

BETTER

H425

SOFT WOOD | STONE

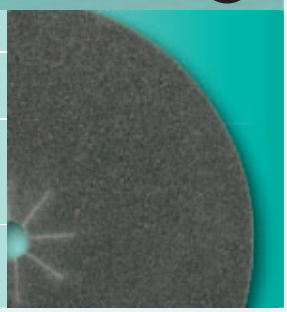
FEATURES	BENEFITS
Extremely sharp silicon carbide abrasive	Ideal for use on stone surfaces
Strong E-weight paper	High cut rate For dry applications only



S413

PAINT/ VARN. HARD WOOD & SOFT WOOD

FEATURES	BENEFITS
Very strong combination backing	High tear resistance
Sharp silicon carbide abrasive	Very high cutting action for rough floor sanding applications Long life
Very open grain distribution	Aggressive cut & clog resistant



VELKOOBCHOD BRUSIVA

GOOD

Q421 SCREEN-BAK®

PAINT/VARN. HARD WOOD SOFT WOOD

FEATURES

- Silicon carbide abrasive on an open mesh backing

BENEFITS

- Extreme resistance to loading
- Long life
- Waterproof

DOUBLE-SIDED DISCS

DIM DIAxH(mm)	GRIT	PK QTY	BETTER		GOOD
			H425	S413	Q421
425x30	16	25		6626103**3840**	
	24	25		6364253**4134**	
	36	25	6364253**4436**		
	40	25	6626103**3845**		
	60	25	6364253**2879**		
	80	25	6364253**2880**		
	100	25	6364253**2881**		
	120	25	6364253**2882**		
406	60	10			6626112**0519**
	80	10			6364253**6521**
	100	10			6626112**0517**
	120	10			6626112**0516**
	150	10			6364253**6524**
	180	10			6364251**5105**
	220	10			6364255**2254**

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

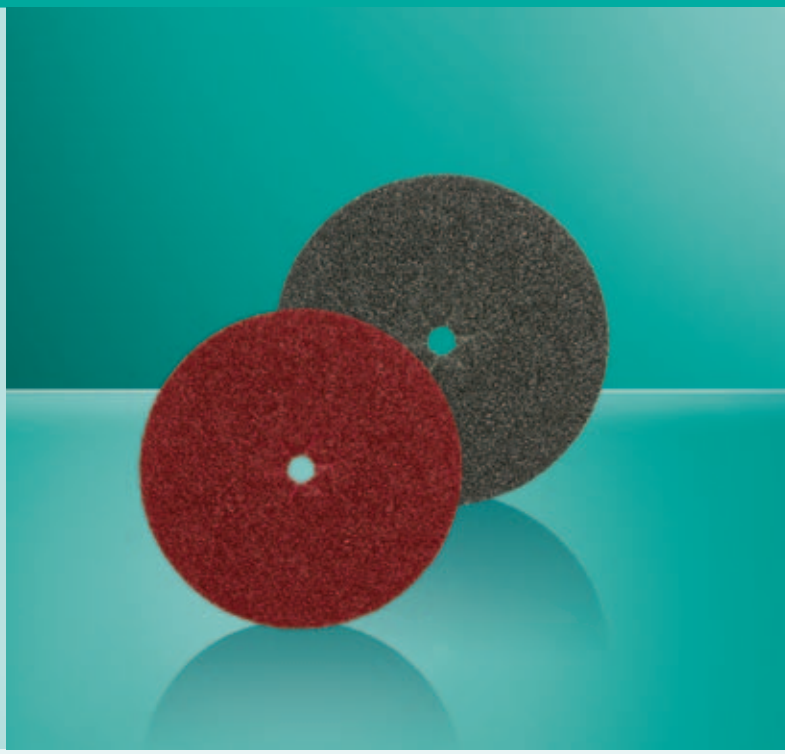
Jimi VELKOOBCHOD BRUSIVA

PLAIN DISCS

Norton offers a range of plain sanding discs to suit all the most commonly encountered applications.

APPLICATIONS & MARKETS

- Preparing primed & painted surfaces
- Stripping primer & paint
- Sanding plastic & fibreglass
- Light weld blending & deburring
- Finishing metal



PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS		HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Stone	Coarse sanding	S422		
	Finishing	H425		
Wood - Floor Sanding	Surface Preparation	H231		

BETTER

S413

SOFT WOOD

FEATURES	BENEFITS
Very strong combination backing	High tear resistance
Sharp silicon carbide abrasive	Very high cutting action for rough floor sanding applications Long life
Very open grain distribution	Aggressive cut & clog resistant

H425

STONE SOFT WOOD

FEATURES	BENEFITS
Silicon carbide abrasive	High cut rate For dry applications only
Strong E-weight paper	Ideal for use on stone surfaces

VELKOOBCHOD BRUSIVA

BETTER

H231

SOFT WOOD

FEATURES	BENEFITS
■ High performance aluminium oxide abrasive	■ Ideal for roughing, intermediate sanding & finishing of solid wood ■ Ideal for floor & furniture applications ■ Finer grits ideal for polishing metal, plastics & leathers, smoothing fillers, sanding primers, within vehicle repair markets
■ Semi-open / open coat (depending on grit size)	■ Resists clogging
■ Very strong, F-weight paper	■ High performance
■ Anti-static properties	■ Excellent surface quality

PLAIN DISCS

DIM DIAxH(mm)	GRIT	PK QTY	BETTER S413	BETTER H425	BETTER H231
140x22	36	100		63642546555	
	60	100		63642546518	
	80	100		63642546519	
	100	100		63642546520*	
	120	100		69957360223	
150x12	24	50	63642512874		
	36	50		63642546553	
	40	100		69957360199	
	50	100		63642546525	
	60	100		63642546527	
	80	100		63642546529	
	100	100		69957360218	
185x22	36	100		63642546559	
	60	100		63642546548	
	80	100		63642546549	
	100	100		63642546550	
350x40	40	100			63642540076
	50	100			63642540078
	60	100			63642540079
	80	100			63642540080
	100	100			63642546072*

* Made-to-order

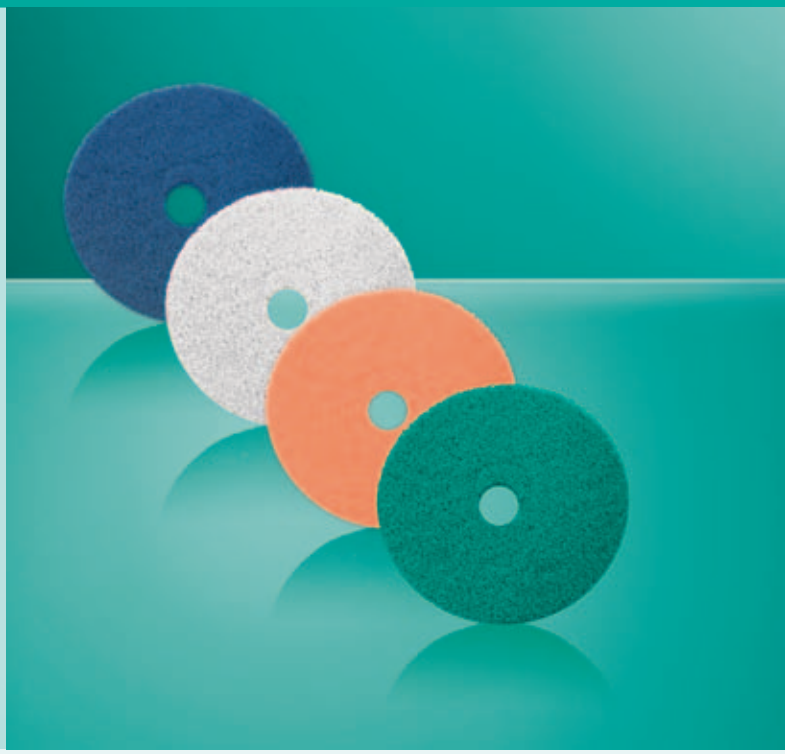
BEARTEX PLAIN DISCS

DIA (mm)	CAP CODE	GRADE	PK QTY	ART. NO.
150	F2520	Very Fine	10	63642557497
	F4804	Ultra Fine	10	63642557498

Dimensions Key: DIM = Dimensions, DIA = Diameter, H = Hole

BEARTEX FLOOR PADS

BearTex® offers a wide range of floor pads from stripping right through to mirror gloss finishing. For general scrubbing and cleaning applications BearTex® offers two pads that will remove surface dirt and grime to get the floor back in shape before recoating or buffing.



APPLICATIONS & MARKETS

- Cleaning & polishing floors
- Factory & utility maintenance
- Janitorial applications

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Wood - Floor Sanding	JF178	JF181	JF177

PRODUCT SELECTION

Black Super Strip		A thick pad that is aggressive, durable, & consistent, for wet stripping applications
Green Super Scrub		A heavy duty wet scrubbing pad that will remove the toughest scuff marks in heavily soiled traffic areas
Blue Super Clean		For general duty scrubbing or heavy spray cleaning jobs
Beige		For buffing & polishing, good for light traffic areas
Red Buffer		Generally used where a high gloss finish is desired when dry or spray buffing. It can also be used for light cleaning applications
White Super Gloss		A non-abrasive polishing/buffing pad, used dry or with a fine mist to yield a mirror gloss shine

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

STANDARD FLOOR PADS

DIA (mm)	CAP CODE	GRADE	PK QTY	ART. NO.
406	JF175	White Super Gloss	5	63642**85892**
	JF176	Red Buffer	5	63642**85890**
	JF177	Beige	5	63642**85873**
	JF178	Black Super Strip	5	63642**85841**
	JF180	Green Super Scrub	5	63642**85877**
	JF181	Blue Super Clean	5	63642**85868**

All standard floor pads come with an 89mm removable centrepiece

THIN LINE FLOOR PADS

DIA (mm)	CAP CODE	GRADE	PK QTY	ART. NO.
406	JU014	Black	10	63642**85895**
	JF068	Green	10	63642**85899**
	JF040	Beige	10	63642**85903**
	JF175	White	10	63642**85904**

BUFFING & POLISHING

- Designed to produce consistent performance & assure you a mirror gloss shine

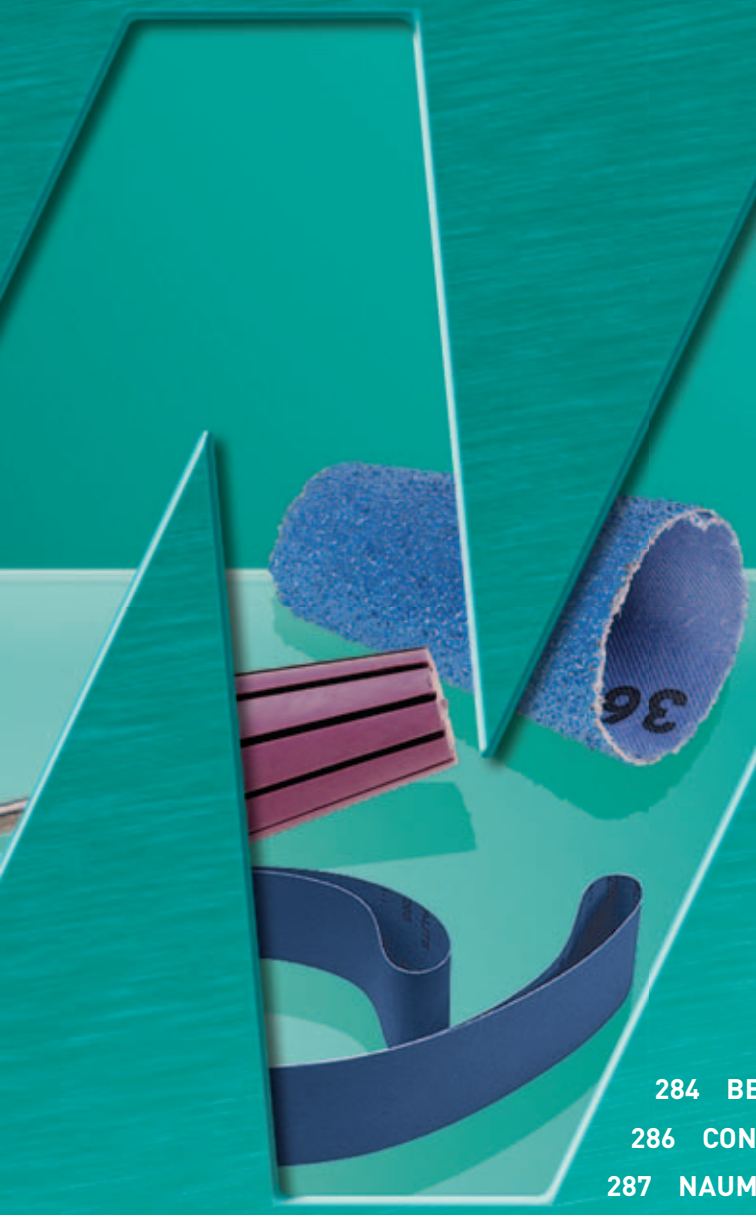
Dimensions Key: DIA = Diameter

Jimi VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN



284 BELTS
286 CONES
287 NAUMKEAG CAPS

Shoes

JMI VELKOOBCHOD BRUSIVA

SHOE APPLICATIONS

Shoe making and repair requires especially design product for precision cleaning and finishing of leather and rubber. For this traditional business, Norton uses its long experience in abrasives to provide specially shaped products like naumkeag caps for fast and consistent result.

APPLICATIONS & MARKETS

- Leather cleaning and preparation
- Rubber and leather soles shaping
- Glue removal

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Leather / Shoe		R817	

BETTER

R817 NORZON®

NORZON

FERR. & NON FERR. | HARD WOOD | SHOE

FEATURES	BENEFITS
Heavy polyester cloth	Stiff tear resistant backing
100% NorZon® abrasive	Long lasting cutting edges of NorZon® brings long life even at high pressure
Open grain distribution	Recommended for grinding soft materials like aluminium, plastic, rubber or leather
	Very good performance on hard wood

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CLOTH BELTS FOR SHOE REPAIR

DIM WxL(mm)	GRIT	PK QTY	NORZON BETTER R817
40x1150	24	10	63642545912
40x1480	24	10	63642530673
	40	10	63642539334
	60	10	63642536456
	80	10	63642539379
	100	10	63642539376
40x1500	24	10	63642539381
	80	10	63642530691
40x1650	24	10	63642536454
	40	10	63642539336
	60	10	63642530675
	80	10	63642530677
	100	10	63642530676
	120	10	63642531859
70x1003	24	10	69957355880
100x1480	24	10	63642519730

Dimensions Key: DIM = Dimensions, W = Width, L = Length

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BETTER

CONES

FERR. & NON FERR. SHOE

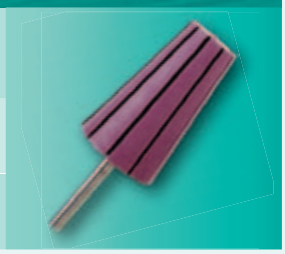
FEATURES	BENEFITS
■ Available in varying heights & diameters	■ Ideal for use on irregular shaped components such as curves, or recesses
■ Mounted on expanded rubber drums	■ Easy fitting
■ Used for grinding, deburring & polishing	■ Useful for repair work in the shoe industry

CONES ZCO

DIM BxLxDG(mm)	GRIT	PK QTY	BETTER R822
20x14x63	36	100	66261**76761**
	50	100	66261**76657**
	80	100	66261**76656**
	120	100	66261**76540**
29x22x30	50	100	63642**513692**
36x22x60	36	100	63642**520987**
	50	100	63642**536572**
	80	100	63642**545922**
	120	100	66261**76703**
50x20x40	40	100	63642**536708**
64x16x31	40	100	63642**547686**
82x38x40	40	100	63642**546300**
85x34x45	40	100	63642**546211**

CONE HOLDERS ML(ZCO)

DIM BxLxDG(mm)	ART. NO.
20x14x63	07660**740439**
36x22x63	07660**740441**



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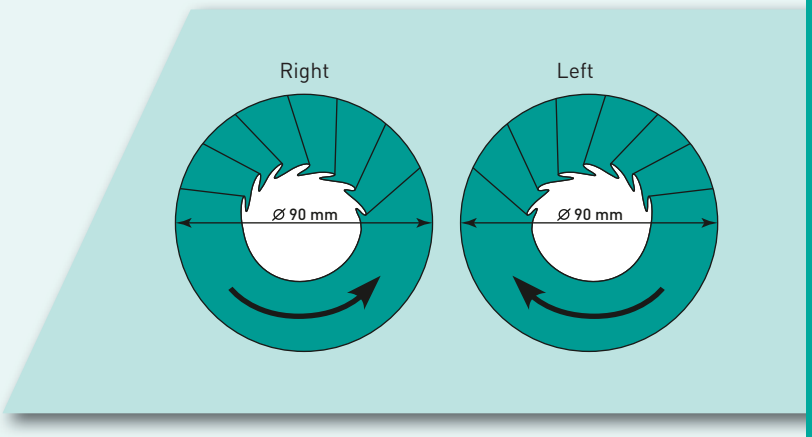
NAUMKEAG CAPS

FEATURES	BENEFITS
■ Aluminium oxide abrasive	■ Long lasting and consistent cut
■ Open coat grain layer	■ Anti-clogging effect
■ Flexible backing – bumped shape	■ Conforms perfectly to the profile of a shoe ■ Perfect and smooth finish
■ Left and Right crimped direction	■ Adapts to machine axle rotation

NAUMKEAG CAPS K229

DIM DIA(mm)	CRIMP DIRECTION	GRIT	PK QTY	ART. NO.
90	Left	60	25	636425**20900**
		80	25	636425**20899**
		100	25	636425**20898**
	Right	60	25	636425**34616**
		80	25	636425**34466**
		100	25	636425**34617**



SPEC CHECK

■ Choose proper crimp direction based on machine axle rotation. See above visual guide.

Dimensions Key: DIM = Dimensions, DIA = Diameter, B = Bore, L = Length, DG = Degree

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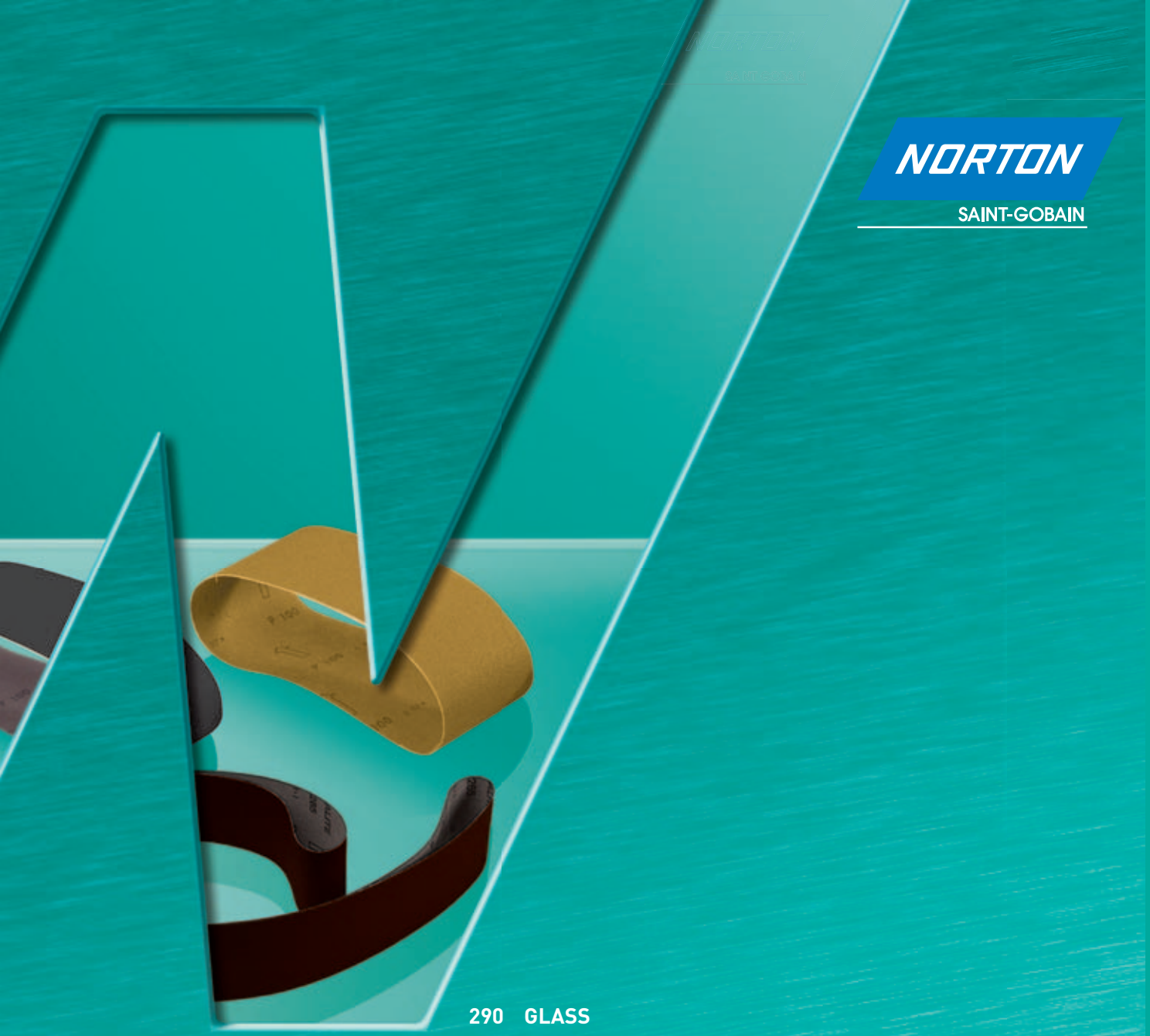
NOTES

VELKOOBCHOD BRUSIVA

NORTON

SAINT-GOBAIN



290 GLASS

Gl

VELKOOBCHOD BRUSIVA

Coated & BearTex

GLASS

Norton provides a range of specially designed abrasive belts for the glass market. Our products provide fast work with minial effort for a perfect finish.

APPLICATIONS & MARKETS

- Edge breaking
- Bevelling
- Finishing

PRODUCT SELECTION GUIDE

MATERIALS / APPLICATIONS	HIGHLY RECOMMENDED	RECOMMENDED	SUITABLE
Glass	U366*	R427/W445	

BEST

U366 NORaX®

NORaX

FERR. & NON FERR.

GLASS

FEATURES	BENEFITS
Polyester cloth	Generates a high quality finish Can be used wet
Special multi-layer abrasive products	Very long life & good cutting rate Increases productivity
Aluminium oxide abrasive	Grit X5 is ideal for final finishing of glass edges

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BETTER

W445

GLASS

FEATURES	BENEFITS
Polyester cloth	To be used wet or dry
Cork grain	Ideal for final finishing of glass edges

GOOD

R427

NON FERR. STONE GLASS

FEATURES	BENEFITS
X-weight cotton cloth	Can be used for dry applications only
Silicon carbide abrasive	Ideal for grinding glass & stone

PORTABLE BELTS

DIM WxL(mm)	GRIT	PK QTY	BETTER W445	GOOD R427
75x604	60	20		63642539437
	120	20		63642539434
	180	20		63642545905
	320	20		63642539433
	CORK	20	63642539439	

Dimensions Key: DIM = Dimensions, W = Width, L = Length

Jimi VELKOOBCHOD BRUSIVA

GOOD

R445

FERR. & NON FERR. GLASS

FEATURES	BENEFITS
■ Heavy to medium weight polyester cloth	■ Standard cloth for wet applications
■ Silicon carbide abrasive	■ For use on glass, titanium or cast iron ■ Ideal for use on stainless steel, especially for finer final finishing

CLOTH BELTS FOR GLASS

DIM WxL(mm)	GRIT	PK QTY	BEST U366	BETTER W445	GOOD R445
100x3350	60	10			63642546593
	80	10			63642546594
	100	10			63642530703
	120	10			63642546597
	150	10			63642546599
	180	10			63642546600
	220	10			63642546602
	240	10			63642546603
	320	10			63642546605
	400	10			63642546616
	CORK	10		63642546035	
	X5 (3000)	10	63642518504*		
200x3350	80	10			63642546606
	100	10			63642546607*
	120	10			63642546608
	150	10			63642546610*
	180	10			63642546611
	240	10			63642546614*
	320	10			63642546615*
	CORK	10		63642546037	

* Made-to-order

Dimensions Key: DIM = Dimensions, W = Width, L = Length

NORTON SAINT-GOBAIN

NORTON
SAINT-GOBAIN

294 INTRODUCTION

298 APPLICATION GUIDE

VITRIFIED

302 METAL PRECISION GRINDING WHEELS

318 GEAR GRINDING WHEELS

320 NON-FERROUS PRECISION GRINDING WHEELS

324 BENCH WHEELS

326 DISHES

330 CUPS

336 CYLINDERS

338 SEGMENTS

342 MOUNTED POINTS & WHEELS

350 DRESSING STICKS

354 BENCH & COMBINATION OIL STONES

358 ABRASIVE & PRECISION FILES

364 ABRASIVE SLIPS & SPECIALTIES

ORGANIC

368 CUT-OFF WHEELS

374 SNAGGING WHEELS & CUPS

378 MOUNTED POINTS

Jimi
VELKOOBCHOD BRUSIVA

Bonded Abrasives

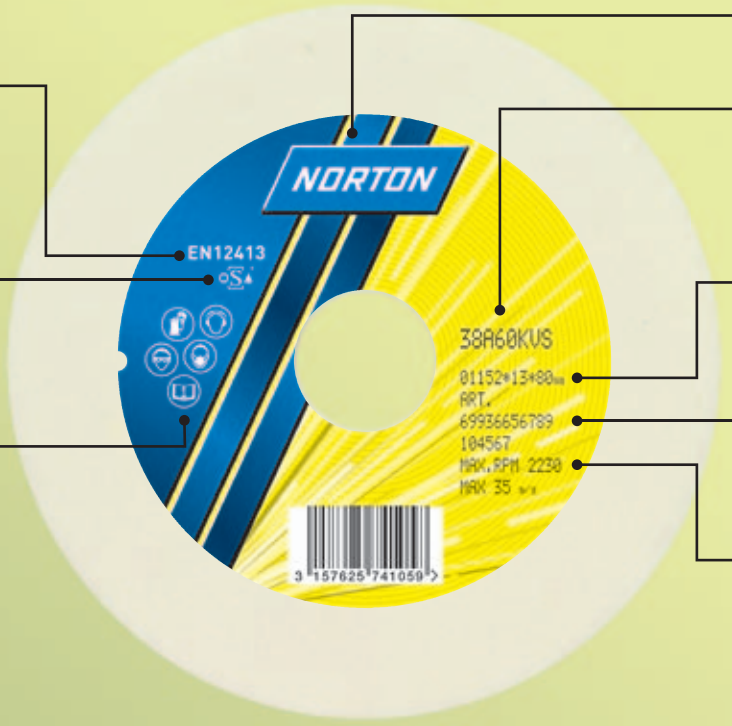
INTRODUCTION

From standard aluminum oxide bench wheels to premium ceramic abrasive surface grinding wheels, Norton offers high performance abrasive solutions that can maximise productivity in virtually all industrial applications.

The extensive product range is designed to meet all your precision grinding and roughing application needs, with all the most appropriate abrasive specifications, including grinding wheels, segments, mounted points, dressing sticks and sharpening stones.

Norton, the industry's most comprehensive Bonded abrasive product line.

UNDERSTANDING THE PRODUCT



European safety standard EN 12413

oSa certified The Organisation for Safety of Abrasives

Safety pictograms

Strong Norton branding

Product specification

Product dimensions (mm)

Article number; for use when re-ordering

Maximum operating speed

jimi VELKOOBCHOD BRUSIVA

ABRASIVE TYPES

CERAMIC ALUMIUM OXIDE Norton SG®, Norton Quantum® are patented ceramic forms of aluminium oxide that is harder and sharper than conventional abrasive grains. The ceramic grain has a unique microcrystalline structure and when used in a grinding operation this microstructure becomes self-sharpening. This leads to a reduction in the need for wheel dressing and a considerably cooler cutting action.

ALUMINIUM OXIDE Generally recommended for grinding materials of high tensile strength, such as stainless steel and tool steels, but it can also be used on some high tensile aluminium and bronze alloys. It is manufactured in varying qualities.

SILICON CARBIDE Harder than aluminium oxide with a very sharp abrasive grain shape. It is recommended for grinding relatively soft materials such as aluminium or cast iron as well as grinding extremely hard materials such as cemented carbide.

ZIRCONIA ALUMINA For use in rough grinding applications where high stock removal is required. Associated with high tech resin bonds.

GRIT SIZE

The number in the grinding wheel, marking designating grit size, represents the approximate number of openings per linear inch in the final screen size used to size the grain. The following rules should be followed:

USE COARSE GRIT

- For soft, ductile, stringy materials such as soft steel or aluminium
- For rapid stock removal
- Where finish is not important
- For large areas of contact

USE FINE GRIT

- For hard, brittle materials such as hard tool steels, cemented carbides & glass
- For fine finishes
- For small areas of contact
- For holding small corner radii

WHEEL GRADE

The grade indicates the relative holding power of the bond, which holds abrasive grains in a wheel. This is represented in the specification by letters running through the alphabet from softest to hardest. The following rules should be followed with regard to grade:

USE SOFT GRADE

- For hard materials such as hard tool steels & carbides
- For large areas of contact
- For rapid stock removal

USE HARD GRADE

- For soft materials
- For small or narrow areas on contact
- For longer wheel life

COMMON RANGE OF GRADES

E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T	U
					CYLINDRICAL/CENTRELESS											
SURFACE GRINDING																
					ID GRINDING											
				TOOL GRINDING												
						THREAD GRINDING										
	NON-REINFORCED ORGANIC															
											REINFORCED ORGANIC					

VELKOOBCHOD BRUSIVA

BOND TYPES-VITRIFIED

Vitrified bonds are the most common precision grinding bond. Porosity and strength of the wheels made with this bond give high stock removal along with their rigidity helping to attain high precision.
Not affected by water, acid, oils or ordinary temperature variations. The most common vitrified bonds are:

V	V is the original high temperature vitrified bond, usually used where tougher acting wheels are required
VS	VS is a very versatile, low temperature, high performance vitrified bond system used in almost all applications but predominately for tool room, centreless, cylindrical, & surface grinding
VTECH	Low temperature, very technical bond, used with conventional abrasives & recommended for high tech applications to maximise performance & dressing parameters
VX	VX bond provides improved corner/form holding for most applications
VXP	Induced porosity VX bond suitable for large contact areas & surface grinding
VQN/ VQNP	These bonds are associated with Norton Quantum® technology - a versatile technology for low, medium and high force applications.

UNDERSTANDING THE SPECIFICATION

ABRASIVE			GRIT SIZE			GRADE			STRUCTURE		BOND
ALUMINIUM OXIDE	SILICON CARBIDE	CERAMIC ALUMINIUM OXIDE	COARSE	MEDIUM	FINE	SOFT	MEDIUM	HARD	CLOSED	OPEN	
A	37C	SGB	12	30	80	E	I	Q	5	10	VS
19A	39C	3SG	16	36	90	F	J	R		11	VXP
25A		5SG	20	46	100	G	K	S		12	VXPM
38A		1TGP	24	54	120	H	L	T			VTECH
40A				60			M				
57A				70			N				
86A							O				
IPA			46	60	80	ME	HA	EH	17	26	VTX
										20	
		5NQ		60	80	J	K	L			VQN
										12	VQNP

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BOND TYPES-ORGANIC

These bonds are used in two types of wheels. Firstly, wheels used on portable or fixed machines for the rapid removal of metal. Secondly, cutting-off wheels either un-reinforced or reinforced, for use on portable or fixed machines. The most common organic bonds are:

SNAGGING WHEELS & CUPS	
B & B3	Foundry wheels: multi-purpose bond that gives satisfactory results on most applications
B28	Foundry wheels: high level bond suitable for most technical applications requiring high powered machines
CUTTING-OFF WHEELS	
BF1	Specific bond ensuring the best quality of cut in dry or wet conditions
BF3	New generation bond assuring the best wheel life in dry cutting operations; versatile & long wheel life. Ideal for heavy duty operations
B24	New generation bond used on silicon carbide cut-off wheels that gives the best performance & the ultimate cut quality on non-ferrous metals in wet conditions
B25	Standard multi-purpose bond that offers durability & freeness of cut in a wide variety of materials & applications. Can also be used in wet cutting on softer grades
B26	New generation bond used on aluminium oxide cut-off wheels that gives the best performance & the ultimate cut quality on ferrous metals in wet conditions
B65	Traditional bond gives good performance & long wheel life in dry cutting conditions

DIFFERENTIATION IN THE RANGE

Norton offers the industry's widest selection of sharpening and grinding wheels to meet every customer requirement. The range is classified into 3 tiers (Best/Better/Good) to help you choose the right product for your specific application according to the type of abrasive used.

INNOVATION BEST	Using unparalleled abrasive technology, & extremely high performance, high concentration ceramic aluminium oxide abrasive, Norton provides innovative products dedicated to improving productivity in all industrial applications	BETTER	The SGB abrasive is used in the majority of Norton's Better products. SGB contains a medium concentration of SG ceramic aluminium oxide abrasive. SG is harder & sharper than conventional abrasive grains & gives excellent cutting capability on a wide variety of materials
BEST	High concentrations of the well renowned SG abrasive are used to supply Norton's high performance abrasive grains, 5SG & 3SG. These products meet the demands of the most discerning user giving high stock removal rates & long product life for lower operating costs	GOOD	Standard aluminium oxide grains, both blended & pure, give highly durable solutions that produce good performance levels

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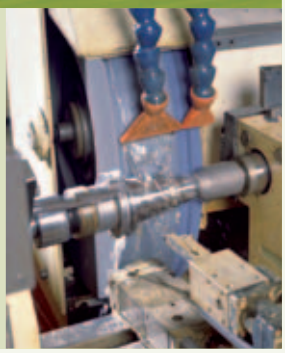
For further information please go to the Technical Information Section at the back of this catalogue.

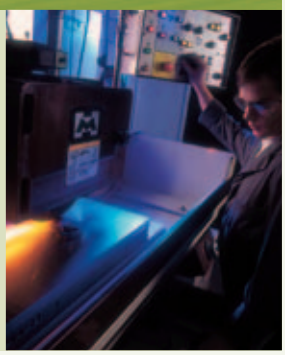
CYLINDRICAL GRINDING

Cylindrical grinding includes all outside grinding of round work, even when the finished product is not always a true cylinder. Requirements in cylindrical grinding vary from fast stock removal to ultra smooth (mirror) finishes. Cylindrical wheels are used extensively in the automotive, aerospace, shipbuilding, engine manufacture, turbine manufacture and bearing industry, as well as general shops and tool rooms



SURFACE GRINDING

The term surface grinding is used to describe the grinding of flat surfaces in which the wheel moves past the workpiece in a flat plane, or vice versa. Surface grinding applications range from heavy rapid stock removal, to precision contour grinding



INTERNAL GRINDING

Internal grinding refers to the grinding of bores or holes and is probably one of the most difficult types of grinding. Internal grinding applications range from very rapid stock removal to more controlled processes capable of generating sizes and concentricity measured in microns

TOOL & CUTTER

Tool room grinding refers to the maintenance and repair of the cutting tools used in manufacturing operations. Wheels of all sizes and shapes are used in tool and cutter applications. Most wheels used are vitrified, in grit sizes 36 to 220, and in grades H through to N

VELKOOBCHOD BRUSIVA

APPLICATION GUIDE

	CYLINDRICAL	INTERNAL	SURFACE	TOOL & CUTTER
Aluminium	37C 46 KVS	37C 80 IV	37C 46 KVS	
			38A 54 I12VXP	
Brass/Bronze	37C 60 KVS	37C 80 IV	37C 46 KVS	
			38A 54 I12VXP	
Cast iron	37C 60 KVS	37C 80 MVS	37C 54 JVS	
	38A 60 KVS	38A 80 MVS	38A 54 JVS	
Ceramic (green)	38A 60 KVS	38A80 I10VXP	38A 60 J10VQP	
Ceramic (fired)	39C 100 KVS			
Chrome plate	SGB 80 I10VXP	5NQ 80 JVQN	SGB 70 G12VXP	
	38A 80 J10VXP		86A 70 G12VXP	
Crankshaft (regrind)	19A 60 MVS			
Glass (cutting)			39C 60 KVS	
Glass (polishing)			A150 MVS	
Aerospace alloys: Nimonic, Inconel, Hastalloy	3NQ 80 I10VQNP	5NQ 60 KVQN	IPA 60 HA26VTX	
	SGB 80 I10VXP	SGB 60 KVX	3NQ 60 G12VQNP	
Plastics	37C 80 JVS	5NQ 60 KVQN	IPA 60 XH20VTX	
	SGB 80 IVXP			
Metal spray	39C 60 KVS	39C 80 IV	39C 46 KVS	
	39C 100 KVS			
Rubber	IPA 60 HA26VTX			
	37C 46 E12VP			
Steel – soft (Up to 45Rc)	57A 60 LVS	SGB 60 KVX	SGB 54 KVS	
	SGB 60 LVX	38A 60 LVS	38A 46 KVS	
Steel high carbon high chrome content – (46 - 56 Rc) D2, D3 etc.	3NQ 60 KVQN	5NQ 60 KVQN	IPA 60 XH17VTX	
	SGB 60 KVX	SGB 60 KVX	3SG 60 JVX	
Steel hardened (Over 56 Rc)	3SG 60 KVX	5NQ 80 KVQN	1TGP 60 HVX	5NQ 80 JVQN
	SGB 60 KVX	5SG 60 KVX	IPA 60 HA20VTX	SGB 60 JVX
		3SG 60 KVX	3SG 60 IVXP	
Stainless steel	39C 60 KVX	39C 80 JVS	39C 60 JVS	
	SGB 60 KVX	5NQ 60 KVQN	SGB 54 I12VXP	
		SGB 60 KVX		
Stellite	38A 60 LVS	SGB 60 KVX	SGB 60 H12VXPM	
Titanium	39C 60 KVX	39C 60 KVX	39C 60 KVX	
High speed steel	3NQ 60 KVQN	5NQ 60 JVQN	SGB 54 I12VXP	3NQ 60 KVQN
	SGB 60 KVX	SGB 60 JVX	IPA 60 EH20VTX	SGB 60 JVX
			3NQ54I12VXP	38A 60 JV
Tungsten carbide	39C 80 JVS	39C 80 IVS	39C 80 IVS	39C 80 JVS

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SAW SHARPENING

Saw sharpening refers to the maintenance and repair of sawblades. Vitrified flat wheels and cups are used in grit sizes 54 to 60. Resin treatment reinforces the wheel and helps reduce wheel face deformation

SAW SHARPENING

MATERIAL	TYPE OF TOOTH	OPERATION	RESIN	WHEEL GRADE	REFERENCE	RECOMMEND. SPEC
High quality steel	Large	All	None	Soft	MTVS	19A 60 MVS MTVS
Standard quality steel	Small	All	None	Hard	MDVS	19A 60 OVS MDVS
Standard quality steel	Double cut	Finishing	1mm resin coated on one side	Soft	T6	38A 60 MVS T6
Treated steel	Swage	Roughing		Medium	M6	86A 54 KVS M6
		Finishing		Soft	T6	38A 60 MVS T6
Stellite tipped	Stellite tipped	Finishing		Soft	T6	38A 60 MVS T6
		Roughing		Medium	M6	86A 54 KVS M6
		Truing		Hard	D6	86A 54 OVS D6

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NOTES

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METAL PRECISION GRINDING WHEELS

Norton vitrified grinding wheels have set the standard for generations – leading the way with technological improvements to maximise performance and productivity.

APPLICATIONS & MARKETS

- Surface grinding
- Tool & cutter grinding
- Sharpening
- Internal grinding
- Cylindrical grinding

INNOVATION BEST

5NQ

Type 01 Type 05

NORTON QUANTUM

FEATURES	BENEFITS
Engineered ceramic grain shape and chemistry with new bond technology.	Versatile in all low, medium and high force applications
A perfect blend between sharpness (free cutting) and toughness (life)	30% to 100% higher metal removal rate >15% lower threshold power

BEST

5SG®

Type 01

FEATURES	BENEFITS
Very high concentration of SG® ceramic aluminium oxide abrasive	Ultimate cutting capability High removal rate & extended wheel life Perfect for technical applications where grinding parameters can be adjusted to optimise performance

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

BEST

3SG®

Type 01

FEATURES	BENEFITS
■ High concentration of SG® ceramic aluminum oxide abrasive	■ Very good cutting capability
■ Unique, self sharpening, microcrystalline structure	■ High removal rate & extended wheel life ■ Suitable for very hard steels

BETTER

IPA VORTEX™ TECHNOLOGY

Type 01

VORTEX technology

FEATURES	BENEFITS
■ High performance engineered alumina grain	■ Very high metal removal rates, resulting in reduced cycle times
■ High porosity & permeability for maximum coolant diffusion	■ Improved part quality thanks to reduced heat generation
■ Optimal grain spacing for improved chip clearance & reduced friction	■ Increase wheel life ■ Consistent grinding performance ■ Extremely cool cutting action promoting burn free results

1TGP

Type 01

FEATURES	BENEFITS
■ High performance SG® ceramic aluminium oxide abrasive	■ Blend of premium TG grain with pink alumina
■ Harder & sharper than conventional abrasive grains	■ Extremely high removal rate & wheel life
■ Unique, self sharpening, microcrystalline structure	■ Effective when productivity is the primary concern
■ Elongated grain shape	■ Suitable for medium to high power & stiff machines

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METAL PRECISION GRINDING WHEELS

BETTER

SGB®

Type 01 Type 05

FEATURES	BENEFITS
■ Medium concentration of SG® ceramic aluminum oxide	■ Good cutting capability
■ Harder & sharper than conventional abrasive grains	■ Suitable for low to medium power machines ■ Very versatile on a wide variety of steels

38A

Type 01 Type 05

FEATURES	BENEFITS
■ High purity white aluminium oxide abrasive	■ Cool & burn free cutting
■ Friable	■ Ideal for heat-sensitive applications with light to moderate feed rates

GOOD

86A

Type 01 Type 05

FEATURES	BENEFITS
■ Highly refined pink aluminium oxide abrasive	■ Very versatile
■ Tougher abrasive than pure white aluminium oxide	■ Reduced dress frequency
■ Contains a small portion of chromium oxide	

19A

Type 01

FEATURES	BENEFITS
■ A blend of A & 38A abrasives	■ Very versatile. For use on a wide variety of steels
■ Primarily used in saw grinding applications	■ Good yield, good removal rate ■ Good balance between cut rate & form holding ability

57A

Type 01

FEATURES	BENEFITS
■ Semi-pure brown fused aluminium oxide abrasive	■ For use on steel & steel alloys
■ High durability	■ Versatile, durable, & free cutting ■ Economical ■ Ideal for general purpose applications

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STRAIGHT WHEELS

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
						BEST					
			Type 01				Type 05				
10x10x4			01	45	10	5NQ 80 JVQN	66253244877				
			01	45	10	5NQ 80 LVQN	66253262415				
13x13x4			01	45	10	5NQ 60 LVQN	66253244878				
			01	45	10	5NQ 80 LVQN	66253262414				
13x13x4,76	6	6	05	45	10	5NQ 60 KVQN	66253244880				
16x16x6			01	45	10	3NQ 60 LVQN	66253261880	38A 60 LVS	66253050359**		
			01	45	10	5NQ 80 JVQN	66253244881				
	10	8	05	45	10	5NQ 60 LVQN	69083163785				
20x20x6			01	45	10	3NQ 60 LVQN	66253261903	38A 60 LVS	69936641129		
	13	10	05	45	10	5NQ 60 LVQN	66253261908	SGB 60 KVX	69936681793		
	13	10	05	45	10	5NQ 80 JVQN	66253244883				
20x20x6,35	10	10	05	45	10	5NQ 60 KVQN	66253244884				
25x25x6,35	13	12	05	45	10	5NQ 80 IVQN	66253244885				
25x25x8	13	12	05	45	10	5NQ 60 LVQN	66253244886				
	13	10	05	45	10	5NQ 80 JVQN	66253244887	SGB 60 KVX	69936681795		
32x20x10	16	10	05	45	10			SGB 60 JVX	69936641074**		
32x25x8	13	10	05	45	10	5NQ 60 JVQN	66253244888				
32x30x10	18	12	05	45	10			SGB 60 KVX	69936681798*		
32x32x9,53	16	16	05	45	10	5NQ 80 IVQN	66253244898				
32x32x10	16	16	05	45	10			SGB 60 JVX	69936676291		
	16	16	05	45	10			38A 60 LVS	69936675118		
40x25x9,53	20	12	05	45	10	5NQ 60 KVQN	66253244889				
40x25x10	16	12	05	45	10	5NQ 80 KVQN	66253244890				
40x32x10	20	16	05	45	10	5NQ 60 LVQN	66253244891				
40x40x10	16	20	05	45	10	5NQ 60 KVQN	66253244897				
50x6x6			01	45	10			38A 60 NVS	69936675122		
50x32x13	30	16	05	45	10	5NQ 60 LVQN	69083163788				

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

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STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER	BETTER	GOOD	GOOD
			Type 01								
50x40x10	25	20	05	45	10					86A 60 KVTECH	662530**49914****
50x40x12,7	25	20	05	45	10	5NQ 60 KVQN	662532**44892**	38A 60 LVS	699366**21569***		
50x40x13	25	20	05	45	10	5NQ 80 IVQN	662532**44893**				
50x40x16	25	20	05	45	10	5NQ 60 KVQN	662532**44894**			86A 60 KVTECH	662530**49929****
63x10x20			01	45	10			38A 60 NVS	662530**50376**		
63x40x12,7	32	20	05	45	10	5NQ 80 IVQN	662532**44895**	38A 60 LVS	699366**21565**		
65x50x16	25	25	05	45	10			SGB 60 JVX	699366**76211**		
70x7,1x17			01	45	10	3NQ 60 HVQN	662532**62413**				
76x32x20	42	16	05	45	10	5NQ 60 JVQN	662532**44896**				
80x10x32			01	45	10			38A 60 LVS	662530**50241****		
100x6x32			01	45	2			38A 60 LVS	662530**50244**		
100x10x32			01	45	2	3SG 60 KVX	662530**50246**	38A 60 LVS	662530**50404**		
100x13x32			01	45	2			SGB 60 KVX	662530**49862***		
			01	45	2			38A 60 LVS	662530**50409**		
100x16x32			01	45	2	3SG 46 KVX	662530**50283***				
100x20x32			01	45	2			38A 46 KVS	662530**54532***		
			01	45	2			38A 60 KVS	662530**51062***		
			01	45	2			38A 60 LVS	662530**50413**		
100x50x32	60	25	05	45	2	5NQ 60 LVQN	662532**62024***				
125x6x32			01	45	2	3SG 60 LVX	662530**54862***	38A 60 LVS	662530**50440**		
			01	45	2			38A 60 NVS	699366**75721****		
125x8x32			01	45	2			38A 60 LVS	662530**50443****		
125x10x32			01	45	2			38A 46 JVS	662530**50441***		
			01	45	2			38A 60 KVS	662530**51063****		
			01	45	2			38A 60 LVS	699366**75731**		
			01	45	2			38A 80 LVS	662530**50254****		
			01	45	2			38A 120 JVS	662530**50449****		
125x13x32			01	45	2	3SG 60 JVX	662530**50290**	38A 100 JVS	662530**50257**		
125x16x32			01	45	2			38A 60 MVS	662530**50237**		
125x20x32			01	45	2	3SG 60 JVX	662530**50255***	SGB 60 LVX	662530**50286***		
			01	45	2			38A 60 KVS	662530**50620**		
			01	45	2			38A 60 LVS	699366**75736**		
150x2x32			01	45	6			38A 80 NVS	699366**77254***		
150x3,2x32			01	63	6					19A 60 MVS MTVS	699366**75941**
150x4x20			01	45	6			38A 60 LVS	699366**75591**		
			01	45	6			38A 80 NVS	699366**76720**		
			01	45	6			38A 100 MVS	699366**40219**		
150x4x30			01	63	6	3SG 80 NVX	699366**78980***	38A 80 NVS	699366**39730***		

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER	BETTER	GOOD	GOOD
			Type 05								
50x40x10	25	20	05	45	10					86A 60 KVTECH	662530**49914****
50x40x12,7	25	20	05	45	10	5NQ 60 KVQN	662532**44892**	38A 60 LVS	699366**21569***		
50x40x13	25	20	05	45	10	5NQ 80 IVQN	662532**44893**				
50x40x16	25	20	05	45	10	5NQ 60 KVQN	662532**44894**			86A 60 KVTECH	662530**49929****
63x10x20			01	45	10			38A 60 NVS	662530**50376**		
63x40x12,7	32	20	05	45	10	5NQ 80 IVQN	662532**44895**	38A 60 LVS	699366**21565**		
65x50x16	25	25	05	45	10			SGB 60 JVX	699366**76211**		
70x7,1x17			01	45	10	3NQ 60 HVQN	662532**62413**				
76x32x20	42	16	05	45	10	5NQ 60 JVQN	662532**44896**				
80x10x32			01	45	10			38A 60 LVS	662530**50241****		
100x6x32			01	45	2			38A 60 LVS	662530**50244**		
100x10x32			01	45	2	3SG 60 KVX	662530**50246**	38A 60 LVS	662530**50404**		
100x13x32			01	45	2			SGB 60 KVX	662530**49862***		
			01	45	2			38A 60 LVS	662530**50409**		
100x16x32			01	45	2	3SG 46 KVX	662530**50283***				
100x20x32			01	45	2			38A 46 KVS	662530**54532***		
			01	45	2			38A 60 KVS	662530**51062***		
			01	45	2			38A 60 LVS	662530**50413**		
100x50x32	60	25	05	45	2	5NQ 60 LVQN	662532**62024***				
125x6x32			01	45	2	3SG 60 LVX	662530**54862***	38A 60 LVS	662530**50440**		
			01	45	2			38A 60 NVS	699366**75721****		
125x8x32			01	45	2			38A 60 LVS	662530**50443****		
125x10x32			01	45	2			38A 46 JVS	662530**50441***		
			01	45	2			38A 60 KVS	662530**51063****		
			01	45	2			38A 60 LVS	699366**75731**		
			01	45	2			38A 80 LVS	662530**50254****		
			01	45	2			38A 120 JVS	662530**50449****		
125x13x32			01	45	2	3SG 60 JVX	662530**50290**	38A 100 JVS	662530**50257**		
125x16x32			01	45	2			38A 60 MVS	662530**50237**		
125x20x32			01	45	2	3SG 60 JVX	662530**50255***	SGB 60 LVX	662530**50286***		
			01	45	2			38A 60 KVS	662530**50620**		
			01	45	2			38A 60 LVS	699366**75736**		
150x2x32			01	45	6			38A 80 NVS	699366**77254***		
150x3,2x32			01	63	6					19A 60 MVS MTVS	699366**75941**
150x4x20			01	45	6			38A 60 LVS	699366**75591**		
			01	45	6			38A 80 NVS	699366**76720**		
			01	45	6			38A 100 MVS	699366**40219**		
150x4x30			01	63	6	3SG 80 NVX	699366**78980***	38A 80 NVS	699366**39730***		

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
						BEST					
			Type 01				Type 01F				
150x4x32			01	63	6					19A 60 MVS MTVS	69936**74920**
			01	63	6					19A 60 OVS MDVS	69936**75946**
150x6x20			01F	45	6					86A 80 OVS	69936**86760**
150x6x32			01	45	2	3SG 60 LVX	662530**55040**	SGB 80 LVX	662530**49867****		
			01	45	2	3SG 80 LVX	662530**54873***	38A 80 NVS	69936**41572****		
			01	45	2			38A 120 JVS	69936**75746***		
			01	45	2			38A 80 KVS	662530**51068***		
			01F	63	6					19A 60 MVS MTVS	69936**75964**
			01F	63	6					19A 60 OVS MDVS	69936**75963***
150x6x38			01	45	2			SGB 60 KVX	662530**49900**		
150x8x20			01F	45	6					86A 80 OVS	69936**86743***
150x8x32			01	45	2	3SG 60 JVX	662530**55041**	38A 60 LVS	69936**75743**		
			01	45	2			38A 80 MVS	662530**50388****		
			01	45	2			38A 120 JVS	69936**75748**		
			01F	63	6	3SG 80 NVX	662530**52706****	38A 60 MVS T6	69936**58071****	19A 60 NVS MTVS	662530**51097****
150x10x32			01	45	2	3NQ 60 LVQN	662532**62029***	SGB 60 KVX	662530**49871**		
			01	45	2	5SG 60 KVX	69936**40331***	SGB 100 JVX	662530**49894**		
			01	45	2	3SG 60 LVX	662530**50280**	38A 46 KVS	662530**51072****		
			01	45	2			38A 46 MVS	662530**50261***		
			01	45	2			38A 60 JVS	69936**74921**		
			01	45	2			38A 60 KVS	662530**51070**		
			01	45	2			38A 60 LVS	69936**75744**		
			01	45	2			38A 60 MVS	69936**41112**		
			01	45	2			38A 80 KVS	662530**51071****		
			01	45	2			38A 80 MVS	662530**50373**		
			01F	63	6					19A 60 OVS	662530**50201**
			01	45	2			38A 100 MVS	662530**50371***		
			01	45	2			38A 120 JVS	69936**75749**		
150x13x32			01	45	2	5SG 60 KVX	662530**54864***	38A 46 HVS	69936**75753***		
			01	45	2	3SG 46 HVX	662530**54863**	38A 46 LVS	69936**75754**		
			01	45	2	3SG 60 LVX	662530**50142**	38A 60 IVS	69936**75756**		
			01	45	2			38A 60 NVS	69936**75758**		
			01	45	2			38A 80 LVS	69936**75759**		
			01	45	2			38A 120 JVS	69936**75760**		
150x16x32			01	45	2	5SG 60 KVX	662530**54866***	38A 46 HVS	69936**75761**	86A 46 G12VXP	662530**50296****
			01	45	2	3SG 60 H12VXP	69936**77177**	38A 46 LVS	69936**75763**		
			01	45	2	3SG 60 LVX	662530**50367**	38A 46 NVS	69936**75762****		
			01	45	2			38A 60 LVS	69936**75764**		
			01	45	2			38A 80 LVS	69936**75767**		

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
						BEST					
Type 01											
150x20x32			01	45	2	5SG 60 KVX	69936**40816**	SGB 60 KVX	66253**049874**		
			01	45	2	3SG 60 KVX	66253**050155**	SGB 60 MVX	66253**050169****		
			01	45	2			SGB 100 JVX	66253**049895**		
			01	45	2			38A 46 KVS	66253**051064***		
			01	45	2			38A 46 MVS	66253**050372**		
			01	45	2			38A 60 KVS	66253**051065**		
			01	45	2			38A 60 LVS	69936**41391**		
			01	45	2			38A 60 NVS	69936**41392**		
			01	45	2			38A 80 KVS	66253**051067**		
			01	45	2			38A 80 LVS	69936**39416**		
			01	45	2			38A 100 JVS	66243**570493**		
150x25x32			01	45	2			38A 60 KVS	66253**050452**		
			01	45	2			38A 60 MVS	66253**050381**		
175x4x51			01	63	6					19A 60 MVS MTVS	66253**052709**
175x6x51			01	63	6					19A 60 MVS MTVS	69936**675980**
175x8x51			01	45	2			38A 60 LVS	69936**675786****		
180x6x32			01	45	2			SGB 120 JVX	69936**638720***		
			01	45	2			38A 60 LVS	69936**675784**		
			01	45	2			38A 120 LVS	69936**675791***		
			01	63	6					19A 60 MVS MTVS	69936**675979****
180x8x32			01	63	6					19A 60 MVS MTVS	69936**675982****
180x10x32			01	45	2			SGB 60 JVX	69936**639145***		
			01	45	2			38A 80 JVS	69936**675781**		
			01	63	6					19A 60 MVS MTVS	69936**675984**

* Made-to-order **Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

NORTON SAINT-GOBAIN

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER	BETTER	GOOD	GOOD
Type 01			Type 01F								
			01	45	2	3NQ 46 JVQN	66253262031	1TGP 60 H12VXP	69936676106		
			01	45	2	3SG 46 JVX	66253054876	38A 46 HVS	69936675798		
			01	45	2	3SG 80 JVX	66253054892	SGB 60 JVX	69936639148		
180x13x32			01	45	2	3SG 120 JVX	66253054874	38A 60 LVS	69936675797		
			01	45	2			SGB 80 JVX	69936639149		
			01	45	2			38A 80 LVS	69936675801		
			01	45	2			38A 120 JVS	69936675802*		
			01	45	2	3SG 46 HVX	66253054882	SGB 70 G12VXP	69936639169		
180x16x32			01	45	2			38A 46 HVS	69936675804*		
			01	45	2			38A 60 KVS	66253050453	86A 70 G12VXP	66253050358*
			01	45	2	3SG 46 HVX	66253054883	SGB 46 H12VXP	69936638723		
			01	45	2	3SG 60 I12VXP	66253050166**	38A 46 HVS	66253050454**		
			01	45	2			SGB 60 H10VXP	69936639170		
180x20x32			01	45	2			38A 46 JVS	69936693706**		
			01	45	2			SGB 60 KVX	66253049878		
			01	45	2			38A 60 JVS	69936675810		
			01	45	2			38A 60 MVS	66253050273		
180x25x32			01	45	2			38A 60 KVS	66253050365**		
			01	45	2			38A 60 LVS	69936675812		
180x25x51			01	45	2			38A 46 NVS	69936640967*		
			01	45	2			38A 60 MVS	69936641085*		
200x4x32			01	63	6					19A 60 OVS MDVS	69936675986
			01	45	2	3SG 60 LVX	69936639434**	SGB 120 JVX	69936677029		
			01	45	2			38A 60 MVS	66253050455		
200x6x32			01	45	2			38A 80 NVS	69936639662		
			01	63	6					19A 60 MVS MTVS	69936675988
			01	63	6					19A 60 OVS MDVS	69936675987*
200x8x20			01F	45	6			38A 60 NVS	69936688291*		
200x8x32			01	63	6			38A 60 MVS T6	69936658078*	19A 54 OVS MDVS	69936675989
			01	63	6					19A 60 MVS MTVS	69936675990

* Made-to-order ** Destock

DIAMOND DRESSING

- Norton offers an extensive range of complimentary diamond dressing solution
For more information see page 412

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST BEST		BETTER		GOOD	
			Type 01								
			01	45	2	3SG 60 LVX	662530**54884**	SGB 60 JVX	699366**39157**		
			01	45	2			38A 60 LVS	699366**75818**		
			01	45	2			SGB 80 JVX	699366**39158**		
200x10x32			01	45	2			38A 120 JVS	699366**75819**		
			01	63	6			38A 60 MVS T6	699366**75927**	86A 54 OVS D6	662530**50147***
			01	63	6					19A 54 OVS MDVS	699366**75991****
			01	63	6					19A 60 MVS MTVS	699366**75992****
			01F	63	6			38A 54 OVS	699366**67264***		
200x10x50,8			01	45	2	3NQ 60 JVQN	662532**61994***				
			01	45	2			SGB 60 JVX	699366**39160**		
			01	45	2			38A 46 HVS	699366**75826****		
			01	45	2			SGB 60 KVX	662530**49881**		
			01	45	2			38A 60 JVS	699366**75821**		
200x13x32			01	45	2			SGB 80 JVX	699366**39161**		
			01	45	2			38A 60 LVS	699366**75823**		
			01	45	2			SGB 120 JVX	699366**76608**	86A 70 G12VXP	662530**50374****
			01	63	6			38A 60 MVS T6	699366**75928**	19A 54 OVS MDVS	699366**75993****
			01	63	6					19A 60 MVS MTVS	699366**75994***
200x13x50,8			01	45	2			38A 60 JVS	699366**39432****		
200x16x32			01	45	2			38A 46 HVS	699366**75828****		
			01	45	2			38A 60 KVS	662530**50456****		
200x16x50,8			01	45	2			38A 60 JVS	699366**41314***		
200x16x76,2			01	45	2			38A 60 LVS	699366**75827**		
			01	45	2	3NQ 60 H12VQNP	662532**62059***	SGB 46 HVX	699366**39171**	86A 54 H12VXP	662530**51532****
			01	45	2	3NQ 60 JVQN	662532**62023***	38A 46 HVS	699366**75551**		
			01	45	2	3NQ 46 JVQN	662532**61995**	SGB 60 H12VXP	699366**39172**		
			01	45	2	3SG 60 H12VXP	699366**77181**	38A 46 KVS	662530**51075**		
			01	45	2	3SG 60 IVX	662530**50258****	SGB 60 KVX	662530**49887**		
200x20x32			01	45	2	3SG 60 JVX	662530**55869**	38A 46 NVS	699366**41400**		
			01	45	2			SGB 60 MVX	662530**50173****		
			01	45	2			38A 60 KVS	662530**51077**		
			01	45	2			38A 60 NVS	699366**67154**		
			01	45	2			38A 80 KVS	662530**51080**		
			01	45	2	3SG 46 E12VXP	699366**76703***	38A 46 KVS	699366**41104**	86A 46 IVTECH	662530**50386****
200x20x50			01	45	2	3SG 60 HVX	662530**54886***				
			01	45	2	3SG 60 JVX	662530**50362***				

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

JIMI VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER	BETTER	GOOD	GOOD
Type 01											
200x20x50,8			01	45	2	5NQ 46 G12VQNP	662532**61978**	38A 46 JVS	699366**75832**		
			01	45	2	3NQ 60 H12VQNP	662532**57432***	38A 46 KVS	662530**50103****		
			01	45	2	3NQ 60 JVQN	662532**62001**	38A 60 HVS	699366**75834**		
			01	45	2	3NQ 46 JVQN	662532**61996***	38A 60 KVS	662530**49967**		
			01	45	2	3NQ 46 KVQN	662532**61991**	38A 100 JVS	699366**39795****		
			01	45	2	3SG 46 I12VXP	662530**52711**				
			01	45	2	3SG 60 H12VXP	662435**93696**				
			01	45	2	3SG 80 HVX	699366**76399***				
200x20x51			01	45	2	5NQ 46 F12VQNP	662532**61993***	SGB 60 JVX	699366**39251**		
			01	45	2			38A 46 KVS	662530**51084***		
			01	45	2			38A 60 KVS	662530**51085****		
200x20x76			01	45	2	3SG 46 IVX	662530**54888**			86A 46 IVTECH	662530**50250****
200x20x76,2			01	45	2	3SG 46 HVX	662530**50156**	38A 46 HVS	699366**41521**		
			01	45	2	3SG 60 IVX	662530**50157****	38A 60 LVS	699366**75836**		
200x25x32			01	45	2	3NQ 60 JVQN	662532**62033***	SGB 46 GV12XP	662530**51385***		
			01	45	2	3SG 60 JVX	662530**54889**	38A 46 LVS	699366**27127**		
			01	45	2			SGB 60 KVX	662530**49888**		
			01	45	2			38A 46 NVS	699366**41406**		
			01	45	2			38A 60 LVS	699366**41407**		
			01	45	2			38A 60 MVS	662530**51079**		
			01	45	2			38A 80 KVS	662530**51082**		
			01	45	2			38A 80 NVS	699366**75847**		
			01	45	2			38A 100 JVS	662435**70496**		
200x25x50,8			01	45	2			SGB 46 KVX	662530**50183**		
			01	45	2			38A 46 HVS	699366**75840**		
			01	45	2			38A 54 I12VXP	699366**81147***		
200x25x51			01	45	2			SGB 46 HVX	662530**49855***		
			01	45	2			38A 46 KVS	662530**51086**		
			01	45	2			38A 60 KVS	662530**51089***		
			01	45	2			38A 60 LVS	699366**40125**		
200x25x76,2			01	45	2			38A 46 HVS	699366**41562****		
			01	45	2			38A 46 KVS	662530**49968***		
			01	45	2			38A 46 NVS	699366**75841**		
			01	45	2			38A 60 MVS	662530**49969****		
			01	45	2			38A 60 NVS	699366**75846**		
200x32x32			01	45	2			SGB 60 KVX	662530**49892**		
			01	45	2			38A 46 MVS	662530**52712**		
			01	45	2			38A 60 LVS	699366**75855**		
			01	45	2			38A 60 NVS	699366**67155**		

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER		GOOD	
			Type 01								
200x32x51			01	45	2			38A 60 LVS	69936**40245**		
200x32x76,2			01	45	2			38A 46 IVS	662530**52713****		
			01	45	2			38A 46 NVS	69936**75849**		
			01	45	2			38A 60 MVS	662530**49972**		
			01	45	2			38A 60 NVS	69936**75854**		
200x35x32			01	45	2			SGB 46 KVX	662530**49859***		
200x40x50,8			01	45	2			SGB 46 H12VXP	69936**76377****		
			01	45	2			38A 46 IVS	69936**81707**		
225x5x60			01	45	2			38A 54 JVS	69936**75859**		
225x20x51			01	45	2	3NQ 60 H12VQNP	662532**62058***	SGB 60 HVX	69936**40943**		
			01	45	2	3SG 60 H12VXP	69936**76452**	38A 46 IVS	69936**40871**		
225x25x51			01	45	2	3SG 54 F12VXP	69936**76380***				
225x25x76,2			01	45	2	3SG 46 HVX	662435**70377**				
225x32x76,2			01	45	2	3SG 46 HVX	662530**55043**				
			01	45	2	3SG 60 H12VXP	662435**93705**				
230x6x50,8			01	45	2			38A 100 JVS	69936**39629**		
230x10x32			01	63	6			38A 60 MVS T6	69936**75929**		
230x10x50,8			01	45	2			38A 100 JVS	69936**40665***		
230x13x32			01	63	6			38A 60 MVS T6	69936**75930**		
230x20x50,8			01	45	2	3SG 60 IVX	662530**50240***	38A 60 JVS	69936**39549****		
230x25x50,8			01	45	2			38A 60 HVS	69936**39829**		
250x10x32			01	45	1			38A 60 KVS	662530**49904***		
			01	63	6			38A 60 MVS T6	69936**75931**	86A 54 KVS M6	662530**50146***
			01	63	6					86A 54 OVS D6	662530**50139**
			01	63	6					19A 54 OVS MDVS	69936**75998***
			01	63	6					19A 60 MVS MTVS	69936**75999***
			01F	45	6			38A 46 MVS	662530**50218****		
			01F	45	6			38A 54 OVS	69936**67265***		
250x13x32			01	63	6			38A 60 MVS T6	69936**75932**	86A 54 KVS M6	662530**50123**
			01	63	6					86A 54 OVS D6	662530**50128**
			01	63	6					19A 60 MVS MTVS	69936**76001**
250x13x76,2			01	45	1	3SG 60 KVX	69936**23734**				
250x20x32			01	45	1			38A 46 KVS	662530**49918****		
			01	45	1			38A 60 KVS	662530**49920***		

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
						BEST					
Type 01											
			01	45	1	5NQ 46 G12VQNP	662532**61918***	38A 60 LVS	699366**75862**		
250x20x76,2			01	45	1	3NQ 46 JVQN	662532**61919**				
			01	45	1	3NQ 60 JVQN	662532**61990**				
			01	45	1	3SG 60 HVX	662530**50363****	SGB 60 KVX	662530**50160****	86A 46 IVTECH	662530**50275****
			01	45	1			38A 60 JVS	662530**51098***	86A 60 IVTECH	662530**50390****
			01	45	1			38A 60 KVS	662530**49930****		
250x25x32			01	45	1			38A 60 LVS	662530**49927**		
			01	45	1			38A 60 MVS	662530**51380***		
			01	45	1			38A 80 KVS	662530**49932****		
250x25x50,8			01	45	1	3SG 46 KVX	662530**50107**	38A 46 LVS	699366**23714****		
			01	45	1			38A 46 IVS	699366**40283***		
250x25x51			01	45	1			38A 46 KVS	662530**49936***		
			01	45	1			38A 60 KVS	662530**49939****		
			01	45	1	5NQ 46 G12VQNP	662532**62010**	38A 46 KVS	662530**49902****		
250x25x76			01	45	1			38A 60 KVS	662530**49905***		
			01	45	1			38A 60 LVS	699366**78984***		
			01	45	1			38A 80 KVS	662530**49907****		
			01	45	1	3SG 46 KVX	699366**23668**	IPA 60 EH17VTX	662530**52716**		
			01	45	1	3SG 54 F12VXP	699366**76054**	38A 46 G12VXP	662530**50292***		
			01	45	1	3SG 60 KVX	662530**55045**	IPA 60 XH17VTX	662530**52721**		
			01	45	1			38A 46 IVS	662530**50369**		
			01	45	1			SGB 46 HVX	662435**70378***		
			01	45	1			38A 46 LVS	699366**23691**		
250x25x76,2			01	45	1			SGB 46 KVX	662530**50124**		
			01	45	1			38A 60 IVS	662530**50101**		
			01	45	1			SGB 60 KVX	662530**50126**		
			01	45	1			38A 60 LVS	699366**23733**		
			01	45	1			SGB 70 H12VXP	699366**23901**		
			01	45	1			38A 80 LVS	699366**23651**		
250x25x120,6			01	45	1			38A 60 LVS	699366**23688****		
			01	45	1			SGB 60 KVX	662530**50162***		
			01	45	1			38A 46 KVS	662530**49909****		
250x32x32			01	45	1			38A 60 KVS	662530**49911**		
			01	45	1			38A 60 NVS	699366**67158**		
			01	45	1			38A 80 KVS	662530**49915**		
250x32x76			01	45	1			38A 60 KVS	662530**51102****		
			01	45	1	3NQ 46 HVQN	662532**62034***				
250x32x76,2			01	45	1	3SG 46 HVX	662530**55046**				

* Made-to-order ** Destock

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER		GOOD	
Type 01											
250x40x32			01	45	1			38A 60 KVS	662530**51093***		
250x40x51			01	45	1			38A 60 KVS	662530**51095***		
250x40x76			01	45	1			38A 46 KVS	662530**51104***		
250x40x76,2			01	45	1	3NQ 46 G12VQNP	662532**62056***	SGB 46 I10VXP	662530**50205***		
			01	45	1	3SG 46 G12VXP	699366**76056**	38A 46 I12VXP	699366**81148***		
			01	45	1	3SG 46 IVX	662530**50259**	38A 46 KVS	662530**50186**		
250x50x76,2			01	45	1			SGB 46 KVX	662530**50129***		
			01	45	1			38A 46 LVS	699366**23717***		
300x13x127			01	45	1			SGB 60 KVX	662530**50131****		
			01	45	1			38A 60 LVS	699366**23652***		
300x20x127			01	45	1			38A 60 LVS	699366**75872**		
300x25x127			01	45	1	3NQ 60 KVQN	662532**62040**	SGB 60 KVX	662530**50132**	57A 60 LVS	662530**50370****
			01	45	1	3SG 46 KVX	662530**55050**	38A 46 LVS	699366**23601**		
			01	45	1	3SG 60 H12VXP	699366**77184**	SGB 80 I12VXP	662530**50121**		
			01	45	1	3SG 60 KVX	662530**55052**	38A 60 KVS	662530**50105**		
			01	45	1			38A 80 LVS	699366**23648**		
300x32x32			01	45	1			38A 46 NVS	699366**75879**		
			01	45	1			38A 60 KVS	662530**51100**		
			01	45	1			38A 60 NVS	699366**39618**		
300x32x76,2			01	45	1			38A 46 HVS	699366**75880**		
300x32x127			01	45	1	3SG 60 KVX	662530**55872**	IPA 60 EH20VTX	662530**49858**		
			01	45	1			38A 46 HVS	699366**75883**		
			01	45	1			IPA 60 XH20VTX	662530**49861***		
			01	45	1			38A 60 LVS	699366**75884**		
			01	45	1			SGB 46 F12VXP	699366**76705**		
			01	45	1			SGB 46 HVX	662435**70380***		
			01	45	1			SGB 46 IVX	662530**50175***		
			01	45	1			SGB 60 KVX	699366**76386**		
300x40x51			01	45	1			38A 46 KVS	662530**51096***		
			01	45	1			38A 60 KVS	662530**49944****		
300x40x76			01	45	1			38A 46 KVS	662530**49948**		
			01	45	1			38A 60 KVS	662530**49953**		
300x40x76,2			01	45	1			IPA 60 EH20VTX	662530**49863**		
			01	45	1			IPA 60 XH20VTX	662530**49866**		

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

NORTON SAINT-GOBAIN

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST BEST		BETTER		GOOD	
Type 01											
300x40x127			01	45	1	3NQ 60 KVQN	66253262046*	SGB 46 G12VXP	69936639946	86A 54 G12VXP	66253051533**
			01	45	1	3SG 46 HVX	66253055893				
			01	45	1	3SG 60 KVX	66253055053	SGB 60 KVX	66253050179*		
			01	45	1			38A 60 LVS	69936675891		
300x50x76,2			01	45	1			38A 46 IVS	66253050251		
	160	10	07	45	1	3NQ 46 HVQN	66253262412*				
300x50x127			01	45	1			IPA 60 EH20VTX	66253049869*		
			01	45	1			38A 46 JVS	69936623649		
			01	45	1			IPA 60 XH20VTX	66253049872*		
			01	45	1			38A 60 KVS	66253054524**		
			01	45	1			SGB 46 G12VXP	66243570384		
355x25x127			01	45	1	3SG 60 LVX	66253055895	IPA 60 EH20VTX	66253049873		
			01	45	1			38A 60 LVS	69936675901		
			01	45	1			IPA 60 XH20VTX	66253049875**		
			01	45	1			SGB 46 JVX	66253050118*		
			01	45	1			SGB 60 LVX	66253050135		
355x30x127			01	45	1			SGB 46 G11VXP	66253050177**		
355x32x127			01	45	1	3SG 60 KVX	66253055902	SGB 54 E12VXP	69936676713		
			01	45	1			38A 60 LVS	69936675903		
355x40x51			01	45	1			38A 46 KVS	66253051373**		
			01	45	1			38A 60 KVS	66253049963**		
355x40x127			01	45	1	3NQ 46 HVQN	66253262048*	IPA 60 EH20VTX	66253049877		
			01	45	1	3SG 46 HVX	66253055056	38A 46 JVS	69936623753		
			01	45	1	3SG 60 LVX	66253055057	IPA 60 XH20VTX	66253049879		
			01	45	1			38A 60 LVS	69936675908		
			01	45	1			SGB 46 G12VXP	66253049901		
			01	45	1			SGB 46 JVX	66253050117		
			01	45	1			SGB 80 I12VXP	66253055058**		
355x50x51			01	45	1			38A 46 KVS	66253049941**		
			01	45	1			38A 60 KVS	66253051101**		
355x50x127			01	45	1	3NQ 46 HVQN	66253262049	IPA 60 EH20VTX	66253049880		
			01	45	1	3NQ 46 F12VQNP	66253262055*	38A 46 IVS	69936675913		
			01	45	1	3SG 46 F12VXP	69936623900	IPA 60 XH20VTX	66253049883		
			01	45	1	3SG 46 HVX	66253055059	38A 46 I11VXP	66253050212		
			01	45	1	3SG 46 JVX	66253055063	SGB 46 H11VXP	66253054500		
			01	45	1			38A 46 KVS	66253051108		
			01	45	1			SGB 46 J12VX	69936623781		
			01	45	1			38A 60 KVS	66253049951		
			01	45	1			SGB 54 G12VXP	66253049857		
			01	45	1			38A 80 KVS	66253049955**		
			01	45	1			SGB 60 KVX	66253050138		

* Made-to-order ** Destock

VELKOOBCHOD BRUSIVA

METAL PRECISION GRINDING WHEELS

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
						BEST					
Type 01											
355x63x127			01	45	1			38A 46 KVS	662530**49957***		
			01	45	1			38A 60 KVS	662530**49959***		
406x25x127			01	45	1	3SG 60 LVX	662530**55083**	SGB 60 KVX	699366**44046**		
			01	45	1			38A 60 LVS	699366**94018**		
406x32x127			01	45	1			38A 60 LVS	662530**49841**		
406x40x127			01	45	1	3SG 60 LVX	662530**55086**	SGB 60 KVX	662530**49843**		
			01	45	1			38A 46 JVS	662434**66541**		
			01	45	1			38A 46 KVS	662530**55066***		
			01	45	1			38A 60 LVS	662434**66542**		
			01	45	1			38A 80 KVS	662530**55069***		
406x50x127			01	45	1	5NQ 46 G12VQNP	662532**60614***	IPA 60 EH20VTX	662530**49884**		
			01	45	1	3NQ 46 HVQN	662532**58471***	38A 46 I12VXP	662530**54508**		
			01	45	1	5SG 46 G12VXP	662434**68188**	IPA 60 XH20VTX	662530**49885***		
			01	45	1	3SG 46 HVX	662530**55912**	38A 46 JVS	662434**66547***		
			01	45	1	3SG 54 F12VXP	662530**54506**	SGB 46 G12VXP	662434**68401**		
			01	45	1			38A 60 LVS	662434**66546***		
			01	45	1			SGB 46 HVX	662434**48363**		
			01	45	1			SGB 60 KVX	662530**55072**		
406x50x203			01	45	1			38A 46 KVS	662530**55078****		
			01	45	1			38A 60 KVS	662530**55079***		
406x60x127			01	45	1			38A 60 LVS	662530**49839****		
406x76x127	215/215	12/25	07	45	1	3NQ 54 E12VQNP	662532**60644***				
457x50x127			01	45	1			38A 60 LVS	662434**66558**		

* Made-to-order ** Destock

DIAMOND DRESSING

- Norton offers an extensive range of complimentary diamond dressing solution
For more information see page 412

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, P = Recess Diameter, F = Recess Depth

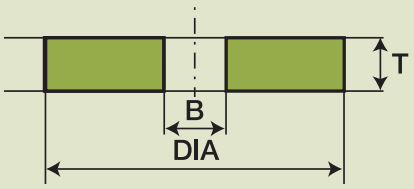
STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB (mm)	P (mm)	F (mm)	SHAPE	MOS (m/s)	PK QTY	INNOVATION BEST	BEST	BETTER		GOOD	
Type 01											
500x50x203			01	45	1			38A 60 KVS	662530**54504***		
500x50x203,2			01	45	1			SGB 60 KVX	662434**48367***		
500x60x203,2			01	45	1			SGB 60 KVX	662530**49853***		
500x63x203,2			01	45	1			38A 60 LVS	662434**47835****		
500x80x203,2			01	45	1			SGB 60 JVX	662530**49850****		
508x50x203,2			01	45	1	3NQ 60 KVQN	662532**60617***				
			01	45	1	3SG 60 KVX	662530**55088**				
508x80x203,2			01	45	1			38A 60 LVS	662434**65706**		
508x203x304,8			01	45	1					57A 60 MVS	662530**49852**
710x40x50			01	45	1					A90 NVS	662530**49847****

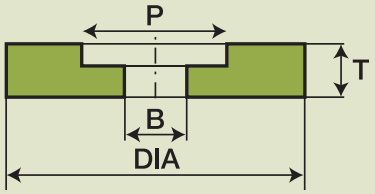
* Made-to-order ** Destock

SHAPE KEY

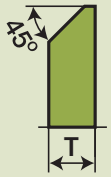
Type 01



Type 05



Type 01F



Jimi VELKOOBCHOD BRUSIVA

GEAR GRINDING WHEELS

Introducing the new Norton Gear Grinding Fast Track Service. All Norton profile wheels are produced on a made to order basis using CNC controlled machines & are finished using Norton dressing tools. This gives Norton gear grinding wheels excellent accuracy & repeatability.

APPLICATIONS & MARKETS

- Gear Grinding

BEST

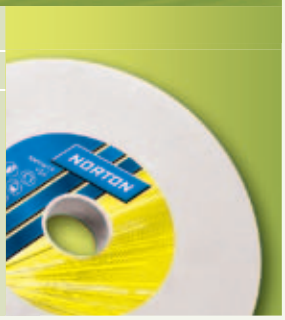
ALTOS

FEATURES	BENEFITS
100% high performance ceramic aluminium oxide grain	Extremely sharp ceramic grain with excellent cutting capability
High porosity and permeability, which maximises the amount of coolant in the grinding zone	Very high metal removal rates – 2 to 3 times more than standard abrasives
Optimum grain spacing	Improved form holding and reduced wheel dressing

GOOD

27AH

FEATURES	BENEFITS
Monocrystalline grain	Consistent grinding performance
Tougher abrasive than pure white aluminium oxide	Cool & burn free cutting



KEY PROGRAM FEATURES

- Fast Track Service; 2 weeks leadtime

VELKOOBCHOD BRUSIVA

WORM GEAR GRINDING

MACHINE	DIMENSIONS DIAxTxB(mm)	BEST	
KLINGELNBERG	400x20-60*x127	TGX120F13VCF5	662532**53540****

* Please indicate required dimensions at time of ordering. Please also send a technical drawing if available. ** Destock

PROFILE GEAR GRINDING

MACHINE	DIMENSIONS DIAxTxB(mm)	BEST	
PFAUTER	400x30-60*x127	TGX120F13VCF5	662532**53540****
NILES	400x30-60*x127	TGX120F13VCF5	662532**53540****

* Please indicate required dimensions at time of ordering. Please also send a technical drawing if available. ** Destock

CONTINUOUS GENERATED GEAR GRINDING

MACHINE	DIMENSIONS DIAxTxB(mm)	GOOD	
REISHAUER	350x84x160	27AH100K8V4181	003103**21581****
	350x104x160	27AH100K8V4181	003103**21581****
	300x125x160	27AH100K8V4181	003103**77385****
	275x125x160	27AH100K8V4181	003103**77385****
GLEASON	350x104x160	27AH100K8V4181	003103**21581****
	240x125x120	27AH100K8V4181	003103**77385****
OKAMOTO	350x104x160	27AH100K8V4181	003103**21581****

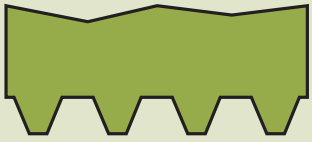
To proceed correctly customer's order, we would require indication of module number, angle, number of starts and/or drawing. ** Destock

SHAPE KEY

Worm Gear Grinding

Profile Gear Grinding

Continuous Generated Gear Grinding



Jimi VELKOOBCHOD BRUSIVA

NON-FERROUS PRECISION GRINDING WHEELS

Norton vitrified grinding wheels have set the standard for generations – leading the way with technological improvements to maximise performance and productivity. Silicon carbide wheels are used primarily on tungsten carbide, non-magnetic stainless steel, aluminium and glass.

APPLICATIONS & MARKETS

- Surface grinding
- Tool & cutter grinding
- Sharpening

BETTER

39C

Type 01

FEATURES	BENEFITS
Highest purity green silicon carbide abrasive	Ideal for precision grinding & sharpening applications on metal carbide
Harder & more friable than aluminium oxide abrasive	

DIAMOND DRESSING

- Norton offers an extensive range of complimentary diamond dressing solution
For more information see page 412

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

NORTON SAINT-GOBAIN

STRAIGHT WHEELS

DIM DIAxTxB(mm)	SHAPE	MOS (m/s)	PK QTY	BETTER	
Type 01					
76x25x12,7	01	45	10	39C 80 IV	66253052726
76x25x13	01	45	10	39C 80 IV	66253050168**
80x25x12,7	01	45	10	39C 60 MV	66253051624
80x25x13	01	45	10	39C 60 MV	66253051623
100x10x32	01	45	2	39C 80 LVS	66253050380
	01	45	2	39C 120 KVS	66253049701*
125x13x32	01	45	2	39C 80 KVS	66253049896
125x16x32	01	45	2	39C 80 LVS	66253050393
125x20x32	01	45	2	39C 80 LVS	69936667443
150x4x32	01	45	2	39C 120 KVS	66253050248
150x6x32	01	45	2	39C 100 KVS	66253050377
	01	45	2	39C 120 KVS	69936675617
150x10x32	01	45	2	39C 80 KVS	66253050357
	01	45	2	39C 120 KVS	69936675629
150x13x32	01	45	2	39C 80 KVS	66253049897*
150x16x32	01	45	2	39C 60 KVS	69936675656
	01	45	2	39C 120 KVS	69936675659
	01	45	2	39C 80 LVS	69936675657
150x20x20	01	45	2	39C 60 JV	66253051383**
150x20x32	01	45	2	39C 60 KVS	69936641411
	01	45	2	39C 80 LVS	69936641413
	01	45	2	39C 100 JVS	66253050300**
	01	45	2	39C 120 KVS	69936641414
150x25x32	01	45	2	39C 60 KVS	69936675661
	01	45	2	39C 80 KVS	66253050278
	01	45	2	39C 120 KVS	69936675664
180x20x32	01	45	2	39C 60 KVS	69936641415
	01	45	2	39C 80 LVS	69936676582
	01	45	2	39C 120 KVS	69936675666
180x25x32	01	45	2	39C 60 KVS	69936675667
	01	45	2	39C 80 LVS	69936667101
200x6x32	01	45	2	39C 120 KVS	69936675636
200x10x32	01	45	2	39C 120 KVS	69936675637
200x13x32	01	45	2	39C 80 JVS	69936676152
200x20x20	01	45	2	39C 80 KVS	69936641417
	01	45	2	39C 80 MVS	69936640220
200x20x32	01	45	2	39C 60 KVS	69936641418
	01	45	2	39C 80 KVS	69936676351
	01	45	2	39C 100 JVS	66253050389**
	01	45	2	39C 120 KVS	69936641421
200x20x51	01	45	2	39C 60 KVS	69936640176
200x20x76,2	01	45	2	39C 80 LVS	69936675671

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB(mm)	SHAPE	MOS (m/s)	PK QTY	BETTER	
Type 01					
200x25x32	01	45	2	39C 46 LVS	69936**75639**
	01	45	2	39C 60 KVS	69936**41424**
	01	45	2	39C 80 KVS	66253**50276**
	01	45	2	39C 100 JVS	66253**50375***
	01	45	2	39C 120 KVS	69936**41428**
200x25x76,2	01	45	2	39C 60 KVS	69936**75672**
	01	45	2	39C 80 LVS	69936**75673**
	01	45	2	39C 120 KVS	69936**75674**
200x32x32	01	45	2	39C 60 KVS	69936**40293**
	01	45	2	39C 80 KVS	69936**67106**
	01	45	2	39C 120 KVS	69936**75677**
200x32x51	01	45	2	39C 60 KVS	69936**41031**
200x32x76,2	01	45	2	39C 60 KVS	69936**75643**
	01	45	2	39C 80 KVS	69936**75644**
	01	45	2	39C 120 KVS	69936**75678****
225x25x32	01	45	2	39C 60 LVS	69936**67108***
225x32x32	01	45	2	39C 80 KVS	69936**67109****
250x13x32	01	45	1	39C 36 KV	69936**55917****
250x25x32	01	45	1	39C 60 KV	66253**49923***
	01	45	1	39C 60 LVS	69936**67111***
	01	45	1	39C 80 KV	66253**50477**
	01	45	1	39C 80 LVS	69936**75679**
250x25x76,2	01	45	1	39C 54 MVS	69936**23732**
	01	45	1	39C 100 KVS	69936**23643**
250x32x32	01	45	1	39C 60 KVS	69936**39837**
	01	45	1	39C 80 KVS	69936**40845**
300x25x127	01	45	1	39C 60 KVS	69936**23687**
	01	45	1	39C 80 JVS	69936**40343**
	01	45	1	39C 100 KVS	69936**23679****
300x32x127	01	45	1	39C 60 KVS	69936**93249**
300x40x32	01	45	1	39C 60 KVS	69936**39362**
	01	45	1	39C 80 KVS	69936**76387**
300x40x76	01	45	1	39C 90 KVS	69936**39836***
300x40x127	01	45	1	39C 46 KV	66253**50289***
	01	45	1	39C 60 KVS	69936**75684**
	01	45	1	39C 80 KVS	69936**75649**
355x32x127	01	45	1	39C 60 KVS	69936**75650**
	01	45	1	39C 80 KVS	69936**75651**
355x40x127	01	45	1	39C 60 KVS	69936**75685**
406x40x127	01	45	1	39C 80 KVS	66243**66414**

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

NOTES

VELKOOBCHOD BRUSIVA

BENCH WHEELS

Vitrified bench grinding wheels are used for off-hand tool sharpening and grinding.

APPLICATIONS & MARKETS

- Sharpening
- Tool room

GOOD

A

Type 01

FEATURES	BENEFITS
Regular brown aluminium oxide abrasive	Very tough, suitable for grinding most types of steel & soft iron
Contains 3% titanium oxide	Good cost/performance compromise
Unique, self sharpening, microcrystalline structure	Hard wearing wheels for general purpose cylindrical off-hand bench & pedestal grinding applications

DIAMOND DRESSING

- Norton offers an extensive range of complimentary diamond dressing solutions For more information see page 412

STRAIGHT WHEELS

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	GOOD	
			Type 01	
125x15x20	45	2	A 60 NVS	662530**50184**
125x20x32	45	2	A 36 PVS	699366**66907**
	45	2	A 46 NVS	699366**75558**
	45	2	A 60 NVS	699366**66909**
150x16x32	45	2	A 36 PVS	699366**75559**
	45	2	A 46 NVS	699366**75560**
	45	2	A 60 NVS	699366**75561**
150x20x20	45	2	A 60 MVS	662530**51382**
150x20x31,75	45	2	A 36 PVS	699366**23300***
150x20x32	45	2	A 24 RVS	699366**66911****
	45	2	A 36 PVS	699366**41366**
	45	2	A 36 QVS	662530**50263***
	45	2	A 46 NVS	699366**41367**
	45	2	A 60 NVS	699366**41368**

* Made-to-order ** Destock

VELKOOBCHOD BRUSIVA

STRAIGHT WHEELS (CONTINUED)

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	GOOD	
Type 01				
150x25x32	45	2	A 36 PVS	69936**66914**
	45	2	A 36 QVS	66253**50265**
	45	2	A 46 NVS	69936**41370**
180x20x32	45	2	A 46 NVS	69936**41372**
	45	2	A 60 NVS	6993**680380**
180x25x32	45	2	A 24 RVS	69936**66922****
	45	2	A 30 PVS	6993**639691**
	45	2	A 36 QVS	69936**66923****
	45	2	A 46 NVS	69936**75564**
	45	2	A 60 NVS	69936**76609**
200x20x32	45	2	A 24 RVS	69936**66926***
	45	2	A 30 PVS	69936**75566**
	45	2	A 36 QVS	69936**66928***
	45	2	A 46 NVS	69936**41375**
	45	2	A 60 NVS	69936**66929**
200x25x32	45	2	A 24 RVS	69936**76374**
	45	2	A 30 PVS	69936**41382**
	45	2	A 36 PVS	69936**41383**
	45	2	A 36 QVS	66253**50267**
	45	2	A 46 MVS	66253**50271**
	45	2	A 60 NVS	6993**693708**
200x25x76,2	45	2	A 30 PVS	69936**75567**
	45	2	A 46 NVS	69936**75568**
	45	2	A 60 NVS	69936**75569**
200x32x32	45	2	A 24 RVS	69936**66930***
	45	2	A 36 PVS	69936**66932**
	45	2	A 46 NVS	69936**40814**
	45	2	A 60 NVS	6993**690246**
200x32x51	45	2	A 60 NVS	69936**40748**
200x32x76,2	45	2	A 46 NVS	66243**93707**
225x32x32	45	2	A 36 QVS	69936**66938**
	45	2	A 60 NVS	6993**694426***
250x25x32	45	1	A 36 PVS	69936**66940**
	45	1	A 46 NVS	69936**41386**
250x32x32	45	1	A 24 QVS	69936**66942**
	45	1	A 30 PVS	69936**75572**
	45	1	A 36 PVS	69936**66943**
	45	1	A 46 NVS	69936**40194**
	45	1	A 60 MVS	69936**42130**

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	GOOD	
Type 01				
250x40x32	45	1	A 36 QVS	69936**66945**
	45	1	A 60 NVS	69936**66946**
300x32x32	45	1	A 24 QVS	69936**75574**
	45	1	A 36 OVS	69936**75575**
	45	1	A 60 KVS	66253**51091***
300x32x50,8	45	1	A 24 QVS	69936**75577**
	45	1	A 46 NVS	69936**75578**
300x32x127	45	1	A 24 QVS	69936**75579**
	45	1	A 36 OVS	69936**75580**
	45	1	A 46 NVS	69936**75581**
300x40x30	45	1	A 36 PVS	69936**81734**
	45	1	A 60 NVS	69936**81735**
300x40x32	45	1	A 46 NVS	69936**39682**
	45	1	A 60 MVS	69936**40221**
300x40x50	45	1	A 90 OVS	69936**40787***
300x40x50,8	45	1	A 60 NVS	69936**23670***
300x40x51	45	1	A 24 PVS	66253**51090***
	45	1	A 60 KVS	66253**51092****
300x40x76	45	1	A 60 NVS	69936**39611***
300x40x76,2	45	1	A 36 OVS	69936**75607**
300x40x127	45	1	A 24 QVS	69936**75583**
	45	1	A 36 OVS	69936**75584**
	45	1	A 46 NVS	69936**75585**
300x50x32	45	1	A 24 QVS	69936**39767**
	45	1	A 36 OVS	69936**81823**
	45	1	A 46 NVS	66243**70460***
	45	1	A 60 NVS	66243**70484**
350x40x35	45	1	A 36 QVS	69936**81739**
350x50x35	45	1	A 24 RVS	69936**81743***
	45	1	A 36 QVS	69936**81741***
	45	1	A 60 NVS	69936**81742**
355x40x127	45	1	A 24 QVS	69936**75586**
	45	1	A 46 NVS	69936**75587**
355x45x127	45	1	A 36 OVS	69936**76013**
	45	1	A 46 NVS	6993**675910****
355x50x127	45	1	A 24 QVS	69936**75588**
	45	1	A 36 OVS	69936**75589**
	45	1	A 46 NVS	69936**75590**
406x40x50,8	45	1	A 24 QVS	6993**694363****
406x50x50	45	1	A 24 QVS	66243**48177**
406x50x127	45	1	A 24 QVS	66243**67496**
	45	1	A 36 QVS	66243**67497**

* Made-to-order ** Destock

All wheels with diameters 100mm-200mm and a 32mm bore are supplied with plastic bushes to reduce the bore size to 20mm. For a full range of plastic bushes please refer to the Technical Information Section at the back of this catalogue.

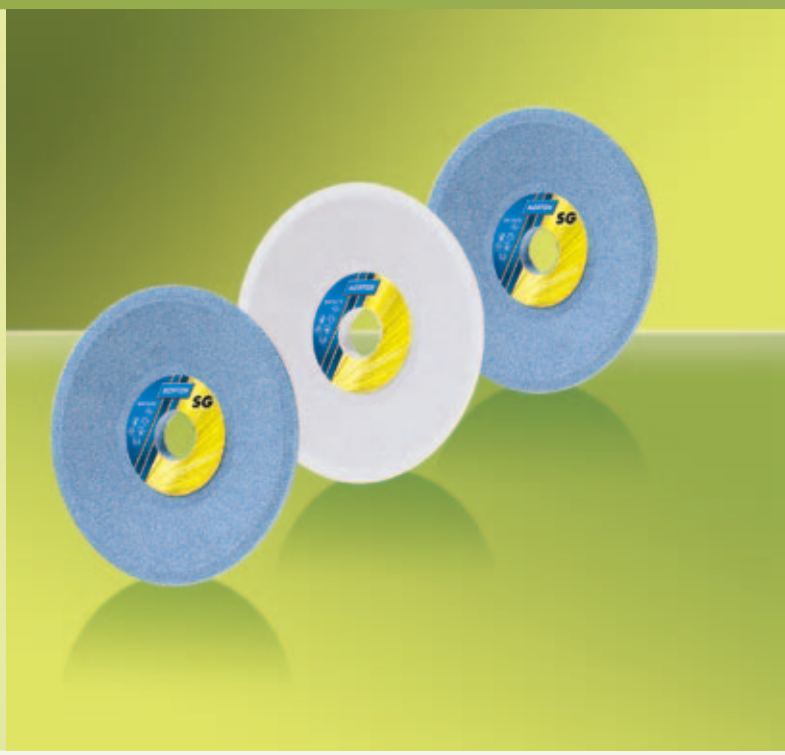
Dimensions Key: DIM = Dimensions, D = Diameter, T = Thickness, B = Bore

DISHES

Manufactured using Norton's market leading abrasives technology, vitrified dishes are designed to maximise performance and productivity in sharpening applications.

APPLICATIONS & MARKETS

- Sharpening



INNOVATION BEST

5NQ

Type 12

NORTON QUANTUM

FEATURES	BENEFITS
Engineered ceramic grain shape and chemistry with new bond technology.	Versatile in all low, medium and high force applications
A perfect blend between sharpness (free cutting) and toughness (life)	30% to 100% higher metal removal rate >15% lower threshold power

BEST

3SG®

Type 12

FEATURES	BENEFITS
High concentration of SG® ceramic aluminium oxide abrasive	Very high cutting capability
Unique, self sharpening, microcrystalline structure	High removal rate & extended wheel life Suitable for very hard steels

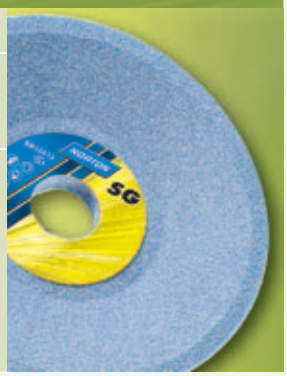
VELKOOBCHOD BRUSIVA

BETTER

SGB®

Type 12

FEATURES	BENEFITS
■ Medium concentration of SG® ceramic aluminium oxide abrasive	■ Good cutting capability
■ Harder & sharper than conventional abrasive grains	■ Suitable for low to medium power machines ■ Very versatile, for use on a wide variety of steels



GOOD

38A

Type 12

FEATURES	BENEFITS
■ High purity white aluminium oxide abrasive	■ Cool & burn free cutting
■ Friable abrasive	■ Ideal for heat-sensitive applications with light to moderate feed rates

Jimi VELKOOBCHOD BRUSIVA

METAL PRECISION

DIM DIAxTxB (mm)	W (mm)	E (mm)	J (mm)	K (mm)	U (mm)	MOS (m/s)	PK QTY	INNOVATION BEST BEST		BETTER		GOOD	
Type 12													
76x8x12,7	5	8	25	25	1	45	10					38A 80 MVS	699366**23916***
80x10x13	4	6	35	35	2,5	45	10					38A 60 LVS	699366**88738**
100x13x12,7	5	7	45	50	2,5	45	2					38A 60 KVS	699366**24605**
100x13x20	5	7	41	41	3,2	45	2	3NQ 60 KVQN	662532**62312***	SGB 60 LVX	699366**86659***	38A 60 KVS	699366**86186**
	5	7	41	41	3,2	45	2	3SG 60 KVX	662530**50236**			38A 120 MVS	699366**86189**
125x13x20	6	7	61	61	3,2	45	2	3NQ 60 KVQN	662532**62411**				
	6	7	61	61	3,2	45	2	3SG 60 JVX	699366**86768**			38A 60 KVS	699366**86192**
	6	7	61	61	3,2	45	2	3SG 60 KVX	662530**50242**				
150x13x20	7	9	86	86	3,2	45	2	3NQ 46 KVQN	662532**62311***			38A 60 KVS	699366**86199**
	7	9	86	86	3,2	45	2	3SG 46 KVX	662530**50143**				
	7	9	86	86	3,2	45	2	3SG 60 JVX	699366**86771****				
150x13x20	8	9	56	56	3,2	45	2	3SG 60 LVX	662530**50231**	SGB 46 LVX	699366**86732**	38A 60 NVS	699366**86818****
	8	9	56	56	3,2	45	2			SGB 60 LVX	699366**82791**		
150x13x32	7	9	86	86	3,2	45	2	3NQ 60 KVQN	662532**61916***			38A 46 KVS	699366**86194**
	7	9	86	86	3,2	45	2	3SG 46 KVX	662530**50238**			38A 60 KVS	699366**86198**
	7	9	86	86	3,2	45	2	3SG 60 KVX	662530**50239**			38A 120 JVS	699366**86204***
150x16x20	8	9	66	66	3,2	45	2	3SG 54 LVX	699366**86772***	SGB 60 KVX	662530**50256****	38A 60 KVS	699366**82252***
150x16x32	8	9	66	66	3,2	45	2	3SG 46 KVX	662530**50141***			38A 60 KVS	699366**88577***
	8	9	66	66	3,2	45	2			SGB 60 KVX	662530**50245**		
180x16x32	9	10	96	96	3,2	45	2			SGB 60 KVX	662530**50247****		
180x20x32	9	11	70	70	3,2	45	2	3SG 54 KVX	662530**50234**	SGB 54 KVX	662530**50260**		
200x16x20	12	10	90	90	3,2	45	2					38A 46 JVS	699366**88749***
200x20x32	10	12	90	90	3,2	45	2			SGB 46 JVX	662530**50249****	38A 60 KVS	699366**86215**
	10	12	90	90	3,2	45	2			SGB 60 KVX	662530**50252**		
200x32x32	10	12	92	92	3,2	45	2			SGB 46 IVX	662530**50253**		

* Made-to-order ** Destock

jimi VELKOOBCHOD BRUSIVA

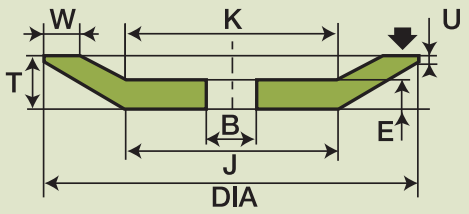
NON-FERROUS PRECISION

DIM DIAxTxB (mm)	W (mm)	E (mm)	J (mm)	K (mm)	U (mm)	MOS (m/s)	PK QTY	GOOD	
Type 12									
150x13x32	7	9	86	86	3,2	45	2	39C 80 JV	699366**83998**
200x20x32	10	12	90	90	3,2	45	2	39C 80 JV	699366**84001****

** Destock

SHAPE KEY

Type 12



Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, W = Rim Width, E = Back Thickness, J = External Flat Diameter, K = Internal Flat Diameter, U = Rim Depth

CUPS

Manufactured with the Norton's leading technology, vitrified cups are designed to maximise performance and productivity for sharpening applications.

APPLICATIONS & MARKETS

- Sharpening

INNOVATION BEST

5NQ

Type 06 Type 11

NORTON QUANTUM

FEATURES	BENEFITS
Engineered ceramic grain shape and chemistry with new bond technology.	Versatile in all low, medium and high force applications
A perfect blend between sharpness (free cutting) and toughness (life)	30% to 100% higher metal removal rate >15% lower threshold power

BEST

5SG®

Type 06 Type 11

FEATURES	BENEFITS
Very high concentration of SG® ceramic aluminium oxide abrasive	Ultimate cutting capability High removal rate & extended cup life Perfect for technical applications where grinding parameters can be adjusted to optimise performance

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

BEST

3SG®

Type 06 Type 11

FEATURES	BENEFITS
■ High concentration of SG® ceramic aluminium oxide abrasive	■ Very good cutting capability
■ Unique, self sharpening, microcrystalline structure	■ High removal rate & extended wheel life ■ Suitable for very hard steels

BETTER

SGB®

Type 06 Type 11

FEATURES	BENEFITS
■ Medium concentration of ceramic aluminium oxide abrasive	■ Good cutting capability
■ Harder & sharper than conventional abrasive grains	■ Suitable for low to medium power machines ■ Very versatile on a wide variety of steels

39C

Type 06

FEATURES	BENEFITS
■ Highest purity green silicon carbide abrasive	■ Ideal for precision grinding & sharpening applications on metal carbide & non-ferrous metals
■ Harder & more friable than aluminium oxide type abrasive	

GOOD

38A

Type 06 Type 11

FEATURES	BENEFITS
■ High purity white aluminium oxide abrasive	■ Cool & burn free cutting
■ Friable abrasive	■ Ideal for heat-sensitive applications with light to moderate feed rates

86A

Type 06 Type 11

FEATURES	BENEFITS
■ Highly refined pink aluminium oxide abrasive	■ Very versatile
■ Tougher abrasive than pure white aluminium oxide	■ Reduced dress frequency
■ Contains a small portion of chromium oxide	

VELKOOBCHOD BRUSIVA

METAL PRECISION

DIM DIAxTxB (mm)	W (mm)	E (mm)	MOS (m/s)	PK QTY	INNOVATION BEST BEST		BETTER		GOOD	
Type 06										
63x40x20	10	10	45	10					38A 60 KVS	6993674852
80x40x20	6	8	63	6					38A 60 MVS M6	6993674809
	6	10	45	10			SGB 60 JVX	6624357039**1**		
	8	8	63	6					38A 60 KVS T6	6993674810
	8	10	45	10	5NQ 60 LVQN	6625324518**6***				
	10	10	45	10			SGB 60 LVX	6625305009**8**		
80x40x32	10	10	45	10					38A 46 KVS	6993674853
100x40x32	13	13	45	2					38A 60 KVS	6993674854
100x50x19,8	11	11	45	2					38A 120 KVS	6993623690*
100x50x20	8	10	45	2			SGB 46 JVX	6624357039**2**		
	8	10	45	2			SGB 60 KVX	6993641284		
	10	10	45	2	3NQ 60 JVQN	6625326228**4***			38A 46 KVS	6993644193
	10	10	45	2	3SG 46 KVX	6625305007**1***			38A 60 JVS	6993674860
	10	10	45	2	3SG 60 JVX	6625305006**9**			38A 60 KVS	6993674857
	10	10	45	2	3SG 60 KVX	6625304996**5**			38A 80 JVS	6993639600
	10	10	45	2	3SG 70 KVX	6625305006**7**				
	10	13	45	2	3SG 60 LVX	6625304996**0**			38A 60 LVS	6993639450
	10	13	45	2	3SG 80 LVX	6625304996**6**			38A 60 MVS	6993639460
	10	13	45	2					38A 80 KVS	6993639436
100x50x32	10	10	45	2	5SG 60 KVX	6625305007**0****			38A 60 KVS	6993674859
	10	10	45	2	3SG 46 JVX	6625305007**2**				
	10	10	45	2	3SG 60 KVX	6625305007**3**				
125x50x32	10	13	45	2					38A 60 LVS	6993639992
	13	13	45	2	3SG 46 JVX	6993676356	SGB 60 JVX	6625305007**5**	38A 46 KVS	6993674867
125x63x32	8	13	45	2					38A 46 KVS	6625304995**8**
	10	10	45	2					86A 46 E12VXP	6625305152**8**
	10	13	45	2			SGB 60 KVX	6993640579		
	13	16	45	2					86A 46 G12VXP	6625305152**5***
150x32x32	35	12	45	2					38A 60 LVS	6993640294*
150x32x60	32	13	45	2					38A 60 MVS	6993674871
150x40x32	16	13	45	2					38A 46 HVS	6993674872
	16	13	45	2					38A 60 KVS	6993674875
150x50x32	16	16	45	2	3NQ 46 KVQN	6625326227**7***	SGB 46 KVX	6625305009**3**	38A 46 JVS	6993676128*
	16	16	45	2	3SG 46 KVX	6625305006**8**	SGB 60 KVX	6625305007**6**	38A 60 KVS	6993674879
150x50x65	20	16	45	2					38A 60 LVS	6993639480
150x60x32	10	16	45	2			SGB 54 KVX	6625305009**9**		
150x63x32	16	16	45	2			SGB 46 JVX	6625305472**7**	38A 36 IVS	6993640369
	16	16	45	2					38A 46 JVS	6993674881
150x63x50,8	16	16	45	2			SGB 36 HVX	6625305008**0**		
	16	16	45	2			SGB 60 JVX	6625305008**2**		

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, W = Rim Width, E = Back Thickness

METAL PRECISION (CONTINUED)

DIM DIAxTxB (mm)	W (mm)	E (mm)	MOS (m/s)	PK QTY	INNOVATION BEST		BETTER		GOOD	
					BEST					
Type 06										
150x80x32	20	20	45	2			SGB 46 G12VXP	69936**76357**	38A 46 HVS	69936**74905**
	20	20	45	2			SGB 46 HVX	66253**50096**	38A 46 IVS	69936**58606***
165x63x32	10	13	45	2					38A 46 F12VXP	66253**51529**
175x75x76,2	20	20	45	2			SGB 46 G12VXP	66253**50097**	38A 36 IVS	69936**81747**
	20	20	45	2					38A 46 H12VXP	69936**81146***
180x40x76,2	32	13	45	2					38A 46 MVS	69936**74884**
180x45x60	40	16	45	2					38A 60 MVS	69936**74886**
180x63x50,8	16	16	45	2			SGB 46 JVX	66253**50084**	38A 36 HVS	69936**74887**
180x76x32	16	16	45	2					38A 36 IVS	69936**39449**
180x76x78	16	16	45	2	3NQ 36 IVQN	66253**62062***			38A 24 JVS	69936**39987***
	16	16	45	2	3SG 36 IVX	66253**49962***			38A 36 IVS	69936**39587**
	16	16	45	2					38A 36 JVS	69936**39817**
	16	16	45	2					38A 46 HVS	69936**39616***
	16	16	45	2					38A 46 IVS	69936**39533***
180x80x32	13	10	45	2			SGB 46 G12VXP	69936**40451**		
	16	16	45	2					38A 46 HVS	69936**74889**
200x40x32	45	15	45	2					38A 46 LVS	66243**70536**
	45	15	45	2					38A 60 LVS	66243**70537**
200x40x76,2	40	13	45	2			SGB 46 LVX	66253**50085***	38A 46 KVS	69936**74880**
	40	13	45	2			SGB 60 LVX	66253**50087**	38A 46 MVS	69936**74890**
200x63x50,8	20	20	45	2					38A 46 HVS	69936**74898**
200x82x78	16	20	45	2	3NQ 36 IVQN	66253**62063***	SGB 36 H12VXP	69936**79013**	38A 36 IVS	69936**39502**
	16	20	45	2	3SG 36 IVX	66253**49964**			38A 46 IVS	69936**39387**
200x100x32	20	25	45	2			SGB 46 G12VXP	69936**40271***		

* Made-to-order

Jimi VELKOOBCHOD BRUSIVA

METAL PRECISION (CONTINUED)

DIM DIAxTxB (mm)	W (mm)	E (mm)	MOS (m/s)	PK QTY	INNOVATION BEST	INNOVATION BEST	BETTER	BETTER	GOOD	GOOD
Type 11										
80x32x20	6	8	45	6			SGB 46 KVX	66253**050125**	38A 60 KVS	69936**682483***
	6	8	45	6			SGB 60 LVX	66253**050137**		
80x40x20	8	10	45	6	5NQ 80 JVQN	66253**245187***				
100x40x20	8	10	45	2	3NQ 60 KVQN	66253**262286**	SGB 60 LVX	69936**686717***	38A 46 KVS	69936**686166***
	8	10	45	2	3SG 46 KVX	66253**050127**			38A 60 KVS	69936**686170**
	8	10	45	2	3SG 60 KVX	66253**050110**				
	8	10	45	2	3SG 60 LVX**	66253**055956****				
100x40x32	8	10	45	2	3NQ 46 KVQN	66253**262299**	SGB 60 JVX	66253**050130****	38A 54 KVS	69936**686224****
	8	10	45	2	3SG 46 KVX	66253**050112**			38A 60 KVS	69936**686169**
	8	10	45	2	3SG 60 KVX	66253**050114**			38A 60 LVS	69936**688495***
125x40x20	8	10	45	2	3SG 46 KVX	69936**686770**			38A 46 JVS	69936**688603****
125x40x32	8	10	45	2	5SG 46 KVX	66253**050122****	SGB 60 JVX	69936**682429**	38A 46 KVS	69936**686175**
	8	10	45	2	3SG 60 KVX	66253**050116**			38A 60 JVS	66253**050104****
	8	10	45	2					38A 60 KVS	69936**686176**
	8	10	45	2					38A 80 KVS	66253**050106****
125x45x20	6	13	45	2	3NQ 46 KVQN	66253**262300***	SGB 60 KVX	69936**686736**	38A 60 LVS	69936**688494***
	6	13	45	2	3SG 46 KVX***	66253**055954***			86 A 46 KVTECH	66253**050102****
	6	13	45	2	3SG 60 KVX***	66253**055955***				
150x50x20	10	13	45	2					38A 60 KVS	69936**682567****
150x50x32	10	13	45	2	3SG 60 KVX	66253**050119**	SGB 46 KVX	69936**688939****	38A 46 KVS	69936**686177**
	10	13	45	2			SGB 46 JVX	66253**050133**	38A 60 KVS	69936**682576**
	10	13	45	2			SGB 60 KVX	66253**050134**		

**Type 11R ***Type11F

* Made-to-order ** Destock

NON-FERROUS PRECISION

DIM DIAxTxB (mm)	W (mm)	E (mm)	MOS (m/s)	PK QTY	GOOD	GOOD
Type 06						
100x50x20	10	10	45	2	39C 80 KV	69936**68290**
	10	13	45	2	39C 80 JVS	69936**640131**
100x50x32	10	10	45	2	39C 60 JV	69936**68288**
125x63x32	25	16	45	2	39C 60 JV	69936**68305**
150x32x60	32	13	45	2	39C 80 JV	69936**68308***
200x40x76,2	40	13	45	2	39C 60 JV	69936**68347**
	40	13	45	2	39C 80 JV	69936**68348**
	40	13	45	2	39C 120 JV	69936**68353***
300x63x127	40	20	45	1	39C 60 JV	69936**68365**

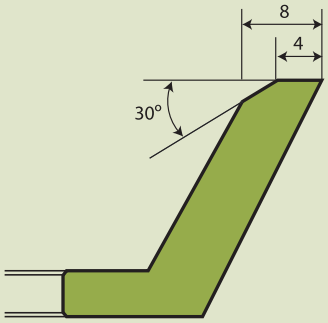
* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, W = Rim Width, E = Back Thickness

VELKOOBCHOD BRUSIVA

SHAPE KEY

Type 11R



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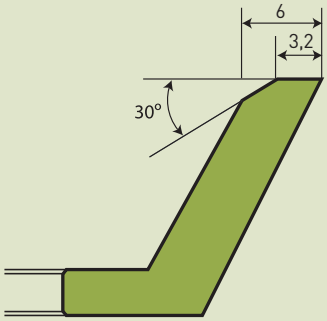
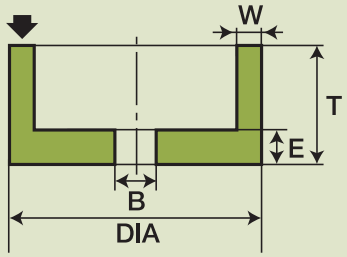
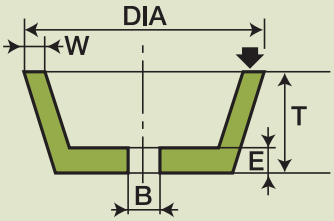


Type 06



Type 11



VELKOOBCHOD BRUSIVA

CYLINDERS

Cylinders are relatively soft and have a thin contact area. They are normally used in a chuck or fixed to a plate. The part is held on a table and either reciprocates or turns in a clockwise direction. To improve safety, cylinders are bound with layers of multi-filament high strength tape.

APPLICATIONS & MARKETS

- Surface grinding

INNOVATION BEST

5NQ

Type 02

NORTON QUANTUM

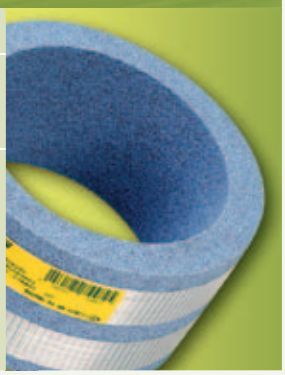
FEATURES	BENEFITS
Engineered ceramic grain shape and chemistry with new bond technology.	Versatile in all low, medium and high force applications
A perfect blend between sharpness (free cutting) and toughness (life)	30% to 100% higher metal removal rate >15% lower threshold power

BETTER

SGB®

Type 02

FEATURES	BENEFITS
Medium concentration of ceramic aluminium oxide abrasive	Good cutting capability
Harder & sharper than conventional abrasive grains	Suitable for low to medium power machines Very versatile, for use on a wide variety of steels



VELKOOBCHOD BRUSIVA

GOOD

38A

Type 02

FEATURES	BENEFITS
High purity white aluminium oxide abrasive	Cool and burn free cutting
Friable abrasive	Ideal for heat-sensitive applications with light to moderate feed rates

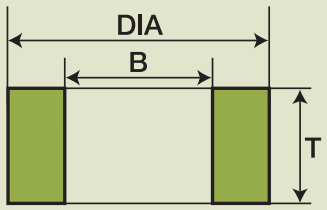
CYLINDERS

DIM DIAxTxB(mm)	PK QTY	MOS (m/s)	INNOVATION BEST	INNOVATION BEST	BETTER		GOOD	
Type 02								
127x50x101,6	2	45					38A 46 IVS	699366**23695***
150x16x20	2	45	3NQ 54 LVQN	662532**62061***				
152,4x50x127	2	45					38A 36 IVS	699366**23639***
200x100x160	2	45			SGB 46 HVX	699366**86693**	38A 46 GVS	699366**86231**
254x100x204	1	45					38A 46 GVS	699366**86297**
457x125x377	1	45					38A 30 HVS	662434**65839****

* Made-to-order ** Destock

SHAPE KEY

Type 02



Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

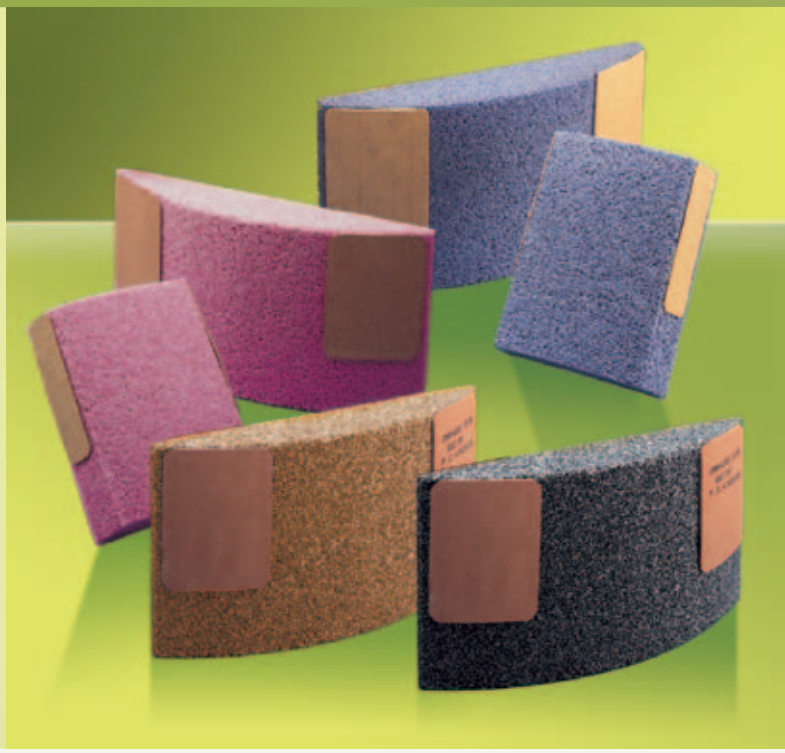
Jimi VELKOOBCHOD BRUSIVA

SEGMENTS

Surface grinding segments are generally used to grind flat stock or flat surfaces within a workpiece. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

APPLICATIONS & MARKETS

- Grinding large moulds & dies
- Sharpening knives, blades



INNOVATION

BEST

5NQ

Type 31

NORTON QUANTUM

FEATURES

- A perfect blend between sharpness (free cutting) and toughness (life)
- A new alumina grain chemistry and shape developed from the NORTON patended Seeded-Gel Technology

BENEFITS

- 33% to 100% longer life v/s competiive ceramic products
- 30% to 100% higher metal removal rate

BEST

3SG®

Type 31

FEATURES

- High concentration of SG® ceramic aluminium oxide abrasive
- Unique, self sharpening, microcrystalline structure

BENEFITS

- Very high cutting capability
- High removal rate & extended product life
- Suitable for very hard steels

VELKOOBCHOD BRUSIVA

GOOD

38A

Type 31

FEATURES	BENEFITS
■ High purity white aluminium oxide abrasive	■ Cool & burn free cutting
■ Friable abrasive	■ Ideal for heat-sensitive applications with light to moderate feed rates

86A

Type 31

FEATURES	BENEFITS
■ Highly refined pink aluminium oxide abrasive	■ Very versatile
■ Tougher than pure white aluminium oxide abrasive	■ Reduced dress frequency
■ Good profile holding	■ Better part geometry
■ Contains a small portion of chromium oxide abrasive	

19A

Type 31

FEATURES	BENEFITS
■ A blend of A & 38A abrasives	■ Very versatile, for use on a wide variety of steels ■ Very good yield, good removal rate

37C

Type 31

FEATURES	BENEFITS
■ High purity black silicon carbide abrasive	■ Suitable for roughing operations in coarse grit & resinoid wheels
■ Harder & more friable than aluminum oxide abrasive	■ Ideal for grinding & sharpening applications on metal carbide & non-ferrous metals

Jimi VELKOOBCHOD BRUSIVA

METAL PRECISION

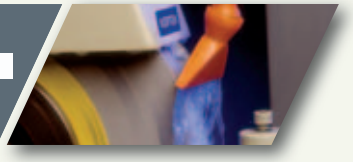
Type 31

SHAPE	DIM LxBxC(mm)	SEGMENT A(mm)	SEGMENT R(mm)	PK QTY	INNOVATION BEST BEST		GOOD	
SA	80x25x150			4	3NQ 36 E12VQNP	662532**61917***		
SA	90x35x150			4	3NQ 36 E12VQNP	662532**61998**		
SA	150x80x25			4			38A 30 IVS	699366**86253**
SB	38x103x150	83,2		4	3NQ 30 HVQN	662532**61906***		
SB	100x65x25	56,9	205	4			86A 30 IV TECH	662530**50274***
SB	150x103x38			4	3NQ 36 HVQN	690831**40907***		
	150x103x38			4	3NQ 36 E12VQNP	690831**41436**		
SB	200x103x38	84,8	228,6	4	5NQ 46 G12VQNP	690831**41438***	38A 24 F12VXP	699366**25436***
SC	190x112,3x44,4	78,6	381	4			38A 30 G12VXP	662530**50262****
SD	25x80x160	70		4	3NQ 30 E12VQNP	662532**61907***		
SD	110x70x20	47	100	4			86A 36 IV TECH	662530**50288***
	110x70x20	47	100	4			86A 46 HV TECH	662530**50272****
SE	90x50x16	45	91	4	3NQ 36 IVQN	690831**41439***	38A 36 IVS	699366**88543**
	90x50x16	45	91	4	3NQ 46 HVQN	690831**41440**	38A 46 HVS	699366**82335**
SE	110x53,5x16	47	89	4			38A 36 IVS	699366**88485**
	110x53,5x16	47	89	4			38A 46 HVS	699366**88614***
SO	25x70x150	64		4	3NQ 46 HVQN	662532**61905**		
SO	60x65x20	58		4			86A 36 IV TECH	662530**50269****
SO	90x42x20	38		4	3NQ 46 HVQN	690831**41441**	38A 36 HVS	699366**86257***
	90x42x20	38		4			38A 46 HVS	699366**86263***
	90x42x20	38		4			38A 60 GVS	699366**86264**
SO	110x50x25	43,5		4	3NQ 46 GVQN	690831**41443**	38A 46 GVS	699366**86266**
	110x50x25	43,5		4	3NQ 60 GVQN	690831**41444**	38A 60 GVS	699366**86267**
	110x50x25	43,5		4	3NQ 46 F12VQNP	690831**41447***	19A 54 IVS	699366**86249**
SO	110x60x22	54		4	3SG 36 HVX	662530**50266**	38A 36 HVS	699366**82248**
SO	110x70x25	64		4			38A 36 IVS	699366**82640**
SO	121x59,5x21	48		4			38A 30 HVS	699366**24796**
	121x59,5x21	48		4			38A 36 IVS	699366**82231**
	121x59,5x21	48		4			86A 46 HV TECH	662530**50264****
SO	150x70x25	64		4	3NQ 36 E12VQNP	690831**41449***	38A 30 IVS	699366**82296**
	150x70x25	64		4	3NQ 36 HVQN	690831**41450**	38A 36 IVS	699366**86248**
SO	180x103x38	94		4	3NQ 36 HVQN	690831**41453**	38A 30 IVS	699366**86273***
	180x103x38	94		4	3NQ 30 IVQN	690831**41455***		
	180x103x38	94		4	3NQ 36 F12VQNP	690831**41456***		

* Made-to-order ** Destock

DIAMOND DRESSING

- Norton offers an extensive range of complimentary diamond dressing solution
For more information see page 412



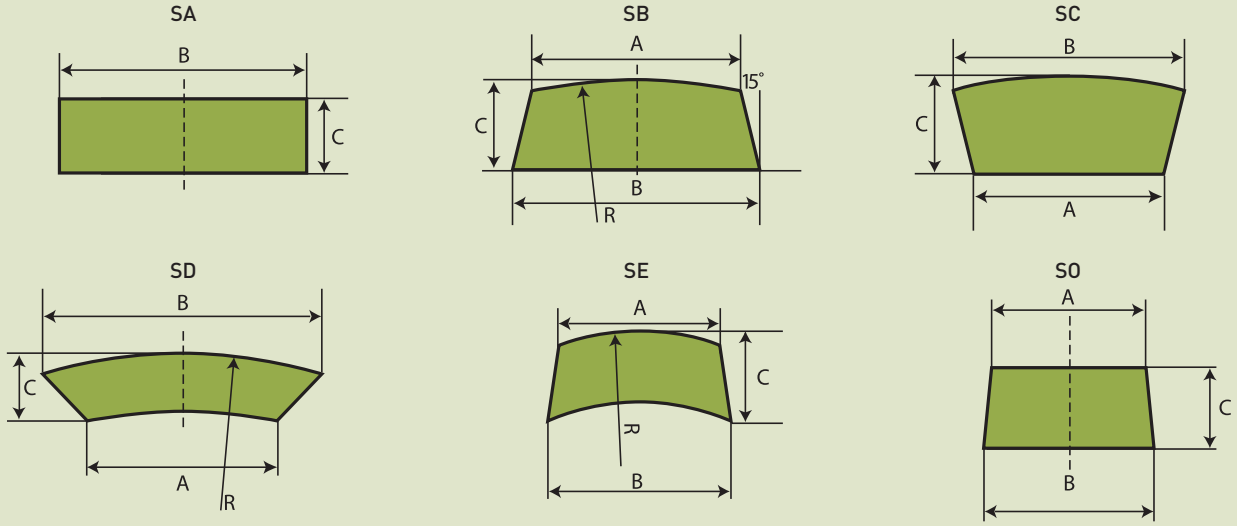
VELKOOBCHOD BRUSIVA

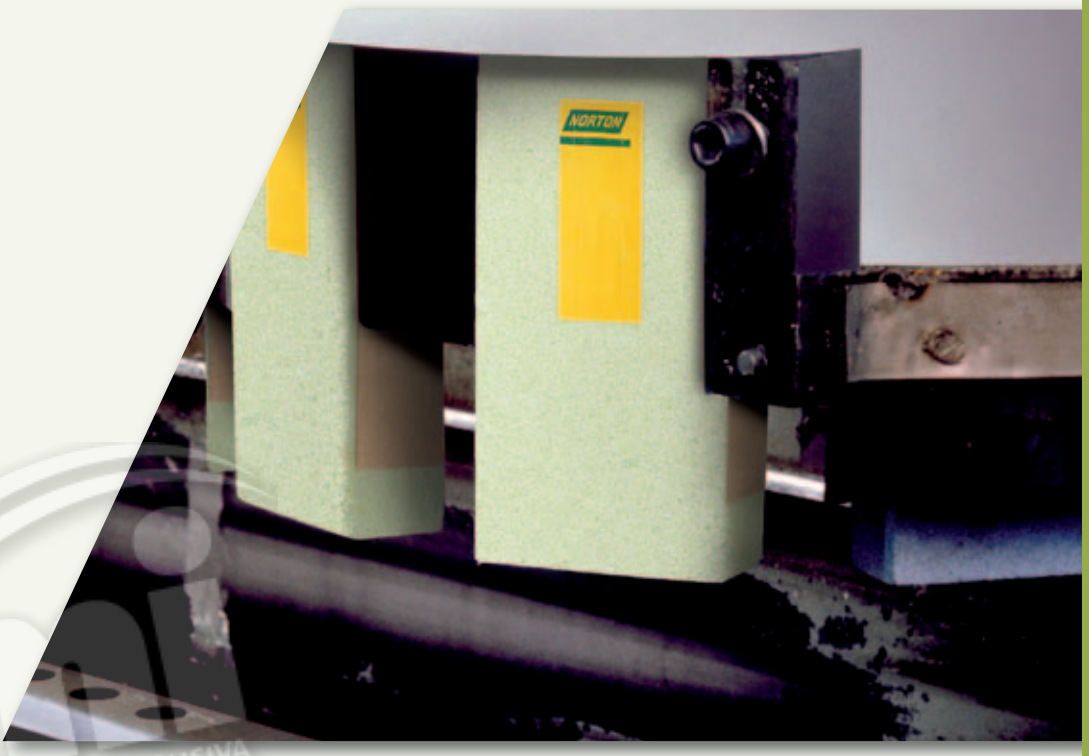
NON-FERROUS PRECISION

Type 31

SHAPE	DIM LxBxC(mm)	SEGMENT A(mm)	SEGMENT R(mm)	PK QTY	GOOD	
SB	100x65x25	56,9	205	4	37C 30 HV	699366**88426**
SO	110x70x25	64		4	37C 24 IV	699366**83895**

SHAPE KEY TYPE 31





Dimensions Key: DIM = Dimensions, L = Length, B = Width, C = Thickness, A = Segment, R = Segment External Radius

MOUNTED POINTS & WHEELS

Norton Quantum (NQ) vitrified mounted points are the best, versatile choice for high volume Foundry and Aerospace operations. The unique, engineered ceramic grain shape in combination with the chemistry of the proven bond technology can provide 33%+ longer life versus competitive ceramic products with 30%+ higher metal removal rates. With minimal loading and heat build-up they are ideal for grinding Inconel and similar alloy turbine blade components, e.g. to attain final geometry and to create a uniform finish.

Less pressure is needed to get optimum performance so... **Let the Quantum grain do the work!**

APPLICATIONS & MARKETS

- Deburring
- Blending
- Finishing

BEST

NORTON QUANTUM (NQ)

FEATURES	BENEFITS
Unique, engineered ceramic grain shape and chemistry with proven bond technology	Ideal for high-volume foundry operations – grinding Inconel and similar alloy turbine blade components
	Minimal loading and heat build-up
	33%+ longer life vs. competitive ceramic products
	30%+ higher metal removal rates
	Versatile, optimized for all low, medium and high force applications
	Exceptional productivity and life

GOOD

86A

FEATURES	BENEFITS
Highly refined pink aluminium oxide abrasive	Very versatile
Tougher than pure white aluminium oxide abrasive	Reduced dress frequency
Good profile holding	Better part geometry
Contains a small portion of chromium oxide abrasive	

JMI VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

MOUNTED POINTS SHAPE A

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	BEST		GOOD	
A1	20x65	6x40	15000	10	3NQ 80-OVQN	614636**88951**	86A 36 PVS	662530**55235**
	20x65	6x40	15000	10			86A 60 PVS	662530**55218**
A3	22x70	6x40	14000	10			86A 30 PVS	662530**55021**
	22x70	6x40	14000	10			86A 60 PVS	662530**55212**
A4	30x30	6x40	20000	10			86A 36 PVS	662530**55179**
	30x30	6x40	20000	10			86A 60 PVS	662530**54956**
A5	20x28	6x40	30000	10	3NQ 80-OVQN	614636**88954**	86A 60 PVS	662530**55094**
A7	30x50	6x40	13000	10			86A 30 PVS	662530**55022**
A8	20x50	6x40	18000	10			86A 36 PVS	662530**55308**
	20x50	6x40	18000	10			86A 60 PVS	662530**55877**
A9	30x50	6x40	13000	10			86A 30 PVS	662530**55395**
A10	22x70	6x40	14000	10			86A 36 PVS	662530**55237**
A11	21x45	6x40	18000	10	3NQ 80-OVQN	614636**20969**	86A 30 PVS	662530**55307**
	21x45	6x40	18000	10			86A 36 PVS	662530**55095**
	21x45	6x40	18000	10			86A 46 PVS	662530**55023***
	21x45	6x40	18000	20			86A 60 PVS	662530**55214**
A12	18x30	6x40	30000	10			86A 36 PVS	662530**54962**
	18x30	6x40	30000	10			86A 60 PVS	662530**55096**
A13	25x25	6x40	25000	10			86A 60 PVS	662530**55125**
A14	18x22	6x40	35000	10			86A 60 PVS	662530**55180**
A15	6x25	6x40	30000	10			86A 90 PVS	662530**55126**
A19	30x50	6x40	13000	10			86A 36 PVS	662530**54960**
	30x50	6x40	13000	10			86A 60 PVS	662530**54961**
A20	40x50	6x40	10000	10			86A 36 PVS	662530**54963***
A21	25x25	6x40	25000	10	3NQ 80-OVQN	614636**88956**	86A 36 PVS	662530**55238**
	25x25	6x40	25000	10			86A 60 PVS	662530**54965***
A23	20x25	6x40	25000	10	3NQ 80-OVQN	614636**89937**		
A24	6x20	6x40	41000	10			86A 60 PVS	662530**55127**
	6x20	6x40	41000	10			86A 90 PVS	662530**55311***
A25	25x25	6x40	25000	10			86A 60 PVS	662530**55128**
A26	16x16	6x40	54000	10	3NQ 80-OVQN	614636**88957**	86A 46 PVS	662530**55204**
	16x16	6x40	54000	10			86A 60 QVS	662532**68641**
	16x16	6x40	54000	10			86A 90 PVS	662530**54952***
A36	40x10	6x40	25000	10	3NQ 80-OVQN	614636**88960**	86A 60 PVS	662530**55129**
	40x10	6x40	25000	10			86A 90 PVS	662530**54968***
A37	30x6	6x40	30000	10			86A 90 PVS	662530**55313**
A38	25x25	6x40	25000	10			86A 60 PVS	662530**54946**
A39	20x20	6x41	25000	10	3NQ 80-OVQN	614636**89938**		

* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length

JIMI VELKOOBCHOD BRUSIVA

MOUNTED POINTS SHAPE B

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	BEST		GOOD	
B44	6x10	3x40	61000	10			86A 90 PVS	662530**55183**
B46	3x8	3x40	90000	10			86A 90 PVS	662530**55185**
B51	11x20	3x40	41000	10			86A 90 PVS	662530**55402**
B52	10x20	3x40	41000	10	3NQ 80-OVQN	614636**88963**	86A 90 PVS	662530**55232**
B53	6x16	3x40	54000	10			86A 90 PVS	662530**55305**
	6x16	3x40	54000	10			86A 120 PVS	662530**55090***
B54	6x13	3x40	54000	10			86A 90 PVS	662530**55139**
B55	3x6	3x40	90000	10			86A 90 PVS	662530**55401***
B61	20x8	3x40	47000	10			86A 90 PVS	662530**55020**
B81	20x4	3x40	47000	10			86A 90 PVS	662530**55140**
B91	13x16	3x40	58000	10			86A 90 PVS	662530**55199**
B97	3x10	3x40	90000	10	3NQ 80-OVQN	614636**88964**	86A 90 PVS	662530**55141**
B121	13x13	3x40	58000	10			86A 90 PVS	662530**55143**
B122	10x3	3x40	58000	10	3NQ 80-OVQN	614636**88965**		
B123	5x5	3x40	73000	10			86A 90 PVS	662530**55207**
B131	13x13	3x40	58000	10	3NQ 80-OVQN	614636**89939**		

* Made-to-order

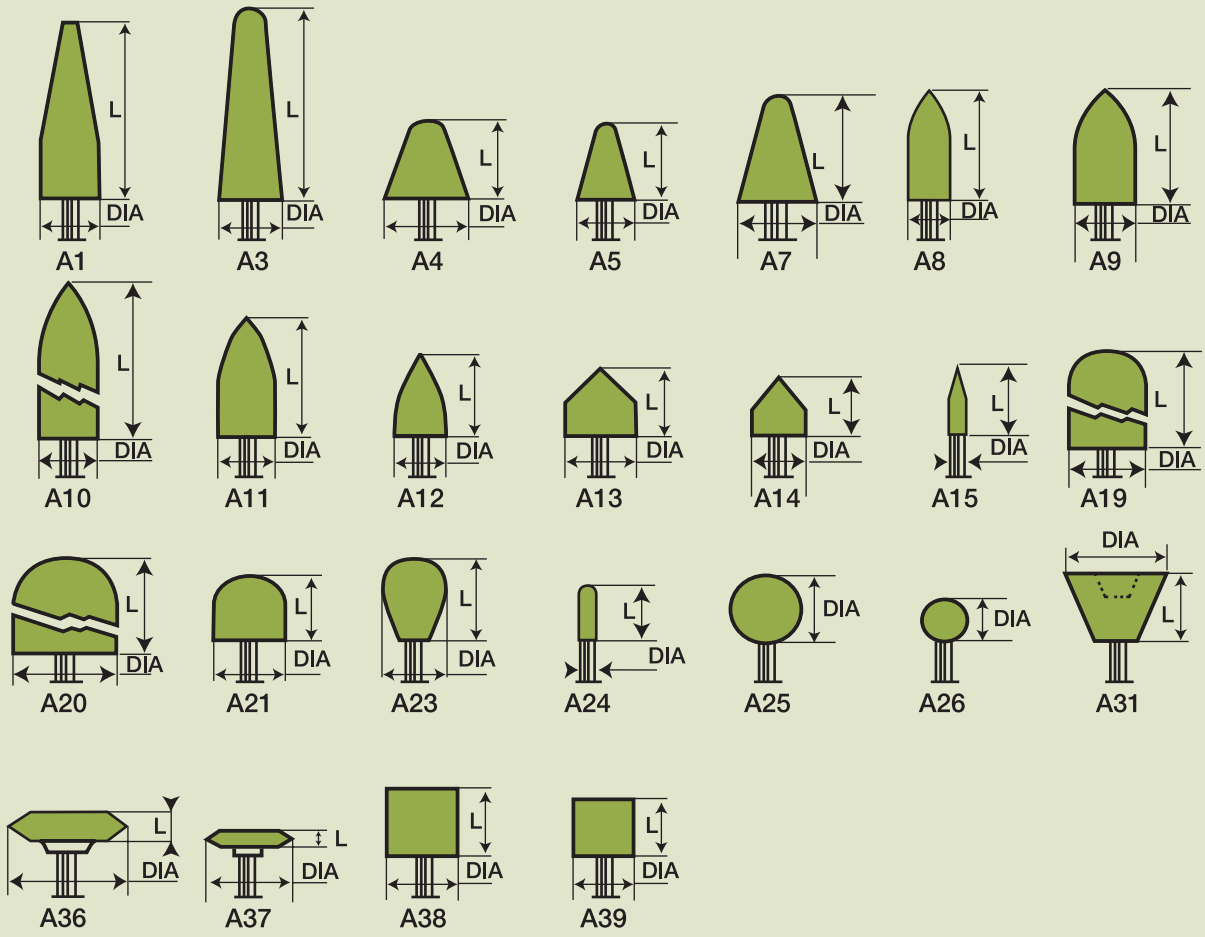
MOUNTED POINTS SHAPE C

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	GOOD	
C262	16x32	6x40	25000	10	86A 90 PVS	662530**55217***
	16x32	6x40	25000	10	86A 150 PVS	662530**55025***
C263	20x32	6x40	30000	10	86A 60 PVS	662530**55177**

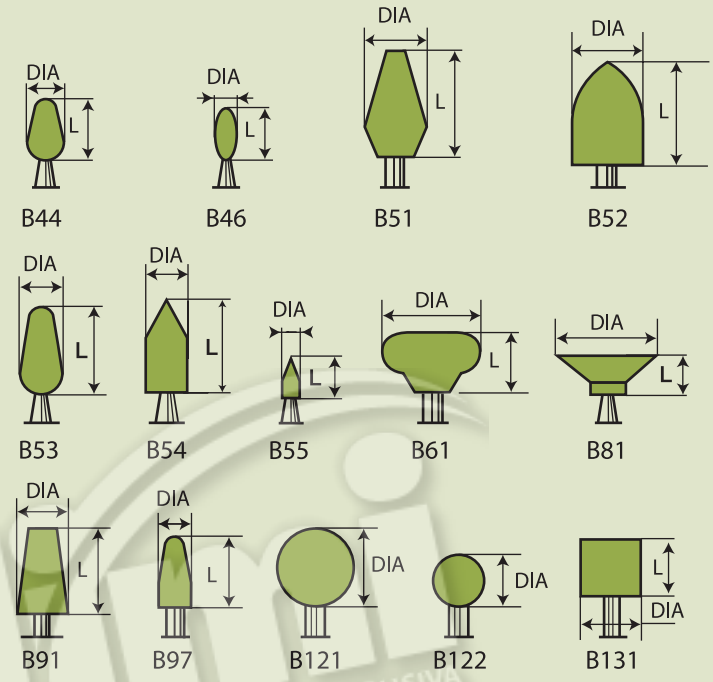
* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length

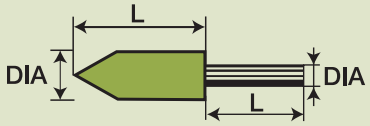
SHAPE A KEY



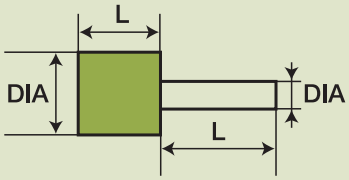
SHAPE B KEY



SHAPE C KEY



SHAPE W KEY



VELKOOBCHOD BRUSIVA

MOUNTED WHEELS

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	BEST		GOOD	
W144	3x6	3x40	90000	10			86A 60 PVS	662530**55396***
	3x6	3x40	90000	10			86A 90 PVS	662530**55147**
	3x6	3x40	90000	10			86A 100 PVS	662530**55036***
W145	3x10	3x40	90000	10			86A 90 PVS	662530**55145***
W146	3x13	3x40	80000	10			86A 90 PVS	662530**55148***
W149	4x6	3x40	80000	10			86A 90 PVS	662530**55150**
W153	5x10	3x40	73000	10	3NQ 80-OVQN	614636**97526***	86A 90 PVS	662530**55160**
W154	5x13	3x40	70000	10	3NQ 80-OVQN	614636**88966**	86A 90 PVS	662530**55162**
W160	6x6	3x40	61000	10			86A 90 PVS	662530**55164***
W161	6x8	3x40	61000	10			86A 90PVS	662530**55306***
W162	6x10	3x40	61000	10	3NQ 80-OVQN	614636**97527***	86A 60 PVS	662530**55166**
	6x10	3x40	61000	10			86A 90 PVS	662530**55206**
	6x10	6x40	61000	10	3NQ 80-OVQN	614636**97672***		
W163	6x13	6x40	54000	10			86A 60 PVS	662530**55210**
	6x13	3x40	54000	10			86A 90 PVS	662530**55167**
W164	6x20	3x40	41000	10	3NQ 80-OVQN	614636**88967**	86A 90 PVS	662530**55168**
W169	8x10	3x40	61000	10	3NQ 80-OVQN	614636**97605***	86A 60 PVS	662530**55398**
W169	8x10	6x40	61000	10			86A 90 PVS	662530**55241***
W170	8x13	6x40	54000	10			86A 60 PVS	662530**55248**
W171	8x20	3x40	41000	10			86A 60 PVS	662530**55171**
	8x20	3x40	41000	10			86A 90 PVS	662530**55208***
W175	10x10	3x40	61000	10			86A 80 PVS	662530**55202***
	10x10	3x40	61000	10			86A 90 PVS	662530**55173**
W176	10x13	3x40	54000	10			86A 90 PVS	662530**55176***
	10x13	6x40	54000	10			86A 60 PVS	662530**55315**
W177	10x20	6x40	41000	10	3NQ 80-OVQN	614636**97673***	86A 60 PVS	662530**55092**
W177	10x20	3x40	41000	10			86A 90 PVS	662530**55203**
W178	10x25	6x40	41000	10	3NQ 80-OVQN	614636**97675***		
W179	10x32	6x40	25000	10			86A 60 PVS	662530**55223**
	10x32	6x40	25000	10			86A 90 PVS	662530**55346***
W185	13x13	6x40	58000	10	3NQ 80-OVQN	614636**88969**	86A 90 PVS	662530**55211***
W186	13x20	6x40	48000	10			86A 46 PVS	662530**55250**
	13x20	6x40	48000	10			86A 60 PVS	662530**54953***
	13x20	6x40	48000	10			86A 90 PVS	662530**54970***
W188	13x40	6x40	20000	10			86A 46 PVS	662530**54972**
	13x40	6x40	20000	10			86A 90 PVS	662530**55131**
W195	16x20	6x40	47000	10	3NQ 80-OVQN	614636**97610***	86A 46 PVS	662530**55351***
	16x20	6x40	47000	10			86A 60 PVS	662530**55091**
	16x20	6x40	47000	10			86A 90 PVS	662530**55133***
W196	16x25	6x40	35000	10	3NQ 80-OVQN	614636**97835***	86A 46 PVS	662530**55357***
	16x25	6x40	35000	10			86A 90 PVS	662530**54973**
W197	16x50	6x40	18000	10			86A 46 PVS	662530**55213***
	16x50	6x40	18000	10			86A 90 PVS	662530**55010***
W204	20x20	6x40	42000	10			86A 36 PVS	662530**55181**
	20x20	6x40	42000	10			86A 60 PVS	662530**55134**

* Made-to-order

VELKOOBCHOD BRUSIVA

MOUNTED WHEELS (CONTINUED)

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	BEST		GOOD	
W205	20x25	6x40	32000	10			86A 36 PVS	66253054948
	20x25	6x40	32000	10			86A 60 PVS	66253055135
W206	20x32	6x40	30000	10			86A 36 PVS	66253055233*
	20x32	6x40	30000	10			86A 60 PVS	66253055013
W207	20x40	6x40	24000	10	3NQ 80-OVQN	61463697628*	86A 46 PVS	66253055089*
W215	25x3	6x40	38000	10			86A 90 PVS	66253055358*
W215	25x3	3x40	38000	10	3NQ 80-OVQN	61463688973		
W220	25x25	6x40	25000	10			86A 36 PVS	66253055231
	25x25	6x40	25000	10			86A 46 PVS	66253055014*
	25x25	6x40	25000	10			86A 60 PVS	66253055136
W221	25x40	6x40	19000	10			86A 36 PVS	66253055016
W222	25x50	6x40	19000	10	3NQ 80-OVQN	61463697689*		
W225	32x6	6x40	27000	10			86A 60 PVS	66253055137*
W228	32x20	6x40	24000	10			86A 36 PVS	66253055017*
	32x20	6x40	24000	10			86A 60 PVS	66253055087
W230	32x32	6x40	17000	10			86A 36 PVS	66253055221
	32x32	6x40	17000	10			86A 46 PVS	66253055064
	32x32	6x40	17000	10			86A 60 PVS	66253055138
W232	32x50	6x40	11000	10			86A 36 PVS	66253055252
	32x50	6x40	11000	10			86A 60 PVS	66253055300
W236	40x13	6x40	25000	10			86A 46 PVS	66253055224
	40x13	6x40	25000	10			86A 60 PVS	66253055304
	40x13	6x40	25000	10			86A 90 PVS	66253055301*
W237	40x25	6x40	19000	10			86A 36 PVS	66253055215*
	40x25	6x40	19000	10			86A 46 PVS	66253055093*
W238	40x40	6x40	12000	10			86A 36 PVS	66253055019
	40x40	6x40	12000	10			86A 60 PVS	66253055065

* Made-to-order

SPEC CHECK

- Use 36 grit & coarser for rough grinding
- Use 60 grit for imparting fine finishes or when grinding on narrow surfaces

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length

Jimi VELKOOBCHOD BRUSIVA

MOUNTED POINT KITS

TYPE		STYLE	KIT CONTENTS PER SHAPE	ART. No.
Norton Quantum A Assorted	6mm spindle dia	1 pc each in card headed plastic bag	A1, A5, A11, A21, A23, A26, A36, A39, W242 Norton Quantum (and BF3 W220 A80-HBF3 - for polishing scratches from NQ)	614636**92247**
Norton Quantum B Assorted	3mm spindle dia	1 pc each in card headed plastic bag	B42, B52, B97, B122, B131, W154, W164, W185, W215 Norton Quantum (and BF3 W163 A80-HBF3 - for polishing scratches from NQ)	614636**92248**
NZ	6mm spindle dia	1 pc each in card headed plastic bag	A1, A3, A5, A11, W220, NZ24	662531**45961**

VELKOOBCHOD BRUSIVA

NOTES

JMI VELKOOBCHOD BRUSIVA

DRESSING STICKS

Regular use of properly selected dressing sticks will help you achieve maximum performance from your vitrified wheels.

APPLICATIONS & MARKETS

- Truing, cleaning & dressing Diamond, CBN & conventional abrasive wheels

BEST

NORBIDE

FEATURES	BENEFITS
■ Manufactured from sintered boron carbide	■ Excellent chemical & wear resistance ■ Long product life, reduced maintenance & less downtime
■ Extremely hard & very dense	■ Suitable also for dressing tool & cutter wheels 200mm & smaller, especially cup & dish shapes

BETTER

39C

FEATURES	BENEFITS
■ Highest purity green silicon carbide abrasive	■ Ideal for dressing conventional vitrified grinding wheels
■ Harder & more friable than aluminium oxide abrasive	■ Outperforms 37C for better cutting efficiency & longer life

Jmi VELKOOBCHOD BRUSIVA

GOOD

38A

FEATURES	BENEFITS
■ High purity white aluminium oxide abrasive	■ Ideal for dressing CBN Super Abrasive wheels
■ Friable abrasive	

37C

FEATURES	BENEFITS
■ High purity black silicon carbide abrasive	■ Ideal for dressing conventional vitrified grinding wheels
■ Harder & more friable than aluminium oxide abrasive	

DRESSING STICKS FOR SUPER ABRASIVE GRINDING WHEELS

RECTANGULAR

DIM WxHxL(mm)	PK QTY	GOOD	
13x25x150	10	38A 150 HVBE	614636**05565**
	10	38A 220 HVBE	614636**05066**
	10	38A 320 HVBE	699366**84889**

SQUARE

DIM WxHxL(mm)	PK QTY	GOOD	
13x13x150	10	37C 80 MV	699366**85063**
	10	38A 220 HVS	699366**82631**
	10	38A 150 IVBE	699366**82314**
	10	37C 320 HV	662434**53547**
20x20x150	10	38A 150 HVBE	699366**85064**
	10	38A 220 IVBE	614636**03606**

SPEC CHECK

- Use 38A dressing sticks to dress CBN wheels
- Use 37C dressing sticks to dress Diamond wheels

Dimensions Key: DIM = Dimensions, W = Width, H = Height, L = Length

JIMI VELKOOBCHOD BRUSIVA

DRESSING STICKS

DRESSING STICKS FOR BONDED ABRASIVE GRINDING WHEELS

RECTANGULAR

DIM WxHxL(mm)	PK QTY	GOOD	
5x12,7x76,2	1	NORBIDE	614636**10148**
25x50x200	10	37C 24 TV	699366**85072**

SQUARE

DIM WxHxL(mm)	PK QTY	GOOD	
25x25x150	10	37C 30 UV	699366**24620**

ROUND

DIM DIAxL(mm)	PK QTY	GOOD	
25,4x203,2	10	37C 30 TV	614636**25024**

GENERAL PURPOSE DRESSING STICKS

RECTANGULAR

DIM WxHxL(mm)	PK QTY	GOOD	
13x25x150	10	38A 220 KV	662434**60886**
25x50x200	10	39C 60 KV	699366**85066**

Dimensions Key: DIM = Dimensions, DIA = Diameter, W = Width, H = Height, L = Length

NOTES

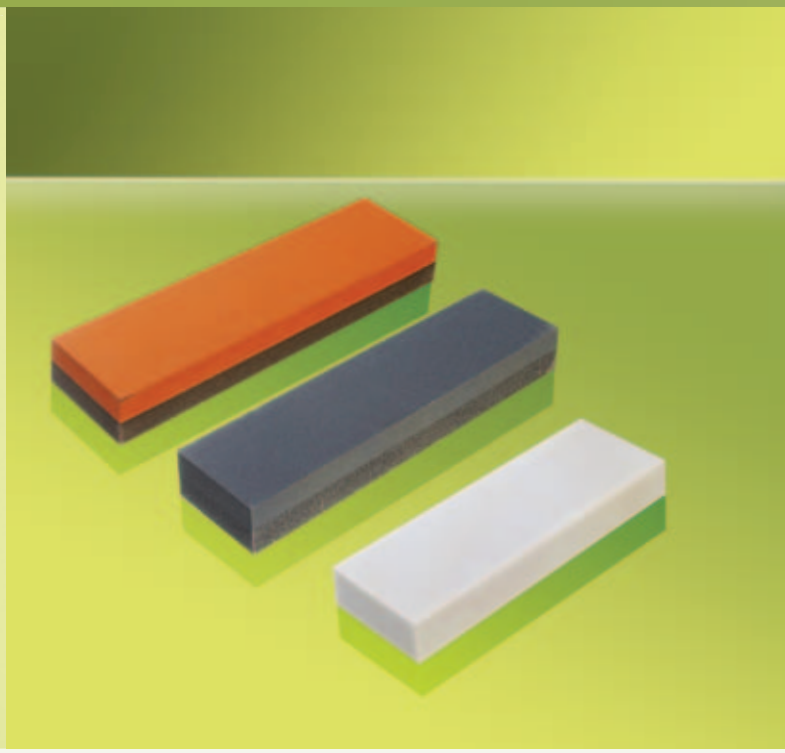
VELKOOBCHOD BRUSIVA

BENCH & COMBINATION OIL STONES

Since 1823, Norton has been the leading supplier of benchstones, files, slips and rubbing bricks. Our comprehensive line of sharpening and finishing stones delivers superior performance solutions.

APPLICATIONS & MARKETS

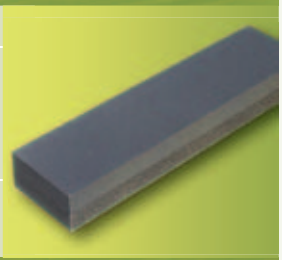
- Chisels
- Wood lathe cutters
- Knives
- Plane blades
- Precision tools & delicate instruments



GOOD

CRYSTOLON

FEATURES	BENEFITS
Premium silicon carbide abrasive	Fast cutting stone; ideal for general sharpening of cutting tools Fast stock removal for quick edge shaping with minimal loading
Pre-filled with oil	Saves time by eliminating the need for pre-soaking prior to use



INDIA

FEATURES	BENEFITS
Smooth cutting aluminium oxide abrasive	Long lasting cutting edge
Norton's trademark for a fine finish	Ideal for cleaning, deburring & good quality finishes
Pre-filled with oil	Saves time by eliminating the need for pre-soaking prior to use

ARKANSAS

FEATURES	BENEFITS
Natural premium Novaculite quarried in Arkansas & available in soft & hard	Sharpest possible razor edges Near mirror finishes Use for finer honing after India stone
Dense construction	Absorbs oil at a slower rate, hence does not require pre-filling

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

PRODUCT SELECTION

APPLICATION	COARSE / MEDIUM SHARPENING	FINE STONING
Carbide tool	Medium & coarse Crystolon Bench	Fine Crystolon Bench
	Coarse/fine Crystolon Combination	Coarse/fine Crystolon Combination
Steel tool	Medium & coarse India Bench	Fine India Bench
	Coarse/fine India Combination	Coarse/fine India Combination

BENCH & COMBINATION OIL STONES

BENCH STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
76x22x10	FBP3	5	Fine India	614636**25077****
102x25x6	MB14	5	Medium India	614636**85575**
	FB14	5	Fine India	614636**85570**
102x25x13	CB24	5	Coarse India	614636**85595**
	MB24	5	Medium India	614636**85590**
	MJB24	5	Medium Crystolon	614636**85480**
	FB24	5	Fine India	614636**85585**
	FJB24	5	Fine Crystolon	614636**85475***
102x44x13	MB124	5	Medium India	614636**26048**
127x51x16	MB35	5	Medium India	614636**85605****
152x38x13	MB26	5	Medium India	614636**26034**
152x51x19	HB6	5	Hard Arkansas	614636**85660**
	UPB6	10	Medium India	614636**90694**
152x51x25	CB6	5	Coarse India	614636**85620**
	MB6	5	Medium India	614636**85615**
	MJB6	5	Medium Crystolon	614636**85505**
	FB6	5	Fine India	614636**85610**
	FJB6	5	Fine Crystolon	614636**85500**
203x51x25	CB8	5	Coarse India	614636**85635**
	UPB8	5	Medium India	614636**85755**
	MB8	5	Medium India	614636**85630**
	FB8	5	Fine India	614636**85625**

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, L = Length, W = Width, H = Height

Jimi VELKOOBCHOD BRUSIVA

BENCH & COMBINATION OIL STONES (CONTINUED)

COMBINATION OIL STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
76x38x13	IB34	10	Coarse/Fine India	076607**87630****
102x25x13	IB24	5	Coarse/Fine India	614636**26001**
102x44x16	JB134	5	Coarse/Fine Crystolon	614636**85440**
	IB134	5	Coarse/Fine India	614636**85550**
127x51x19	JB45	5	Coarse/Fine Crystolon	614636**85445**
	IB45	5	Coarse/Fine India	614636**85555**
152x51x25	JB6	5	Coarse/Fine Crystolon	614636**85450**
	IB6	5	Coarse/Fine India	614636**85560**
152x64x25	IB20	5	Coarse/Fine India	614636**26103**
178x51x25	IB7	5	Coarse/Fine India	614636**90647**
203x51x25	JB8	5	Coarse/Fine Crystolon	614636**85455**
	IB8	5	Coarse/Fine India	614636**25078**

PEN KNIFE STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
102x25x10	HB14	5	Hard Arkansas	614636**87555**
	SB14	5	Soft Arkansas	614636**87565**

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, L = Length, W = Width, H = Height

NOTES

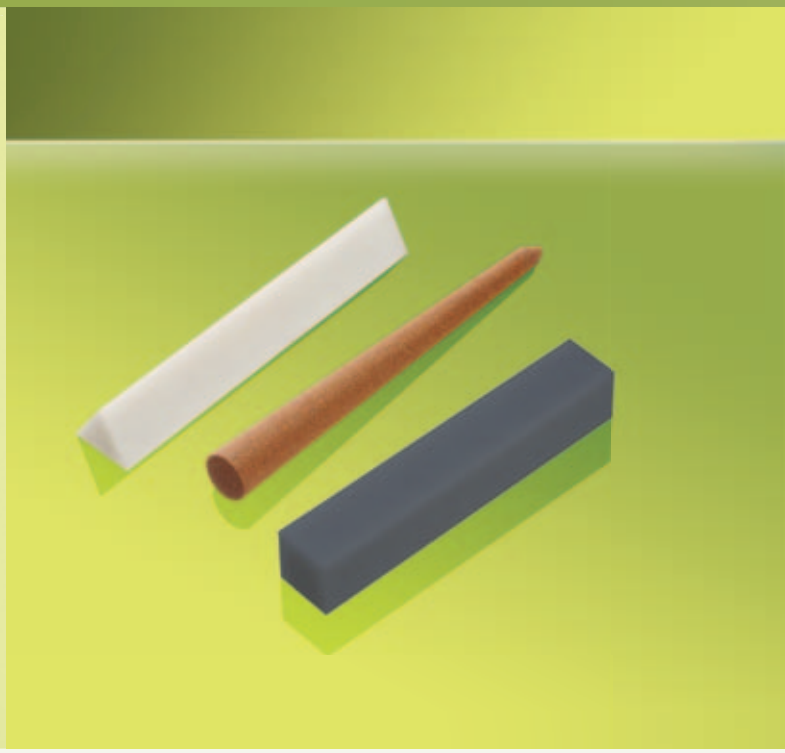
VELKOOBCHOD BRUSIVA

ABRASIVE & PRECISION FILES

Norton abrasive files hold their shape while imparting the finest, most uniform finish on precision machine parts, and in tool and die making.

APPLICATIONS & MARKETS

- Deburring
- Chamfering
- Radiusing



GOOD

CRYSTOLON

FEATURES	BENEFITS
■ Premium silicon carbide abrasive	■ Fast cutting ■ Ideal for general sharpening

INDIA

FEATURES	BENEFITS
■ Smooth cutting aluminium oxide abrasive	■ Ideal when a close tolerance is more important than the speed of cut

ARKANSAS

FEATURES	BENEFITS
■ Hard Novaculite abrasive quarried in Arkansas	■ Produces the finest edge possible while maintaining tolerances unequalled by any other abrasive ■ Produces a highly polished finish

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

PRODUCT SELECTION

APPLICATION	COARSE / MEDIUM SHARPENING	FINE STONING	FINISH HONING
Carbide tool	Medium Crystolon square		
Centre punches	Medium India triangle	Fine India triangle	
Countersinks	Coarse/medium India triangle	Fine India triangle	Hard Arkansas triangle
Form cutter	Coarse/medium India knife blade	Fine India knife blade	Hard Arkansas knife blade
Keyways	Coarse/medium India square	Fine India square	Hard Arkansas square
Lathe bits		Fine India square	Hard Arkansas square
Machine knife stone	Coarse Crystolon machine knife		
Magnetic chucks		India round	
Pointed	Medium India pointed		Hard Arkansas pointed
Precision machine knife	Medium India half round	Fine India half round	
Radius tools	Medium India round	Fine India round	Hard Arkansas round
Router bits		Fine India square	
Silversmith	Medium India Silversmith	Fine India Silversmith	
Tap threads		Fine India triangle	

ABRASIVE FILES

HALF ROUND

DIM LxH(mm)	TYPE	PK QTY	GOOD	
102x6	MF314	5	Medium India	614636**86355****
102x8	MF324	5	Medium India	614636**86370****
102x10	MF334	5	Medium India	614636**86385**
	FF334	5	Fine India	614636**86380**
102x13	MF344	5	Medium India	614636**86400**
	FF344	5	Fine India	614636**86395**

** Destock

Dimensions Key: DIM = Dimensions, L = Length, H = Height

JIMI VELKOOBCHOD BRUSIVA

ABRASIVE FILES (CONTINUED)

ROUND

DIM LxDIA(mm)	TYPE	PK QTY	GOOD	
76x6	HF813	5	Hard Arkansas	614636**86800**
102x3	MF212	5	Medium India	614636**26143**
	FF212	5	Fine India	614636**26076**
102x6	MF214	5	Medium India	614636**86475**
	FF214	5	Fine India	614636**86470**
	CF214	5	Coarse India	614636**86480****
102x8	MF224	5	Medium India	614636**26036**
	FF224	5	Fine India	614636**26071***
102x10	MF234	5	Medium India	614636**86490**
	FF234	5	Fine India	614636**86485**
102x13	MF244	5	Medium India	614636**86505**
	FF244	5	Fine India	614636**86500**
152x10	MF236	5	Medium India	614636**90575**
	FF236	5	Fine India	614636**26106**
152x13	MF246	5	Medium India	614636**86520**
	FF246	5	Fine India	614636**86515**
152x16	MF256	5	Medium India	614636**86535**
	FF256	5	Fine India	614636**86530**
152x19	MF266	5	Medium India	614636**86550**

SQUARE

DIM LxH(mm)	TYPE	PK QTY	GOOD	
76x6	HF13	5	Hard Arkansas	614636**86590**
76x10	HF33	5	Hard Arkansas	614636**86595**
76x13	HF43	5	Hard Arkansas	614636**86600**
102x6	FF14	5	Fine India	614636**86065**
	MF14	5	Medium India	614636**86070**
	CF14	5	Coarse India	614636**86075****
102x8	FF24	5	Fine India	614636**90673**
	MF24	5	Medium India	614636**26072**
102x10	FF34	5	Fine India	614636**86080**
	MF34	5	Medium India	614636**86085**
	CF34	5	Coarse India	614636**86090**
102x13	CF44	5	Coarse India	614636**86105**
	FF44	5	Fine India	614636**86095**
	MF44	5	Medium India	614636**86100**
152x10	FF36	5	Fine India	614636**26037**
	MF36	5	Medium India	614636**26038**
152x13	CF46	5	Coarse India	614636**86120**
	FF46	5	Fine India	614636**86110**
	MF46	5	Medium India	614636**86115**

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length, H = Height

* Made-to-order ** Destock

NORTON SAINT-GOBAIN

ABRASIVE FILES (CONTINUED)

SQUARE (CONTINUED)

152x16	CF56	5	Coarse India	61463686135**
	FF56	5	Fine India	61463686125
	MF56	5	Medium India	61463686130
152x19	CF66	5	Coarse India	61463686150
	FF66	5	Fine India	61463686140
	MF66	5	Medium India	61463686145
152x25	FF76	5	Fine India	61463686155
	MJF76	5	Medium Crystolon	61463625039
	MF76S	5	Medium India	61463626141

TRIANGLE

DIM LxH(mm)	TYPE	PK QTY	GOOD	
76x6	HF113	5	Hard Arkansas	61463686620
76x10	HF133	5	Hard Arkansas	61463686625
76x13	HF143	5	Hard Arkansas	61463686630
102x6	MF114	5	Medium India	61463686235
	FF114	5	Fine India	61463686230
	CF114	5	Coarse India	61463686240*
102x8	MF124	5	Medium India	61463626027
	FF124	5	Fine India	61463626028
102x10	MF134	5	Medium India	61463686250
	FF134	5	Fine India	61463686245
	CF134	5	Coarse India	61463686255
102x13	CF144	5	Coarse India	61463686270
	MF144	5	Medium India	61463686265
	FF144	5	Fine India	61463686260
152x10	MF136	5	Medium India	61463626090
	FF136	5	Fine India	61463626054
152x13	MF146	5	Medium India	61463686280
	MJF146	5	Medium Crystolon	61463625043
	FF146	5	Fine India	61463686275
152x16	MF156	5	Medium India	61463686295
	FF156	5	Fine India	61463686290
152x19	CF166	5	Coarse India	61463686315
	MF166	5	Medium India	61463686310
	MJF166	5	Medium Crystolon	61463625048*
	FF166	5	Fine India	61463686305
152x25	MF176	5	Medium India	61463686325
	FF176	5	Fine India	61463686320
203x16	MF178	5	Medium India	61463626073
203x19	MF180	5	Medium India	61463626130
	FF180	5	Fine India	61463626082
254x25	CF182	5	Coarse India	61463626043
	MF182	5	Medium India	61463626074

* Made-to-order ** Destock

VELKOOBCHOD BRUSIVA

PRECISION FILES

KNIFE BLADE FILES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
76x19x3	HF873	5	Hard Arkansas	614636**86830**
102x25x3	MF724	5	Medium India	614636**86775**
	FF724	5	Fine India	614636**86770**

POINTED FILES

DIM LxH(mm)	TYPE	PK QTY	GOOD	
76x8	MF723	5	Medium India	614636**86745****

SILVERSMITH FILES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
102x13x2	FF444	5	Fine India	614636**86955**
	MF444	5	Medium India	614636**86960**
76x10x3	HF823	5	Hard Arkansas	614636**86805**

** Destock

Dimensions Key: DIM = Dimensions, L = Length, W = Width, H = Height

NOTES

VELKOOBCHOD BRUSIVA

ABRASIVE SLIPS & SPECIALTIES

Norton abrasive slips and specialty stones impart the finest, most uniform finish on a wide range of tools. These fast acting slips hold their shape and are long lasting.

APPLICATIONS & MARKETS

- Honing
- Gear deburring
- Die cleaning
- Reshaping

GOOD

CRYSTOLON

FEATURES	BENEFITS
■ Premium silicon carbide abrasive	■ Fast cutting stone; ideal for general sharpening of cutting tools ■ Fast stock removal for quick edge shaping with minimal loading

INDIA

FEATURES	BENEFITS
■ Smooth cutting aluminium oxide abrasive ■ Norton's trademark for a fine finish	■ Ideal when a close tolerance is more important than the speed of cut

ARKANSAS

FEATURES	BENEFITS
■ Natural premium Novaculite quarried in Arkansas & available in soft & hard	■ Sharpest possible razor edges ■ Near mirror finishes ■ Use for finer honing after India stone

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

PRODUCT SELECTION

APPLICATION	COARSE / MEDIUM SHARPENING	FINE STONING	FINISH HONING
Carbide tools	Medium & Crystolon round edge slip	Fine Crystolon round edge slip	
	Coarse or medium Crystolon carbide tool slip	Fine Crystolon carbide tool slip	
Gouges (wood)		Fine India gouge Sharpening stone	
Leather	Medium Crystolon Tradesmen		
Milling cutter	Medium India round edge slip	Fine India round edge slip	Hard Arkansas round edge slip
Pen knife			Arkansas pen knife
Reamers	Medium India reamer stone	Fine India reamer stone	
Scythe stone	Scythe stone		
Steel tool			Rubber stick

SLIP STONES

CARBIDE TOOL SLIP STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
89x19x13	MJT63	5	Medium Crystolon	614636**87290**
	FJT63	5	Fine Crystolon	614636**87285**

ROUND EDGE SLIP STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
102x25x11	MS14	5	Medium India	614636**87140**
	FS14	5	Fine India	614636**87135**
102x32x6	HS14	5	Hard Arkansas	614636**87050**
102x44x10	HS4	5	Hard Arkansas	614636**87045**
114x44x6	MJS24	5	Medium Crystolon	614636**87080**
	MS24	5	Medium India	614636**87150**
	FJS24	5	Fine Crystolon	614636**87075**
	FS24	5	Fine India	614636**87145**
114x44x10	MS34	5	Medium india	614636**87165**
	FS34	5	Fine India	614636**87160**
114x44x13	MJS44	5	Medium Crystolon	614636**87095**
	MS44	5	Medium India	614636**87180**
	FJS44	5	Fine Crystolon	614636**87090****
	FS44	5	Fine India	614636**87175**
114x54x16	MS54	5	Fine India	614636**90656***
127x25x8	MS15	5	Medium India	614636**87195****
	FS15	5	Fine India	614636**87190****

CARVING TOOL SLIP STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
57x22x5	AS22	5	Hard Arkansas ultra-fine	614636**87255**

Dimensions Key: DIM = Dimensions, L = Length, W = Width, H = Height

* Made-to-order ** Destock

ABRASIVE SLIPS & SPECIALTIES

SPECIALITY STONES

GOUGE SHARPENING STONE

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
152x51x35	FS76	5	Fine India	614636**87305**

TRADEMAN'S STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
241x35x13	JT911	5	Medium Crystolon	076607**87938****

MACHINE KNIFE STONE

DIM DIAxH(mm)	TYPE	PK QTY	GOOD	
102x38	JB74	5	Coarse Crystolon	614636**87570**

REAMER STONES

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
127x25x5	FT125	5	Fine India	614636**87430**
	MT125	5	Medium India	614636**87425**
152x25x6	MT126	5	Medium India	614636**87440****

RUBBING BRICK

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
203x51x51	BF28	5	Hand Crystolon	614636**87845**
203x89x38	235	5	Fluted Crystolon	614636**87795**

SCYTHE STONE

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
240x35x13	TJ4	10	Scythe Stone	699366**93133**
254x32x19	JT930	5	Scythe Stone	614636**87675**

RUBBER STICK

DIM LxWxH(mm)	TYPE	PK QTY	GOOD	
200x10x20	-	5	A240FR96	699366**25667**

** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length, W = Width, H = Height

NOTES

VELKOOBCHOD BRUSIVA

ORGANIC CUT-OFF WHEELS

Reinforced cut-off wheels contain fabric incorporated throughout the entire diameter which stops the wheel bending during operation. Non-reinforced cut-off wheels are only designed for use on fixed base machines, where the work is securely clamped, the wheel is adequately guarded and operating on a controlled cutting plane. They are suitable for use in dry or wet conditions, depending on bond type.

APPLICATIONS & MARKETS

REINFORCED CUT-OFF WHEELS

- Foundry – all steel types
- Aerospace
- Automotive

NON-REINFORCED CUT-OFF WHEELS

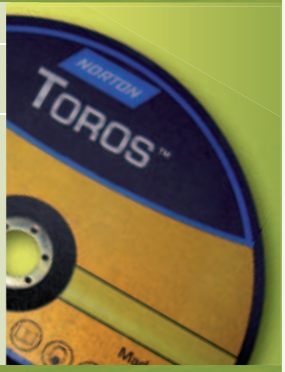
- Saw sharpening
- Tool cut-off
- Lab cut-off
- Industrial cut-off

BEST

4NZ (TOROS)

Type 41 Type 42

FEATURES	BENEFITS
■ High concentration of zirconia oxide abrasive	■ Very long wheel life
■ Extremely tough aluminium oxide abrasive	■ Very high cutting capability & high metal removal rate if high right pressure is applied: shelf re-sharpening ■ Perfect for technical applications for premium performances



5NZ (TOROS)

Type 41 Type 42

FEATURES	BENEFITS
■ Medium concentration of zirconia oxide abrasive	■ Long wheel life
■ Extremely tough aluminium oxide abrasive	■ Good metal removal rate ■ Versatile: suitable for most steels

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

BEST

XGP (TOROS)

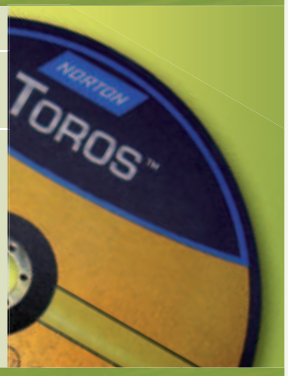
Type 41

FEATURES	BENEFITS
■ Special combination of abrasive blends	■ Very long wheel life & high metal removal rate
■ High durability with a good cutting capability	■ Perfect for lab applications ■ Suitable for use on all types of steel

39C (TOROS)

Type 41

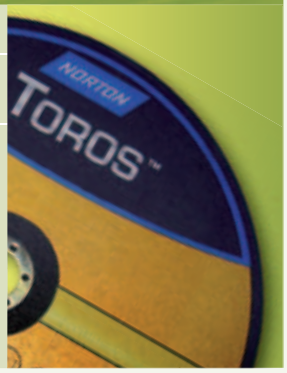
FEATURES	BENEFITS
■ Highest purity green silicon carbide abrasive	■ Excellent to cut all non metals (titanium, aluminum, bronze)
■ Harder & more friable than aluminium oxide abrasive	■ Extremely friable abrasive for better cutting efficiency & cut quality



74C (TOROS)

Type 41

FEATURES	BENEFITS
■ Special blend silicon carbide abrasives	■ Good wheel life, limited metal removal rate
■ More durable than the sharper 39C abrasive	■ Good to cut aluminum, cast iron & bronze



BETTER

U57A

Type 41 Type 42

FEATURES	BENEFITS
■ Specially treated brown aluminium oxide abrasive	■ Long wheel life
■ Tough & hard aluminium oxide abrasive	■ Ideal for heavy duty applications
■ Not suitable for use on extremely hard materials	

VELKOOBCHOD BRUSIVA

ORGANIC CUT-OFF WHEELS

GOOD

57A

Type 41

FEATURES	BENEFITS
■ Semifriable aluminium oxide abrasive	■ Cool & burn free cutting
■ Less tough than type A abrasive but offers better cutting quality	■ Ideal for heat-sensitive applications with light to moderate feed rates
■ Pointed shape	■ Suitable for all steels ■ Good compromise between cut quality & wheel life ■ Very versatile: suitable for all steels

A

Type 41

FEATURES	BENEFITS
■ Tougher than pure white aluminium oxide abrasive	■ Good wheel life, limited metal removal rate
■ General purpose abrasive suitable for most operations	■ Good for cutting medium to soft steels ■ Economy product ■ First choice for less technical applications

23A

Type 41

FEATURES	BENEFITS
■ An abrasive blend of semifriable 57A aluminium oxide & white monocristalline 32A aluminium oxide	■ Cool & burn free cutting ■ Suitable for all steels ■ Improved metal removal rate compared to 57A pure semifriable aluminium oxide abrasive

SPEC CHECK

- **B24** New generation bond used on silicon carbide cut-off wheels that gives the best performance & the ultimate cut quality on non-ferrous metals in wet conditions
- **B25** Standard multi-purpose bond that offers durability & freeness of cut in a wide variety of materials & applications. Can also be used in wet cutting on softer grades
- **B26** New generation bond used on aluminium oxide cut-off wheels that gives the best performance & the ultimate cut quality on ferrous metals in wet conditions
- **BF1** Specific bond ensuring the best quality of cut in dry or wet conditions
- **BF3** New generation bond assuring the best wheel life in dry cutting operations; versatile & long wheel life. Ideal for heavy duty operations
- **B65** Traditional bond gives good performance & long wheel life in dry cutting conditions

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

NON-REINFORCED

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	BEST		GOOD	
Type 41						
100x1x13	80	25			57A 60 PB25	66253056355
100x1x20	80	25			23A 80 PB25	66253056356
125x1x13	80	25			57A 60 PB25	66253056357*
125x1x16	80	25			23A 80 PB25	66253056358
125x1x20	80	25			57A 60 PB25	66253056359
150x1x13	80	25			23A 80 PB25	66253056361
150x1x16	80	25			23A 80 PB25	66253056363
150x1x20	80	25			23A 80 NB25	66253056367
	80	25			23A 80 PB25	66253056368
150x1x32	80	25			57A 60 PB25	66253056373
150x1,6x16	80	25			23A 60 NB25	66253056362
150x1,6x20	63	25			23A 60 LB25	66253056365
	80	25			23A 60 NB25	66253056366
	80	25			57A 60 PB25	66253056364
150x1,6x31,75	80	25			57A 60 RB25	66253056371*
150x1,6x32	80	25			57A 60 NB25	66253056360
	80	25			57A 60 PB25	66253056372
150x2x20	80	25			23A 60 NB25	66253056370
150x2x32	80	25			57A 60 PB25	66253056369
150x3x32	80	25			57A 60 PB25	66253056374
180x1,6x31,75	80	25			57A 60 PB25	66253056375
	80	25			57A 60 RB25	66253056376
200x1,5x20	63	10	XGP 70 FB26 (Toros)	66253060407*		
200x1,6x20	80	25			57A 60 PB25	66253056377
200x1,6x32	80	25			57A 60 NB25	66253056382
	80	25			57A 60 PB25	66253056380
	80	25			57A 60 RB25	66253056381**
200x2x20	63	25			23A 60 LB25	66253056378
200x2x25,4	80	25			57A 60 PB25	66253056379
250x1,6x25,4	80	10			57A 60 NB25	66253056383
250x1,6x32	63	10	39C 70 DB24 (Toros)	66253060408*		
	63	10	74C 70 FB24 (Toros)	66253060415*		
	63	10	XGP 70 EB26 (Toros)	66253060409		
	63	10	XGP 70 FB26 (Toros)	66253060410		
	63	10	XGP 70 HB26 (Toros)	66253060411		
	63	10	XGP 70 JB26 (Toros)	66253060412		

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

JIMI VELKOOBCHOD BRUSIVA

ORGANIC CUT-OFF WHEELS

NON-REINFORCED (CONTINUED)

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	BEST		GOOD	
Type 41						
300x2x32	63	10	39C 70 DB24 (Toros)	662530**60419***		
	63	10	XGP 70 EB26 (Toros)	662530**60418**		
	63	10	XGP 70 FB26 (Toros)	662530**60417**		
350x2,5x32	63	10	39C 70 DB24 (Toros)	662530**60423****		
	63	10	74C 70 FB24 (Toros)	662530**60422****		
	63	10	XGP 70 EB26 (Toros)	662530**60414****		
	63	10	XGP 70 FB26 (Toros)	662530**60420**		
	63	10	XGP 70 HB26 (Toros)	662530**60421**		
400x3x32	63	10	XGP 60 EB26 (Toros)	662530**60425***		
	63	10	XGP 60 FB26 (Toros)	662530**60424**		
450x3,5x32	63	10	XGP 60 EB26 (Toros)	662530**60428**		

* Made-to-order ** Destock

REINFORCEMENTS

- The main purpose of the fibreglass reinforcement in cut-off wheels is safety. Reinforcements also permit wheels to withstand high rotational speed & make them more flexible. Reinforcements can be external or internal, half or full diameter. Reinforcements impact the cutting profile, affecting both the straightness & quality of cut.

Straight Type 41

Depressed Centre Type 42

NA

NA2*

NA3

NA4

NA6

DA6

DA8

*NA2 is different from NA because it has lighter reinforcements

SPEC CHECK

- Non-reinforced cut-off wheels are designed for use on "fixed base" machines where the work is securely clamped, guarded, & where the wheel operates on a controlled cutting plane
- Run the cut-off machine at the highest possible speed marked on the wheel
- Long life wheels should be used on a cut-off machine with 1 horsepower for every 25mm wheel diameter. With a less powerful machine, we recommend starting with a Free Cut specification

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

REINFORCED

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	BEST		BETTER		GOOD	
Type 41								
150x2x20	80	25			U57A 60 QB25 NA2	662530**56384**		
200x2x20	80	25			U57A 60 QB25 NA2	662530**56385****		
200x2x32	80	25			U57A 60 OB25 NA2	662530**56386**		
300x3,5x25,4	80	10	4NZ 30 TB65 NA	662530**56387**				
350x3,5x25,4	80	10	4NZ 30 TB65 NA	662530**59172**				
	80	10	4NZ 30 TBF3 NA (Toros)	662530**56388**				
400x4x25,4	80	10			U57A 24 TB65 NA	662530**56389****		
400x4,5x25,4	80	10	4NZ 30 XB25 NA	662530**59175***				
	80	10	4NZ 30 YB65	662530**56390****				
400x4,5x40	80	10					57A 24 PB25 NA4	662530**59176**
500x4,5x25,4	80	10	4NZ 24 TB65 NA	662530**56527****				
500x5x25,4	80	10					57A 24 TB25 NA (RC26)	662530**56529**
500x5,5x25,4	80	10	4NZ 30 XB25 NA	662530**56535**				
	80	10					57A 24 PB25 NA4	662530**56533**
	80	10					57A 24 RB25 NA4 (TBDX METAL)	662530**56536**
500x5,5x40	100	10			57A2 44 TBF1 NA4 (Toros)	662530**56534**		
600x6,5x60	100	5					57A 24 PB25 NA6	662530**57645**
600x7x60	100	5			U57A 24 VBF3 NA6 (Toros)	662530**57646**		
Type 42								
400x5x76,2	80	10	4NZ 24 ZB25 DA8 (NZ 28 DR)	662530**56523**	U57A 20 VB25 DA8 (UA26 DR)	662530**56524**		
	80	10	5NZ 24 PBF3 DA6 (Toros)	662530**56525****				
508x6x76,2	80	10	4NZ 24 ZB25 DA8 (NZ 28 DR)	662530**56539**	U57A 20 RB25 DA8	662530**56538**		
	80	10	5NZ 20 PBF3 DA6 (Toros)	662530**56540***				

* Made-to-order ** Destock

Jimi VELKOOBCHOD BRUSIVA

ORGANIC SNAGGING WHEELS & CUPS

Norton offer a range of products for portable snagging foundry applications. Type 01 straight wheels are used on portable machine and Type 06 and 11 cup wheels on vertical grinders. Since finish tolerances are not usually critical, coarse, durable wheels are used with grit sizes ranging from 16 to 24.

APPLICATIONS & MARKETS

- Foundries
- Welding shops
- Steel mills
- Forge shops

BEST

ZF7A/ZF7C

Type 01

FEATURES	BENEFITS
Special design of abrasive blends	Very good compromise between wheel life & metal removal rate
High durability & versatility	ZF7A is premium product for all steels ZF7C is premium product for all non-ferrous metals

GOOD

A/AZ

Type 06 Type 11

FEATURES	BENEFITS
Tougher than pure white aluminium oxide abrasive	Long wheel life, limited metal removal rate AZ is a blend of aluminium oxide & zirconia
General purpose abrasive ideal for most operations	Good for cutting medium to soft steels Economy product First choice for less technical applications

C

Type 11

FEATURES	BENEFITS
Low purity black silicon carbide abrasive	Suitable for roughing operations in coarse grit & resinoid wheels
Harder & more friable than aluminium type abrasives	Ideal for grinding & sharpening applications on metal carbide & non-ferrous metals Cheap alternative, first choice if no technical specific requirement

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

SPEC CHECK

- **B & B3** Foundry & portable wheels: multi-purpose bond that gives satisfactory results on most applications
- **B28** Foundry wheels: high level bond suitable for most technical applications requiring high powered machines

PORTABLE SNAGGING

DIM DIAxTxB(mm)	W (mm)	E (mm)	MOS (m/s)	PK QTY	GOOD	
Type 01						
50x10x10			50	20	A 24 TB	662530**57648****
50x13x10			50	20	A 24 TB	662530**57649**
50x20x10			50	20	A 24 PB	662530**57650***
63x13x9,53			50	20	A 24 TB	662530**57653***
			50	20	A 24 TB	662530**57652****
63x13x10			50	20	A 24 RB	662530**57651***
63x20x10			50	20	A 24 TB	662530**57655***
70x20x10			50	20	A 24 PB	662530**57656***
80x13x10			50	20	A 24 PB	662530**57659***
			50	20	A 24 TB	662530**57658***
100x20x20			50	20	A 24 RB	662530**57660***
100x25x16			50	20	A 16 SB	662530**57661***
100x25x20			50	20	A 16 SB	662530**57662**
			50	20	A 24 PB	662530**57663**
150x25x16			50	10	A 16 PB	662530**57664***
200x25x32			50	10	A 24 QB	662530**60722***
Type 06						
125x68x20	30	18	50	8	AZ 24 RB	662434**50227**
Type 11						
125x50xM14	25	20	50	10	A 20 MB	662435**70663**
	25	20	50	10	C 20 PB	662435**70664**
125x50xW5/8	25	20	50	10	A 20 PB	662435**70671****
	25	20	50	2	C 16 NB	692104**32282**
150x50xW5/8	33,3	20	50	8	A 16 PB	662530**57666****
	32	20	50	8	A 20 MB	662435**70668****
	40	20	50	4	C 16 NB	692104**32287**

* Made-to-order ** Destock

Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore, W = Rim Width, E = Back Thickness

JIMI VELKOOBCHOD BRUSIVA

ORGANIC SNAGGING WHEELS & CUPS

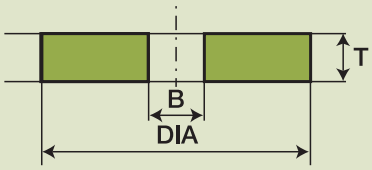
PEDESTAL SNAGGING

DIM DIAxTxB(mm)	MOS (m/s)	PK QTY	BEST		GOOD	
Type 01						
300x50x32	50	2			A 16 NB3	662530**61993***
	50	2			A 36 O6B3	662530**61994**
355x50x127	50	2			A 16 0B28	662530**57667***
400x50x127	50	2			A 24 QB3	662530**60723****
508x50x50	50	1	ZF7A 16 R5B3	662530**57670**		
508x50x127	50	1			A 16 NB28	662530**57668****
508x60x127	50	1	ZF7A 20 Q5B3	662530**57673**		
	50	1	ZF7A 16 R5B3	662530**57671**		
760x80x304,8	50	1	ZF7A 14 3RB28	662530**57675**		
	50	1	ZF7A 16 3RB28	662530**57676***		

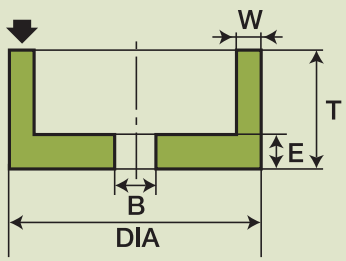
* Made-to-order ** Destock

SHAPE KEY

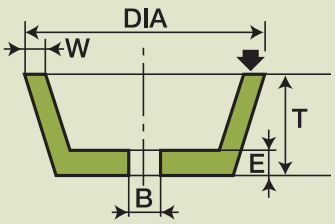
Type 01



Type 06



Type 11



Dimensions Key: DIM = Dimensions, DIA = Diameter, T = Thickness, B = Bore

NOTES

VELKOOBCHOD BRUSIVA

ORGANIC MOUNTED POINTS

NEW Norzon (NZ24) resin bond mounted points are ideal for fast stock removal in tough, aggressive (coarse grit) applications. The Norzon (zirconia alumina) self sharpening abrasive grain and durable organic bond provides 4x faster stock removal than competitive aluminium oxide products with 2x longer life.
The best choice for fast aggressive stock removal...

APPLICATIONS & MARKETS

- Foundries
- Steel mills
- Tool industry

BEST

NZ

FEATURES	BENEFITS
NZ - zirconia alumina (NorZon) self-sharpening abrasive and durable organic bond	4x faster stock removal than competitive aluminum oxide products Longest lasting

GOOD

A

FEATURES	BENEFITS
Tougher than pure white aluminium oxide abrasive	Especially suited for carbon steel, HSS & alloyed steel
General purpose abrasive for most operations	Good for cutting medium hardness – soft steels First choice if no technical specific requirement

VELKOOBCHOD BRUSIVA

NORTON SAINT-GOBAIN

ORGANIC MOUNTED WHEELS

SHAPE	DIM DIAxL(mm)	SPINDLE DIAxL(mm)	MOS (RPM)	PK QTY	BEST		GOOD	
A1	20x65	6x40	15000	10	NZ 24	614636**89077**		
A3	22x70	6x40	14000	10	NZ 24	614636**89079**		
A5	20x28	6x40	30000	10	NZ 24	614636**89081**		
A11	21x45	6x40	18000	10	NZ 24	614636**89082**		
W177	10x20	6x40	66000	10	NZ 24	614636**89084**		
	10x20	6x40	66000	20			A 46 QB	662530**53220***
W178	10x25	6x40	55200	10	NZ 24	614636**89085**		
	10x25	6x40	55200	20			A 46 QB	662530**53221***
W189	13x50	6x40	30370	10	NZ 24	614636**89089**		
W188	13x40	6x40	30370	10	NZ 24	614636**89090**		
	13x40	6x40	30370	20			A 36 QB	662530**53225**
	13x40	6x40	30370	20			A 46 QB	662530**53226***
W204	20x20	6x40	42750	10	NZ 24	614636**89091**		
	20x20	6x40	42750	20			A 46 QB	662530**53229***
W205	20x25	6x40	34500	10	NZ 24	614636**89093**		
	20x25	6x40	34500	20			A 36 QB	662530**53230**
	20x25	6x40	34500	20			A 46 QB	662530**53231**
W207	20x40	6x40	24000	10	NZ 24	614636**89095**		
	20x40	6x40	24000	20			A 46 QB	662530**53232***
W220	25x25	6x40	25500	10	NZ 24	614636**89097**		
	25x25	6x40	25500	20			A 36 QB	662530**53239***
	25x25	6x40	25500	20			A 46 QB	662530**53237**
W221	25x40	6x40	19120	10	NZ 24	614636**89098**		
	25x40	6x40	19120	20			A 46 QB	662530**53243**
W230	32x32	6x40	24000	10	NZ 24	614636**89099**		
	32x32	6x40	24000	20			A 36 QB	662530**53250**
	32x32	6x40	24000	20			A 46 QB	662530**53248**
W236	40x13	6x40	25130	10	NZ 24	614636**89100**		
	40x13	6x40	25130	20			A 46 QB	662530**53251**
W242	50x25	6x40	19100	10	NZ 24	614636**89101**		
	50x25	6x40	19100	20			A 46 QB	662530**53252**

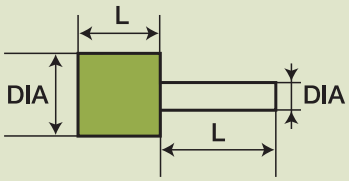
* Made-to-order

Dimensions Key: DIM = Dimensions, DIA = Diameter, L = Length

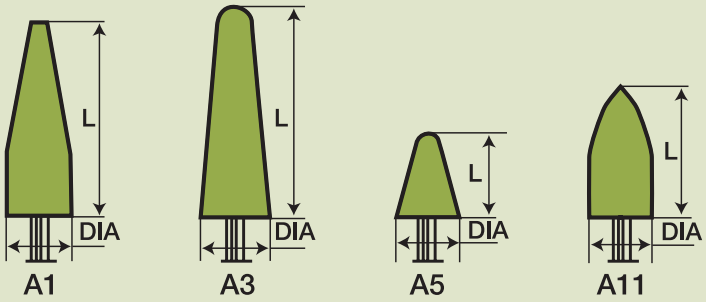
Jimi VELKOOBCHOD BRUSIVA

ORGANIC MOUNTED POINTS

SHAPE W KEY



SHAPE A KEY



SPEC CHECK

- Use “A” shapes for medium- to heavy-duty blending
- Use “W” shapes for offhand and precision grinding of medium to heavy stock

jimi VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

382 INTRODUCTION

386 DIAMOND & CBN GRINDING WHEELS FOR THE MACHINING OF ROUND TOOLS

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Jmi
VELKOOBCHOD BRUSIVA

Super Abrasives

INTRODUCTION

Diamond is the hardest material known to man, closely followed by Cubic Boron Nitride (CBN). As a result of their hardness these materials are used extensively in the most demanding precision grinding, slicing, and cutting applications. Super Abrasive wheels use diamond and CBN technology to cut demanding materials such as carbide, high speed steel, ceramics, and glass.

Norton provides ultimate, high performance Super Abrasive solutions for the cutting tools industry, offering products specifically designed to deal with the hardest and most challenging materials.

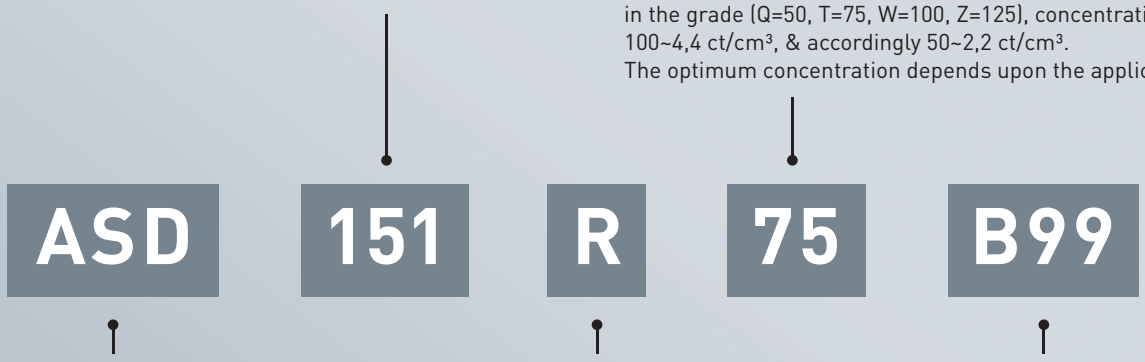
UNDERSTANDING THE PRODUCT

GRIT SIZE

Size of the Super Abrasive particles according to FEPA standards. The smaller the number, the finer the grit size.

CONCENTRATION

Indicates the amount of Super Abrasive grits in the wheel. For CBN wheels the concentration number is included in the grade (Q=50, T=75, W=100, Z=125), concentration 100~4,4 ct/cm³, & accordingly 50~2,2 ct/cm³.
The optimum concentration depends upon the application.



ABRASIVE TYPE

Both diamond & CBN have distinctive characteristics that meet the most demanding applications.

ASD: Synthetic diamond, armoured, high quality, versatile

CB: Cubic boron nitride, armoured, durable

GRADE

Refers to the degree of durability of the wheel, progressing alphabetically from A (softest, least durable) to Z (hardest, most durable).

BOND

The element in a grinding wheel that holds the diamond or CBN grains together.

WHEEL COLOUR

For further information please go to the Technical Information Section at the back of this catalogue.

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GRIT SIZE

The grit size selection depends on the required stock removal rate and the required surface finish.

EUROPEAN (FEPA) SIZE	U.S. STANDARD	US NORTON GRIT SIZE [MESH]	
	MESH	DIAMOND	CBN
1182	16/20	16	–
852	20/30	24	24
602	30/40	36	36
501	35/40	–	–
427	40/50	46	46
301	50/60	60	60
251	60/70	-	-
-	50/80	80	80C
252	60/80	100	80
213	70/80	-	-
181	80/100	105	100
-	80/120	100S	120C
151	100/120	110	120
126	120/140	120	150
107	140/170	150	180
91	170/200	180	220
76	200/230	220	230
64	230/270	240	240
54	270/325	320	320
46	325/400	400	400

APPROXIMATE EUROPEAN (FEPA) SIZE	NOMINAL MICRON SIZE	NORTON GRIT SIZE [MESH]
M63	40/60	–
M40	30/40	500
M25	20/30	–
M16	10/20	600
M10	6/12	800
M6,3	4/8	–
M4,0	2/4	–
M1,0	0/2	–

CONCENTRATION

The concentration influences the stock removal rate and the geometry of the workpiece.

DIAMOND 50/75/100/125 **CBN** Q/T/W/Z

BOND TYPES

B99 Extremely versatile resin bond used in advanced products both for wet and dry applications.

AZTEC IV Premium teflon/silver bond used for dry grinding on in typical tool room applications.

ECO line Especially designed resin bonds for saw blade applications.

APPLICATIONS & MARKETS

Although both diamond and CBN are Super Abrasives, the areas of usage varies dramatically depending on the workpiece material.

DIAMOND

- Cemented carbide
- Glass
- Ceramics
- Fibreglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

CBN

- High speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hard stainless steel
- Abrasion-resistant ferrous materials

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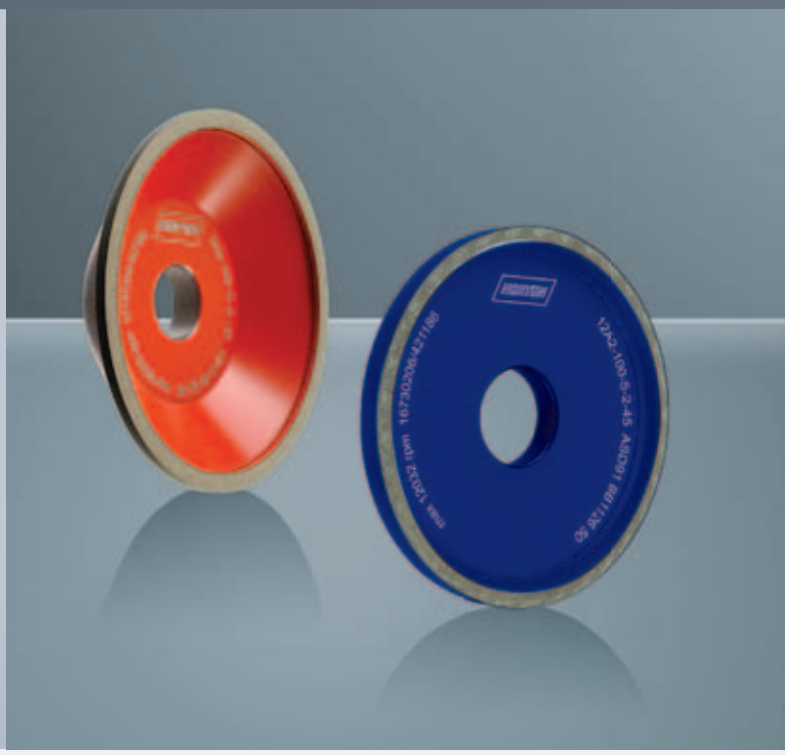
DIAMOND & CBN GRINDING WHEELS

Norton diamond and CBN wheels are designed to grind and cut the hardest materials known to man, helping make 'difficult-to-grind' applications routine operations. Hardness, abrasion resistance, compressive strength, thermal conductivity are all features designed to achieve a high level of precision and quality, making them a logical choice for a wide range of applications.



DIAMOND WHEELS

FEATURES	BENEFITS
■ High quality synthetic diamond	■ High material removal rates. Longer wheel life versus conventional silicon carbide wheels
■ Pre-engineered resin bond - B99	■ Free cutting; superior form holding. Efficient wet or dry ■ Ideal for dry tool room reconditioning applications ■ Ideal for 1A1R cut-off applications and grinding glass or ceramic materials
■ Optimised design	■ Fast stock removal, cool cutting; excellent for dry off-hand finishing of carbide tools, no wheel dressing required ■ Durable under high grinding forces. Excellent for wet off-hand finishing of carbide tools

CBN WHEELS

FEATURES	BENEFITS
■ High quality durable CBN abrasive	■ Easily cuts difficult to grind steel parts, HRC 50 or harder ■ Highly wear resistant and thermally stable
■ Pre-engineered resin bond - B99	■ Free cutting, superior form holding
■ High performance Aztec IV bond	■ Larger cutting depth
■ Optimised design	■ Extremely efficient for dry tool re-sharpening especially when heavy stock removal is required

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WHEEL SHAPES

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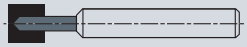
1A1W



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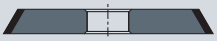

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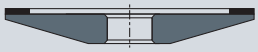

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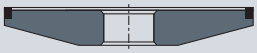

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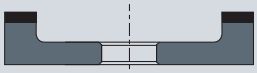

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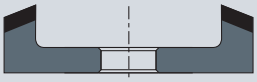

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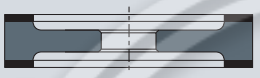

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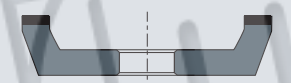
11A2-70°



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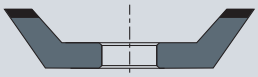

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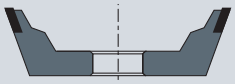

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12A2-20°

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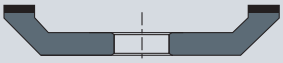
12A2-45°



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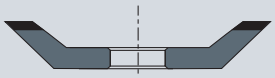

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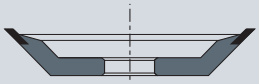

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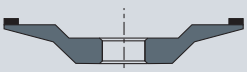

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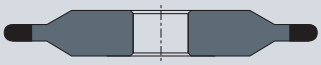

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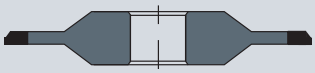

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VELKOOBCHOD BRUSIVA

DIAMOND AND CBN GRINDING WHEELS
FOR THE MACHINING OF ROUND TOOLS

Norton offers a comprehensive, newly designed product range for work on round tools such as drills, end and reamers. Diamond and CBN grinding wheels are ideal for producing and re-sharpening tungsten carbide and HSS tools.

The following sections are arranged by application for easy identification of the correct grinding wheel for fluting, gashing, grinding of clearance angles and re-sharpening. Within the sub-chapters the grinding wheels are ordered by FEPA code.

Source: Rollomatic

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
R100 B99	↑	For CNC grinding operations (wet)
R75 B99		For universal grinding (wet or dry)
R50 B99		For universal grinding (wet or dry)

BOND OVERVIEW CBN

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
W B99	↑	For CNC grinding operations (wet)
T B99		For universal grinding (wet or dry)
Aztec IV		Very free grinding dry grinding bond

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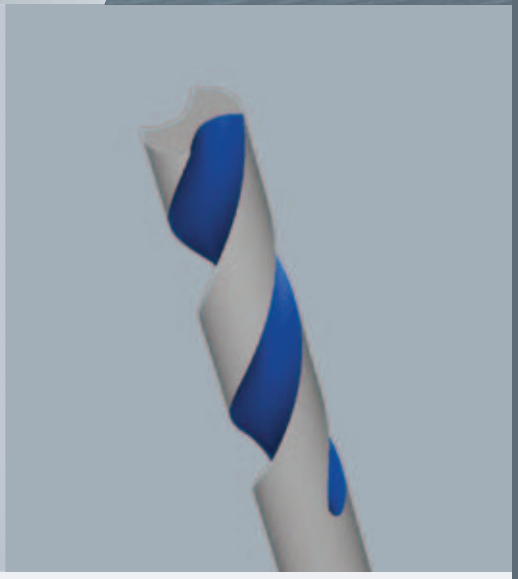
The Norton B99 resin bonded wheel is ideal for flute grinding on CNC machines and is particularly suitable for applications on standard tools.

D64R100B99 and B107 W B99 are the most commonly used products for flute grinding, however other specifications can be made available on request.



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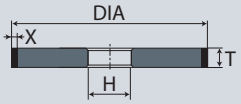

FLUTING

DIAMOND

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	6	3	32	1	ASD91 R100 B99	7958732719
100	10	5	20	1	ASD64 R100 B99	7958732706
100	12	5	20	1	ASD64 R100 B99	7958732713
100	15	5	20	1	ASD64 R100 B99	7958732714
125	5	3	20	1	ASD126 R100 B99	7958732469
125	10	10	20	1	ASD64 R100 B99	7958732470
125	12	10	20	1	ASD64 R100 B99	7958732471
150	12	10	20	1	ASD64 R100 B99	7958732727

CBN

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	10	5	20	1	CB107 W B99	7958732712
125	10	10	20	1	CB107 W B99	7958728828
100	15	5	20	1	CB107 W B99	7958732716

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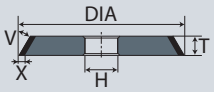
1V1



FLUTING

DIAMOND

D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	10	5	10	20	1	ASD64 R100 B99	79587**32976**
100	15	5	20	20	1	ASD64 R100 B99	79587**32974**
125	10	5	30	20	1	ASD64 R100 B99	79587**32984**

CBN

D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	15	5	20	20	1	CB107 W B99	79587**32994**

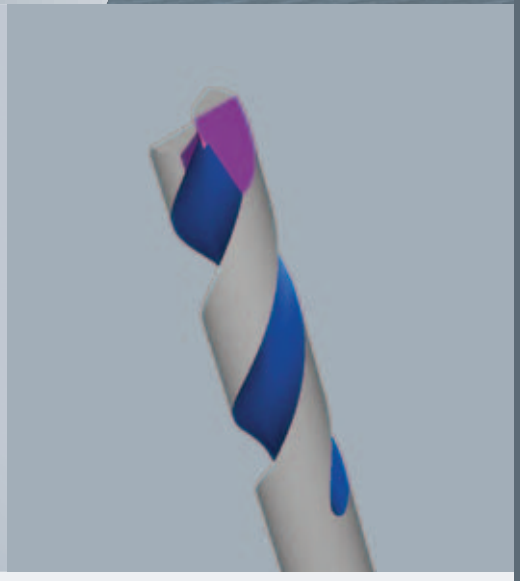
VELKOOBCHOD BRUSIVA

The state-of-the-art Norton B99 resin bond is free cutting and has good corner stability, the most essential characteristic required for CNC gashing.

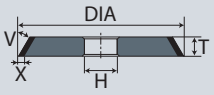
Two standard specifications are offered:
- for tungsten carbide tools: ASD64 R100 B99
- for HSS-tools: CB107 W B99

Both are available in 12V9 as well as in 1V1 shape.

Further combinations of dimensions, grit sizes and concentrations are available on request.



1V1 GASHING



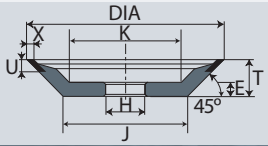
DIAMOND

D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	15	5	45	20	1	ASD64 R100 B99	7958732996	
125	15	5	45	20	1	ASD64 R100 B99	7958733015	

CBN

D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	15	5	45	20	1	CB107 W B99	7958733013	
125	12	5	45	20	1	CB107 W B99	7958733017	

12V9 GASHING



DIAMOND

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	2	10	20	20	52	11	60	1	ASD64 R100 B99	7958732837	Stiffened body
100	3	10	20	20	52	11	60	1	ASD64 R100 B99	7958732832	Stiffened body
125	2	10	20	25	60	12	74	1	ASD64 R100 B99	7958733019	Stiffened body
150	3	10	20	25	81	15	99	1	ASD64 R100 B99	7958732919	Stiffened body

CBN

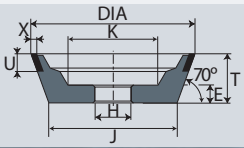
D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	3	10	20	20	52	11	60	1	CB107 W B99	7958732826	Stiffened body
125	3	10	20	25	71	14	74	1	CB107 W B99	7958732814	Stiffened body
150	3	10	20	25	81	15	99	1	CB107 W B99	7958732920	Stiffened body

VELKOOBCHOD BRUSIVA

Norton B99 resin bond tools are an ideal choice for grinding clearances and relief angles on CNC machines.
With excellent cutting behaviour the bond produces a good surface finish. The listed grinding wheels are suitable for the production and re-sharpening of tungsten carbide and HSS round tools.

D64 R100 and B107 W are the most common specifications for clearance angle grinding applications, however, other specifications are available on request.

11V9



CLEARANCE ANGLE GRINDING

DIAMOND

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
75	2	10	20	30	40	10	53	1	ASD64 R100 B99	7958732849	Stiffened body
100	2	10	20	35	59	15	74	1	ASD64 R100 B99	7958732876	Stiffened body
100	3	10	20	35	53	15	74	1	ASD64 R100 B99	7958732877	Stiffened body
125	3	10	20	40	70	18	95	1	ASD64 R100 B99	7958732856	Stiffened body

CBN

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
75	2	10	20	30	40	10	53	1	CB107 W B99	7958732851	Stiffened body
100	2	10	20	35	59	15	74	1	CB107 W B99	7958732874	Stiffened body
100	3	10	20	35	53	15	74	1	CB107 W B99	7958732844	Stiffened body
125	3	10	20	40	70	18	95	1	CB107 W B99	7958732854	Stiffened body

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Norton offers a comprehensive selection of different bonds and concentrations for re-sharpening applications on universal machines. The B99 grinding wheels can be used wet or dry. The lower the diamond or CBN concentration the more suited the product will be to grinding large contact areas. Aztec IV is a special free cutting resin bond which is designed for dry grinding operations and enables high material removal.

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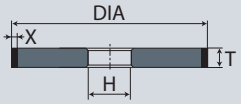

RE-SHARPENING

DIAMOND

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	4	3	20	1	ASD91 R75 B99	7958732717
100	10	5	20	1	ASD91 R75 B99	7958732711
125	10	5	20	1	ASD126 R75 B99	7958732466
150	10	3	20	1	ASD126 R50 B99	7958732724
150	10	3	32	1	ASD126 R75 B99	7958732726

CBN

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	10	3	20	1	CB126 T B99	7958732704
150	10	3	20	1	CB126 T B99	7958732725

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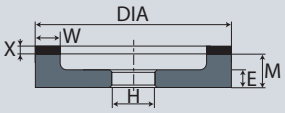
6A2



RE-SHARPENING

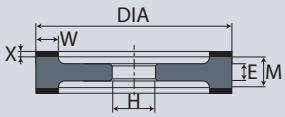
DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	6	4	20	23	10	1	ASD151 R75 B99	7958732881
100	12	2	20	18	10	1	ASD54 R50 B99	7958732886
100	12	2	20	18	10	1	ASD107 R50 B99	7958732879
125	6	5	20	25	10	1	ASD64 R75 B99	7958732922
125	10	2	70	23	10	1	ASD107 R50 B99	7958732882
150	10	2	20	23	10	1	ASD91 R50 B99	7958732932
150	15	2	32	23	10	1	ASD107 R50 B99	7958732933
150	20	2	20	20	10	1	ASD126 R75 B99	7958732934

CBN

D (mm)	T (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
125	6	4	20	23	10	1	CB151 T B99	7958732925
150	6	4	20	23	10	1	CB151 T B99	7958732936
150	6	4	32	23	10	1	CB151 T B99	7958732935

9A3

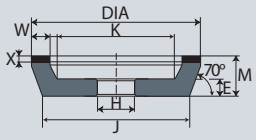


RE-SHARPENING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
175	5	2	20	30	14	1	ASD64 R50 B99	7958733005
175	5	2	20	30	14	1	ASD126 R50 B99	7958733002

11A2-70°



RE-SHARPENING

DIAMOND

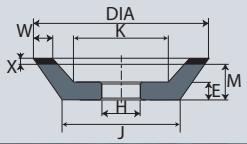
D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	5	4	20	20	75	10	88	1	ASD151 R75 B99	6015782163

CBN

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	5	4	20	20	75	10	88	1	CB126 T B99	6015782165

VELKOOBCHOD BRUSIVA

11V2

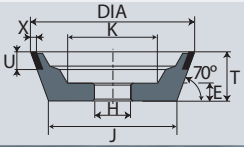


RE-SHARPENING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	5	3	20	20	72	8	82	1	ASD91 R75 B99	7958733007
100	5	3	20	20	72	8	82	1	ASD126 R75 B99	7958733011

11V9



RE-SHARPENING

DIAMOND

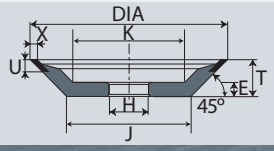
D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
75	2	10	20	30	40	10	53	1	ASD107 R75 B99	7958732857
75	2	10	20	30	40	10	53	1	ASD126 R75 B99	7958732859
100	2	10	20	35	55	10	74	1	ASD126 R75 B99	7958732867
100	3	10	20	35	60	10	74	1	ASD126 R75 B99	7958732862
100	3	10	32	35	60	10	74	1	ASD126 R75 B99	7958732865
125	3	10	20	40	81	10	96	1	ASD126 R75 B99	7958732847
125	3	10	32	40	81	10	96	1	ASD126 R75 B99	7958732848

CBN

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
75	1,5	10	20	30	40	10	53	1	BN181 Aztec IV	6901452323
75	2	10	20	30	40	10	53	1	CB126 T B99	7958732853
100	1,5	10	20	35	55	10	75	1	BN126 Aztec IV	6901452115
100	1,5	10	20	35	55	10	75	1	BN181 Aztec IV	6901452118
100	1,5	10	32	35	55	10	75	1	BN181 Aztec IV	6901452120
100	2	10	20	35	55	10	74	1	CB126 T B99	7958732869
100	2	10	32	35	55	10	74	1	CB126 T B99	7958732871

Jimi VELKOOBCHOD BRUSIVA

12V9



RE-SHARPENING

DIAMOND

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
75	2	10	20	25	34	10	39	1	ASD64 R75 B99	7958732816
75	2	6	20	20	45	10	42	1	ASD126 R75 B99	7958732811
75	3	6	20	20	45	10	42	1	ASD76 R75 B99	7958732890
100	2	10	20	20	64	10	59	1	ASD126 R75 B99	7958732821
100	3	10	20	20	65	10	59	1	ASD46 R75 B99	7958732885

CBN

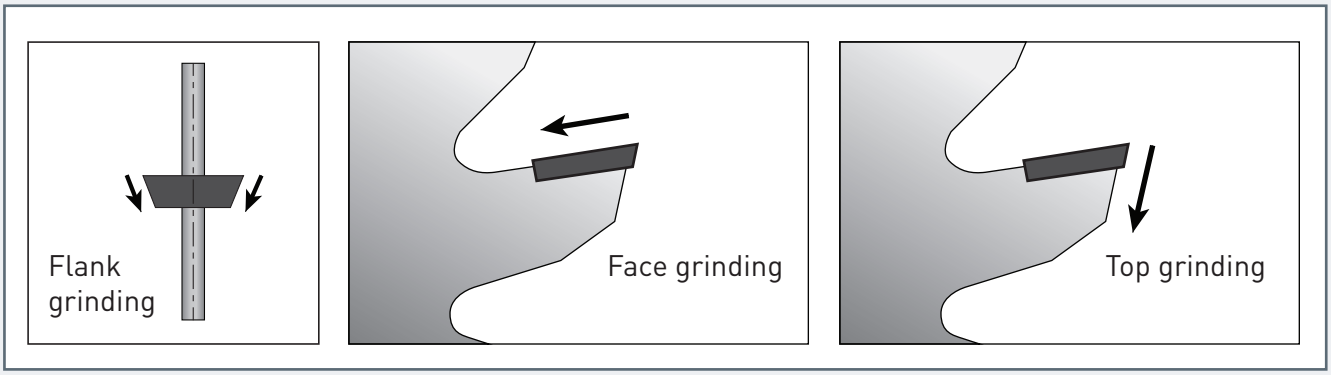
D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
75	2	6	20	20	45	10	42	1	CB107 T B99	7958732813
100	2	10	20	20	65	10	59	1	CB126 T B99	7958732818
100	3	10	20	20	65	10	59	1	CB126 T B99	7958732880

jimi VELKOOBCHOD BRUSIVA

DIAMOND AND CBN GRINDING WHEELS
FOR THE SAW BLADE INDUSTRY

Norton provides a comprehensive range of diamond and CBN grinding wheels. With an emphasis on excellent price vs. performance ratios, the saw blade programme aims to provide the best solutions for grinding tungsten carbide tipped saw blades and one-piece HSS saws.

The tungsten carbide tipped circular saw blade grinding wheels have been specifically designed for face grinding and flank grinding. Norton offers grinding wheels for the most common machine types required for these applications.



1A1W grinding pins for hollow tooth grinding are also available.

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Face	↑	Face grinding of tungsten carbide tipped saw blades
ECO Flank		Flank grinding of tungsten carbide tipped saw blades
ECO Top-AW		Top-grinding of tungsten carbide tipped saw blades on AKEMAT and WOODTRONIC machines
ECO Top		Universal top-grinding of tungsten carbide tipped saw blades
ECO Top-R		Top-grinding of tungsten carbide tipped saw blades, especially re-sharpening
ECO Top-P		Top-grinding of tungsten carbide tipped saw blades, especially production
B99		Universal resin bond for wet and dry grinding

BOND OVERVIEW CBN

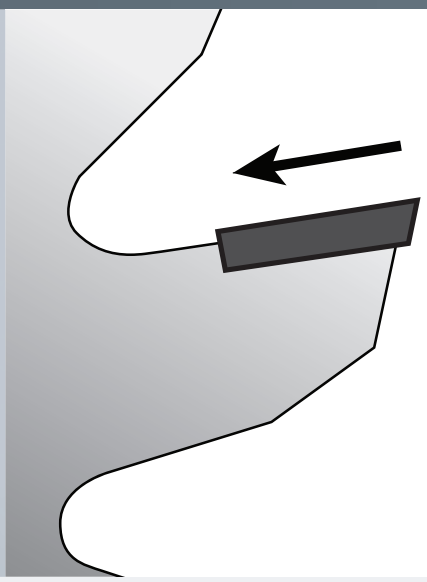
BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Curve		Profiling and re-sharpening of HSS saw blades

VELKOOBCHOD BRUSIVA

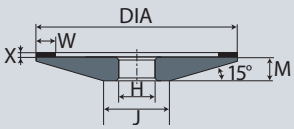
SAW BLADES TUNGSTEN CARBIDE TIPPED SAWS

The tooth face of circular saw blades is ground with sharp angled cup wheels. Depending on the tooth pitch, different angles and wheel thicknesses are required. The greater the number of teeth around the circumference, the narrower the space between them and the thinner the grinding wheel needs to be. Even the narrowest tooth gaps can be machined with our 12V9 ***ECO*** Face wheels.

For reasons of stability, conventional tooth gaps are mainly ground using 4A2 or 12V2 grinding wheels.



4A2



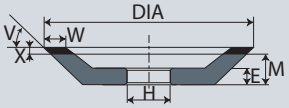
FACE GRINDING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	5	2	25*	7	51,5	1	ASD91 R75 B99	7958725784	For conventional tooth gaps

*4A2K (with Keyway)

12V2

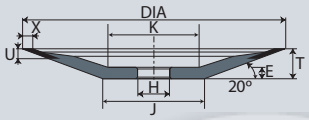


FACE GRINDING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	V (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
125	4	2	32	11	30	9	1	ASD46 R125 B99	60157682189	For conventional tooth gaps
125	4	2	32	11	30	9	1	ASD76 R125 B99	60157682188	For conventional tooth gaps
200	4	2	32	13	30	11	1	ASD46 R125 B99	7958725781	For conventional tooth gaps
200	4	2	32	13	30	11	1	ASD76 R125 B99	7958725780	For conventional tooth gaps

12V9



FACE GRINDING

DIAMOND

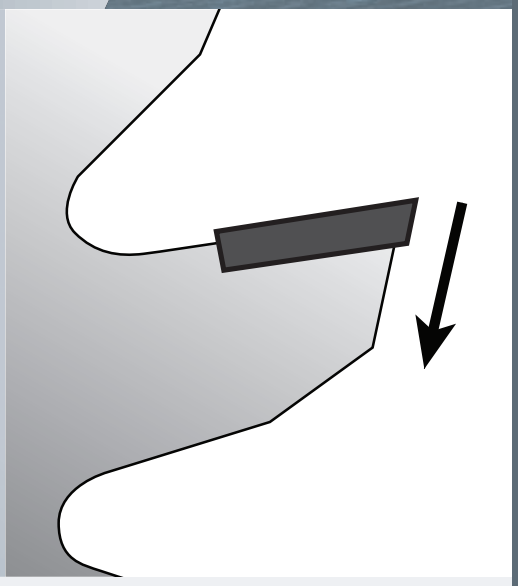
D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	2,3	4	25*	10	77	7	51	1	D46 ***ECO*** Face	7958717431	For narrow tooth gaps
125	2,3	4	25*	10	101	7	76	1	D46 ***ECO*** Face	7958714565	For narrow tooth gaps
125	2,3	4	32	13	101	10	70	1	D46 ***ECO*** Face	6901448184	For narrow tooth gaps
150	2,3	4	32	13	126	10	95	1	D46 ***ECO*** Face	7958719191	For narrow tooth gaps
200	2,3	4	32	13	173	10	145	1	D46 ***ECO*** Face	6901448205	For narrow tooth gaps

*12V9K (with keyway)

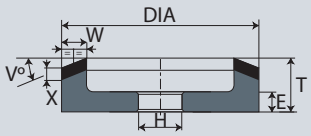
VELKOOBCHOD BRUSNO

To ensure the circular nature of the saw and to define the wedge and clearance angles, the top of the saw blade needs to be ground.

Vollmer and Widma machines normally require 6VV5 cup wheels
Akemat and Woodtronic machines require 14M1 state of the art peripheral wheels.



6VV5



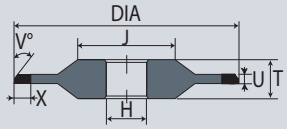
TOP GRINDING

DIAMOND

D (mm)	W (mm)	X (mm)	V (mm)	H (mm)	T (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
100	5	10	8	25*	24	7	1	ASD126/46 R100/R75 ***ECO*** TOP	7958725658	Universal use
125	5	10	8	32	22	11	1	ASD126/46 R100/R75 ***ECO*** TOP	7958725660	Universal use
125	5	10	8	32	22	11	1	ASD126/46 R100/R75 ***ECO*** TOP-P	7958725661	For production, oil
125	5	10	8	32	22	11	1	ASD126/46 R125/R100 ***ECO*** TOP-R	7958725663	For re-sharpening

*6VV5K (with keyway)

14M1



TOP GRINDING

DIAMOND

D (mm)	U (mm)	X (mm)	V (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
150	5	8	8	32	10	119	1	ASD126/46 R100/R75 ***ECO*** TOP-AW	7958725785	D126/D46: U=2,5/2,5
200	5	8	8	32	10	156	1	ASD126/46 R100/R75 ***ECO*** TOP-AW	7958725786	D126/D46: U=2,5/2,5

COLOUR CODES FOR MACHINE MANUFACTURERS

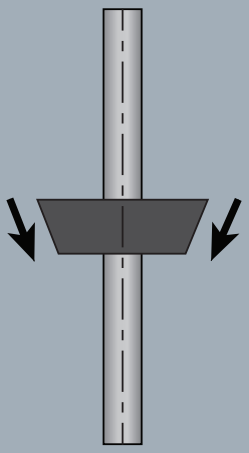
Vollmer-Biberach	Vollmer-Dornhan	Woodtronic	Akemat	Widma

VELKOOBCHOD BRUSNA

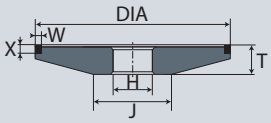
SAW BLADES TUNGSTEN CARBIDE TIPPED SAWS

During the flank grinding process the cutting width of the circular saw blade is defined. Therefore, typically two 4A9 grinding wheels are simultaneously fed from both sides.

When manufacturing saw blades there is a wide variety of tooth geometries and designs to chose from. Depending on the intended use of the saw, the tooth design can be flat, alternate, trapezoid or any combination of these. Hollow ground teeth are very common to achieve finer cuts with no burrs. The rounded shape of hollow ground teeth is produced with 1A1W grinding pins.



4A9



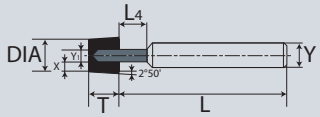
FLANK GRINDING

DIAMOND

D (mm)	X (mm)	W (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
80	4	5	32	10	53	1	ASD64 ***ECO*** Flank	7958725778	Universal use
86	4	5	32	10	59	1	ASD64 ***ECO*** Flank	7958725779	Universal use
100	4	4,5	20*	14	35	1	ASD64 ***ECO*** Flank	7958725739	Universal use
100	4	4,5	20*	14	35	1	ASD126 ***ECO*** Flank	7958725744	Universal use
100	4	5	32	10	55	1	ASD64 ***ECO*** Flank	7958725737	Universal use
100	4	5	32	10	55	1	ASD126 ***ECO*** Flank	7958725738	Universal use

*4A9K (with Keyway)

1A1W



HOLLOW TOOTH GRINDING

DIAMOND

D (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	Y_1 (mm)	L_4 (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
6,5	3	1,75	6	42	4,1	10	1	ASD76 R125 B99	7958725782	For all common machines
7	3	2	6	42	5,1	10	1	ASD76 R125 B99	7958725783	For all common machines

COLOUR CODES FOR MACHINE MANUFACTURERS

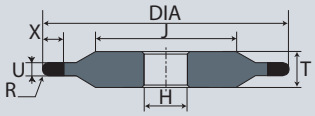
Vollmer-Biberach	Vollmer-Dornhan	Woodtronic	Akemat	Widma

VELKOOBCHOD BRUSIVA

HSS saw blades are one-piece saws that are ground from one solid piece of metal. For this process HSS saws require special grinding machines.

14F1 wheels grind the required profile under CNC control. Wheels are ideal for both initial profiling and re-sharpening thanks to the advanced resin bond systems which ensure the wheels are economic and extremely wear resistant.

14F1



INITIAL PROFILING AND RE-SHARPENING

CBN

D (mm)	U (mm)	X (mm)	R (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
200	1,3	6,5	0,65	32	8	169	1	CB107 ***ECO*** Curve	7958706686	For Loroch machines
200	1,6	7	0,8	32	8	164	1	CB107 ***ECO*** Curve	7958714307	For Loroch machines
200	2	8	1	32	8	164	1	CB107 ***ECO*** Curve	7958706684	For Loroch machines
200	2,5	8	1,25	32	8	159	1	CB107 ***ECO*** Curve	7958716444	For Loroch machines
200	3	10	1,5	32	8	160	1	CB107 ***ECO*** Curve	7958718179	For Loroch machines
200	4	12,5	2	32	8	157	1	CB107 ***ECO*** Curve	7958716216	For Loroch machines

jimi VELKOOBCHOD BRUSIVA

DIAMOND AND CBN GRINDING WHEELS
FOR GENERAL ENGINEERING

Norton diamond and CBN wheels for general engineering are suitable for many grinding applications like OD-, ID-, and flat grinding, machining of knives, milling cutters and polishing.

Most of the bonds listed in this section are made with ASD (armoured synthetic diamonds) grit and are suitable for wet and dry grinding applications. Some wheels use AMD (armoured metal bond diamonds) which are more wear resistant but require a coolant.

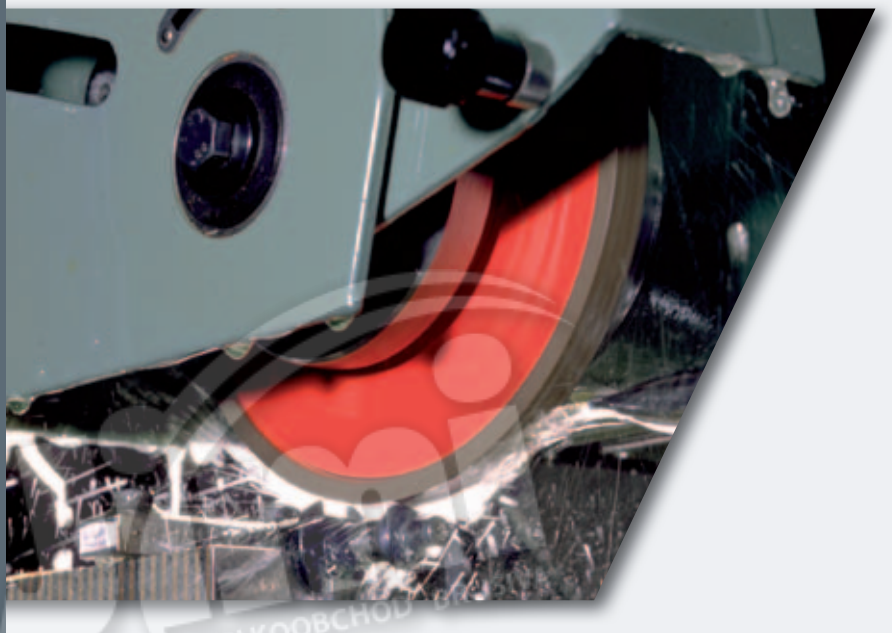
More information about the application can be found in the relevant sub-chapters.

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
R100 B99	↑	For universal grinding (wet or dry)
R75 B99		For universal grinding (wet or dry)
R50 B99		For universal grinding (wet or dry)

BOND OVERVIEW CBN

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
W B99	↑	For universal grinding (wet or dry)
T B99		For universal grinding (wet or dry)
Q B99		For universal grinding (wet or dry)

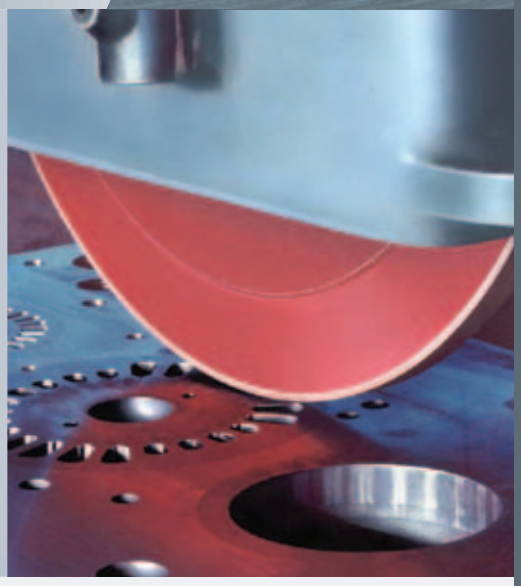


VELKOOBCHOD

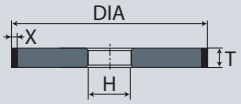
Norton offers a comprehensive stock programme for resin bonded 1A1 standard grinding wheels designed for OD- and flat grinding tungsten carbide and steel parts.

All specified grinding wheels can be used for OD- and flat grinding. However wheels (R50) with lower concentration have been specifically designed for flat grinding operations.

Other specifications are available on request.



1A1



OD- AND FLAT GRINDING

DIAMOND

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
175	15	3	32	1	ASD126 R50 B99	7958732730
200	10	3	32	1	ASD126 R75 B99	7958732731
200	10	3	51	1	ASD126 R75 B99	7958732732
200	15	3	32	1	ASD126 R75 B99	7958732840
250	15	3	76,2	1	ASD126 R75 B99	7958732804
300	10	3	127	1	ASD126 R75 B99	7958732824
300	15	3	127	1	ASD126 R75 B99	7958732810
300	20	3	127	1	AMD126 R50 B99	7958732812

CBN

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
200	10	3	51	1	CB126 T B99	7958732803
200	15	3	32	1	CB126 Q B99	7958732838
200	15	3	76,2	1	CB126 T B99	7958732835
250	20	3	76,2	1	CB126 Q B99	7958732802
300	15	3	127	1	CB126 T B99	7958732808
300	20	3	127	1	CB126 Q B99	7958732815

Jimi VELKOOBCHOD BRUSIVA

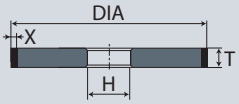
GENERAL ENGINEERING

Resin bonded grinding pins and grinding wheels can be used for wet or dry applications, either manually or on automatic grinding machines.

To avoid burning and to ensure stable grinding conditions the diameter must be carefully selected. It is highly recommended to chose a diameter no bigger than 70% of the bore. When using grinding pins it is very important to follow the permitted speed instructions, which are engraved on the grinding tool.

If the permitted speed is slower than the adjustable speed of the grinding spindle, a different technical solution is required.

1A1



ID- GRINDING

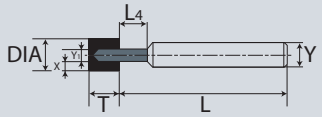
DIAMOND

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
15	12	2	6	1	ASD126 R100 B99	79587**32728**
20	10	2	6	1	ASD126 R100 B99	79587**32950**
25	10	2	6	1	ASD126 R75 B99	79587**32942**
30	10	3	6	1	ASD126 R75 B99	79587**32952**
30	10	3	10	1	ASD126 R75 B99	79587**32956**
40	15	3	10	1	ASD126 R75 B99	79587**32971**
50	15	3	20	1	ASD126 R75 B99	79587**32977**

CBN

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
12	10	2	6	1	CB126 W B99	79587**32722**
15	12	2	6	1	CB126 W B99	79587**32729**
20	10	2	6	1	CB126 W B99	79587**32948**
20	15	2	6	1	CB126 W B99	79587**32957**
25	10	2	10	1	CB126 W B99	79587**32945**
25	12	2	10	1	CB126 W B99	79587**32939**
30	15	3	10	1	CB126 W B99	79587**32937**
40	15	3	10	1	CB126 W B99	79587**32961**
50	15	3	20	1	CB126 W B99	79587**32981**

jimi VELKOOBCHOD BRUSIVA

1A1W  ID- GRINDING

DIAMOND

D (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	Y_1 (mm)	L_4 (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
3	6	0,65	3	60	1,7	8	1	ASD64 R100 B99	7958732951
3	6	0,65	3	60	1,7	8	1	ASD126 R100 B99	7958732949
5	6	1,5	3	60	2,1	8	1	ASD64 R100 B99	7958732944
5	6	1,5	3	60	2,1	8	1	ASD126 R100 B99	7958732943
6	6	1,5	6	60	3,1	8	1	ASD64 R100 B99	7958732940
6	6	1,5	6	60	3,1	8	1	ASD126 R100 B99	7958732941
8	10	2	6	60	4,1	12	1	ASD64 R100 B99	7958732954
8	10	2	6	60	4,1	12	1	ASD126 R100 B99	7958732953
10	10	2	6	60			1	ASD126 R100 B99	7958732960
10	10	2	6	60			1	ASD64 R100 B99	7958732959
12	12	2	6	60			1	ASD126 R100 B99	7958732964
12	12	2	6	60			1	ASD64 R100 B99	7958732963

CBN

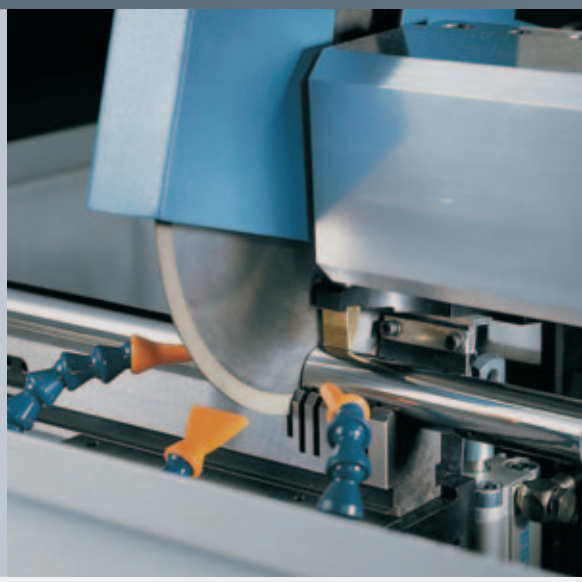
D (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	Y_1 (mm)	L_4 (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
3	6	0,65	3	60	1,7	8	1	CB126 W B99	7958732947
5	6	1,5	3	60	2,1	8	1	CB126 W B99	7958732946
6	6	1,5	6	60	3,1	8	1	CB126 W B99	7958732938
8	10	2	6	60	4,1	12	1	CB126 W B99	7958732955
10	10	2	6	60			1	CB126 W B99	7958732958
12	12	2	6	60			1	CB126 W B99	7958732962

Jimi VELKOOBCHOD BRUSIVA

GENERAL ENGINEERING

Norton offers a small assortment of standard resin bonded cut-off grinding wheels (ex stock). The specified diamond cut-off wheels cut hard, short-chipping and wear resistant materials such as glass, ceramics and carbide.
The contained CBN cut-off wheels are ideal for machining high speed steel, hardened steel, 55 HRC and magnetic materials.

Further specifications for resin bond, sintered metal and electroplated metal bond are available on request.



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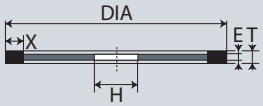


CUT-OFF

DIAMOND

D (mm)	T (mm)	X (mm)	E (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	0,9	5	0,7	20	1	ASD126 R75 B99	601576**81683**
125	1	5	0,7	20	1	ASD126 R75 B99	601576**81686**
150	1	5	0,8	20	1	ASD126 R75 B99	601576**81688**

CBN

D (mm)	T (mm)	X (mm)	E (mm)	H (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	0,9	5	0,7	20	1	CB151 T B99	601576**81767**
125	1	5	0,7	20	1	CB151 T B99	601576**82094**
150	1	5	0,8	20	1	CB151 T B99	601576**82103**

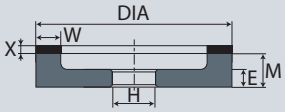
jimi VELKOOBCHOD BRUSIVA

Norton offers a range of resin bonded grinding wheels for machining flat, circular and profile knives (ex stock).

The 6A2 grinding wheels are specifically designed for wet grinding of circular knifes with tungsten carbide-steel combinations on Göckel and Reform machines.

The 14F1 grinding wheels are designed for use on Weinig machines for grinding profile knives for the wood industry.

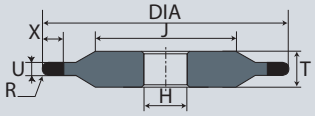
6A2 FLAT GRINDING



DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
200	8	4	50	31	23	1	AMD126 R100 B99	7958732926	For Göckel machines
200	8	4	75	31	23	1	AMD126 R100 B99	7958732850	For Reform machines

14F1 PROFILE GRINDING



DIAMOND

D (mm)	U (mm)	X (mm)	R (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
200	2	7	1	60	10	129	1	ASD64 R100 B99	7958732992	For Weinig machines
200	4	7	2	60	10	134	1	ASD151 R100 B99	7958732986	For Weinig machines

CBN

D (mm)	U (mm)	X (mm)	R (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.	ADDITIONAL INFORMATION
200	2	7	1	60	10	129	1	CB126 T B99	7958732990	For Weinig machines
200	4	7	2	60	10	134	1	CB151 W B99	7958732988	For Weinig machines

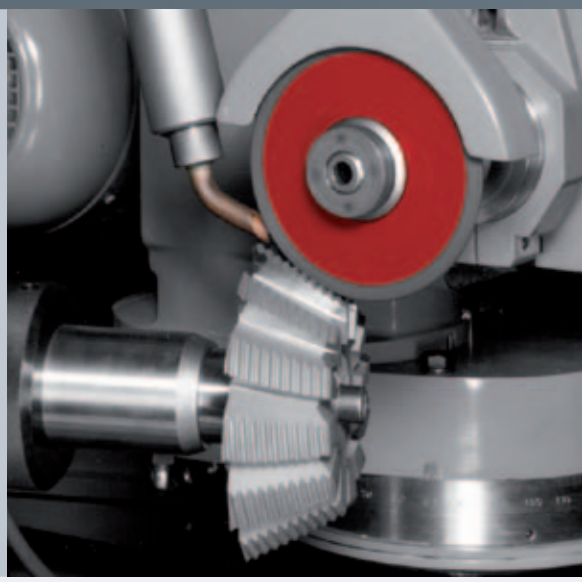
Jimi VELKOOBCHOD BRUSIVA

GENERAL ENGINEERING MILLING CUTTER

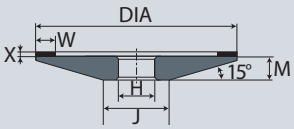
Grinding tool faces and clearances are the main applications of the milling cutter.

Norton offers a diverse range of grinding wheels to enable excellent performance in both applications. A comprehensive range of grit sizes and concentrations provides the ideal solution for each application (ex stock).

The price vs. performance ratio of these tools is the underlying benefit of this product range.



4A2



FACE GRINDING

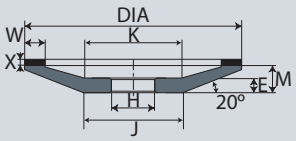
DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
175	5	4	32	11	104	1	ASD126 R75 B99	7958732929
150	5	2	32	9	94	1	ASD91 R75 B99	7958732855
150	5	2	20	9	94	1	ASD64 R75 B99	7958732863
150	5	2	32	9	94	1	ASD54 R50 B99	7958732858
150	5	2	20	9	94	1	ASD126 R75 B99	7958732864
125	5	2	32	7	84	1	ASD91 R75 B99	7958732866
125	5	2	20	7	84	1	ASD64 R75 B99	7958732868
125	5	2	20	7	84	1	ASD126 R75 B99	7958732870
125	10	2	20	7	84	1	ASD107 R75 B99	7958732873
100	5	2	20	6	66	1	ASD64 R75 B99	7958732965

CBN

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
175	5	4	20	11	104	1	CB126 T B99	7958733000
150	5	4	20	9	94	1	CB107 T B99	7958732852
100	5	2	20	6	66	1	CB126 T B99	7958732884

jimi VELKOOBCHOD BRUSIVA

12A2-20° 

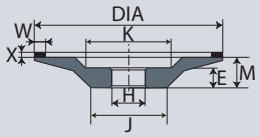
FACE GRINDING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
125	6	4	20	14	54	8	54	1	ASD126 R100 B99	601576**82171**
125	6	4	32	14	54	8	54	1	ASD91 R75 B99	601576**82172**
150	5	2	20	16	68	9	68	1	ASD64 R50 B99	690141**51397**
150	5	2	20	16	68	9	68	1	ASD126 R75 B99	690141**51961**
150	5	2	32	16	68	9	68	1	ASD126 R75 B99	690141**51963**
150	5	3	32	16	68	9	68	1	ASD64 R100 B99	601576**82177**
150	5	3	32	16	68	9	68	1	ASD91 R100 B99	601576**82176**
150	6	4	32	16	68	9	68	1	ASD91 R75 B99	601576**82179**
175	5	2	20	14	54	8	54	1	ASD126 R75 B99	690141**51721**
175	5	2	20	18	82	10	82	1	ASD126 R75 B99	690141**51422**
175	5	2	32	18	82	10	82	1	ASD126 R75 B99	690141**51424**

CBN

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
150	5	4	20	16	68	9	68	1	CB126 Q B99	690141**51412**
150	6	4	32	16	68	9	68	1	CB126 T B99	601576**82182**
175	5	4	20	18	82	10	82	1	CB126 T B99	690141**51427**

13A2 

FACE GRINDING

DIAMOND

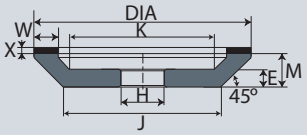
D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
125	5	4	20	19	50	9	73	1	ASD64 R50 B99	795873**2980**
125	5	4	20	19	50	9	73	1	ASD126 R50 B99	795873**2995**
125	5	4	20	19	50	9	73	1	ASD126 R75 B99	795873**2991**

CBN

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
125	5	4	20	19	50	9	73	1	CB64 Q B99	795873**2973**
125	5	4	20	19	50	9	73	1	CB107 Q B99	795873**2979**
125	5	4	20	19	50	9	73	1	CB151 Q B99	795873**2978**

JM VELKOOBCHOD BRUSIVA

12A2-45°



TOP GRINDING

DIAMOND

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	5	2	20	23	54	10	56	1	ASD107 R50 B99	7958732999
100	6	3	20	20	64	10	62	1	ASD76 R75 B99	7958732968
100	6	3	20	20	64	10	62	1	ASD126 R75 B99	7958732966
125	6	3	32	23	83	10	81	1	ASD126 R75 B99	7958732969

CBN

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ARTICLE NO.
100	5	2	20	23	54	10	56	1	CB126 Q B99	7958732997
125	6	2	20	23	83	10	81	1	CB126 T B99	7958732970

jimi VELKOOBCHOD BRUSIVA

Norton lapping compounds are supplied in a standard concentration of 5g dispenser syringes. Perfectly sized synthetic diamond powder is mixed with a paste. When used, this compound should be diluted with water or alcohol.

APPLICATIONS & MARKETS

- Used for lapping an extremely wide range of parts by hand
- Superfinishing of electronic components, semi-conductors, magnetic heads, rigid discs and optical discs
- Finishing for routine operations
- Preparatory lapping
- Fast removal of material, roughing

DIAMOND COMPOUND PASTE

FEATURES	BENEFITS
Optimised diamond grit distribution	Easy and safe application

DIAMOND COMPOUND PASTE

GRADE (MICRONS)	COLOUR	CONTENTS	PK QTY	ARTICLE NO.
1/4	GREY	5g	1	69014**54990**
1/2	LIGHT GREY	5g	1	69014**54991**
1	IVORY	5g	1	69014**54992**
3	YELLOW	5g	1	69014**54993**
6	ORANGE	5g	1	69014**54994**
9	GREEN	5g	1	69014**54995**
12	LIGHT BLUE	5g	1	69014**54996**
15	BLUE	5g	1	69014**54997**
20	BROWN	5g	1	69014**54998**
30	RED	5g	1	69014**54999**
45	CHESTNUT	5g	1	69014**55000**
60	VIOLET	5g	1	69014**55001**

VELKOOBCHOD BRUSIVA

Norton offers a range of diamond files in various shapes.

APPLICATIONS & MARKETS

- Deburring
- Tool profiling
- Touching up hardened steels and metal carbides
- Glass
- Ceramics
- Hard plastics

FILES

FEATURES	BENEFITS
■ Several shapes available	■ Free cutting and very high wear resistant, requiring only low contact pressure

FILES

SHAPE	T (mm)	H (mm)	L (mm)	PK QTY	ARTICLE NO.
▭	1,4	4,8	140	6	60157**36812**
◠	1,9	5,3	140	6	60157**36813**
△	3,6	3,6	140	6	60157**36814**
□	2,5	2,5	140	6	60157**36815**
○	∅	3,0	140	6	60157**36816**
▭▭	1,4	4,8	140	6	60157**36817**
Set - all above				6	60157**36811**

Dimensions Key: T = Thickness, H = Height, L = Length

VELKOOBCHOD BRUSIVA

NOTES

VELKOOBCHOD BRUSIVA

DIAMOND DRESSERS

Norton stationary diamond dressing tools have a worldwide reputation for quality and technology.

APPLICATIONS & MARKETS

- For the profiling and straight dressing of all conventional grinding wheels

PRODUCT SELECTION

USAGE KEY

■ Highly recommended

◧ Recommended

DRESSING TOOL	GENERAL CHOICE					
	STRAIGHT GRINDING WHEELS WITH NO PROFILE	PROFILED GRINDING WHEELS	GRIT	AUTOMATIC DRESSING PROCESS	ECONOMICAL DRESSING	HIGH REMOVAL RATE
Single-point	◧		All			
Multi-point	■		36-180		■	■
Blade tool dresser	■	◧	36-180	■	■	◧
Profile dresser		■	80-180			

SPEC CHECK

- A new dressing tool should be put through at least 5 dressing cycles in order to fit the diameter of the grinding wheel
- The lifetime of the dressing tool is extended by ensuring that adequate coolant pressure and volume are directed at the tool

jimi VELKOOBCHOD BRUSIVA

BEST

BLADE TOOL DRESSERS HPB-D 3565 & 3585

FEATURES	BENEFITS
■ Synthetic multi-crystaline diamond	■ Gives the most repeatable and consistent dresser for the highest demands in profiling and straight dressing

BETTER

BLADE TOOL DRESSERS HPB-D & -C 30, 45, 60

FEATURES	BENEFITS
■ Natural diamond	■ An economical dressing solution for all Alox and SiC wheels. Needles are recommended for profile dressing

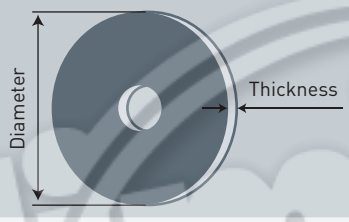
SELECTION OF BLADE TOOL DRESSERS

Dressing of profiles with blade tools	Dressing tools use a 'needle' form of natural or synthetic diamonds. Needle diamonds are especially suited to dressing profiles using infeeds and angular feeds.
Natural diamonds	An effective diamond layer with a length of up to 15mm creates an economical dressing solution. Using precise diamond setting patterns, with overlapped rows of stones, ensures that consistent dressing results are achieved.
Synthetic diamonds	The constant cross section given by synthetic diamonds, guarantees a constant dressing behaviour through the complete life of the dressing tool.

SELECTION OF GRIT SIZE

Grit size of grinding wheel	Synthetic diamond size	Natural diamond size
46	0,8x0,8	D1181
60	0,8x0,8	D1001
80-120	0,6x0,6	D711

SELECTION OF TOOL SIZE



Diameter x Thickness (mm)	No. of synthetic needles	Dimensions
<35000	2	10,5x28
35000-60000	3	20,5x28
60000-100000	4	20,5x28

VELKOOBCHOD BRUSIVA

DIAMOND DRESSERS

BLADE TOOL DRESSERS

W (mm)	L (mm)	DL (mm)	GRIT	PK QTY	BEST		BETTER	
10,5	28	12	D711	1			HPB-D 30	601576**82759**
	28	12	D1001	1			HPB-D 45	601576**82782**
	28	12	D1181	1			HPB-D 60	601576**82786**
	28	12	NEEDLE	1			HPB-D	601576**82790**
20,5	28	10	D711	1			HPB-C 30	601576**82801**
	28	10	D1001	1			HPB-C 45	601576**82806**
	28	10	D1181	1			HPB-C 60	601576**82809**
	28	10	NEEDLE	1			HPB-C	601576**82814**
10,5	28	4	0,6x0,6	1	HPB-D 3565 / 2	601576**82820**		
	28	4	0,6x0,6	1	HPB-D 3565 / 3	601576**82856**		
	28	4	0,6x0,6	1	HPB-D 3565 / 4	601576**82895**		
	28	4	0,8x0,8	1	HPB-D 3585 / 2	601576**82899**		
	28	4	0,8x0,8	1	HPB-D 3585 / 3	601576**82902**		
	28	4	0,8x0,8	1	HPB-D 3585 / 4	601576**82904**		

SCREWED SHANKS FOR BLADE TOOL DRESSERS

DIA (mm)	L (mm)	SHANK CODE	PK QTY	BEST	
12,065	40	MT1	1	HPB-H3	601576**82832**
9,045	25,5	MT0	1	HPB-H4	601576**82907**
11,11	50	Z11,11	1	HPB-H2	601576**82910**
10,00	50	Z10	1	HPB-HX	601576**82911**

Dimensions Key: DIA = Diameter, W = Width, L = Length, DL = Diamond Length

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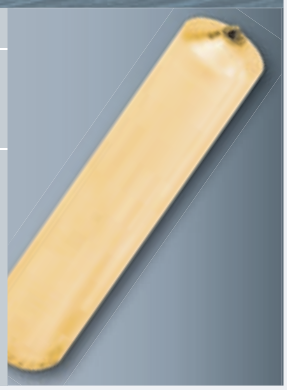
BEST

SINGLE-POINT DRESSER BC SG

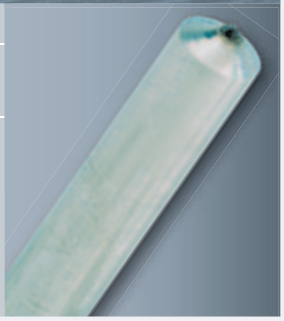
FEATURES	BENEFITS
■ Highest quality diamonds	■ Specifically developed for dressing ceramic abrasive (SG/TG) wheels which require faster traverse speed dressing
■ High performance tools	■ Enables dressing costs to be reduced, especially at production grinding stations



BETTER

SINGLE-POINT DRESSER BC (CYLINDRICAL SHANK)

FEATURES	BENEFITS
■ Standard diamonds	■ Ideal for applications where it is difficult to measure the performance of the dressing tool
■ Economy product	■ Suitable for dressing conventional abrasive wheels



GOOD

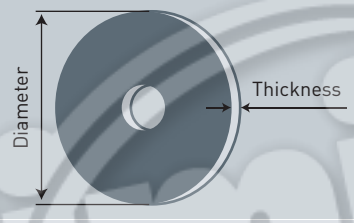
SINGLE-POINT DRESSER SP (MK- SHANK)

FEATURES	BENEFITS
■ Commercial standard diamonds	■ Standard dresser for conventional abrasive wheels

CHOICE OF SINGLE-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed.
In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
< 6000	0,33 Carat
6000 – 18000	0,50 Carat
> 18000	1,0 Carat

For best results, always use a coolant when dressing

VELKOOBCHOD BRUSIVA

DIAMOND DRESSERS

SINGLE-POINT DRESSERS

SHANK (mm)	CARAT	PK QTY	BEST	BETTER
			BC SG	BC
Z8	0,33	1		66260**61753**
	0,50	1	66260**61757**	66260**61752**
	1,00	1	66260**61755**	66260**61750**
Z10	0,33	1	66260**61769**	66260**61764**
	0,50	1	66260**61768**	66260**61763**
	1,00	1	66260**61766**	66260**61761**
Z11,11	0,33	1	66260**56906**	66260**95003**
	0,50	1	66260**56907**	66260**95005**
	1,00	1	66260**57010**	66260**95009**
Z12	0,33	1		66260**61775**
	0,50	1	66260**61779**	66260**61774**
	1,00	1	66260**61777**	

SINGLE-POINT DRESSERS

SHANK	CARAT	PK QTY	GOOD
			SP
MK0	0,3	1	69014**19596**
	0,5	1	69014**19598**
	1,0	1	69014**19599**
	1,5	1	69014**19600**
MK1	0,3	1	69014**19570**
	0,5	1	69014**19591**
	1,0	1	69014**19594**
	1,5	1	69014**19595**

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BEST

PROFILE DRESSER

FEATURES	BENEFITS
■ Extremely high performance tools	■ Used to meet extremely high profile accuracy requirements

PROFILE DRESSERS

SHANK (mm)	RADIUS (mm)	ANGLE	BEST	
Z9,52	0,13	40°	DC 40/130	601576**82850**
	0,25	40°	DC 40/250	601576**82889**
	0,50	40°	DC 40/500	601576**82901**
	0,13	60°	DC 60/130	601576**82903**
	0,25	60°	DC 60/250	601576**82905**
	0,50	60°	DC 60/500	601576**82909**

Jimi VELKOOBCHOD BRUSIVA

BEST

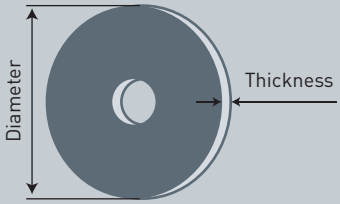
MULTI-POINT DRESSER

FEATURES	BENEFITS
■ Economical and robust tool	■ Ideal for straight dressing at high speed with low technical demands

CHOICE OF MULTI-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed.
In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
< 30000	1,3 Carat
30000 – 60000	2,5 Carat
> 60000	5,0 Carat

For best results, always use a coolant when dressing

CHOICE OF DIAMOND GRIT	
Wheel abrasive	Diamond
80-120	D301
60-80	D711
46-60	D1001
36-46	D2240

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MULTI-POINT DRESSERS

SHANK (mm)	GRIT	PK QTY	BEST		
			D11x11 (5 CARAT)	D8x11 (2,5 CARAT)	D6x8 (1,3 CARAT)
Z8	D2240	1	601576**82849**	601576**82915**	
	D1001	1	601576**82896**	601576**82920**	
	D711	1	601576**82906**	601576**82970**	601576**82986**
	D301	1			601576**83153**
Z10	D2240	1	601576**82892**	601576**82916**	
	D1001	1	601576**82897**	601576**82922**	
	D711	1	601576**82908**	601576**82968**	601576**82990**
	D301	1			601576**83154**
Z11,11	D2240	1	601576**82893**	601576**82917**	
	D1001	1	601576**82898**	601576**82923**	
	D711	1	601576**82912**	601576**82977**	601576**82992**
	D301	1			601576**83155**
MT1 12,065	D2240	1	601576**82894***	601576**82918**	
	D1001	1	601576**82900**	601576**82925**	
	D711	1	601576**82914**	601576**82981**	601576**82996**
	D301	1			601576**83156**

* Made-to-order

BEST

HAND DRESSER

FEATURES	BENEFITS
■ High diamond concentration	■ High wear resistance and long product life time
■ Grit 18/25 SPC	■ Suitable for face and side dressing

HAND DRESSER

PK QTY	BEST	
1	HD-150	601576**82852**

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

BEST

BRAKE CONTROLLED TRUING DEVICE

FEATURES	BENEFITS
■ For fast effective truing of Diamond and CBN wheels with minimum loss of abrasive	■ Ideal for truing the following diamond and CBN wheel types: straight wheels with diamond in the periphery, tool and cutter grinding wheels, wheels used on surface and cylindrical grinding machines, cut-off wheels and internal grinding wheels and cup wheels with diamonds in the rim, as used on vertical spindle surface grinders

BRAKE CONTROLLED TRUING DEVICE

PK QTY	BEST	
1	BCTD	662602**74459**

REPLACEMENT WHEELS

DIA (mm)	T (mm)	B (mm)	PK QTY	BEST	
80	25	13	10	Wheel 37C60-NV	699366**68764**

SPEC CHECK

- Mount the device spindle parallel to the wheel spindle to ensure correct straight face truing
- For cup shaped wheels, the device spindle will be mounted perpendicularly to the wheel spindle
- Use appropriate traverse rates

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore

Jimi VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

422 INTRODUCTION
424 ANGLE GRINDERS
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438 MASONRY SAWS
444 TILE SAWS
446 CORE BITS

Jimi
VELKOOBCHOD BRUSIVA

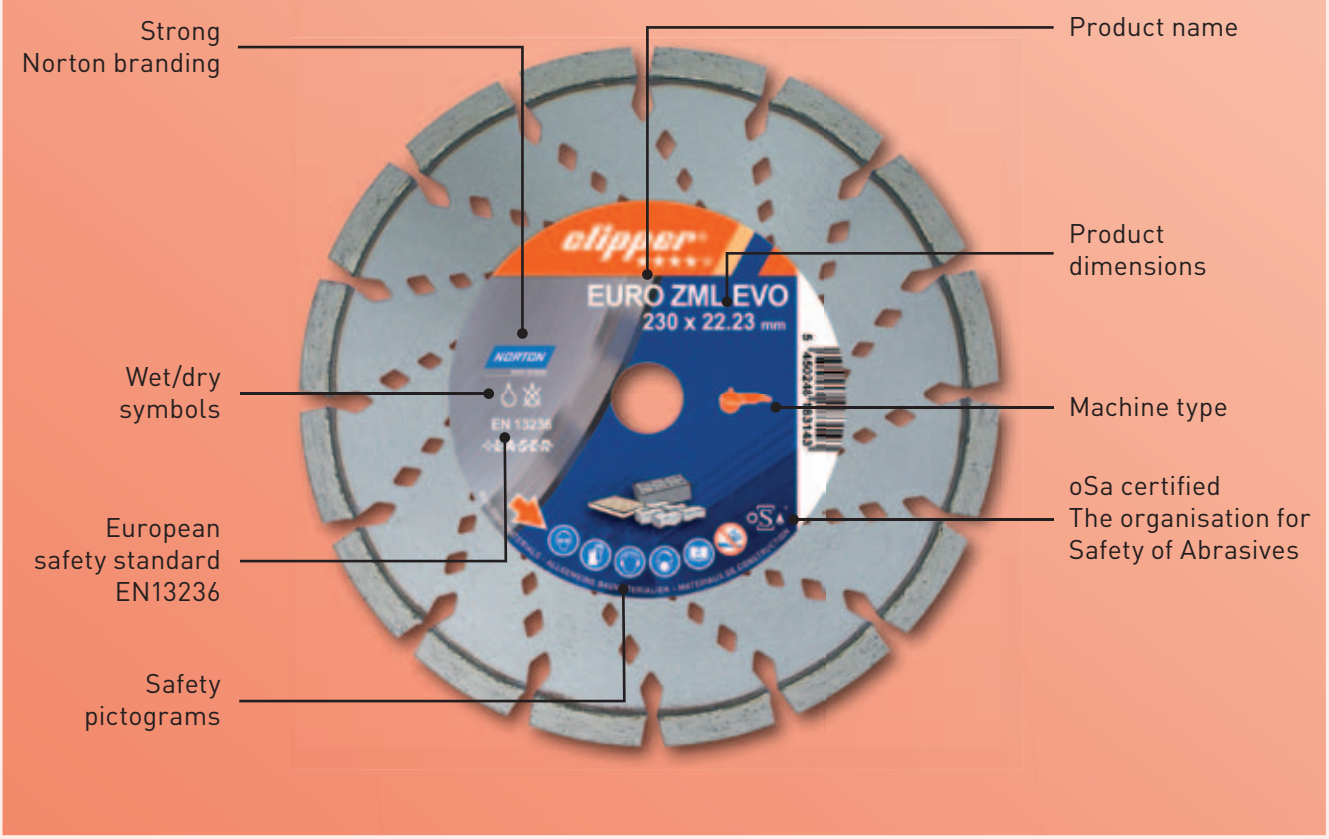
Diamond Blades

INTRODUCTION

Norton Diamond Blades are the ultimate abrasive cutting solution in construction and building industries. With a range of products suitable for use on concrete, tile, brick, and asphalt, Norton offers the best choice for every cutting and drilling application in the building/construction industry.

Norton, the industry's most comprehensive Diamond Blade product line.

UNDERSTANDING THE PRODUCT



VELKOOBCHOD BRUSIVA

DIFFERENTIATION IN THE RANGE

Norton offers the industry's widest selection of Diamond Blades to meet every customer requirement. The range is classified into 3 quality-tiers (Best/Better/Good) to help you choose the right product for your specific application.

INNOVATION BEST	The Norton 4x4 Explorer, a multi-purpose blade designed to cut all materials. The new Norton SILENCIO is the most silent blade on the market and displays the best cutting performance in our product range.	BETTER	High performance & high value professional products, ideal for regular use
BEST	This product line offers a range of high performance tools that meet the needs of the most demanding user	GOOD	This product line provides a range of standard blades offering good levels of performance

Choosing the right diamond tool for the job is not always straight forward. For this reason Norton diamond blades are colour coded to ensure you pick the most appropriate tool for the job.

MULTI-PURPOSE	
CONCRETE & REINFORCED CONCRETE	
GENERAL PURPOSE BUILDING MATERIALS	
ASPHALT & ABRASIVE MATERIALS	
CERAMIC & STONE TILES	

Jimi VELKOOBCHOD BRUSIVA

For further information please go to the Technical Information Section at the back of this catalogue.

ANGLE GRINDERS MULTI-PURPOSE

Norton Diamond Blades offer the user a cost-effective range of safe, easy to use products designed for use on all common types of building materials.

APPLICATIONS & MARKETS

- Construction
- Renovation
- Maintenance
- Tiling
- Plumbing
- Engineering

INNOVATION BEST

4X4 EXPLORER

For use on granite, engineering bricks, hard paviors, reinforced concrete, concrete kerbs & slabs, medium block paviors, facing brick, concrete roof tiles, sandstone, asphalt over concrete & asphalt

FEATURES	BENEFITS
Designed to cut the widest range of materials	Less need for blade changing so reduced down time & increased productivity
Features the innovative patent-pending "depth of cut indicator"	Helps optimise cutting speed & blade life in step-cutting
Special patent-pending ellipsoid gullets & specially treated steel centre	Increase fatigue resistance Directional arrows show the way of rotation for easy mounting
Not recommended for steel parts thicker than 5mm	

MULTI-PURPOSE

4x4 EXPLORER

DIA (mm)	HxTxB (mm)	PK QTY	INNOVATION	BEST
115	10,0x2,2x22,23	1		70184625307
125	10,0x2,2x22,23	1		70184625308
180	10,0x2,5x22,23	1		70184643654
230	10,0x2,5x22,23	1		70184624846

VELKOOBCHOD BRUSIVA

INNOVATION

SILENCIO

For use on engineering bricks, cured concrete, reinforced concrete, hard paviors, concrete paving slabs, concrete kerbs, concrete pipes, limestone, medium block paviors, & facing bricks

FEATURES	BENEFITS
Sandwich steel-centre with newly developed absorbing material	The Norton Silencio features unprecedented noise-dampening effect, reaching reductions of up to 15dB – 30 times less noise !!
Patent-pending offset gullets prevent air from flowing through the steel-centre gullets	The blade does not whistle at all while running idle, for a much better comfort of the operator and the surrounding area
Up to 17mm high segments, with a bespoke specification for each different application	The Norton Silencio is among the best cutting Clipper diamond blades. Select the blade specifically designed for your machine type to get the best cutting performance

BEST

DUO EXTREME

For use on engineering bricks, cured concrete, reinforced concrete, hard paviors, concrete paving slabs, concrete kerbs, concrete pipes, limestone, medium block paviors, & facing bricks

FEATURES	BENEFITS
Laser-welded, segmented diamond blade	
15mm segment height on 230mm diameter blades	Extreme long life
Double segments	Exceptional cutting speed
Very soft cut	Low vibrations
Special gullets indicate the way of rotation	Easy to mount

CONCRETE & REINFORCED CONCRETE

DIA (mm)	HxTxB (mm)	PK QTY	SILENCIO	DUO EXTREME
			INNOVATION / BEST	BEST
230	15,0x2,8x22,23	1		70184624576
	17,0x2,8x22,23	1	70184630308	

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

JMI VELKOOBCHOD BRUSIVA

BEST

AERO JET

Suitable for use on very hard masonry materials, block paviors, granite & marble

FEATURES	BENEFITS
Sintered, continuous rim diamond blade with corrugated steel centre	
Special blade geometry	Gives more rigidity
Protection segments	Protect the steel centre & provide outstanding rigidity
Ventilated steel centre	Provides efficient cooling during cutting
Heavy duty diamond blade	Has extreme long life & an excellent cutting speed

CG2

Suitable for surface grinding on all types of masonry materials

FEATURES	BENEFITS
Double rim, brazed, segmented cup grinder	Recommended for removal of shuttering marks

BETTER

EURO-JET

Suitable for use with engineering bricks, clay pipes/paviors, marble, clay roof tiles, concrete pipes/kerbs, slate, hard paviors, facing bricks, concrete roof tiles, medium block paviors, breeze blocks & concrete paving slabs

FEATURES	BENEFITS
Sintered, corrugated continuous rim diamond blade	
10mm segment height	Longer life
High-quality diamond blade	Long life, excellent cutting speed & all round excellent performance

TP

Suitable for removing mortar prior to the rejointing of brick walls

FEATURES	BENEFITS
Brazed, segmented diamond blade especially designed for the removal of mortar prior to rejointing	Premium performance
Tungsten carbide tips	Gives undercutting protection

VELKOOBCHOD BRUSIVA

BETTER

EURO-ZML

For use on cured concrete, reinforced concrete, hard paviors, facing bricks, concrete paving slabs, concrete kerbs, concrete pipes, limestone, medium block paviors, concrete roof tiles & breeze blocks

FEATURES	BENEFITS
Laser-welded, segmented diamond blade	
10mm segment height	Longer life
Diamond-shape apertures on 230mm diamond blades	Prevent over-heating of the diamond blade

GOOD

CLASSIC JET

For use on engineering bricks, clay pipes/paviors, clay roof tiles, concrete pipes/kerbs, facing bricks, concrete roof tiles, medium block paviors, breeze blocks & concrete paving slabs

FEATURES	BENEFITS
Sintered, continuous rim diamond blade with corrugated segments	
Economy diamond blade	Value for money

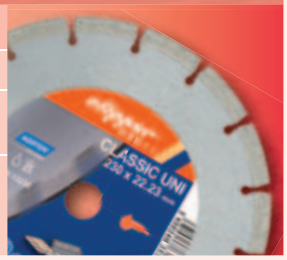
CLASSIC LASER

Cured concrete, concrete pipes, concrete kerbs, hard paviors, reinforced concrete, roof tiles, medium block paviors, concrete paving slabs

FEATURES	BENEFITS
Laser-welded, segmented diamond blade	
Economy diamond blade	Value for money

CLASSIC UNI

For use on concrete pipes, concrete kerbs, roof tiles, medium block paviors & concrete paving slabs



FEATURES	BENEFITS
Sintered, segmented diamond blade	
Economy diamond blade	Value for money Recommended for soft to medium hard materials Not recommended for very hard materials

JIMI VELKOOBCHOD BRUSIVA

GOOD

CG SLANT

Suitable for surface grinding of all types of masonry materials

FEATURES	BENEFITS
Single rim, brazed, segmented cup grinder	
Slant segments	Value for money
Hollow steel centre	Makes the product very light weight

GENERAL PURPOSE BUILDING MATERIALS

			AERO JET	CG2	EURO-JET	TP	EURO-ZML	CLASSIC JET	CLASSIC LASER	CLASSIC UNI	CG SLANT
DIA (mm)	HxTxB (mm)	PK QTY	BEST		BETTER			GOOD			
100	22,23/16	1		70184**10268**							
105	22,23	1									70184**24781**
115	12,0x2,2x22,23	1	70184**23598**								
	10,0x1,8x22,23	1								70184**26806**	
	10,0x2,1x22,23	1						70184**26814**			
	10,0x2,2x22,23	1			70184**10314**		70184**24738**				
	7,0x2,2x22,23	1							70184**26834**		
	6,5x4,5x22,23	1				70184**10712**					
	6,5x6,5x22,23	1				70184**10305**					
125	12,0x2,2x22,23	1	70184**23599**								
	10,0x1,8x22,23	1								70184**26807**	
	10,0x2,1x22,23	1			70184**10315**			70184**26815**			
	10,0x2,2x22,23	1					70184**24739**				
	7,0x2,2x22,23	1							70184**26835**		
	6,5x4,5x22,23	1				70184**10713**					
	6,5x6,5x22,23	1				70184**10307**					
	6,5x8,0x22,23	1				70184**10716**					
	22,23(flat)	1		70184**11096**							
	22,23	1		70184**10363**							70184**23049**
150	22,23/19	1									70184**24760**
180	10,0x2,2x22,23	1								70184**26809**	
	10,0x2,5x22,23	1					70184**25563**				
	7,0x2,2x22,23	1			70184**10317**			70184**26816**			
	7,0x2,5x22,23	1							70184**26837**		
	22,23	1		70184**10270**							70184**24782**
230	12,0x2,8x22,23	1	70184**23180**								
	10,0x2,2x22,23	1								70184**26810**	
	10,0x2,5x22,23	1					70184**11396**	70184**26818**	70184**26838**		
	10,0x2,6x22,23	1			70184**10267**						

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

BEST

SUPER GRES XT EVO

NEW!

For use on granite slabs, ceramic tiles, quarry tiles, porcelain & terazzo

FEATURES	BENEFITS
For professional cutting of tiles	
Extra-thin diamond blade	Best quality of cut & cutting speed even on the hardest tiles
Additional metal flanges on each side of the blade	Prevents the steel-centre wobbling during the cut
10mm high continuous rim	For longer product life

BETTER

MD110CD

For use on all ceramic tiles, marble & slate

FEATURES	BENEFITS
Sintered, continuous rim diamond blade	
High-quality diamond blade with excellent performance	Long product life combined with an excellent cutting speed

GOOD

CLASSIC CERAM

Suitable for use on ceramic tiles

FEATURES	BENEFITS
Sintered, continuous rim diamond blade	
Economy diamond blade	Value for money

Jimi VELKOOBCHOD BRUSIVA

CERAMIC & STONE TILES

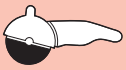
DIA (mm)	HxTxB (mm)	PK QTY	SUPER GRES XT EVO NEW! BEST	MD110CD BETTER	CLASSIC CERAM GOOD
115	10,0x1,4x22,23	1	70184**44759**		
	9,0x1,6x22,23	1		70184**25942**	
	7,0x1,5x22,23	1			70184**26825**
125	10,0x1,4x22,23	1	70184**44760**		
	9,0x1,6x22,23	1		70184**25940**	
	7,0x1,6x22,23	1			70184**26826**
230	10,0x1,8x22,23	1	70184**27653**		
	9,0x7,0x22,23	1		70184**25946**	

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

PRODUCT SELECTION

USAGE KEY

- Highly recommended
- Recommended



	INNOVATION													CUP GRINDERS		
	BEST	BEST	BEST	BEST	BETTER	BETTER	BETTER	GOOD	GOOD	GOOD	BEST	BETTER	GOOD		BEST	GOOD
	4X4 EXPLORER	SILENCIO	DUO EXTREME	AERO JET	EURO JET	TP	EURO ZML	CLASSIC JET	CLASSIC LASER	CLASSIC UNI	SUPER GRES XT	MD110 CD	CLASSIC CERAM		CG2	CG SLANT
	MULTI-PURPOSE	CONCRETE & REINFORCED CONCRETE		GENERAL PURPOSE BUILDING MATERIALS							CERAMIC & STONE TILES				GENERAL PURPOSE BUILDING MATERIALS	
Steel	■															
Granite	◧	■	■	■							■	◧			◧	◧
Engineering bricks	◧	■	■	■	■		◧									
Cured concrete	■	■	■	■	◧		■	◧	■	◧					■	◧
Clay/pipes/paviors	◧	■	◧	■	■							◧				
Quarry tiles			◧	◧							■	■	◧			
Marble		◧	◧	■	■						◧	◧	◧			
Hard paviors	■	■	■	■	■		■	◧	■	◧						
Clay roof tiles	◧	◧	◧	■	■		◧	◧	◧	◧					◧	◧
Terrazo			◧	◧							■	■				
Facing bricks	◧	■	■	■	■		■	◧	◧	◧	◧	◧				
Reinforced concrete	◧	■	■	◧	◧		■	◧	■	◧					◧	◧
Concrete paving slabs	■	■	■	■	◧		■	◧	■	◧					■	◧
Concrete pipes/kerbs	■	■	■	■	■		■	◧	■	◧	■				◧	◧
Slate			■	■	■						■	■	◧			
Limestone concrete	■	■	■	◧	◧		■	◧	◧	◧						
Medium block paviors	■	■	■	■	◧		■	◧	■	◧						
Concrete roof tiles	■	◧	■	■	■		■	◧	■	◧					◧	◧
Sandstone	◧	■	◧													
Asphalt over concrete	■															
Breeze blocks	■		■				■									
Tarmac top blocks	◧															
Mortar jointing						■										
Asphalt	◧															
Green concrete															◧	◧

VELKOOBCHOD BRUSIVA

PETROL HAND HELD & FLOOR SAWS MULTI-PURPOSE

Norton offers a large range of high performance diamond tools for all applications and user needs.

APPLICATIONS & MARKETS

- Construction
- Civil Engineering
- Road Contractors

APPLICATIONS KEY

- MULTI-PURPOSE
- CONCRETE & REINFORCED CONCRETE
- ASPHALT & ABRASIVE MATERIALS
- GENERAL PURPOSE BUILDING MATERIALS
- CERAMIC & STONE TILES

INNOVATION

BEST

4X4 EXPLORER

For use on granite, engineering bricks, hard paviors, reinforced concrete, concrete kerbs & slabs, medium block paviors, facing brick, concrete roof tiles, sandstone, asphalt over concrete & asphalt

FEATURES	BENEFITS
Designed to cut the widest range of materials	Less need for blade changing so reduced down time & increased productivity
Features the innovative patent-pending "depth of cut indicator"	Helps optimise cutting speed & blade life in step-cutting
Special patent-pending ellipsoid gullets & specially treated steel centre	Increase fatigue resistance Directional arrows show the way of rotation for easy mounting
Not recommended for steel parts thicker than 5mm	

VELKOOBCHOD BRUSIVA

MULTI-PURPOSE

4x4 EXPLORER

DIA (mm)	HxTxB (mm)	PK QTY	INNOVATION	BEST
300	10,0x2,8x20	1		70184622936
	10,0x2,8x25,4	1		70184622937
350	10,0x3,0x20	1		70184622938
	10,0x3,0x25,4	1		70184622939
400	10,0x3,2x20	1		70184623897
	10,0x3,2x25,4	1		70184623899
450	10,0x3,4x25,4	1		70184625430

INNOVATION BEST

SILENCIO

For use on cured concrete, reinforced concrete, concrete paving slabs, concrete pipes/kerbs, medium block paviors & concrete roof tiles

FEATURES	BENEFITS
■ Patent-pending offset gullets** prevent air from flowing through the steel-centre gullets	■ The blade does not whistle at all while running idle, for a much better comfort of the operator and the surrounding area
■ Sandwich steel-centre with newly developed absorbing material	■ The Norton Silencio features unprecedented noise-dampening effect, reaching reductions of up to 15dB – 30 times less noise !!
■ Up to 17mm high segments, with a bespoke specification for each different application	■ The Norton Silencio is among the best cutting Clipper diamond blades. Select the blade specifically designed for your machine type to get the best cutting performance

CONCRETE & REINFORCED CONCRETE

SILENCIO

DIA (mm)	HxTxB (mm)	PK QTY	INNOVATION / BEST
300	15,0x3,1x20,0	1	70184629000
	15,0x3,1x25,4	1	70184642421*
350	15,0x3,1x25,4	1	70184628999*
	15,0x3,1x25,4	1	70184628997**
450	15,0x3,2x25,4	1	70184631020
500	15,0x3,2x25,4	1	70184630416

* Only for use with petrol saws; ** Only for use with floor saws

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

Silencio
The new generation of silent diamond blades !
30x LESS NOISE
Silencio
BETON - CONCRETE
NORTON
Silencio
NORTON
SAINT-GOBAIN
Silencio
BETON
350 x 25.4
350mm
PATENT PENDING

BETTER

SUPER ASPHALT EVO

For use on all abrasive materials including asphalt, tarmac top blocks, breeze blocks, sandstone, mortar jointing & green concrete

FEATURES	BENEFITS
■ Laser-welded diamond blade with 7mm segment height	
■ Features the innovative patent-pending "depth of cut indicator"	■ The perfect device to optimise cutting speed & blade life in step-cutting. It also shows the way of rotation for an easier mounting of the diamond blade
■ High-quality diamond blade for professional requirements	■ Slant segments protect against undercutting giving excellent performance

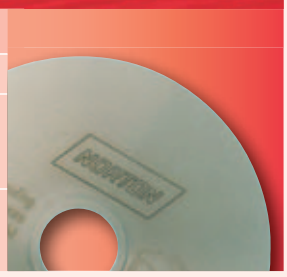
ASPHALT & ABRASIVE MATERIALS

DIA (mm)	HxTxB (mm)	PK QTY	SUPER ASPHALT EVO
			BETTER
300	10,0x2,8x25,4	1	70184623184
350	10,0x3,2x25,4	1	70184623186

QUICKFIX REDUCTION RINGS

For use only with petrol saws

FEATURES	BENEFITS
■ A patented device designed to safely convert blade bores to suit different machines	
■ Converts 300mm & 350mm x 25,4mm or 22,23mm bore to 20mm	■ Can reduce inventory



QUICKFIX REDUCTION RINGS

DIA (mm)	BORE (mm)	PK QTY	QUICKFIX
103	25,4/22,23	1	70184622589
	25,4/22,23/20	1	70184623894

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

Jimi VELKOOBCHOD ABRUSIVA

PRODUCT SELECTION

USAGE KEY

■ Highly recommended

▨ Recommended

	INNOVATION BEST		BETTER
	4X4 EXPLORER	SILENCIO	SUPER ASPHALT EVO
	MULTI-PURPOSE	CONCRETE & REINFORCED CONCRETE	ASPHALT & ABRASIVE MATERIALS
Steel	▨		
Granite	▨	▨	
Engineering bricks	▨	▨	
Cured concrete	▨	▨	
Clay/pipes/paviors	▨	▨	
Marble		▨	
Hard paviors	▨	▨	
Clay roof tiles	▨	▨	
Facing bricks	▨	▨	
Rienforced concrete	▨	▨	
Concrete paving slabs	▨	▨	
Concrete pipes/kerbs	▨	▨	
Limestone concrete	▨	▨	
Medium block paviors	▨	▨	
Concrete roof tiles	▨	▨	
Sandstone	▨	▨	■
Asphalt over concrete	▨		■
Breeze blocks	▨		■
Tarmac top blocks	▨		■
Asphalt	▨		■
Green concrete			▨

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

NOTES

VELKOOBCHOD BRUSIVA

MASONRY SAWS MULTI-PURPOSE

Norton offers the best range of diamond tools for masonry saws ensuring great performance and clean results in wet cutting conditions.

APPLICATIONS & MARKETS

- Construction

APPLICATIONS KEY

- MULTI-PURPOSE
- CONCRETE & REINFORCED CONCRETE
- GENERAL PURPOSE BUILDING MATERIALS
- CERAMIC & STONE TILES

BEST INNOVATION

4X4 EXPLORER

For use on granite, engineering bricks, hard paviors, reinforced concrete, concrete kerbs & slabs, medium block paviors, facing brick, concrete roof tiles, sandstone, asphalt over concrete & asphalt

FEATURES	BENEFITS
Designed to cut the widest range of materials	Less need for blade changing so reduced down time & increased productivity
Features the innovative patent-pending "depth of cut indicator"	Helps optimise cutting speed & blade life in step-cutting
Special patent-pending ellipsoid gullets & specially treated steel centre	Increase fatigue resistance Directional arrows show the way of rotation for easy mounting
Not recommended for steel parts thicker than 5mm	

VELKOOBCHOD BRUSIVA

MULTI-PURPOSE

4x4 EXPLORER

DIA (mm)	HxTxB (mm)	PK QTY	INNOVATION	BEST
300	10,0x2,8x25,4	1		70184622937
350	10,0x3,0x25,4	1		70184622939
400	10,0x3,2x25,4	1		70184623899
450	10,0x3,4x25,4	1		70184625430

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

INNOVATION

BEST

SILENCIO

For use on engineering bricks, cured concrete, reinforced concrete, hard paviors, concrete paving slabs, concrete kerbs, concrete pipes, limestone, medium block paviors, facing bricks

FEATURES	BENEFITS
Patent-pending offset gullets* prevent air from flowing through the steel-centre gullets	The blade does not whistle at all while running idle, for a much better comfort of the operator and the surrounding area
Sandwich steel-centre with newly developed absorbing material	The Norton Silencio features unprecedented noise-dampening effect, reaching reductions of up to 15dB – 30 times less noise !!
Up to 17mm high segments, with a bespoke specification for each different application	The Norton Silencio is among the best cutting Clipper diamond blades. Select the blade specifically designed for your machine type to get the best cutting performance

BEST

FMD DUO

For use on general purpose masonry materials, granite, concrete slabs, reinforced concrete, hard paviors, hard facing bricks, concrete roof tiles

FEATURES	BENEFITS
Laser-welded diamond blade	
12mm segment height	Long product life
High quality diamond blade	Extremely high cutting speed
Trapezoidal segments	Provide the quality of cut of a continuous rim with the safety of a laser-welded blade

BETTER

BS-U

For use on general purpose masonry materials, breeze blocks, concrete paving slabs & concrete pipes/kerbs

FEATURES	BENEFITS
Brazed, segmented diamond blade	Ideal for abrasive to medium hard material

VELKOOBCHOD BRUSIVA

GOOD

ALFA

For use on general purpose masonry materials

FEATURES	BENEFITS
Laser-welded diamond blade	Ideal for abrasive to medium hard material
Good performance	Good product life & high cutting speed

GENERAL PURPOSE BUILDING MATERIALS

			SILENCIO	FMD DUO	BS-U	ALFA
DIA (mm)	HxTxB (mm)	PK QTY	INNOVATION BEST	BEST	BETTER	GOOD
300	15,0x2,8x30/25,4	1		70184612282		
	15,0x3,1x25,4	1	70184640269			
350	15,0x2,8x30/25,4	1		70184612283		
	15,0x3,1x25,4	1	70184628998			
	10,0x2,8x25,4	1				70184611209
400	15,0x3,1x25,4	1	70184640270			
	15,0x3,2x25,4	1		70184611438		
500	15,0x3,2x25,4	1	70184630309			
650	7,0x4,4x25,4	1			70184620425	
900	7,0x4,4x60	1			70184620428	

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

Jimi VELKOOBCHOD BRUSIVA

BEST

SUPER GRES XT

For use on the hardest building materials, granite slabs, ceramic tiles, quarry tiles, porcelain, terrazzo

FEATURES	BENEFITS
■ Extra-thin diamond blade	■ For professional cutting of tiles ■ The best quality of cut & cutting speed even on the hardest tiles
■ Additional metal flanges	■ Prevent wobbling of the steel-centre during the cut
■ 10mm continuous rim	■ Longer product life

BETTER

MD120C

For use on ceramic tiles, stone tiles, marble granite, terrazzo & limestone

FEATURES	BENEFITS
■ Sintered, continuous rim diamond blade	■ Excellent cutting speed, producing a very clean cut
■ 9mm segment height	■ Long life
■ Heavy duty diamond blade	■ Ideal for glazed materials

CERAMIC & STONE TILES

			SUPER GRES XT	MD120C
DIA (mm)	HxTxB (mm)	PK QTY	BEST	BETTER
300	10,0x1,8x25,4	1	7018462**5429**	
	9,5x2,0x25,4	1		7018462**5098**
350	9,5x2,0x25,4	1		7018462**5100**

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

PRODUCT SELECTION

USAGE KEY

■ Highly recommended

◧ Recommended

	INNOVATION	BEST	BEST	BEST	BETTER	GOOD	BEST	BETTER
		4X4 EXPLORER	SILENCIO	FMD DUO	BS-U	ALFA	SUPER GRES XT	MD120C
		MULTI-PURPOSE	GENERAL PURPOSE BUILDING MATERIALS				CERAMIC & STONE TILES	
Steel		■						
Granite		◧	■	◧			■	◧
Engineering bricks		◧	■	◧	◧			
Cured concrete		■	■	■		◧		
Clay/pipes/paviors		◧	■	◧				◧
Quarry tiles				◧			■	◧
Marble			◧	◧			◧	■
Hard paviors		■	■	◧		◧		
Clay roof tiles		◧	◧	◧		◧		
Terrazo				◧	◧		■	■
Facing bricks		◧	■	■		■	◧	
Reinforced concrete		◧	■	■	■			
Concrete paving slabs		■	■	◧	■	◧		
Concrete pipes/kerbs		■	■	■		■	■	
Slate				■	◧		■	■
Limestone concrete		■	■	■	◧	■		
Medium block paviors		■	■	■		■		
Concrete roof tiles		■	◧	■		◧		
Sandstone		◧	■	◧		◧		
Asphalt over concrete		■						
Breeze blocks		■						
Tarmac top blocks		◧						
Asphalt		◧						

Jimi VELKOOBCHOD BRUSIVA

TILE SAWS CERAMIC & STONE TILES

Norton tile saw blades come in a range of sizes designed to all common tile saw machines.

APPLICATIONS & MARKETS

- Construction
- Tiling
- Bathroom fitting
- Kitchen fitting

BEST

SUPER GRES XT

For use on the hardest building materials, granite slabs, ceramic tiles, quarry tiles, porcelain, terrazzo

FEATURES	BENEFITS
Extra-thin diamond blade	For professional cutting of tiles The best quality of cut & cutting speed even on the hardest tiles
Additional metal flanges	Prevent wobbling of the steel-centre during the cut
10mm continuous rim	Longer product life

BETTER

MD120C

For use on ceramic tiles, stone tiles, marble granite, terrazzo & limestone

FEATURES	BENEFITS
Sintered, continuous rim diamond blade	Excellent cutting speed, producing a very clean cut
9mm segment height	Long life
Heavy duty diamond blade	Ideal for glazed materials

VELKOOBCHOD BRUSIVA

GOOD

CLASSIC CERAM

For use on ceramic tiles

FEATURES	BENEFITS
Sintered, continuous rim diamond blade	
Economy range	Value for money

CERAMIC & STONE TILES

			SUPER GRES XT	MD120C	CLASSIC CERAM
DIA (mm)	HxTxB (mm)	PK QTY	BEST	BETTER	GOOD
180	9,0x1,6x25,4	1		70184625561	
	7,0x1,7x25,4	1			70184626828
200	10,0x1,6x25,4	1	70184625427		
	9,0x1,6x25,4	1		70184625093	
230	9,0x1,6x25,4	1		70184625096	
	7,0x1,8x25,4	1			70184626830
250	10,0x1,6x25,4	1	70184625428		
	9,0x1,6x25,4	1		70184625097	
300	9,0x2,0x25,4	1		70184625098	
350	9,0x2,4x25,4	1		70184625100	

PRODUCT SELECTION

USAGE KEY

■ Highly recommended

◧ Recommended

	BEST	BETTER	GOOD
	SUPER GRES XT	MD120C	CLASSIC CERAM
	CERAMIC & STONE TILES		
Granite	◧	◧	
Clay/pipes/paviors	■	◧	
Quarry tiles	■	◧	◧
Marble	◧	■	◧
Terrazo	■	■	
Slate	■	■	◧

Dimensions Key: DIA = Diameter, H = Height, T = Thickness, B = Bore

JMI VELKOOBCHOD BRUSIVA

CORE BITS CONCRETE & REINFORCED CONCRETE

Norton core bits are extremely high performance products, and give an extremely good cutting speed and a long product life. The products meet the professional requirements of all users in industrial markets, including builders, electricians and plumbers. They are recommended for use on motors up to 1400W.

APPLICATIONS & MARKETS

- For installation of electrical wall sockets & switches
- For use on cured concrete, reinforced concrete & bricks

APPLICATIONS KEY

- MULTI-PURPOSE
- CONCRETE & REINFORCED CONCRETE
- ASPHALT & ABRASIVE MATERIALS
- GENERAL PURPOSE BUILDING MATERIALS
- CERAMIC & STONE TILES

BETTER

PRO CB BETON CROWNED

Crowned corebit for use on cured concrete, reinforced concrete & bricks

FEATURES	BENEFITS
Back end R1/2'' male	
Length 300mm	
Excellent performance for professional requirements	Excellent cutting speed and long product life
Recommended for engines up to 1400W	

JIMI VELKOOBCHOD BRUSIVA

BETTER

PRO CB BETON SEGMENTED

Laser-welded segmented corebit for use on cured concrete, reinforced concrete & bricks

FEATURES	BENEFITS
Laser-welded heavy-duty corebit	Excellent cutting speed
Tapered segment shape	Easier drilling start
Back end 1 1/4" UNC	
Length 450mm	

GOOD

CLASSIC CB BETON

Brased segmented corebit for use on reinforced concrete, cured concrete & normal aggregates

FEATURES	BENEFITS
Good quality product	Good cutting speed
Back end 1 1/4" UNC	
Length 450mm	

Jimi VELKOOBCHOD BRUSIVA

CORE BITS

CORE BITS – WET

DIA (mm)	Useful Length (mm)	Segment Height (mm)	PK QTY	PROFESSIONAL CB BETON CROWNED	PROFESSIONAL CB BETON SEGMENTED	CLASSIC CB BETON
				BETTER		GOOD
14	300	10	1	70184612947		
18	300	10	1	70184612824		
22	300	10	1	70184612826		
25	300	10	1	70184612827		
28	300	10	1	70184612828		
30	300	10	1	70184612829		
32	300	10	1	70184612830		
35	300	10	1	70184612831		
40	300	10	1	70184612834		
51	300	10	1	70184612835		
	450	7	1			70184613201
52	450	10	1		70184624870	
56	450	7	1			70184613202
61	450	7	1			70184613203
62	450	10	1		70184624872	
66	450	7	1			70184613204
71	450	7	1			70184613205
72	450	10	1		70184624874	
76	450	7	1			70184613206
81	450	7	1			70184613207
82	450	10	1		70184624876	
86	450	7	1			70184613208
91	450	7	1			70184613209
101	450	7	1			70184613210
102	450	10	1		70184624880	
106	450	7	1			70184613211
107	450	10	1		70184624881	
111	450	7	1			70184613212
112	450	10	1		70184624882	
121	450	7	1			70184613213
122	450	10	1		70184624883	
126	450	7	1			70184613214
127	450	10	1		70184624884	
131	450	7	1			70184613215
132	450	10	1		70184624885	
141	450	7	1			70184613216

Dimensions Key: DIA = Diameter

VELKOOBCHOD BRUSIVA

CORE BITS – WET (CONTINUED)

DIA (mm)	Useful Length (mm)	Segment Height (mm)	PK QTY	PROFESSIONAL CB BETON CROWNED	PROFESSIONAL CB BETON SEGMENTED	CLASSIC CB BETON
				BETTER		GOOD
151	450	7	1			701846**13217**
152	450	10	1		701846**24887**	
161	450	7	1			701846**13218**
162	450	10	1		701846**24888**	
171	450	7	1			701846**13219**
181	450	7	1			701846**13220**
182	450	10	1		701846**24890**	
191	450	7	1			701846**13221**
201	450	7	1			701846**13222**
202	450	10	1		701846**24892**	
211	450	7	1			701846**13223**
225	450	7	1			701846**13252**
251	450	7	1			701846**13224**
252	450	10	1		701846**24895**	
271	450	7	1			701846**13253***
300	450	7	1			701846**13225**
	450	10	1		701846**24897**	

* Made-to-order

VELKOOBCHOD BRUSIVA

CORE BITS

BEST

ARID9

Most efficient specification for demanding professionals.

FEATURES	BENEFITS
Brased segmented corebit	Extreme long life
Heavy duty diamond tool	Excellent cutting speed
Connection R1/2'' female	Useful length 150mm

BETTER

ARID7

Newly developed specification for improved productivity on the jobsite.

FEATURES	BENEFITS
Brased segmented corebit	Long life, ideal for craftsmen
Heavy duty diamond tool	Excellent cutting speed
Connection R1/2" female	Useful length 150mm

DD5

Laser-welded dry-drilling corebits with M16 connection.

FEATURES	BENEFITS
Laser-welded core bit	High speed & long product life
Useful length 150mm, connection M16	

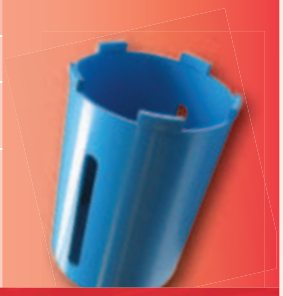
VELKOOBCHOD BRUSIVA

GOOD

ARID5

Affordable corebits for professional craftsmen.

FEATURES	BENEFITS
Heavy welded segmented core bit	Extreme long life
Connection R1/2" female	



CLASSIC ARID DS

Suitable for drilling domestic & industrial installation of electrical wall sockets & switches

FEATURES	BENEFITS
Laser-welded segments	Extreme long life
For dry & wet drilling	
Heavy diamond tool	Excellent cutting speed
Useful length	
Connection M16	

jimi VELKOOBCHOD BRUSIVA

CORE BITS

CORE BITS – DRY

				ARID9	ARID7	DD5	ARID5	CLASSIC ARID DS
DIA (mm)	Useful Length (mm)	Segment Height (mm)	PK QTY	BEST	BETTER		GOOD	
28	300	7	1				70184620351	
32	150	7	1	70184620764		70184623576		
38	150	7	1	70184616550	70184640160		70184620352	
48	150	7	1	70184615513		70184623579		
52	150	7	1	70184620168	70184640161	70184623580	70184620353	
65	150	7	1	70184615514	70184640162	70184622640	70184640268	
68	60	7	1					70184620422
78	150	7	1	70184616555	70184640163	70184622641	70184620354	
82	60	7	1					70184620423
91	150	7	1	70184615515		70184623581		
102	150	7	1			70184623582		
107	150	7	1	70184616559	70184640164	70184622642	70184620355	
117	150	7	1	70184620169	70184640165	70184623583	70184620356	
127	150	7	1	70184616565	70184640166	70184622643	70184620357	
152	150	7	1	70184615516	70184640167	70184623584	70184620358	
162	150	7	1	70184628591		70184622644		

PRODUCT SELECTION

USAGE KEY

- Highly recommended
- Recommended

CORE BITS	BEST	BETTER	BETTER	GOOD	GOOD
	ARID 9	ARID 7	DD5	ARID5	CLASSIC ARID DS
	GENERAL PURPOSE BUILDING MATERIALS				
Cured concrete	■	■	■	◧	◧
Hard paviors	■	◧	■	◧	◧
Reinforced concrete			■		
Concrete paving slabs	■	■	◧	■	
Medium block paviors	■	■	◧	■	◧
Asphalt	◧	◧	◧	◧	

CORE BITS	BETTER	BETTER	GOOD
	PRO CB BETON CROWNED	PRO CB BETON SEGMENTED	CLASSIC BETON
	CONCRETE & REINFORCED CONCRETE		
Cured concrete	■	■	■
Hard paviors	◧	■	◧
Reinforced concrete	■	■	◧
Concrete paving slabs		■	
Medium block paviors	◧	■	◧
Asphalt		◧	

VELKOOBCHOD BRUSIVA

NORTON
SAINT-GOBAIN

454 INTRODUCTION

459 BRUSHES FOR BENCH GRINDERS

461 BRUSHES FOR ANGLE GRINDERS

465 BRUSHES FOR HAND DRILLS

468 HAND BRUSHES

474 TUNGSTEN CARBIDE BURRS

482 STEEL WOOL

484 CLEANING & POLISHING PRODUCTS

488 TAPES

Wire Brushes, Burrs, Cleaning & Polishing Products, Tapes

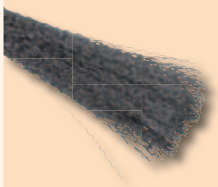
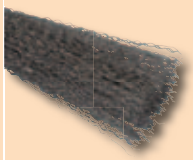
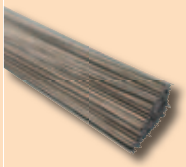
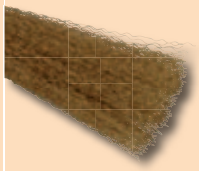
VELKOOBCHOD BRUSIVA

INTRODUCTION

Norton offers a broad range of wire brushes suitable for a wide range of surface processing applications. The range encompasses crimped & knotted wire power wheel brushes, bevelled brushes, cup brushes, end brushes & hand bruches.

Our high quality products contain a number different types of wire which have been specifically selected to give the best results in any specific application.

WIRE TYPES

TEMPERED QUALITY STEEL WIRE			STAINLESS STEEL WIRE			BRASS WIRE
CRIMPED	STRAIGHT		CRIMPED	STRAIGHT		CRIMPED
						
Removing dust and smoothing low-grade and non alloys steels			Brushing and smooting chome-nickel steels, including stainless steel			For brushing, cleaning and smoothing brass, copper and bronz
NOSCW NOrmal Steel Crimped Wire	**NOSKW** NOrmal Steel Knotted Wire	**NOSSW** NOrmal Steel Straight Wire	**STSCW** STainless Steel Crimped Wire	**STSKW** STainless Steel Knotted Wire	**STSSW** STainless Steel Straight Wire	**BRACW** BRAss Crimped Wire

SHAPE KEY

CODE	PRODUCT TYPE	TOOL	APPLICATION
WHB	Crimped Wheel Brushes		Supplied as standard with arbour hole as indicated. The size of the arbour hole can be reduced with reduction rings. Wheel brushes with short wire are more aggressive. Larger widthes require more horse power.
	Twist Knotted Wheel Brushes		This brush is ideally suited for brushing out welded joints and brushing sharp corners.
BEB	Bevel Brushes		Specially designed for brushing hard-to-reach places such as edges and corners.
CPB	Crimped Cup Brushes		This brush is designed for cleaning jobs, especially on larger surfaces. It is ideal for removing rust, corrosion, paint & primers. Removal of rust, corrosion, paint and primers.
	Twist Knotted Cup Brushes		An aggressive brush which is excellent for heavy-duty cleaning and finishing of large surfaces. Extremely suitable for removing barnacles, scale, paint, rust and corrosion, as well as cleaning weld seams and spot-welds.
WHB/ENB	Shaft Mounted Brushes		Suitable for industrial use. Ideal for hard-to-reach areas. All shaft mounted brushes are equipped with a 6mm shank.
HCB/SPB	Hand Brushes		With wooden core. Available in different widths. For use on narrow work pieces. Ideal for light deburring & cleaning profiled surfaces
TUB	Pipe Brushes		With handle or thread. For deburring and cleaning tubes.

VELKOOBCHOD BRUSIVA

OPERATING SPEED

Peripheral speed is a decisive factor in achieving optimum performance from a brush, the table opposite enables you to determine the relevant peripheral speed by simply reading down and across the appropriate diameter and drive shaft operating speed columns.

BRUSH DIAMETER (mm)	PERIPHERAL SPEEDS (m/s)											
	20	40	50	80	100	125	150	180	200	250	300	350
min^{-1}												
800				3,35	4,19	5,23	6,28	7,53	8,37	10,47	12,56	14,75
900			2,35	3,77	4,71	5,88	7,06	8,48	9,41	11,77	14,12	16,47
1150			3,01	4,81	6,01	7,52	9,02	10,83	12,03	15,04	18,04	21,04
1200	1,26	2,51	3,14	5,02	6,28	7,85	9,41	11,3	12,55	15,69	18,83	21,97
1400	1,46	2,93	3,66	5,86	7,32	9,15	10,98	13,18	14,64	18,31	21,97	25,63
1500	1,57	3,14	3,92	6,28	7,85	9,81	11,77	14,13	15,69	19,61	23,54	27,46
1800	1,88	3,77	4,71	7,54	9,41	11,77	14,12	16,95	18,83	23,54	28,24	32,95
2000	2,09	4,19	5,23	8,37	10,26	13,08	15,69	18,84	20,92	26,15	31,38	36,61
2500	2,62	5,23	6,54	10,47	13,08	16,35	19,61	23,55	26,15	32,67	39,23	45,76
2800	2,93	5,86	7,32	11,72	14,64	18,31	21,97	26,37	29,29	36,61	43,93	51,25
3000	3,14	6,28	7,85	12,56	15,69	19,62	23,54	28,26	31,38	39,23	47,07	54,92
3200	3,35	6,7	8,37	13,4	16,74	20,92	25,1	30,14	33,47	41,84	50,21	58,58
3500	3,66	7,33	9,15	14,65	18,31	22,89	27,46	32,97	36,61	45,76	54,92	64,07
4000	4,19	8,37	10,46	16,75	20,92	26,16	31,38	37,68	41,84	52,33	62,76	73,22
4500	4,7	9,42	11,77	18,84	23,54	29,43	35,3	42,4	47,07	58,84	70,61	82,43
5000	5,23	10,47	13,08	20,93	26,15	32,7	39,23	47,1	52,33	65,38	78,5	
5400	5,65	11,3	14,12	22,94	28,24	35,31	42,36	50,67	56,48	70,61	84,78	
6000	6,28	12,56	15,69	25,12	31,38	39,24	47,07	56,52	62,76	78,5		
7000	7,33	14,66	18,31	29,31	36,61	45,78	54,92	65,94	73,22	91,58		
8000	8,37	16,75	20,92	33,94	41,48	52,32	62,76	75,36	83,73			
9000	9,42	18,84	23,54	37,68	47,07	58,86	70,61	84,78	94,2			
10000	10,47	20,93	26,17	41,86	52,33	65,4	78,5	94,2				
12500	13,08	26,17	32,71	52,33	65,42	81,75	98,13					
15000	15,7	31,4	39,25	62,8								
17500	18,32	36,63	45,79	73,26								
20000	20,93	41,87	52,33	83,73								
22500	23,55	47,1	58,88	94,2								
25000	26,17	52,33	65,42	104,66								

Jimi VELKOOBCHOD BRUSIVA

INTRODUCTION

MAXIMUM OPERATING SPEED

TYPE	DIAMETER (mm)	MAX RPM
WHEEL BRUSHES	80	10000
	100	8000
	125	6000
	150	6000
	180	6000
	200	4500
	250	3600
	250 - 1 row	3500
	300	3000
CUP BRUSHES	60/65/75	11000
	60/65/75	11000
	60/65/75	10000
	75	9300
	80/100	8500
	125/150	6500

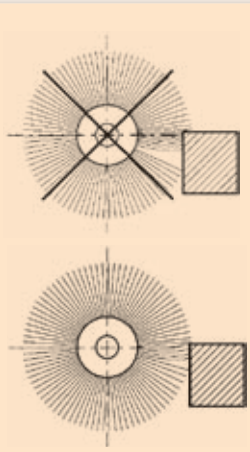
TYPE	DIAMETER (mm)	MAX RPM
BEVEL BRUSHES	100	11000
	100/115	11000
	115	10000
TWIST KNOTTED WHEEL BRUSHES	100	11000
	115	11000
	125	10000
	150/180	8500
	200	6500
SHAFT MOUNTED WIRE BRUSHES	20	20000
	30	20000
	40	18000
	50	15000
	60	15000
	70	15000
	80	12000

The maximum RPM ratings are safety ratings not recommended operating speeds. The optimum operating speed is determined by the application and in most cases lower operating speeds will prove more efficient and achieve the best result. As a general guide we recommend the following peripheral speeds when working on the materials listed with:

	CRIMPED WIRE	TWIST KNOTTED
STEEL	30m/s	35-40m/s
NON FERROUS	18-20m/s	
PLASTIC	15m/s	

BRUSHING PRESSURE

- Let the tips of a wire brush do the work. Operate the brush with the lightest pressure so only the tips of the wire come in contact with the work.
- If heavy pressure is used, wires will be over stressed, resultin action, and if this is continued, the life of the brush will be sho to wire fatigue.
- Apply the work to the face of the brush ensuring as much of th face as possible is in full contact. Applying the work to the side of the brushing tool will result in wire breakage and shortened brush life.
- Reversing the wheel brush rotation periodically will tend to increase the life of the brush. This results in the sharpening of the wire tips or ends, ensuring faster cutting action.



jimi VELKOOBCHOD BRUSIVA

SIZE OF WIRE

- Use the finest size of wire suitable for the application
- Finer wire size will perform better and last longer than heavier

TROUBLESHOOTING

Several factors can influence a brush application. If the selected brush does not achieve the expected result, the following table may provide solutions for the most common problems faced by a user.
For further information, please contact our technical department.

PROBLEM	RECOMMENDED ACTIONS
Brush is too aggressive	■ Increase trim length ■ Reduce wire diameter ■ Reduce operating speed
Brush is not aggressive enough	■ Reduce trim length ■ Increase wire diameter ■ Increase operating speed
Action of brush does not totally remove scale	■ Reduce trim length ■ Increase wire diameter
Finish is to coarse	■ Increase trim length ■ Reduce wire diameter ■ Increase operating speed ■ Choose a nylon abrasive brush
Finish is to smooth	■ Reduce trim length ■ Increase wire diameter
Action of brush is not uniform	■ Reduce brushing pressure ■ Automate operations to avoid human inaccuracy
Wire breaks more than usual	■ Reduce brushing pressure ■ Reduce wire diameter ■ Reduce operating speed
Life of the brush is too short	■ Reduce wire diameter ■ Increase brush diameter ■ Reduce brushing pressure

SAFETY & STORAGE

Safety goggles or full face shields with side shields must be worn by all operators and others in the immediate area of power brush operations.

- Keep all machine guards in place.
- Observe all speed restrictions indicated on brushes.
- Appropriate protective clothing and equipment must be used.
- Brushes should be carefully checked when removed from the original carton. Do not use if rusted or damaged.
- Store brushes in the original carton. Wire brushes should not be exposed to heat, high humidity, acids, fumes or liquids that can result in deterioration of the wire filaments, and subsequently, premature failure of the wires. Also, check for distortion of brush fill that can cause imbalance and excessive vibration when the brush is running.
- Check maximum spindle speed. Do not mount and operate the brush if spindle RPM exceeds the maximum safe free speed for which the brush is rated. Spindle length should be sufficient to permit a full nut mounting.
- Before starting the machine, rotate the wire brush with a gloved hand to determine that the brush has been correctly mounted and turns freely.

VELKOOBCHOD BRUSIVA

METAL REDUCING FLANGES FOR WHEEL BRUSHES

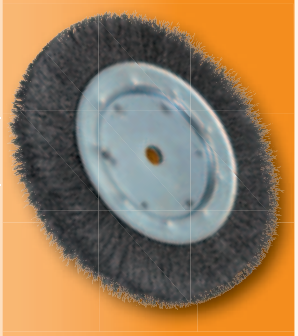
SIZE (mm) R³xA	PK QTY	ART. NO.
20x13	1	662544**06503***
20x16	1	662544**06501***
30x13	1	662544**06500***
30x16	1	662544**06487***
30x20	1	662544**06486***
30x25,4	1	662544**06484***
50,8x30	1	662544**06482***
50,8x32	1	662544**06481***
80x30	1	662544**06478***
80x32	1	662544**06476***
80x50,8	1	662544**06472***
100x30	1	662544**06468***
100x32	1	662544**06467***
100x50,8	1	662544**06457***
120x30	1	636425**89202***
120x32	1	636425**89203***
120x50,8	1	636425**89204***

* Made-to-order

VELKOOBCHOD BRUSIVA

BRUSHES FOR BENCH GRINDERS

FEATURES	BENEFITS
■ Wheel brushes are ideal for removing corrosion, rust, hardened paints & hard adhesive residues	■ Can be used universally on all kinds of applications (tubes, corners, angles)
■ Twist Knotted Wire is ideal for heavier applications	■ Good surface finish, especially smaller diameter wheels
■ Crimped Wire is ideal for lighter applications	■ Good price/performance ratio



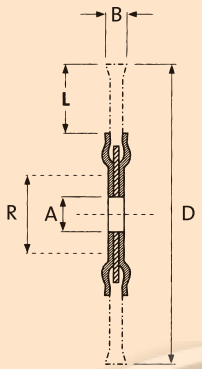
WHEEL BRUSHES (WHB)

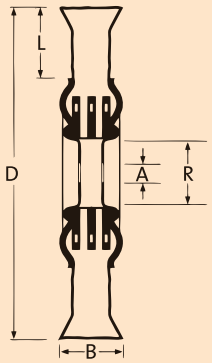
NORMAL STEEL CRIMPED WIRE (NOSCW) - 1 ROW

SHAPE	D	B	A	R	WIRE Ø	ROW	L	PK QTY	ART. NO.
WHB	100	11	12	20	0,30	1R	T22	1	66254406455*
	125	11	12	20	0,30	1R	T34	1	66254406454*
	150	13	12	32	0,30	1R	T34	1	66254406453
	180	13	12	50,8	0,30	1R	T33	1	66254406452
	200	13	12	50,8	0,30	1R	T43	1	66254406451

* Made-to-order

SHAPE KEY





Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

Jimi BRUSIVA VELKOOBCHOD

BRUSHES FOR BENCH GRINDERS

WHEEL BRUSHES (WHB) (CONTINUED)

NORMAL STEEL CRIMPED WIRE (NOSCW) - 2/3 ROWS

SHAPE	D	B	A	R	WIRE Ø	ROW	L	PK QTY	ART. NO.
	100	20	20	30	0,20	2R	T24	1	662544**06450**
	125	24	20	30	0,20	2R	T36	1	662544**06409**
	150	29	32	51	0,20	2R	T27	1	662544**06407**
	180	22	32	51	0,20	2R	T42	1	662544**06403**
	200	26	32	80	0,20	2R	T40	1	662544**06401**
	80	15	20	20	0,30	2R	T20	1	662544**06399**
	100	20	20	30	0,30	2R	T24	1	662544**06284**
	100	28	20	30	0,30	3R	T24	1	662544**06283***
	125	24	20	30	0,30	2R	T36	1	662544**06282**
	150	18	32	51	0,30	2R	T27	1	662544**06265**
WHB	150	29	32	51	0,30	2R	T27	1	662544**06264**
	180	22	32	51	0,30	2R	T42	1	662544**06263**
	180	28	32	51	0,30	2R	T42	1	662544**06259**
	200	26	32	80	0,30	2R	T40	1	662544**06255**
	200	36	32	80	0,30	3R	T40	1	662544**06243**
	250	32	50,8	100	0,30	2R	T50	1	662544**06241**
	300	32	50,8	100	0,30	2R	T60	1	662544**06240***
	150	29	32	51	0,50	2R	T27	1	662544**06239***
	180	28	32	51	0,50	3R	T42	1	662544**06237***
	200	26	32	80	0,50	2R	T40	1	662544**06216**
	250	38	50,8	100	0,50	3R	T50	1	662544**06214**

STAINLESS STEEL CRIMPED WIRE (STSCW)

SHAPE	D	B	A	R	WIRE Ø	ROW	L	PK QTY	ART. NO.
	150	18	32	51	0,20	2R	T27	1	662544**06211***
	125	24	20	30	0,30	2R	T36	1	662544**06208**
	150	18	32	51	0,30	2R	T27	1	662544**06206**
WHB	150	29	32	51	0,30	3R	T27	1	662544**06203**
	180	22	32	51	0,30	2R	T42	1	662544**06199**
	180	28	32	51	0,30	3R	T42	1	662544**06196**
	200	26	32	80	0,30	2R	T40	1	662544**06187**

BRASS CRIMPED WIRE (BRACW)

SHAPE	D	B	A	R	WIRE Ø	ROW	L	PK QTY	ART. NO.
WHB	150	29	32	51	0,20	3R	T43	1	662544**14433***

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

WHEEL BRUSHES (WHB)

NORMAL STEEL TWIST KNOTTED WIRE (NOSKW)

SHAPE	D	B	A	WIRE Ø	L	PK QTY	ART. NO.
WHB	100	11	22,2	0,35	T22	1	662544**06185***
	115	11	22,2	0,35	T23	1	662544**06180***
	125	13	22,2	0,35	T28	1	662544**06178**
	178	15	22,2	0,35	T35	1	662544**06175**
	115	11	M14	0,35	T23	1	662544**06173**
	125	13	M14	0,35	T28	1	662544**06172**
	100	11	22,2	0,50	T22	1	662544**06170***
	115	11	22,2	0,50	T23	1	662544**06167**
	125	13	22,2	0,50	T28	1	662544**06166**
	150	12	22,2	0,50	T34	1	662544**06164**
	178	15	22,2	0,50	T35	1	662544**06163**
	115	11	M14	0,50	T23	1	662544**06160**
	125	13	M14	0,50	T28	1	662544**06158**
	178	15	M14	0,50	T44	1	662544**06155**

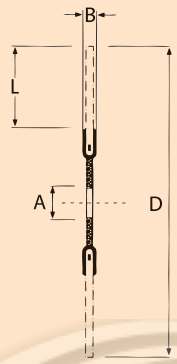
STAINLESS STEEL TWIST KNOTTED WIRE (STSKW)

SHAPE	D	B	A	WIRE Ø	L	PK QTY	ART. NO.
WHB	115	11	22,2	0,50	T23	1	662544**06153**
	125	11	22,2	0,50	T23	1	662544**10928***
	178	15	22,2	0,50	T35	1	662544**06152****

All sizes also available with left hand twist knot direction upon request.

* Made-to-order
** left hand knot direction

SHAPE KEY



Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

Jimi VELKOOBCHOD BRUSIVA

BRUSHES FOR ANGLE GRINDERS

BEVEL BRUSHES

FEATURES	BENEFITS
■ Larger diameter brushes for heavier applications	■ Cup brush ideal for brushing larger surfaces
■ Smaller diameters brushes for finer applications	■ Good price/performance ratio
■ Twist Knotted Wire is ideal for pipes	■ Uniform brushing, even in difficult-to-reach areas

BEVEL BRUSHES (BEB)

NORMAL STEEL TWIST KNOTTED WIRE (NOSKW)

SHAPE	D	B	A	WIRE Ø	L	PK QTY	ART. NO.
BEB	100	13	M14	0,50	T20	1	662544**06149**
	115	15	M14	0,50	T27,5	1	662544**06147**

STAINLESS STEEL TWIST KNOTTED WIRE (STSKW)

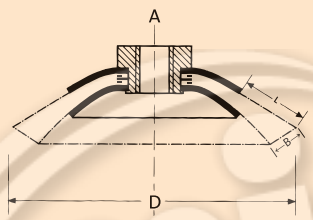
SHAPE	D	B	A	WIRE Ø	L	PK QTY	ART. NO.
BEB	100	10	M14	0,50	T20	1	662544**06146**
	115	15	M14	0,50	T27,5	1	662544**06144**

NORMAL STEEL CRIMPED WIRE (NOSCW)

SHAPE	D	B	A	WIRE Ø	L	PK QTY	ART. NO.
BEB	100	13	M14	0,30	T20	1	662544**06142**
	115	15	M14	0,30	T20	1	662544**06109**

Bevel brushes supplied with left- hand knots. Right- hand knots available upon request.

SHAPE KEY



VELKOOBCHOD BRUSIVA

CUP BRUSHES (CPB)

NORMAL STEEL TWIST KNOTTED WIRE (NOSKW)

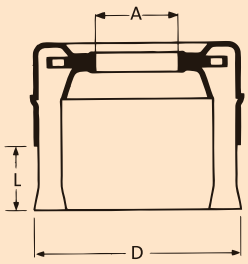
SHAPE	D	A	WIRE Ø	L	PK QTY	ART. NO.
CPB	65	M10	0,35	T20	1	662544**06107***
	65	M14	0,35	T20	1	662544**06104**
	80	M14	0,35	T25	1	662544**06102**
	100	M14	0,35	T25	1	662544**06099**
	120	M14	0,35	T25	1	662544**06097***
	65	M14	0,50	T20	1	662544**06095**
	80	M14	0,50	T25	1	662544**06094**
	80	5/8"	0,50	T25	1	662544**06091***
	100	M14	0,50	T25	1	662544**06088**
	100	5/8"	0,50	T25	1	662544**06086**
	120	M14	0,50	T25	1	662544**06084**
	80	M14	0,80	T25	1	662544**06082**
	80	5/8"	0,80	T25	1	662544**06079***
	100	M14	0,80	T25	1	662544**06076**
	120	M14	0,80	T25	1	662544**06070**

STAINLESS STEEL TWIST KNOTTED WIRE (STSKW)

SHAPE	D	A	WIRE Ø	L	PK QTY	ART. NO.
CPB	65	M14	0,50	T20	1	662544**06068**
	80	M14	0,50	T25	1	662544**06067***
	100	M14	0,50	T25	1	662544**06065***

* Made-to-order

SHAPE KEY



Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

BRUSHES FOR ANGLE GRINDERS

CUP BRUSHES (CONTINUED)

NORMAL STEEL CRIMPED WIRE (NOSCW)

SHAPE	D	A	WIRE Ø	L	PK QTY	ART. NO.
CPB	60	M14	0,20	T16	1	662544**06062***
	75	M14	0,20	T20	1	662544**06059**
	60	M14	0,30	T16	1	662544**06058**
	75	M14	0,30	T20	1	662544**06055**
	80	M14	0,30	T25	1	662544**06054**
	100	M14	0,30	T30	1	662544**06053**
	125	22,2	0,30	T35	1	662544**06052**
	125	M14	0,30	T35	1	662544**06050**
	150	M14	0,30	T55	1	662544**06049**
	80	M14	0,50	T25	1	662544**06048**
	100	M14	0,50	T30	1	662544**06041***

STAINLESS STEEL CRIMPED WIRE (STSCW)

SHAPE	D	A	WIRE Ø	L	PK QTY	ART. NO.
CPB	60	M14	0,30	T16	1	662544**06037**
	80	M14	0,30	T25	1	662544**04868**

* Made-to-order

jimi VELKOOBCHOD BRUSIVA

SPINDLE MOUNTED BRUSHES

FEATURES	BENEFITS
■ Ideal for medium force brushing	■ For difficult-to-reach areas (holes, tubes)
■ Available in crimped and knotted wire	■ Steady brushing
■ Inox wire contains less oil	■ Knotted wire for heavy brushing, crimped wire for normal brushing

CIRCULAR BRUSHES ON SHANK (WHB)

NORMAL STEEL CRIMPED WIRE (NOSCW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
WHB	20	4	6	0,20	T3	10	662544**04872**
	20	9	6	0,20	T3	10	662544**04903**
	30	6	6	0,20	T6,5	10	662544**04875**
	30	9	6	0,20	T6,5	10	662544**04876**
	40	9	6	0,20	T9	10	662544**04879**
	40	13,5	6	0,20	T9	10	662544**04904**
	50	10	6	0,20	T12,5	10	662544**04880**
	50	15	6	0,20	T12,5	10	662544**04881**
	60	10	6	0,20	T17,5	10	662544**04884**
	60	15	6	0,20	T17,5	10	662544**04885**
	70	10	6	0,20	T19	10	662544**04886**
	70	15	6	0,20	T19	10	662544**04887**
	80	10	6	0,20	T19	10	662544**04889**
	80	20	6	0,20	T19	10	662544**04905**
	50	10	6	0,30	T12,5	10	662544**04891**
	50	15	6	0,30	T12,5	10	662544**04893**
	60	10	6	0,30	T17,5	10	662544**04894**
	60	15	6	0,30	T17,5	10	662544**04897**
	60	20	6	0,30	T17,5	10	662544**11025***
	70	10	6	0,30	T19	10	662544**04899**
	70	15	6	0,30	T19	10	662544**04900**
	80	20	6	0,30	T19	10	662544**04907**

* Made-to-order

Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

JIMI VELKOOBCHOD BRUSIVA

BRUSHES FOR HAND DRILLS

CIRCULAR BRUSHES ON SHANK (WHB) (CONTINUED)

STAINLESS STEEL CRIMPED WIRE (STSCW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
WHB	30	9	6	0,20	T6,5	10	662544**04909**
	40	9	6	0,20	T9	10	662544**04910**
	40	13,5	6	0,20	T9	10	662544**04912**
	50	10	6	0,20	T12,5	10	662544**04915**
	50	15	6	0,20	T12,5	10	662544**05238**
	60	10	6	0,20	T17,5	10	662544**05269**
	60	15	6	0,20	T17,5	10	662544**05270**
	70	10	6	0,20	T19	10	662544**05271**
	70	15	6	0,20	T19	10	662544**05390**
	80	20	6	0,20	T19	10	662544**05392**
	60	10	6	0,30	T17,5	10	662544**05393**
	60	15	6	0,30	T17,5	10	662544**05394**
	70	10	6	0,30	T19	10	662544**05395**
	70	15	6	0,30	T19	10	662544**05396**
	80	20	6	0,30	T19	10	662544**05398**

BRASS CRIMPED WIRE (BRACW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
WHB	30	9	6	0,20	T6,5	10	662544**05400**
	40	9	6	0,20	T9	10	662544**05401**
	50	15	6	0,20	T12,5	10	662544**05397**
	60	15	6	0,20	T17,5	10	662544**05402**
	70	15	6	0,20	T19	10	662544**05403**
	80	20	6	0,20	T19	10	662544**05405**

NORMAL STEEL TWIST KNOTTED WIRE (NOSKW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
WHB	70	15	6	0,35	T15	12	662544**05406**
	70	15	6	0,50	T15	12	662544**05407**

Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

END BRUSHES ON SHANK (ENB)

NORMAL STEEL CRIMPED WIRE (NOSCW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	12	60	6	0,20	T20	12	662544**05408**
	17	65	6	0,20	T22	12	662544**05409**
	12	60	6	0,30	T20	12	662544**05410**
	17	65	6	0,30	T22	12	662544**05411**
	24	68	6	0,30	T25	12	662544**05412**
	30	68	6	0,30	T25	12	662544**05413**

STAINLESS STEEL CRIMPED WIRE (STCSW)

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	12	60	6	0,30	T20	12	662544**05414**
	17	65	6	0,30	T22	12	662544**05415**
	24	68	6	0,30	T25	12	662544**05418**
	30	68	6	0,30	T25	12	662544**05419**

NORMAL STEEL TWIST KNOTTED WIRE (NOSKW) - HIGH SPEED

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	19	68	6	0,35	T28	12	662544**05421**
	22	68	6	0,35	T28	12	662544**05422**
	28	68	6	0,50	T28	12	662544**05423**

STAINLESS STEEL KNOTTED WIRE (STSKW) - HIGH SPEED

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	19	68	6	0,25	T28	12	662544**05424***
	22	68	6	0,25	T28	12	662544**05425**

BRASS CRIMPED WIRE (BRACW)

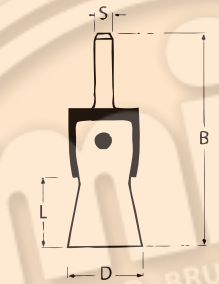
SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	24	68	6	0,30	T25	12	662544**05427***

SPECIALTIES

SHAPE	D	B	SHANK	WIRE Ø	L	PK QTY	ART. NO.
ENB	50	63	6	0,30	T20	5	662544**05428**
	70	68	6	0,30	T25	5	662544**05429**
	10	120	6	0,30	T20	10	662544**05430**

* Made-to-order

SHAPE KEY



VELKOOBCHOD BRUSIVA

HAND BRUSHES

HAND BRUSHES

FEATURES	BENEFITS
■ Ideal for simple brushing operations	■ Flexible, easy to use
■ Ideal for difficult-to-reach areas (corners, tubes, holes)	■ Available in steel, inox and brass
■ Ideal for small parts	■ Good price/performance ratio

HAND BRUSHES (HCB)

WOOD HAND - NORMAL STRAIGHT STEEL WIRE (NOSSW)

SHAPE	L1	L2	L	WIRE Ø	ROW	PK QTY	ART. NO.
HCB	290	140	25	0,30	1R	12	662544**05431***
	290	140	25	0,30	2R	12	662544**05432**
	290	140	25	0,30	3R	12	662544**05434**
	290	140	25	0,30	4R	12	662544**05435**
	290	140	25	0,30	5R	12	662544**05437**
	290	140	25	0,30	6R	12	662544**05439**

WOOD HAND - STAINLESS STEEL STRAIGHT WIRE (STSSW)

SHAPE	L1	L2	L	WIRE Ø	ROW	PK QTY	ART. NO.
HCB	290	140	25	0,30	2R	12	662544**05443**
	290	140	25	0,30	3R	12	662544**05444**
	290	140	25	0,30	4R	12	662544**05447**
	290	140	25	0,30	5R	12	662544**05449**

WOOD HAND - STAINLESS STEEL CRIMPED WIRE (STSCW)

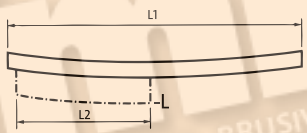
SHAPE	L1	L2	L	WIRE Ø	ROW	PK QTY	ART. NO.
HCB	290	140	25	0,30	2R	12	662544**05457**
	290	140	25	0,30	3R	12	662544**05460**
	290	140	25	0,30	4R	12	662544**05461**
	290	140	25	0,30	5R	12	662544**05462**

WOOD HAND - BRASS CRIMPED WIRE (BRACW)

SHAPE	L1	L2	L	WIRE Ø	ROW	PK QTY	ART. NO.
HCB	290	140	25	0,30	2R	12	662544**05463**
	290	140	25	0,30	3R	12	662544**05465***
	290	140	25	0,30	4R	12	662544**05466**
	290	140	25	0,30	5R	12	662544**05467**
	290	140	25	0,30	6R	12	662544**05468**

* Made-to-order

SHAPE KEY



VELKOOBCHOD BRUSIVA

MULTI HAND BRUSHES

PLASTIC HAND - NORMAL CRIMPED WIRE (NOSCW)

SHAPE	L1	L2	L	WIRE Ø	PK QTY	ART. NO.
HCB	265	140	25	0,30	6	66254405470

PLASTIC HAND - STAINLESS STEEL CRIMPED WIRE (STSCW)

SHAPE	L1	L2	L	WIRE Ø	PK QTY	ART. NO.
HCB	265	140	25	0,30	6	66254405471

PLASTIC HAND - BRASS CRIMPED WIRE (BRACW)

SHAPE	L1	L2	L	WIRE Ø	PK QTY	ART. NO.
HCB	265	140	25	0,30	6	66254405473

SPECIAL HAND BRUSHES

SPARK PLUG BRUSHES

SHAPE	L1	L2	L	WIRE Ø	ROW	PK QTY	ART. NO.
SPB	200	18	45	0,20	3x6R	24	66254405474
	195	26	50	0,20	5x8R	24	66254405478

FILE CARD BRUSHES

SHAPE	L1	L2	L	PK QTY	ART. NO.
SPB	235	25	100	24	66254405479
	235	40	115	24	66254405480

FITTING BRUSH INTERNAL

SHAPE	D	L	L1	WIRE Ø	PK QTY	ART. NO.
SPB	13	25	160	0,20	12	66254405481
	16	25	160	0,20	12	66254405483
	23	32	160	0,20	12	66254405484

FITTING BRUSH EXTERNAL

SHAPE	D	WIRE Ø	PK QTY	ART. NO.
SPB	12	0,30	12	66254405485
	15	0,30	12	66254405486
	22	0,30	12	66254405487

Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

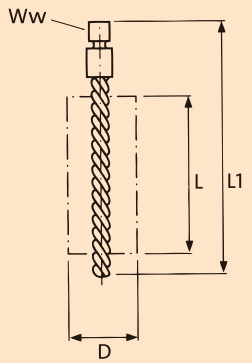
PIPE BRUSHES

PIPE BRUSHES WITH SHANK

SHAPE	D	L	L1	SHANK / W/w	WIRE Ø	PK QTY	ART. NO.
TUB	16	80	115	6	0,20	10	662544**05500***
	18	80	115	6	0,20	10	662544**05502**
	25	80	115	6	0,20	10	662544**05503**
TUB	10	80	115	M6	0,20	10	662544**05504**
	12	80	115	M6	0,20	10	662544**05506**
	16	80	115	M6	0,20	10	662544**05507**
	20	80	115	M6	0,20	10	662544**05628**
DOU	1000					1	662544**05629**
TUB	20	100	160	1/2"BSW	0,20	10	662544**05630**
	25	100	160	1/2"BSW	0,20	5	662544**05631**
	30	100	160	1/2"BSW	0,30	5	662544**05632**
	32	100	160	1/2"BSW	0,30	5	662544**05634**
	38	100	160	1/2"BSW	0,30	5	662544**05637**
	44	100	160	1/2"BSW	0,30	5	662544**05641**
	50	100	160	1/2"BSW	0,40	5	662544**05647**
	63	100	160	1/2"BSW	0,40	5	662544**05649**
	69	100	160	1/2"BSW	0,40	5	662544**05652**
	75	100	160	1/2"BSW	0,40	5	662544**05656**
	82	100	160	1/2"BSW	0,40	5	662544**11027***
DOU	1000					1	662544**05692**

* Made-to-order

SHAPE KEY



jimi VELKOOBCHOD BRUSIVA

PIPE BRUSHES (CONTINUED)

PIPE BRUSHES WITH HANDLE NORMAL STEEL CRIMPED

SHAPE	D	L	L1		WIRE Ø	PK QTY	ART. NO.
ACB	6	100	300	+ handle	0,10	20	66254**05662**
	8	100	300	+ handle	0,10	20	66254**05696**
	10	100	300	+ handle	0,10	20	66254**05706**
	12	100	300	+ handle	0,10	20	66254**05704**
	15	100	300	+ handle	0,10	20	66254**05712**
	18	100	300	+ handle	0,10	20	66254**05713**
	20	100	300	+ handle	0,20	20	66254**05715**
	25	100	300	+ handle	0,20	20	66254**05717**

PIPE BRUSHES WITH HANDLE STAINLESS STEEL CRIMPED

SHAPE	D	L	L1		WIRE Ø	PK QTY	ART. NO.
ACB	12	100	300	+ handle	0,10	20	66254**05720**
	15	100	300	+ handle	0,10	20	66254**05722**

PIPE BRUSHES WITH HANDLE BRASS WIRE

SHAPE	D	L	L1		WIRE Ø	PK QTY	ART. NO.
ACB	6	100	300	+ handle	0,10	20	66254**05723**
	8	100	300	+ handle	0,10	20	66254**05724**
	10	100	300	+ handle	0,10	20	66254**05725**
	12	100	300	+ handle	0,10	20	66254**05726***
	15	100	300	+ handle	0,10	20	66254**05727**
	18	100	300	+ handle	0,10	20	66254**05728**
	20	100	300	+ handle	0,15	20	66254**05730**
	25	100	300	+ handle	0,15	20	66254**05731**

PIPE BRUSHES WITH HANDLE NYLON WIRE

SHAPE	D	L	L1		WIRE Ø	PK QTY	ART. NO.
ACB	6	100	300	+ handle	0,20	20	66254**05732**
	8	100	300	+ handle	0,20	20	66254**05733**
	10	100	300	+ handle	0,20	20	66254**05734**
	12	100	300	+ handle	0,20	20	66254**05735**
	15	100	300	+ handle	0,20	20	66254**05737**
	18	100	300	+ handle	0,25	20	66254**05739**
	20	100	300	+ handle	0,25	20	66254**05740**
	25	100	300	+ handle	0,25	20	66254**05742**

* Made-to-order

Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

MISCELLANEOUS

BROOM STEELWIRE

SHAPE	B	D	ROW	L	PK QTY	ART. NO.
SPB	300	60	6x20	T75	1	662544**05744**

SCRUBBER STEELWIRE

SHAPE	B	D	ROW	L	PK QTY	ART. NO.
SPB	210	60	6x17	T30	1	662544**05745**

Dimensions Key: D = Diameter, B = Width, A = Bore min, R = Bore max, L = Wire Length

NOTES

VELKOOBCHOD BRUSIVA

TUNGSTEN CARBIDE BURRS

Innovative technology is now used in the range in the form of the new "Dtech" cutting edges, as well as the introduction of the new high performance Xtrem products. This new extended line of carbide burrs covers a variety of teeth and cutting shapes giving them optimum adaptation to the key characteristics of various application materials.

APPLICATIONS & MARKETS

- Weld removal
- Chamfering
- Weld preparation
- Deburring
- Aerospace
- Automotive
- Shipbuilding
- Foundry
- Aviation

BEST

XTREM

FERR. & NON FERR.

FEATURES	BENEFITS
■ TiAlN (Titanium aluminium nitride) coating	■ Better sliding characteristics for improved removal of chippings ■ Less wear of toothing ■ Less heat build up ■ Reduction of cutting pressure due to improved lubrication ■ Ideal for use on the hardest, Xtrem materials
■ Tungsten carbide head	■ Capable of being used at high speeds & at high temperatures
■ Skip flute design	■ Long life
■ Wide variety of cuts available	■ Sharp cutting edges for improved productivity & longer product life
■ Wide variety of shapes available	■ Suitable for many different applications

BETTER

STANDARD

FERR. & NON FERR.

FEATURES	BENEFITS
■ Tungsten carbide head	■ Capable of being used at high speeds & at high temperatures
■ Skip flute design	■ Long life
■ Wide variety of cuts available	■ Sharp cutting edges for improved productivity & longer product life
■ Wide variety of shapes available	■ Suitable for many different applications

VELKOOBCHOD BRUSIVA

PRODUCT SELECTION

USAGE KEY
■ Highly recommended
◧ Recommended

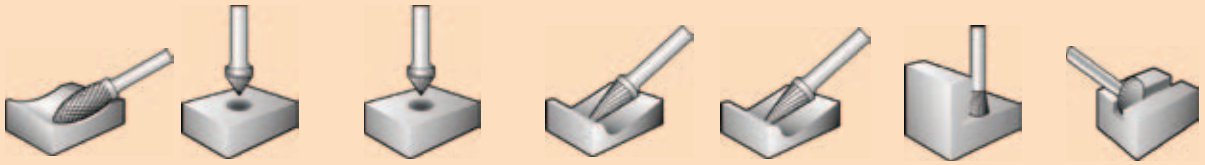
CUT STYLE	D DOUBLE CUT	DTECH DOUBLE CUT EXTRA	ALU ALUMINIUM SPECIAL	DF* FINE DOUBLE CUT	BC* CHIP BREAKER	S* SIMPLE
QUALITIES	Universal cutting style. Fast material removal. Smooth finish. Granular chip break.	Better stock removal. Stronger tooth formation (decreased tooth wedge angle). Longer tool life. Reduced chipping.	For deburring of aluminium alloys & plastic wide tooth formation. Easy chip flow.	Granular chip break. Fine finish applications. Use on heat treated & tough alloy steel.	General purpose deburring.	General purpose application produces scratch free surface.
XTREM						
Steel	■	■				
Hardened steel	◧					
Stainless steel	◧	■				
Cast iron	◧	■				
Titanium		◧	■			
Nickel	■	◧				
Copper/copper alloys	■	■				
Aluminium			■			
Plastics			■			
STANDARD						
Steel	■	■		■	■	■
Hardened steel	■			■		■
Stainless steel	■	■		■	■	■
Cast iron	■	■		■	■	■
Titanium	■	■	■	■		■
Nickel	■	■		■		■
Copper/copper alloys	■	■		■	■	■
Aluminium			■			
Plastics			■			
Cement				■		■

* Made-to-order

VELKOOBCHOD BRUSIVA

PRODUCT SELECTION

A Cylinder | **B** Cylinder with end cut | **C** Ball nosed cylinder | **D** Ball | **E** Oval | **F** Ball nosed tree | **G** Tree

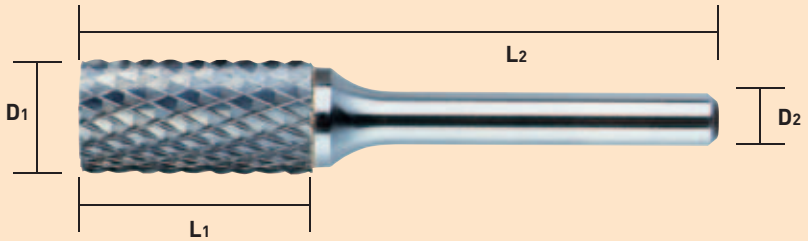


H Flame | **J** Countersink 60°* | **K** Countersink 90°* | **L** Ball nosed cone | **M** Cone | **N** Inverted cone* | Rim*

*Made-to-order

DIMENSIONS & DESCRIPTION OF THE BURR

A	16,0	x	25,0	6x65	DTECH
Shape	Diameter of the head		Length of the head	Diameter of the shank & overall length of the burr (OL)	Cut style
	D_1		L_1	$D_2 + L_2$	



RECOMMENDED OPERATING SPEEDS (RPM)

MATERIAL TYPE	Ø 3mm	Ø 6mm	Ø 10mm	Ø 12mm	Ø 16mm
Steel	60000-90000	45000-90000	30000-40000	22500-30000	18000-24000
Tempered steel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Stainless steel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Casting	45000-90000	22500-60000	15000-40000	11000-30000	9000-24000
Titanium	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Nickel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Copper & copper alloys	45000-90000	22500-60000	15000-40000	11000-30000	9000-24000
Aluminium	30000-90000	15000-70000	10000-50000	7000-38000	6000-30000
Plastics	30000-90000	15000-70000	10000-50000	7000-38000	6000-30000
Cement	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000

VELKOOBCHOD BRUSIVA

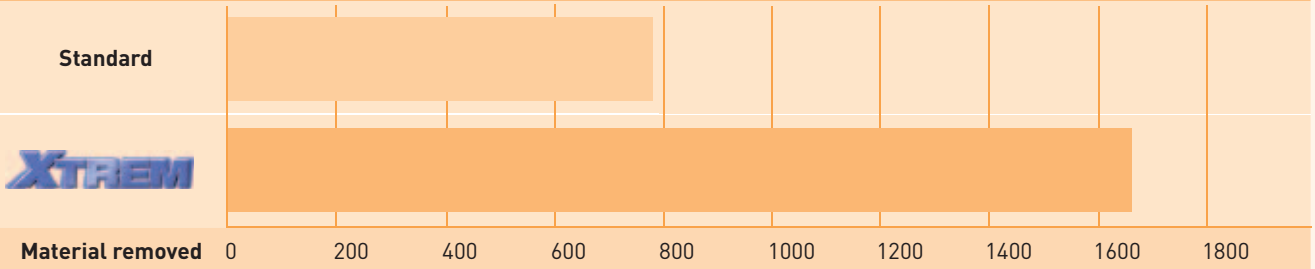
SKIP FLUTE GEOMETRY

Skip flute geometry

All Norton Carbide Burrs have what is known as skip flute geometry, which means products are more precise and have improved cutting characteristics. This also gives greater strength and improved removal of chips.

Conventional "centred" geometry

ADVANTAGES OF XTREM



Tool: **Standard**: Shape F-12x25 6x70 Norton DTECH cut
Xtrem: Shape F-12x25 6x70 Norton XTREM DTECH cut

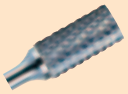
Workpiece: Mild Steel

SPEC CHECK

- For m
  produ
  capab
  Tungs

Dimensions Key: DIM = Dimensions, D^1 = Head Diameter, L^1 = Head Length, D^2 = Shank Diameter, L^2 = Shank Length

TUNGSTEN CARBIDE BURRS

PRODUCT SHAPE	SUB SHAPE	DIM $D^1xL^1xD^2xL^2$ (mm)	PK QTY	XTREM BEST XTREM	BETTER STANDARD
A CYLINDER 	D	3x13x3x38	1		63642**86518**
	D	6x19x6x50	1	69957**83214**	60157**638141**
	D	8x19x6x65	1		60157**638143**
	ALU	10x19x6x65	1	69957**83216**	60157**638195**
	D		1	69957**83215***	60157**638144**
	D	10x25x6x162	1		63642**35764**
	ALU	12x25x6x70	1	69957**83220***	63642**86517**
	D		1	69957**83219**	07660**07808**
	D	16x25x6x70	1		60157**638148**
B CYLINDER WITH END CUT	D	3x13x3x38	1		60157**638140**
	D	6x19x6x50	1		63642**86641**
	D	8x19x6x65	1		07660**07804**
	D	8x19x6x175	1		63642**35757**
	ALU	10x19x6x65	1		07660**39845**
	D		1		60157**638145**
	DTECH		1		07660**39844**
	ALU	12x25x6x70	1		63642**86623**
	D		1		60157**638147**
	DTECH		1		60157**638174**
	D	16x25x6x70	1		60157**638190**
C BALL NOSED CYLINDER	D	3x13x3x38	1		63642**86710**
	D	6x13x6x162	1		63642**35773**
	D	6x19x6x50	1	69957**83234**	60157**638150**
	D	8x19x6x65	1		60157**638151**
	ALU	10x19x6x65	1	69957**83239***	60157**638182**
	D		1	69957**83236**	60157**638152**
	DTECH		1	69957**83238***	07660**39841**
	D	12x19x6x65	1		60157**638153**
	ALU	12x25x6x70	1	69957**83278***	07660**07846**
	D		1	69957**83241**	60157**638154**
	DTECH		1	69957**83277***	60157**638175**
	D	16x25x6x70	1		60157**638191**
D BALL	D	6x5x6x150	1		63642**35770***
	D	6x5,4x6x50	1		60157**638166**
	D	8x7,2x6x52	1		60157**638167**
	D	10x9x6x53	1	69957**83279**	07660**07832**
	D	12x10,8x6x55	1	69957**83281**	69957**83148**

* Made-to-order

Dimensions Key: DIM = Dimensions, D^1 = Head Diameter, L^1 = Head Length, D^2 = Shank Diameter, L^2 = Shank Length

JIMI VELKOOBCHOD BRUSIVA

TUNGSTEN CARBIDE BURRS (CONTINUED)

PRODUCT SHAPE	SUB SHAPE	DIM $D^1xL^1xD^2xL^2$ (mm)	PK QTY	XTREM BEST XTREM	BETTER STANDARD
E OVAL	D	6x10x6x50	1		63642**86892**
	D	10x16x6x60	1		60157**638159**
	D	12x22x6x67	1		60157**638162**
F BALL NOSED TREE	D	6x16x6x50	1	699573**83296**	63642**86955**
	ALU	10x19x6x65	1	699573**83300**	63642**86951**
	D	10x19x6x65	1	699573**83299***	60157**638170**
	ALU	12x25x6x70	1	699573**83303***	60157**638181**
	D	12x25x6x70	1	699573**83301**	60157**638171**
	DTECH	12x25x6x70	1	699573**83302**	60157**638179**
	D	12x25x8x70	1		60157**638172**
	D	16x25x6x70	1		63642**86952**
G TREE	D	6x16x6x50	1	699573**83305**	60157**638164**
	D	10x19x6x65	1	699573**83307**	60157**638165**
	D	12x25x6x70	1		07660**707829**
H FLAME	D	8x19x6x65	1		60157**638160**
	D	12x32x6x77	1	699573**83312**	63642**87971**
L BALL NOSED CONE	D	6x16x5x50	1		60157**638156***
	ALU	6x16x6x50	1		63642**87095**
	D		1	699573**83313**	
	D	8x19x6x69	1		63642**87104**
	D	10x27x6x75	1		63642**87100**
	ALU	12x30x6x75	1	699573**83325**	63642**87101**
	D		1	699573**83320**	63642**87102**
	DTECH	12x30x6x75	1	699573**83321***	63642**87067**
M CONE	D	6x19x6x50	1	699573**83326***	63642**87137**
	D	6x25x6x50	1		63642**87138***
	D	10x16x6x65	1		63642**87133**
	D	12x22x6x70	1	699573**83328**	60157**638149**

* Made-to-order

JIMI VELKOOBCHOD BRUSIVA

TUNGSTEN CARBIDE BURRS

STANDARD BURR KITS

KIT	SHAPE	DIM $D^1xL^1xD^2xL^2$ (mm)	PK QTY	ART. NO.
Mini Burrs Kit x10 - Cut D Norton				
D	A	3x13x3x38	1	07660**08056**
	B	3x13x3x38	1	
	M	3x11x3x38	1	
	C	3x13x3x38	1	
	L	3x8x3x38	1	
	H	3x8x3x38	1	
	E	3x6x3x38	1	
	G	3x13x3x38	1	
	D	3x2,7x3x39	1	
	F	3x13x3x38	1	
Burrs Kit x10 - Cut Dtech Norton				
DTECH	A	10x19x6x65	1	07660**39870**
	A	12x25x6x70	1	
	C	10x19x6x65	1	
	C	12x25x6x70	1	
	L	12x30x6x75	1	
	E	10x16x6x60	1	
	G	10x19x6x65	1	
	G	12x25x6x70	1	
	D	12x10,8x6x55	1	
	F	12x25x6x70	1	
Burrs Kit x5 - Cut D Norton				
D BALL	A	10x19x6x65	1	63642**53618**
	C	12x25x6x70	1	
	F	12x25x6x70	1	
	G	10x19x6x65	1	
	L	12x30x6x75	1	

VELKOOBCHOD BRUSIVA

INTRO STARTER 4 PIECE KITS

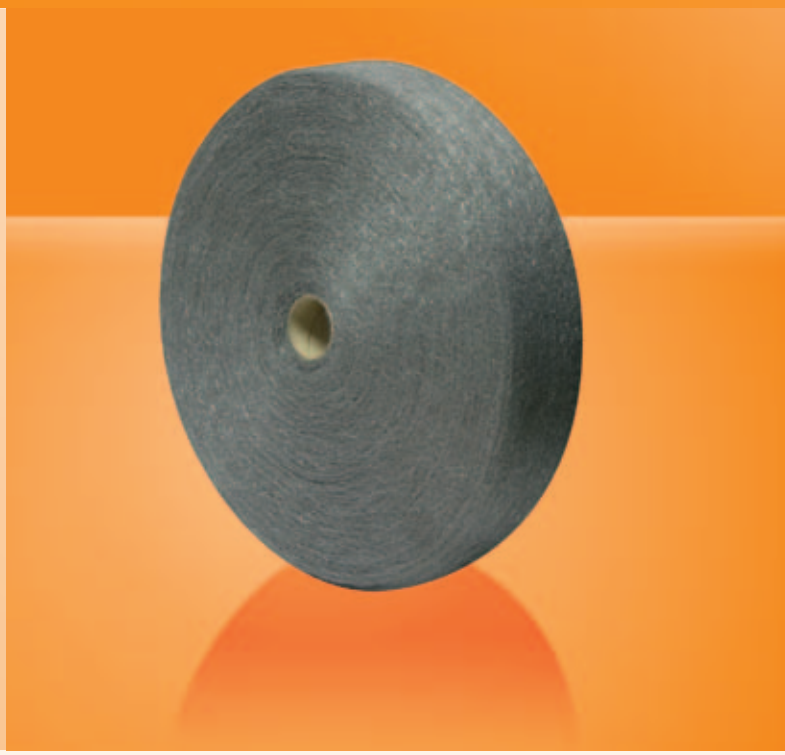
KIT	SHAPE	DIM D^1xL^1xD^2xL^2 (mm)	PK QTY	CUT TYPE	ART. NO.
SOFT STEELS	C	12x25x6x70	1	DTECH	662544**28281**
	D	10x9x6x53	1		
	F	12x25x6x70	1		
	L	12x30x6x75	1		
STAINLESS & HARD STEELS	C	12x25x6x70	1	DF	662544**28285**
	D	10x9x6x53	1		
	F	12x25x6x70	1		
	L	12x30x6x75	1		
ALUMINIUM & PLASTIC	C	12x25x6x70	1	ALU	662544**28260**
	D	10x9x6x53	1		
	F	12x25x6x70	1		
	L	12x30x6x75	1		
BRASS, BRONZE, COPPER	C	12x25x6x70	1	D	662544**28265**
	D	10x9x6x53	1		
	F	12x25x6x70	1		
	L	12x30x6x75	1		

Dimensions Key: DIM = Dimensions, D^1 = Head Diameter, L^1 = Head Length, D^2 = Shank Diameter, L^2 = Shank Length

Jimi VELKOOBCHOD BRUSIVA

STEEL WOOL

For cleaning a variety of materials and highlighting and rubbing wood.
Washable and reusable. Won't rust, shred or splinter.
Compatible with water based finishes.
Synthetic Steel Wool is one of top NORTON quality items.



APPLICATIONS & MARKETS

- Sanding contours & intricate shapes
- Restoring wood surfaces
- Finishing
- Removing minor defects
- Clear coat sanding
- Base coat sanding

BETTER

STEEL WOOL

PAINT/ VARN. &SOFT WOOD

FEATURES

- Made from strands of ultra-fine steel filaments

BENEFITS

- For use on wood, paint, metal, stone, marble & glass
- Can be used with a chemical stripper
- Ideal for cleaning & fine finishing

STEEL WOOL

WEIGHT	GRADE	PK QTY	BETTER
1Kg	0000	12	63642593149
1Kg	000	12	63642593151
1Kg	00	12	63642593153
1Kg	0	12	63642593154

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NOTES

VELKOOBCHOD BRUSIVA

CLEANING & POLISHING PRODUCTS

Norton Cleaning & Polishing Products are designed to provide excellent results, saving time and increasing efficiency. Dry Ice Q260, Norton Ice combined with Liquid Ice are a complete system to achieve a flawless finish. The exceptionally uniform cut of Dry Ice Q260 provides a consistent finish that significantly reduces buffing time using Liquid Ice to produce a finish that will take your work to the next level. Get the job done faster and right the first time.
Norton Ice foam backed discs are ideal for buffing out faster on spot repair applications.
When only the perfect finish is acceptable, use the new Liquid Ice polishing compounds and accessories. By reducing the number of polishing steps required, Liquid Ice Step 1 and Step 2 OEM are a practical solution to improve productivity and quality of work.

APPLICATIONS & MARKETS

- Automotive
- Marine

PROCESSES - RENOVATION

	DEFECT SANDING ON CLEAR COAT
Blending Paint	Norton Ice P1500/P2000

	DEFECT SANDING ON CLEAR COAT		POLISHING		PROTECTION
Old Paint	Q260 P1000	Norton Ice P2000	Liquid Ice 1 + Norwool	Liquid Ice 2 + black foam	Detailer Spray + Blue Magnet Microfibre cloth

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PROCESSES - REPAIR

	DEFECT SANDING ON CLEAR COAT			POLISHING		PROTECTION
Small Imperfections - Small single area	Black ICE 38mm		Norton Ice P3000 76mm	Liquid Ice 2 + blue foam	Liquid Ice 2 + black foam	Detailer Spray + Blue Magnet Microfibre cloth
Small Imperfections - Multiple areas	Q260 P1000 76mm		Norton Ice P2000 76mm			
Paint Runs	Black Ice sheets P1200	Norton Ice P1500 76/150mm	Norton Ice P2000/P3000 76/150mm	Liquid Ice 2 + blue foam	Liquid Ice 2 + black foam	Detailer Spray + Blue Magnet Microfibre cloth
Orange Peel Effect	Q260 P1000 150mm		Norton Ice P2000/P3000 150mm	Liquid Ice 2 + blue foam	Liquid Ice 2 + black foam	Detailer Spray + Blue Magnet Microfibre cloth
Small Defects	Norton Ice P1500 150mm		Norton Ice P2000/P3000 150mm	Liquid Ice 2 + blue foam	Liquid Ice 2 + black foam	Detailer Spray + Blue Magnet Microfibre cloth

Jimi VELKOOBCHOD BRUSIVA

CLEANING & POLISHING PRODUCTS

NORTON ICE

DESCRIPTION	DIMENSIONS	GRADE	ART. NO.	QUANTITY
Foam backed abrasive disc	80mm	1500	63642506213	6
		2000	63642506212	6
		3000	63642506211	6
	150mm	1500	63642506209	15
		2000	63642506208	15
		3000	63642506207	15

For other abrasive discs product for surface preparation prior to polishing, please see Norgrip and Soft-Touch disc section on page 162.

LIQUID ICE

FEATURES	BENEFITS
■ 0% silicone	■ Contamination free
■ Waterbased	■ Environmentally friendly
	■ Reduces polishing and buffing time

LIQUID ICE

DESCRIPTION	VOLUME	ART. NO.	QUANTITY
Liquid Ice Step 1 Quick Cut	1 litre	6625442941 9	6
Liquid Ice Step 2 OEM	1 litre	6626119153 7	6

HOW TO USE LIQUID ICE

POLISHING COMPOUNDS	FOAM SUPPORT	APPLICATION
Liquid Ice Step 1	Blue foam Step 1 or Lambswool	Remove scratches & highlight gloss
Liquid ice Step 2 OEM	Black foam Step 2	For hologram removal
Detailer Spray	Blue Magnet Microfibre cloth	Clean up excess compound residue & paint protection

SPEC CHECK

■ A polished finish can be achieved on most common clear coats using only Liquid Ice Step One. If holograms appear, use Liquid Ice Step 2 with the black foam.

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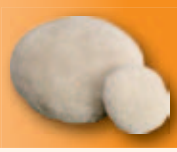
NORWOOL LAMBSWOOL

DESCRIPTION	DIMENSIONS	ART. NO.	QUANTITY
Noorwool Lambswool	76mm	63642567956	12
	150mm	63642567955	6



POLISHING FOAMS

DESCRIPTION	DIMENSIONS	DENSITY	ART. NO.	QUANTITY
Polishing foam - blue	76x25mm	Medium	66254441984	20
	150x25mm	Medium	66254441983	20
Polishing foam - black	76x25mm	Soft	66254441987	20
	150x25mm	Soft	66254441985	20

PAINT PROTECTOR

DESCRIPTION	VOLUME	ART. NO.	QUANTITY
Detailer Finishing Spray Liquid Ice Detailer Spray is designed to easily clean up excess buffing residue and provide excellent paint protection. Simply spray on and wipe off with a Blue Magnet microfibre cloth.	946ml	63642542082	4

BLUE MAGNET

DESCRIPTION	DIMENSIONS	ART. NO.	QUANTITY
Blue Magnet microfibre cloth	400x400mm	63642504402	5

NORTON BACK-UP PADS

DESCRIPTION	DIMENSIONS	ART. NO.	QUANTITY
Norton back-up pad	76mm	63642567810	6
	150mm	63642567812	3

NORTON ICE™ STARTER KIT

DESCRIPTION	ART. NO.	QUANTITY
The Norton Ice Starter Kit is full selection of finishing & polishing products & accessories. An ideal introduction to the Ice range, the kit contains abrasive microfinishing discs, polishing compounds, foams, pads and a finishing spray to provide a taster of the high technology products Norton has to offer to achieve the perfect finish.	66254488515	1

VELKOOBCHOD BRUSIVA

TAPES

Norton Masking Tapes are designed to meet end user demands in many market sectors. All tapes in the range conform easily to contours, adhere to most surfaces and irregular shapes and are resistant to diverse temperatures.

Different product characteristics provide excellent results, saving time and increasing efficiency.

APPLICATIONS & MARKETS

- Industrial
- Building & Construction
- DIY
- Marine
- Automotive

BEST

GOLD TAPE

FEATURES	BENEFITS
Heat resistance (120°C/1hour)	Resistant to high temperature
Conforms to most surfaces	High bond strength
Excellent weather ability / 1-2 months outside durability	Good adhesion
Conformable as Fine Line Masking	Excellent workability
	No adhesive residue after 1-2 months
	Excellent masking line sharpness

Applications: Ideal for Marine, Car body repair, Architectural painting process

PREMIUM MASKING TAPE

FEATURES	BENEFITS
Semi Crepe paper for oven/dry bake painting cycles up to 100°C	Resistant to high temperature
Easy removal at 10°C	No adhesive residue
Conforms to contours, irregular shapes and surfaces	Good adhesion
Compatible with most common paints & lacquers	Removal without ripping

Applications: Car body repair, Lacquering applications

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BETTER

MEDIUM MASKING TAPE

FEATURES	BENEFITS
■ Support oven/dry cycles when temperature does not exceed 80°C ■ Easy removal at 10°C ■ Conforms to contours, irregular surfaces and shapes ■ Compatible with most common paints & lacquers	■ Resistance to high temperature ■ No adhesive residue ■ Good adhesion ■ Removal without ripping

Applications: Car body repair, Painting and decorating

GOOD

GENERAL PURPOSE MASKING TAPE

FEATURES	BENEFITS
■ Optimum product performance up to 60°C ■ Compatible with most common paints	■ Ideal for paint masking ■ Removal without ripping

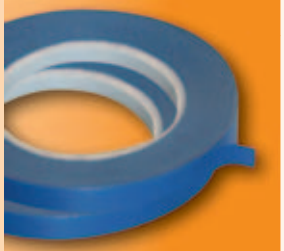
Applications: Interior decoration, Professional painters

BEST

FINE LINE TAPE

FEATURES	BENEFITS
■ Used where there is resistance flakes ■ Conforms to contours, irregular shapes and surfaces ■ Performs in temperatures of up to 150°C for approx 30 minutes ■ Easy to use ■ One thickness for all	■ Follows lines without wrinkling or tearing ■ Leaves a sharp, clean separation line ■ No adhesion residue ■ Longer lasting ■ Minimum build up ■ Longer rolls compared to competitor products (55m)

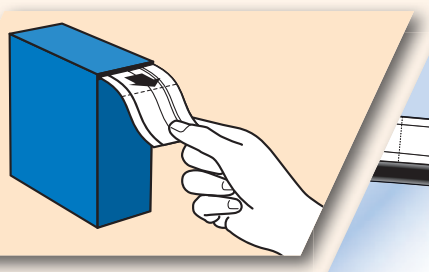
Applications: Delicate paint work

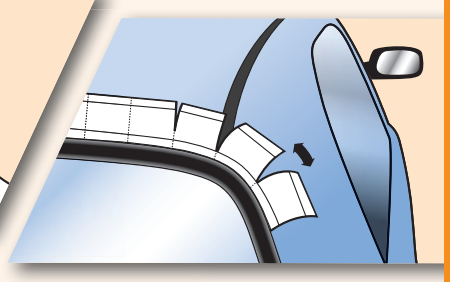


PREMIUM PERFORATED TRIM TAPE

FEATURES	BENEFITS
■ Flexible, follows contours and curves ■ Thicker plastic strip fitting all types of rubber trims ■ Pre –perforated	■ High quality adhesive ■ No adhesive residue ■ No scissors needed ■ Individually packed ■ No paper lines to remove

Applications: Rubber trims during spraying, Body side moulding during spraying





VELKOOBCHOD BRUSIVA

TAPES

BEST

FOAM TAPE PREMIUM

FEATURES	BENEFITS
■ One continuous length ■ Recessed adhesive, no paint edge & no rubbing down ■ Dimensions: 20mm x 50m	■ One size fits all ■ More absorbent ■ Quick and easy protection of painted edges

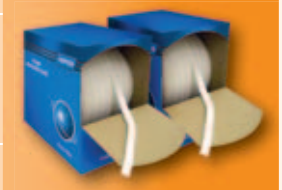
Applications: Car body repair, preparation before spraying, All car door openings

BETTER

FOAM TAPE STANDARD

FEATURES	BENEFITS
■ Recessed adhesive, no paint edge & no rubbing down ■ Dimensions: 13mm x 50m, 19mm x 50m	■ Quick and easy protection of painted edges

Applications: Car body repair, preparation before spraying, All car door openings



DOUBLE SIDED TAPE

FEATURES	BENEFITS
■ Fits all types of covering	■ Conforms to most surfaces ■ High tack

Applications: Polyester cloth for floor covering

DOUBLE SIDED FOAM TAPE

FEATURES	BENEFITS
■ High density foam coated with high strength acrylic ■ Bonds medium to large mouldings and accessories	■ Instant pressure sensitive bonding ■ Does not absorb moisture ■ Superior adhesion to plastics, metal, glass and paint ■ Remains flexible at low/high temperature ■ Conforms to irregular surfaces

Applications: Car body repair

ALUMINIUM TAPE

FEATURES	BENEFITS
■ Aluminium	■ Protect sensitive surfaces against heat and infrared ■ Ideal to reinforce surfaces before applications of structural adhesive ■ Resistant to UV, weather and humidity

Applications: Automotive, general industrial, general maintenance

VELKOOBCHOD BRUSIVA

GOOD

CLOTH TAPE

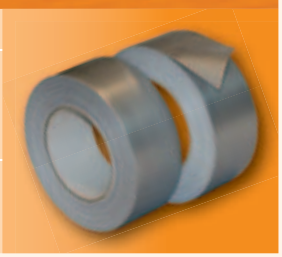
FEATURES

- Very high adhesion
- Water and heat resistant
- Individually packed

BENEFITS

- Excellent immediate adhesion
- Edge protection and wrapping

Applications: Multi-purpose industrial applications



MASKING TAPE

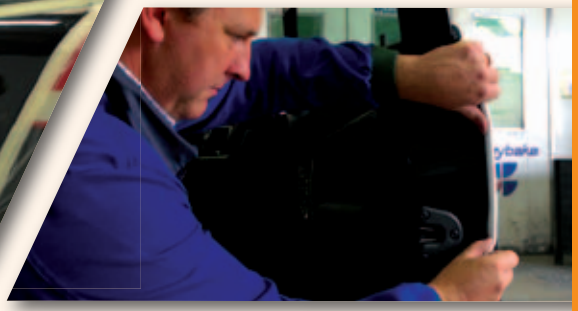
DIM WxL	PK QTY	NEW! BEST GOLD TAPE	BEST PREMIUM QUALITY	BETTER MEDIUM QUALITY	GOOD GENERAL PURPOSE
19mmx50M	24	662610**67434**			
	48		699573**94601**	699573**94605**	
25mmx50M	36	662544**90982**	699573**94602**	699573**94609**	699573**94619**
38mmx50M	12	662610**67435**			
	24		699573**94603**	699573**94611**	699573**94623**
50mmx50M	18	662544**90986**			
	24		699573**94604**	699573**94614**	699573**94631**

FINE LINE TAPE

DIM WxL	PK QTY	BEST
3mmx55M	10	662611**94993**
6mmx55M	10	662611**94994**
9mmx55M	10	662611**94995**
12mmx55M	10	662611**94996**
19mmx55M	10	662611**94997**

PREMIUM PERFORATED TRIM TAPE

DIM WxL	PK QTY	BEST
50mmx10M	10	662611**94743**



Dimensions Key: DIM = Dimensions, W = Width, L = Length

TAPES

FOAM TAPE

DIM WxL	PK QTY	BEST PREMIUM	BETTER STANDARD
13mmx50M	1		662544**70735**
19mmx35M	1		662544**70744**
20mmx50M	1	662544**70746**	

SPEC CHECK

Thanks to its new features, the premium foam tape will ensure perfect jo

- Highly absorbent to avoid any leaking runs of paint.
- Flat and unique size to fit all gap adjustements and to allow to fix having the adhesive hidden.
- Consequently, when removed after spraying, there will be no defect and no need to rework upon removal.

DOUBLE SIDED TAPE

DIM WxL	PK QTY	BETTER
50mmx50M	24	662611**96541**

DOUBLE SIDED FOAM TAPE

DIM WxL	PK QTY	BETTER
6mmx18M	12	636425**05620**
12mmx18M	12	636425**05621**
22mmx18M	12	636425**05622**

ALUMINIUM TAPE

DIM WxL	PK QTY	BETTER
50mmx50M	24	07660**717719**

GENERAL PURPOSE CLOTH TAPE

DIM WxL	PK QTY	COLOUR	GOOD
50mmx50M	24	Grey	07660**717720**

Dimensions Key: DIM = Dimensions, W = Width, L = Length

NORTON
SAINT-GOBAIN

494 INTRODUCTION

496 RESPIRATORY MASKS

500 SINGLE USE GLOVES

502 GLASSES

504 OVERALL

Jimi
VELKOOBCHOD BRUSIVA

Personal Protection Equipment

INTRODUCTION

NORTON: IMPROVING SAFETY STANDARDS

From Norton, the world's leading abrasive brand, comes a new range of personal protection equipment designed to provide the highest standard of protection in the workplace. Through understanding our customers needs and requirements for a safer working environment, we are able to deliver a valuable, effective solution for applications in multiple industries.

SAFETY AND QUALITY IS OUR PRIORITY

All products in the range adhere to the most stringent European directives and regulations. Our responsibility to our customers, particularly in the area of safety and comfort is taken very seriously. Products are designed and produced to the most rigorous quality standards to guarantee optimum personal safety and user comfort. In addition, Norton prides itself on having an environmentally friendly approach to caring for the environment, which is a fundamental part of corporate Saint-Gobain culture.

AN OVERVIEW OF THE RANGE

The range comprises a selection of Respiratory Masks with filters providing varying levels of protection against chemicals, as well as Glasses, Gloves and Overalls.

VELKOOBCHOD BRUSIVA

STANDARD SAFETY REGULATIONS

Protection against major hazards: Respiratory protective devices are PPE Class 3

- The hazard may be serious, irreversible or fatal.
- The design is complex as defined by the directive.
- Certification is provided by an approved body with a CE-type examination combined with a quality control system for production.
- Marking is regulated, with additional markings according to the standard in force at the time of the product's certification.

NORTON UPHOLDS THE FOLLOWING EUROPEAN DIRECTIVES FOR RESPIRATORY MASKS:

- **Directive 89/656/CEE of 30 November 1989: on the use of PPE by workers. It stipulates the employers' obligations.**
- The PPE required for work must be provided free of charge.
- PPE must comply with the legal provisions in force.
- The employer must have, at its disposal, the information needed for proper use of the product.
- The rules and conditions of use must be defined.
- The user must be informed, and training provided.
- **Directive 89/686/CEE of 21 December 1989: on the design, market entry, free circulation of PPE within the European Union. This Directive has evolved and been modified by 95/58/CEE.**
- The essential requirements to be met by PPE in order to be put on the European market
- The specific texts provide a classification with regard to hazards.

The standards can evolve according to the needs of the market, technological developments and modifications linked to proved effectiveness.

SINGLE USE RESPIRATORS AND DUAL CARTRIDGE RESPIRATOR MASK

DISPOSABLE MASK		SEMI DISPOSABLE MASK	
EN149	Filtering half-masks (single use) for protection against particulates. There are three protection classes: FFP1, FFP2, FFP3.	**EN405**	Filtering half-masks with valves for protection against gases or against gases and particulates.

GASES - VAPOURS: FOR EACH TYPE OF CONTAMINANT THERE IS A DEDICATED FILTER

A	Gases and organic vapours, including bolling points above 65°C e.g.: Solvents, hydrocarbons, etc.
AX	Gases and organic vapours, including bolling points below 65°C.
P	Particulates, dust.

STANDARDS AND LEGISLATION FOR GLASSES:

Directive 89/686/EEC (Design) describes the essential requirements to be met in order to sell protective glasses on the European market.
PPE from the European Union must bear a marking testifying to its compliance with **Directive 89/686/EEC**. All our glasses complies with **Directive 89/686/EEC** and **EN 166** which describes "Technical Performance standards". Our premium glasses complies with the **EN 175** which describes "equipment for eye and face protection during welding and allied process".
The "CE" marking appears on the smallest packaging unit.

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RESPIRATORY MASKS

All Norton respiratory masks offer state of the art design, protection and comfort. The Dual Cartridge mask offers improved vision, adjustable head straps, and a form guard to maintain mask shape and cleanliness. All Norton masks protect against dust and potentially harmful gasses found in the automotive refinish, marine, aerospace, metal work and wood work markets.

DUAL CARTRIDGE RESPIRATOR MASK - MODEL 2016

FEATURES	BENEFITS
■ Soft, non-allergenic material	■ Smooth and comfortable on the face
■ Patented hygienic form guard	■ Maintain shape and cleanliness after use
■ Low profile cartridge	■ Improved vision
■ Cradle suspension and adjustable head straps	■ Proper and comfortable fit

DUAL CARTRIDGE RESPIRATOR MASK - MODEL 2016

MEASUREMENTS		PRODUCT DESCRIPTION	PROTECTION LEVEL	QTY PER BOX	SELLING UNIT	ART. NO.
MASK (mm)	ELASTIC LxTxW(mm)					
Inferior part Width 112 Height 134	605x1,5x12	Dual Cartridge Respirator Mask	A2P2	12	12	662544**82016**

EN405:2001+A1:2009

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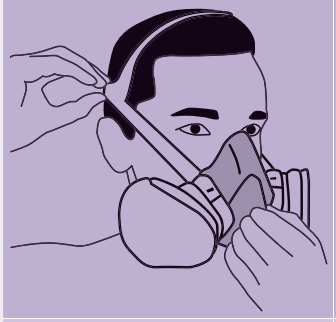
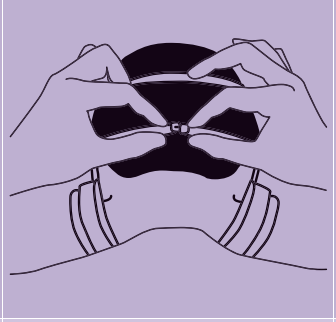
USAGE ADVICE

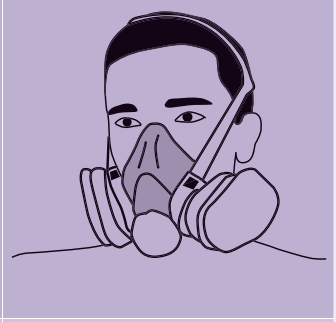


Place the respirator over the mouth and nose, then pull the head harness over the crown of the head.



Attach the bottom straps behind the neck.

Tighten top strap by pulling on ends to obtain a secure and comfortable fit.
Tighten bottom straps by pulling on ends or loosen by pushing out on buckle tab.



Check respirators each time you enter a contaminated area.

PARTICULATE FILTER PAD REPLACEMENT - MODEL 2017

Use with the Dual Cartridge Respirator mask to protect against dust and gases. Filter replacement pads are low maintenance and can be frequently replaced to prevent replacing the mask itself.

FEATURES & BENEFITS

- For use with the half-mask to protect against dust and gases
- Reduces the wear and frequency of replacing the mask itself

PARTICULATE FILTER PAD REPLACEMENT - MODEL 2017

PRODUCT DESCRIPTION	PROTECTION LEVEL	QTY PER BOX	SELLING UNIT	ART. NO.
Particulate filter pad replacement for dual cartridge respirator mask	P2	12	12	662544**82017**

EN405:2001+A1:2009

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RESPIRATORY MASKS

RESPIRATORY MASK WITH VALVE - MODEL 2020

Single use protection mask FFP2D SL, protects against low toxicity solid and liquid aerosols in concentrations of up to 12x0EL. Protects against calcium carbonate, ferrous metal, hardwood, glass fibres, plastic, quartz, copper and aluminium. Not for use where oxygen concentration is less than 17% vol.

FEATURES	BENEFITS
■ Expiration valve	■ Allows easier breathing
■ Disposable	■ Maximum protection every time
■ Polypropylene filter media	■ High filtration efficiency
■ Wire moulding	■ Shapes to the form of the nose

RESPIRATORY MASK WITH VALVE - MODEL 2020

MEASUREMENTS				PRODUCT DESCRIPTION	PROTECTION LEVEL	QTY PER BOX	SELLING UNIT	ART. NO.
MASK (mm)	NOSE PIECE LxWxT (mm)	VALVE DxH(mm)	ELASTIC LxTxW (mm)					
Inferior part Width 85 Superior part Width 200 Height 87	90x9x0,5	41x11	560x0,7x6	Respiratory Mask with valve	FFP2	20	20	662544**82020**
								EN149:2001+A1:2009

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RESPIRATORY MASK - MODEL 2019

Single use protection mask FFP2D SL, protects against low toxicity solid and liquid aerosols in concentrations of up to 12xOEL. Protects against calcium carbonate, ferrous metal, hardwood, glass fibres, plastic, quartz, copper and aluminium. Not for use where oxygen concentration is less than 17% vol.

FEATURES	BENEFITS
■ Disposable	■ Maximum protection every time
■ Polypropylene filter media	■ High filtration efficiency
■ Wire moulding	■ Shapes to the form of the nose

RESPIRATORY MASK - MODEL 2019

MEASUREMENTS			PRODUCT DESCRIPTION	PROTECTION LEVEL	QTY PER BOX	SELLING UNIT	ART. NO.
MASK (mm)	NOSE PIECE LxWxT(mm)	ELASTIC LxTxW(mm)					
Inferior part width 85 Superior part width 200 height 87	90x9x0,5	560x0,7x6	Respiratory Mask	FFP2	20	20	662544**82019**

EN149:2001+A1:2009

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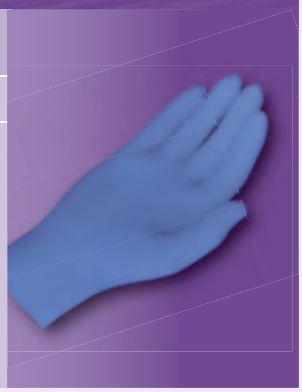
SINGLE USE GLOVES

Nitrile and latex gloves are designed for handling chemical and non-chemical compounds in the automotive refinish, marine, aerospace, metal work and wood work markets.

NON-STERILE NITRILE GLOVES - MODEL 2022

Disposable gloves, designed for handling chemical compounds, powder-free and resistant to disinfectants.



FEATURES	BENEFITS
■ Biocompatible	■ Prevents skin irritation
■ Ambidextrous shape	■ Quick, easy use
■ Latex free, synthetic nitrile rubber	■ Fits all hand sizes

NON-STERILE NITRILE GLOVES - MODEL 2022

PRODUCT DESCRIPTION	QTY PER BOX	SELLING UNIT	ART. NO.
Nitrile gloves for chemical compounds	100	100	662544**82022**

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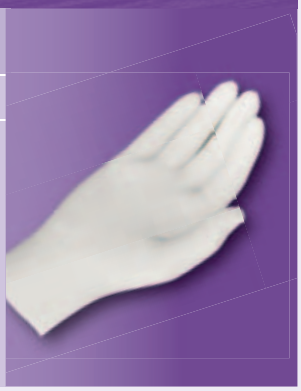
NON-STERILE LATEX GLOVES - MODEL 2023

Disposable gloves for handling non-chemical compounds, powder-free and resistant to disinfectants. Minimum protection level 50µg/g.



FEATURES	BENEFITS
■ Biocompatible	■ Prevents skin irritation
■ Ambidextrous shape	■ Quick, easy use
■ Latex free, synthetic nitrile rubber	■ Fits all hand sizes

NON-STERILE LATEX GLOVES - MODEL 2023

PRODUCT DESCRIPTION	QTY PER BOX	SELLING UNIT	ART. NO.
Latex gloves for non-chemical compounds	100	100	662544**82023**

CERTIFICATIONS

- Certification ISO 9001:2000 + ISO 13485:2003
- Conformity to technical standards EN 455-1 (pinholes detection) + EN 455-2 (physical properties) + EN 455-3 (biological evaluation) + Pr EN 455-4 (shelf life determination)
- Mark according to European Directive 93/42/EEC

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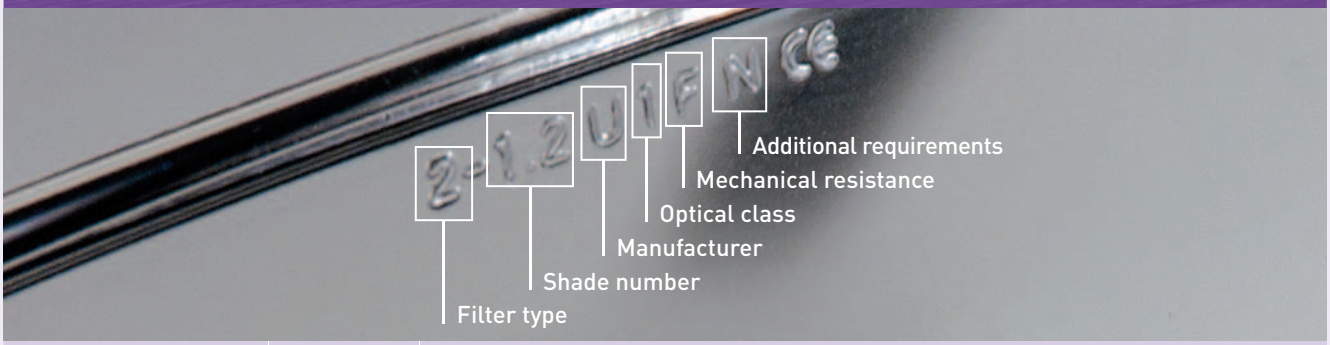
GLASSES

Providing eye protection for metal, welding, cutting, grinding and sanding applications. Adjustable hinges on the Premium glasses allow for comfortable use with respiratory masks.

LENS MARKING GUIDE



Filter type	2	Code N°: Indicates the type of filter 2 & 3 = UV
	C	Enhanced color recognition for lenses category 2 or 4
Shade number	1.2	Indicates the shade of the lens (between 1.2 & 8 for spectacles & goggles)
Manufacturer	U	Identification of the manufacturer
Optical class	1	Optical class (1 = permanent wear, 3 = occasional wear)
Mechanical Resistance	F	Symbol for mechanical strength (F for low impact)
	T	Symbol for resistance to high speed particles at extremes of temperature (-5°C & +55°C) follows impact grade
Additional Requirements	K	K Symbol for resistance to surface damage by fine particles
	N	Symbol for resistance to fogging of lenses

FRAME MARKING GUIDE

Manufacturer	U	Identification of the manufacturer
Optical class	EN 166	Optical class (1 = permanent wear, 3 = occasional wear)
Mechanical Resistance	F	Symbol for mechanical strength (F for high speed particles, low energy)
	T	Symbol for resistance to high speed particles at extremes of temperature (-5°C & +55°C) follows impact grade

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SAFETY GLASSES: PREMIUM - MODEL 2024

FEATURES & BENEFITS

- Ideal eye protection during welding and metal applications
- Frame Marking
- Lens Marking
- Adjustable hinges for comfortable fit

SAFETY GLASSES: PREMIUM - MODEL 2024

PRODUCT DESCRIPTION	QTY PER BAG	SELLING UNIT	ART. NO.
Premium Glasses	1	10	662544**82024**
			EN 175

SAFETY GLASSES: STANDARD - MODEL 2025

FEATURES & BENEFITS

- For general purpose applications
- Frame Marking
- Lens Marking

SAFETY GLASSES: STANDARD - MODEL 2025

PRODUCT DESCRIPTION	QTY PER BAG	SELLING UNIT	ART. NO.
Standard Glasses	1	10	662544**82025**
			EN 166

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OVERALL

Protect clothes from paint, dust and damage with Norton overalls. Overalls are washable and reusable and available in medium, large and extra large sizes.

PAINTING OVERALL

FEATURES & BENEFITS

- Polyester material
- Anti-static
- Breathable
- Washable and reusable
- Available in sizes medium, large and extra large

PAINTING OVERALL

MODEL	PRODUCT DESCRIPTION	QTY PER BOX	ART. NO.
8976	Painting Overall - size M	10	662544**28976**
8977	Painting Overall - size L	10	662544**28977**
8978	Painting Overall - size XL	10	662544**28978**

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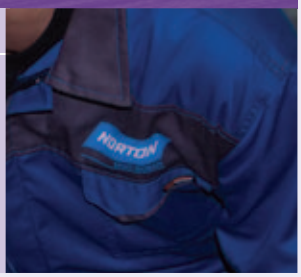
BODY SHOP OVERALL

FEATURES & BENEFITS

- Polycotton material
- Breathable
- Washable and reusable
- Available in sizes medium, large and extra large



BODY SHOP OVERALL

MODEL	PRODUCT DESCRIPTION	QTY PER BOX	ART. NO.
8314	Body shop Overall - size M	5	07660**18314**
8315	Body shop Overall - size L	5	07660**18315**
8316	Body shop Overall - size XL	5	07660**18316**

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NOTES

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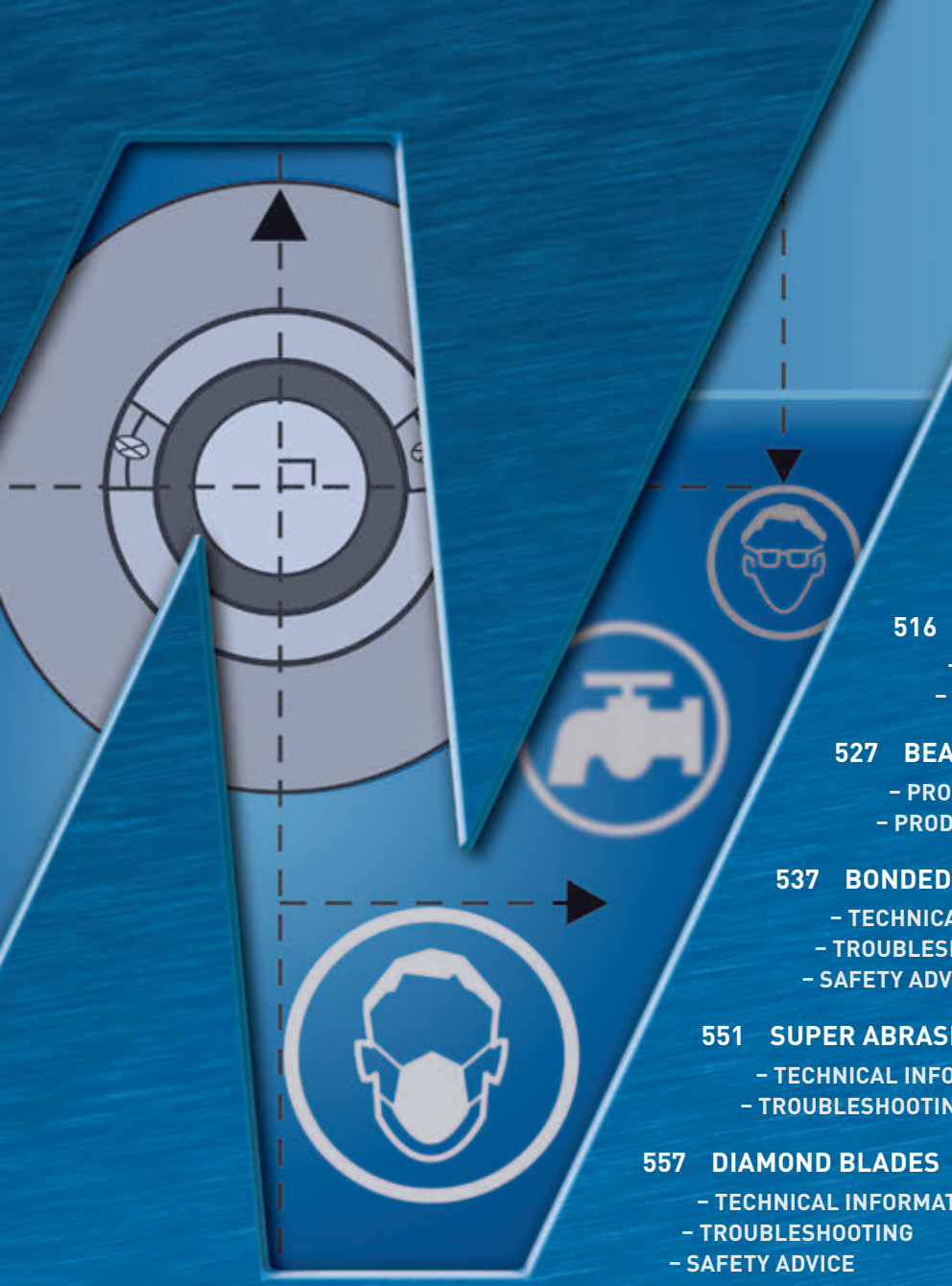

NORTON
SAINT-GOBAIN

508 CUTTING-OFF & GRINDING WHEELS
- TECHNICAL INFORMATION
- TROUBLESHOOTING
- SAFETY ADVICE

516 COATED ABRASIVES
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527 BEARTEX®
- PRODUCT SELECTION - BY MACHINE
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557 DIAMOND BLADES
- TECHNICAL INFORMATION
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- SAFETY ADVICE

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Technical Information

TECHNICAL INFORMATION

SHAPE SPECIFICATION SYSTEM

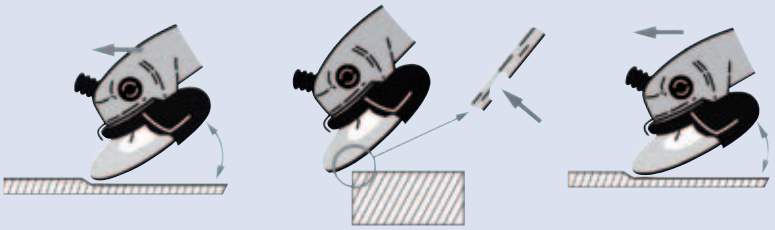
BF 27	BF 29	BF 41	BF 42
Depressed centre grinding wheels. Available in diameters 76-230mm for hand-held machines	Depressed centre grinding wheels. Available in diameters 115mm & 125mm for hand-held machines	Flat cutting-off wheels. Available in diameters 40-400mm for hand-held machines & 250-400mm for stationery machines	Depressed centre cutting-off wheels. Available in diameters 76-230mm for hand-held machines
Application: grinding	Application: grinding	Application: cutting-off	Application: cutting-off

RECOMMENDED PRACTICE

PORTABLE GRINDERS

GRINDING Rough Work

- Do not use a cutting-off wheel for snagging
- Do not work with the side of a wheel, you will cut the reinforcing cloths
- Work at an angle of 10 to 30° with a longitudinal action

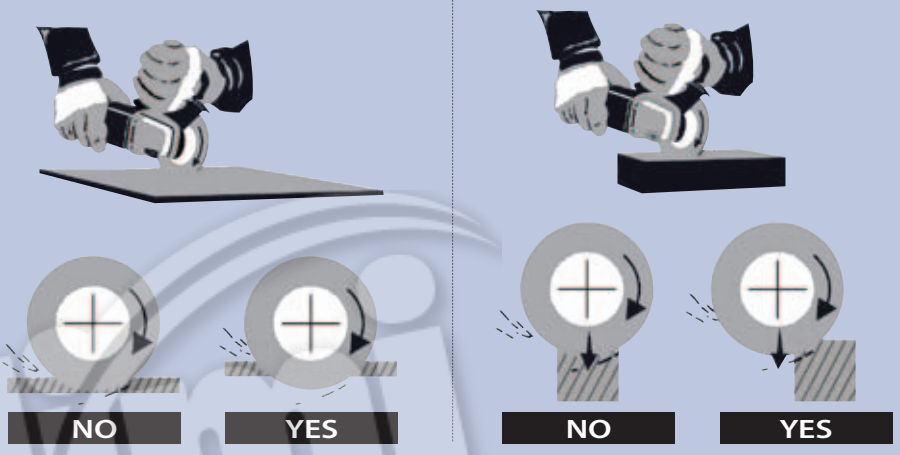


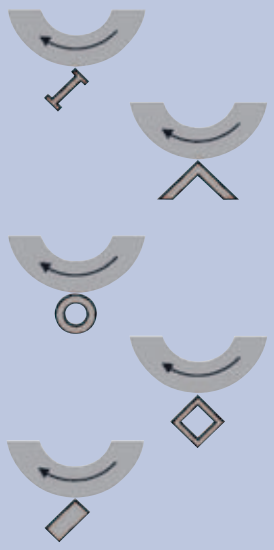
GRINDING Finishing Work

- Angle of work 15°
- Rotary action

CUTTING-OFF

- Arrange the workpiece so that a uniform section can be cut





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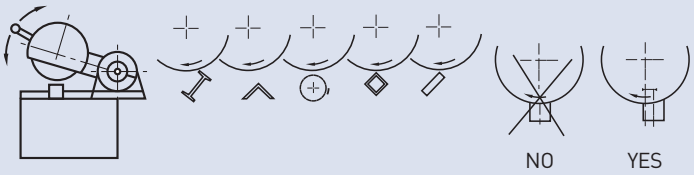
FIXED MACHINE

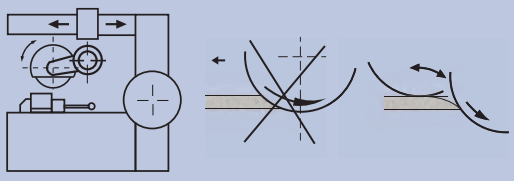
DOWNSTROKE HEADS

- Lay out the shape parts in order to have a constant section
- Avoid any wedging of the grinding wheel
- Make sure the wheel is cleared



AUTOMATIC FEED

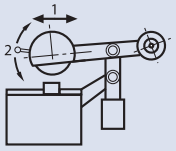
- In the case of thick parts, use the reciprocating motion of the carriage



OSCILLATING HEADS

OPERATING MODE
1 – Oscillating
2 – Cutting-off

- Do not use this type of machine with a downstroke action



METAL RING WITH VALIDITY DATE

V = VALIDITY DATE (PRODUCTION QUARTER + 3 YEAR)

V01	V04	V07	V10
1st quarter	2nd quarter	3rd quarter	4th quarter

Example:
V04/2014 indicates production in the 2nd quarter of 2011 and advised usage before the 2nd quarter of 2014

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PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

Mouth Protection

Wear Gloves

Eye Protection

Ear Protection

Read Instructions

Damaged Wheel – Do not use

Dry

Wet

GENERAL PRECAUTIONS

Safety instructions provided by the machine manufacturers must be followed. Where fitted, all guards, covers and hoods must be in place on the machine during grinding, and should not be modified in any way. Abrasives should not be used near inflammable material or in an environment where there is a risk of explosion.

Sparks should be directed away from the face and body, if possible towards the floor. Dust extraction equipment must be used whenever it is available. The instructions for use given by the abrasive manufacturer must be followed e.g. 'Not to be used without a support', or 'Not to be used for wet grinding'. The workpiece must be firmly fixed before grinding starts. Check all abrasives visually before use and make certain that the product is suitable for the application. No modifications should be made to abrasive products after delivery.

When using a portable grinder always switch it off and allow the spindle to stop completely before putting the tool down. Wet grinding should only be carried out on machines designed for this purpose and with abrasives designated as suitable for this type of operation.

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OPERATING SPEEDS

Norton products are designed and tested for certain applications and operating speeds. Choose a wheel suitable for the application material. Suitable materials are indicated on the wheel label. Before mounting the grinding or cutting-off wheel on the machine, ensure that the operating speed of the machine does not exceed the maximum operating speed as it is marked on the product.

WHEEL DIAMETER (mm)	SPEED CONVERSION FOLLOWING EN 12413								
	MAXIMUM OPERATING SPEED (RPM)								
	35	40	50	63	80	100	125	140	160
6	112000	128000	160000	201000					
8	84000	95500	120000	150500	191000				
10	67000	76500	95500	120500	153000	191000			
13	51500	58800	73500	92600	118000	147000	184000	206000	
16	41800	47800	59700	75200	95500	120000	150000	168000	191000
20	33500	38200	47800	60200	76500	95500	120000	134000	153000
25	26800	30600	38200	48200	61200	76500	95500	107000	123000
32	20900	23900	30000	37600	48000	60000	75000	84000	95500
40	16750	19100	23900	30100	38200	47200	59700	67000	76500
50/51	13400	15300	19100	24100	30600	38200	47750	53500	61200
63/65	10650	12150	15200	19100	24300	30250	37900	42500	48500
76	8800	10100	12600	15850	20150	25150	31450	35200	40250
80	8400	9550	12000	15100	19100	23900	29850	33500	38200
85	7900	9000	11250	14200	18000	22500	28100	31500	36000
100/102	6700	7650	9550	12100	15300	19100	23900	26800	30600
115	5850	6650	8350	10500	13300	16650	20800	23250	26600
125	5350	6150	7650	9650	12250	15300	19100	21400	24500
150/152	4500	5100	6400	8050	10200	12700	16000	17850	20400
180	3750	4250	5350	6700	8500	10650	13300	14900	17000
200	3350	3850	4800	6050	7650	9550	11950	13400	15300
230	2950	3350	4200	5250	6650	8350	10400	11650	13300
250/254	2700	3100	3850	4850	6150	7650	9550	10700	12250
300/305	2250	2550	3200	4050	5100	6400	8000	8950	10200
350/356	1950	2200	2750	3450	4400	5500	6850	7650	8750
400/406	1700	1950	2400	3050	3850	4800	6000	6700	7650
450/457	1500	1700	2150	2700	3400	4250	5350	5950	6800
500/508	1350	1550	1950	2450	3100	3850	4800	5350	6150
600/610	1150	1300	1600	2050	2550	3200	4000	4500	5100
750/762	895	1050	1300	1650	2050	2550	3200	3600	4100
800/813	840	960	1200	1550	1950	2400	3000	3350	3850
900/914	750	850	1100	1350	1700	2150	2700	3000	3400
1000/1020	670	765	960	1250	1550	1950	2400	2700	3100

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TROUBLESHOOTING

CUTTING-OFF WHEELS

WHEEL DOES NOT CUT	
Cause	In case of blue cutting: wheel too hard or too thick
Solution	Use softer or Norton Thin Cut wheels, check peripheral speed
Cause	Peripheral speed too low
Solution	Increase rpm up to max. (80m/sec)
EXCESSIVE WEAR	
Cause	In case of white cutting edge: wheel too soft
Solution	Use harder wheel
Cause	Operating speed too low
Solution	Increase rpm up to max (80m/sec)
Cause	Decrease of rpm during cutting
Solution	Use machine with more power, reduce pressure on the machine
CRUMBLED WHEEL EDGE	
Cause	Cutting-off wheel used for grinding operations
Solution	Use a grinding wheel for grinding operations
Cause	Workpiece is moving
Solution	Clamp the workpiece properly
Cause	Too much side-pressure
Solution	Add only the radial pressure to the wheel
ARBOR HOLE OR CENTRE BREAK OUT	
Cause	Wheel sticks in the workpiece/material
Solution	Use more radial pressure & swing the wheel forwards and backwards
Cause	Cutting-off wheel used for grinding operations
Solution	Use a grinding wheel for grinding operations
Cause	Too much side pressure
Solution	Add only the radial pressure to the wheel
Cause	Different diameter top/bottom flange
Solution	Use flanges with the same diameter

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GRINDING WHEELS

WHEEL DOES NOT CUT

Cause	Wheel too hard, wheelglazing
Solution	Use softer wheel
Cause	Not enough pressure
Solution	Increase pressure
Cause	Machine power too low
Solution	Use machine with more power
Cause	Loading & wheelglazing (non-ferrous)
Solution	Use Norton Alu wheels which counteract loading & wheelglazing

EXCESSIVE WHEELWEAR

Cause	Wheel too soft
Solution	Use harder wheel
Cause	Too much pressure
Solution	Reduce pressure, let the wheel do the grinding
Cause	Decrease of peripheral speed
Solution	Use machine with more power, reduce pressure on the machine
Cause	Too low peripheral speed
Solution	Max. 80m/sec is optimum speed

CRUMBLED WHEEL EDGE

Cause	Grinding angle too flat
Solution	Change angle to 30 - 40°
Cause	Workpiece is moving
Solution	Clamp the workpiece properly
Cause	Too much pressure
Solution	Reduce pressure, let the wheel do the grinding

CRACKS ON THE BOTTOM OF THE WHEEL

Cause	Contact area too large
Solution	Reduce contact area
Cause	Too much pressure
Solution	Reduce pressure, let the wheel do the grinding

UNBALANCE

Cause	Dirty flanges
Solution	Clean flanges
Cause	Wheel mounting insecure
Solution	Tighten flanges
Cause	Flanges with different diameter
Solution	Replace flanges

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SAFETY ADVICE

DOs

✓	**DO** Always handle & store wheels carefully. Cutting-off wheels should be stacked horizontally & flat, preferably on a steel base plate. Depressed centre wheels should be placed on top of each other or stored in the original packaging
✓	**DO** Always visually inspect all wheels before mounting for possible damage in transit
✓	**DO** Always use a safety guard & ensure that it is correctly positioned & securely fitted. It should cover at least one half of the wheel & protect the operator in the unlikely event of a wheel breakage. NON-REINFORCED CUTTING-OFF WHEELS SHOULD ONLY BE USED ON FIXED MACHINES & SHOULD BE CORRECTLY GUARDED.
✓	**DO** Always switch 'OFF' the power at supply source &/or remove the plug from the socket before changing the wheel
✓	**DO** Always ensure that the spindle speed of the machine does not exceed the operating speed marked on the wheel
✓	**DO** Always use the correct wheel mounting flanges & ensure that they are undamaged, clean & free from burrs
✓	**DO** SEE EN 12413
✓	**DO** Allow newly mounted wheels to run at operating speed, with the guard in place, for a reasonable time before cutting or grinding
✓	**DO** Always wear EYE PROTECTION
✓	**DO** Always wear appropriate safety clothing such as DUST MASK, GLOVES, EAR PROTECTION, OVERALLS & SAFETY SHOES
✓	**DO** Always have machine speeds checked regularly, especially after maintenance or repair. Machines fitted with speed control devices (Governors), must be properly maintained at all times
✓	**DO** Check tension of driving belts, where fitted, on a regular basis. Belts must be kept tight to ensure full power transmission.
✓	**DO** Always secure the workpiece firmly while it is being cut or ground
✓	**DO** Put portable machines in suitable cradles, when not being used, to avoid damage to the wheel
✓	**DO** Always use a portable machine in a comfortable position, where the workpiece is well balanced & the machine is well supported
✓	**DO** Grind at an angle above 30 degrees to the workpiece with a depressed centre grinding wheel
✓	**DO** Keep the working area around cutting & grinding operations clear. It is very dangerous if an operator trips & falls with an operating machine in his hands

VELKOOBCHOD BRUSIVA

DON'Ts

✗	**DON'T** Handle wheels roughly
✗	**DON'T** Use non-reinforced cutting-off wheels on portable machines
✗	**DON'T** Store wheels in a damp atmosphere or in extreme temperatures
✗	**DON'T** Mount a damaged wheel
✗	**DON'T** Tighten the mounting nut or locking flange excessively. To do so can distort the flanges
✗	**DON'T** Force a wheel onto a machine spindle
✗	**DON'T** Use mounting flanges which are incorrect, damaged, dirty or burred
✗	**DON'T** Use blotters with depressed centre wheels less than or equal to 406mm (EN 12413)
✗	**DON'T** Use a machine which is not in good mechanical condition
✗	**DON'T** Use a machine without a wheel guard
✗	**DON'T** Use wheels without proper ventilation or dust protection equipment
✗	**DON'T** Apply side pressure to cutting-off wheels. You should not bend the wheel
✗	**DON'T** Stop the wheel by applying pressure to the periphery or face. Always switch the machine off & allow the wheel to stop revolving
✗	**DON'T** Allow the wheel to be trapped or pinched in the cut
✗	**DON'T** Apply excessive pressure onto the wheel so that the driving motor slows down
✗	**DON'T** Grind on the side of cutting-off wheels or depressed centre wheels below 4,0mm thickness
✗	**DON'T** Drop or lower a portable machine by the cable or airline onto the floor. A wheel can be easily cracked, if it is put down hard, by the weight of the machine. This is a common cause of wheel breakage
✗	**DON'T** Grind with a depressed centre grinding wheel at an angle below 30 degrees to the workpiece
✗	**DON'T** Use a machine in a position where you do not have full control of the machine & you are not well balanced

VELKOOBCHOD BRUSIVA

TECHNICAL INFORMATION

WHAT IS A COATED ABRASIVE?

Modern coated abrasives are the product of an extremely technical process developed through many years of research and development. They remain, however, a product composed of three basic elements: a flexible or semi-rigid backing to which abrasive grains are bonded by an adhesive.

ABRASIVE TYPES

The ideal abrasive grain offers maximum resistance to point wear, yet fractures before serious dulling occurs, thereby satisfying both stock removal and finishing requirements.

SYNTHETIC ABRASIVES

- Aluminium oxide is tough and well adapted to grinding high tensile materials, such as carbon steel, alloy steels, tough bronze and hard woods. Wherever toughness (ability to resist fracturing) is the main consideration, aluminium oxide out performs all other coated abrasive grains
- Silicon carbide is the hardest and sharpest of the minerals used in coated abrasives. Its hardness and sharpness make it the ideal abrasive for sanding non-ferrous metals (aluminium, brass, bronze, magnesium, titanium, etc.), rubber, glass, plastics, fibrous woods, enamel and other relatively soft materials. Silicon carbide is superior to any other abrasive in its ability to penetrate and cut faster under light pressure
- Zirconia alumina has a unique self-sharpening characteristic which gives it long life on rugged stock removal operations. Zirconia alumina is well suited for heavy grinding of metals and planing of wood, because the controlled fracturing of the grain continuously produces sharp, new abrading points
- Ceramic aluminium oxide is a long-lasting, tough, dense abrasive due to its micro structure. The extremely small micron size particles break off during grinding, producing multiple new cutting edges. As it stays sharp, especially when used in medium and high pressure operations, it cuts at a higher rate than other abrasives. Recommended for use on forged and carbon steels, high nickel and cobalt alloys

NATURAL ABRASIVES

- Emery is a natural composite of corundum and iron oxide. The particles are blocky in shape and tend to cut slowly, thereby producing a polishing action on the material being abraded. Used for general maintenance and polishing of metals and in very fine grits for highly technical polishing, such as preparing metallurgical specimens requiring very close tolerances. Emery products are black in colour

ABRASIVE GRAIN DISTRIBUTION

There are two types of abrasive grain coverage on the backing:

- Openly spaced distribution where between 30% and 60% of the backing is covered leaving large spaces between each abrasive grain. It is used in operations where the grinding swarf would otherwise 'load' or clog the surface, reducing cutting efficiency and shortening the coated abrasive life
- Closely packed grain distribution is where the grain completely covers the backing. The greater number of abrading points in a given area leads to faster stock removal. It is recommended where loading is not a problem and where smoother surface finishes are desired

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ABRASIVE GRAIN SIZE

After the crude abrasives have been crushed, the grains are separated (graded) into standard particle sizes using screens carefully made from silk threads of exact size and number per square inch to ensure extreme accuracy. The grit number (mesh number) appearing on the coated abrasive backing represents the number of openings per linear inch in the final screen. Grits 240 and finer, called flours, are graded by hydraulic separators, air classifiers and levigating tanks.

The European standard of grit sizes is the FEPA grading system. All FEPA grit sizes are preceded with the letter 'P', i.e. P180 etc.

In the USA a different grading system called CAMI is used. This chart provides a comparison between FEPA and CAMI grades and also shows average particle sizes in microns and inches.

Additionally, some products produced for the woodworking and floor sanding markets are identified with a 'grit symbol'. Although use of this symbol is infrequent, the backing of these products contain both the mesh number and the grit symbol.

PARTICLE SIZE IN INCHES	PARTICLE SIZE IN MICRON	ALUMINIUM OXIDE, GARNET, SILICON CARBIDE, ZIRCONIA ALUMINA			EMERY		GLASS PAPER
		GRADING SYSTEMS		COMP. GRIT SYMBOL	POLISHING PAPER	CLOTH	
		CAMI	FEPA				
,0000118	0,3	–	–	–	–	–	–
,0000197	0,5	–	–	–	–	–	–
,0000394	1,0	–	–	–	–	–	–
,0000787	2,0	–	–	–	–	–	–
,000118	3,0	–	–	–	–	–	–
,000158	4,0	–	–	–	–	–	–
,000197	5,0	–	–	–	–	–	–
,000236	6,0	–	–	–	–	–	–
,00026	6,5	1200	–	–	–	–	–
,00035	9,0	–	–	–	–	–	–
,00036	9,2	1000	–	–	–	–	–
,00047	12,0	–	–	–	–	–	–
,00048	12,2	800	–	–	4/0	–	–
,00059	15,0	–	–	–	–	–	–
,00060	15,3	–	P1200	–	–	–	–
,00062	16,0	600	–	–	3/0	–	–
,00071	18,3	–	P1000	–	–	–	–
,00077	19,7	500	–	–	2/0	–	–
,00079	20,0	–	–	–	–	–	–
,00085	21,8	–	P800	–	–	–	–
,00092	23,6	400	–	10/0	0	–	–
,00098	25,0	–	–	–	–	–	–
,00100	27,75	–	P600	–	–	–	–
,00112	28,8	360	–	–	–	–	–
,00118	30,0	–	–	–	–	–	–
,00118	30,2	–	P500	–	–	–	–
,00137	35,0	–	P400	–	–	–	–
,00140	36,0	320	–	9/0	–	–	–
,001575	40,0	–	–	–	–	–	–
,00158	40,5	–	P360	–	–	–	–
,00172	44,0	280	–	8/0	1	–	–
,00177	45,0	–	–	–	–	–	–
,00180	46,2	–	P320	–	–	–	–
,00197	50,0	–	–	–	–	–	–
,00204	52,5	–	P280	–	–	–	–
,00209	53,5	240	–	7/0	–	–	–
,00217	55,0	–	–	–	–	–	–

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ABRASIVE GRAIN SIZE (CONTINUED)

PARTICLE SIZE IN INCHES	PARTICLE SIZE IN MICRON	ALUMINIUM OXIDE, GARNET, SILICON CARBIDE, ZIRCONIA ALUMINA			EMERY		GLASS PAPER
		GRADING SYSTEMS		COMP. GRIT SYMBOL	POLISHING PAPER	CLOTH	
		CAMI	FEPA				
,00228	58,5	–	P240	–	–	–	–
,0023	60,0	–	–	–	–	–	–
,00254	60,5	–	P220	–	–	–	–
,00257	66,0	220	–	6/0	2	–	–
,00304	78,0	180	P180	5/0	3	–	00
,00363	93,0	150	–	4/0	–	Fine	–
,00378	97,0	–	P150	–	–	–	0
,00452	116,0	120	–	3/0	–	–	–
,00495	127,0	–	P120	–	–	–	1
,00550	141,0	100	–	2/0	–	Medium	–
,00608	156,0	–	P100	–	–	–	1 1/2
,00749	192,0	80	–	0	–	–	–
,00768	197,0	–	P80	–	–	–	F2
,01014	260,0	–	P60	–	–	–	M2
,01045	268,0	60	–	1/2	–	Coarse	–
,01271	326,0	–	P50	–	–	–	S2
,01369	351,0	50	–	1	–	–	–
,01601	412,0	–	P40	–	–	–	2 1/2
,01699	428,0	40	–	-1 1/2	–	–	–
,02044	524,0	–	P36	–	–	–	36
,02087	535,0	36	–	2	–	Extra coarse	–
,02426	622,2	–	P30	–	–	–	–
,02488	638,0	30	–	2 1/2	–	–	–
,02789	715,0	24	–	3	–	–	–
,02886	740,0	–	P24	–	–	–	–
,03530	905,0	20	–	3 1/2	–	–	–
,03838	984,0	–	P20	–	–	–	–
,05148	1320,0	16	–	4	–	–	–
,05164	1324,0	–	P16	–	–	–	–
,06880	1764,0	–	P12	–	–	–	–
,07184	1842,0	12	–	4 1/2	–	–	–

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NARROW BELTS & WIDE BELTS

The results achieved when sanding with belts depends on several factors including:

- The machine condition & available horsepower
- The belt speed
- The grinding pressure
- The contact wheel
- The choice of the belt in relation to the shape of the part & material type
- The use of coolant (when machine & belt allows)

BELT SPEED

The speed of the belt has a direct relationship with its cut rate, as well as the amount of heat generated, the surface finish achieved, and the stress on abrasive grain. Some abrasives like zirconia alumina and ceramic support much higher stresses because they have a better resistance to uncontrolled fracture. Some materials are more sensitive to heat generation. The chart below gives the recommended speed range according to material.

RECOMMENDED GRINDING BELT SPEED

Heat sensitive materials, plastics, etc.	5-15m/s	Stainless steel, high-speed steel & tool steel	20-30m/s
Sintered metals & carbides	8-15m/s	Grey cast iron & cast steel	30-40m/s
Titanium & similar alloys	8-15m/s	Carbon steel	30-40m/s
Glass, porcelain & special steel	8-15m/s	Brass, copper, zinc, bronze & tin	25-35m/s
Heat-resistant plastics	20-30m/s	Aluminium & light metal	20-35m/s
Wood	15-30m/s	Varnish	10-15m/s

GRINDING PRESSURE

The amount of grinding pressure depends on:

- The force used
- The size of the contact area between the belt & the workpiece
- The backing on which the belt runs (generally a contact wheel)

Higher pressure increases the cut rate and the amount of heat generated increases the stress on the individual abrasive grain (a minimum stress is necessary to achieve a controlled fracture of the abrasive grain), and generally generates a rougher finish.

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CONTACT WHEELS

Many machines use contact wheels as a backing for belts. Contact wheels are generally covered with rubber, polyurethane, steel, rubber foam, felt, or compressed canvas, and are classified from soft to hard, with or without serrations. Using a different type of contact wheel has a direct effect on the end results.

- Harder contact wheels provide a higher cut rate, a rougher surface finish & generate a much more uniform surface than softer contact wheels. They are used with stiff belts for a faster cut
- Softer contact wheels provide lower cut rates, a better surface finish & follow the contours of the part. They are generally used for finishing contoured parts or for generating slightly rounded surfaces. They are much less hard wearing on the belt & its joint

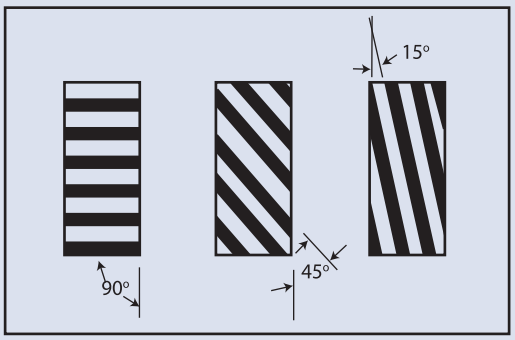
The design of the contact wheel will also have an effect on the contact area, which in turn affects grinding pressure.

- Contact wheels with a larger diameter act softer & should generally be used on larger surfaces
- Serrated contact wheels act harder but should generally be used on smaller surfaces

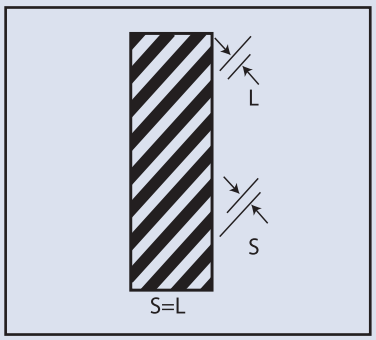
CONTACT WHEEL TYPES

HARD ← → SOFT

Aggressiveness increases as angle increases



Contact surface decreases as lands decrease giving a more aggressive, harder wheel



JOINT TYPES

Belts are made with a standard joint design best adapted to the product and its main application:

Butt joint with tape

Overlap joint with no topskive

Overlap joint with extra topskive

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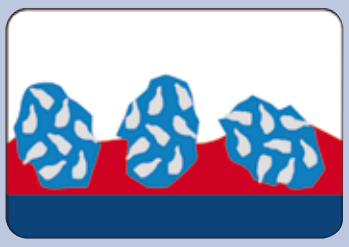
NORaX® AN INNOVATIVE TECHNOLOGY

NORaX® is the innovative coated abrasive technology from Norton. The innovation lies in the abrasive layer: a multi-layer coating of abrasive is engineered into a 3D pattern. These patterns give a controlled contact surface between the abrasive and part that optimises belt performance.

NORaX® works like a grinding wheel on a cloth backing. As the belt wears, dull abrasive particles are removed from the belt surface to expose a new layer of sharp abrasives. This continuous replacement of dulled abrasives results in longer life, higher cut rates, and a more consistent surface finish throughout the belt life. Also, contributing to this higher performance, NORaX® is also covered with a surface powder grinding aid that increases cut and life while decreasing grinding temperature.

Conventional
(Mono layer)



Aggregate
(Multi-layer, non-uniform contact area)

Engineered abrasives
(Multi-layer, controlled contact area)

For more information on NORaX® please contact your local Sales or Customer Service Representative.

BACKING TYPES

Whether paper, cloth, vulcanised fibre, a combination or polyester film, the backing must be smooth enough for uniform adhesive coating, strong enough to withstand grinding pressures and flexible enough to conform to contours (if necessary). For reasons of economy, the least expensive backing compatible with the job requirements should be selected.

PAPER

The standard paper weights used in coated abrasives are indicated by a letter code which appears immediately after the grit size on the finished product backing. Briefly stated, the lighter the backing, the greater the degree of flexibility; the heavier the backing, the greater the resistance to tearing.

A-weight (70gms)
Light and flexible, A-weight is used primarily for hand finishing operations both wet and dry. Grits 80 and finer.

C-weight (120gms)
Stronger and less flexible than A-weight. This backing is chosen for hand sanding, dry or wet, and for use on small portable power sanders. Intermediate through fine sanding. Grits 60 through 180.

D-weight (150gms)
Stronger and less flexible than C-weight. This backing is also chosen for hand sanding and for use on small portable power sanders. Coarse through intermediate sanding. Grits 36 through 80.

E-weight (220gms)
Stronger and less flexible than D-weight, this backing is used primarily on roll, belt and disc applications where high resistance to tearing is needed.

F-weight (300gms)
The strongest, least flexible paper backing utilised. Used for crankshaft lapping rolls, tannery industry belts and rolls, and NorZon® belts only.

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BACKING TYPES (CONTINUED)

CLOTH

Cloth backings are more durable than paper, offer greater resistance to tearing, and tolerate continual bending and flexing during use. Norton use traditional woven cloth in the manufacture of their coated abrasives. The backing has construction and finishing characteristics designed to make it ideally suited to a specific application. The standard cloth weights used in coated abrasives are indicated by a letter code which appears immediately after the grit size on the finished product backing.

J-weight
The lightest and most flexible cloth backing, this backing is used where finish and uniformity of the surface are more important than stock removal. Ideal for finishing, blending and where flexibility and conformity are required, such as contour work or curved surfaces.

X-weight
Stronger and relatively stiff when compared to J-weight, this backing is used on products designed for coarse grit stock removal applications through fine grit finishing and polishing. Consistent productivity, relatively good finishes and long product life are characteristics of products made on X-weight backings.

Y-weight
Stronger and more resistant to longitudinal splitting than regular drills cloth, Y-weight backing is used on products designed for severe applications, such as narrow belt grinding of hand tools and wide belts sanding of lumber and particleboard dimensioning.

FIBRE

Fibre backings, made of multiple layers of impregnated paper, are very hard and strong, yet provide sufficient flexibility for the intended applications. 0,8mm thick fibre has the greatest strength of any backing used for coated abrasives. This backing is used on resin bonded fibre discs designed for heavy duty portable grinding applications.

COMBINATION

Combination backing, constructed by laminating light cloth and stiff E-weight paper, is used where resistance to tearing and breaking is a requirement. Primarily utilised on products designed for chipboard/MDF sanding.

FILM

Polyester is used as the backing media for Norton's range of precision graded microfinishing products. Film backings can be used wet or dry and have excellent resistance to chemical attack, while being tear resistant and durable.

SPECIAL COATED SURFACE TREATMENT

NO-FIL® TREATMENT

In order to provide even further resistance to loading, some Openkote paper products are given a special surface treatment of zinc stearate after the sizing operation. Such products are ideal for sanding between sealer coats on furniture, sanding after primer coats on automobiles, removing varnish from wood, and numerous other operations where conventional abrasive products fail prematurely due to loading. Norton's trademark for products utilising this treatment is No-Fil®

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SURFACE FINISH & GRINDING EFFICIENCY VARIABLES

SURFACE FINISH VARIABLES

Changes in any one of many factors can affect the surface finish generated by a product. The purpose of this chart is to show the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The length of the arrows have no significance as the effect of each variable factor will not be the same. The chart is meant to be general in nature and to show direction or trend.

	VARIABLE FACTOR	ROUGH HIGHER RA READING				SMOOTH SURFACE LOWER RA READING
1.	Grit Size	Coarse				Fine
2.	C/A Product Condition	New				Used
3.	Adhesive Bond	Resin		Resin/Glue		Glue
4.	Coating Method	Open-Coated				Close-Coated
5.	Product Flex	Single Linear				Double Triple
6.	Contact Wheel Configuration	Serrated				Smooth
7.	Composition	Wider Groove Width Steel		Rubber		Wider Width Canvas
8.	Diameter	Smaller				Larger
9.	Belt Speed	Slower				Faster
10.	Grinding Aid	Dry	Water	Oil Solubles	Straight Oils	Grease
11.	Abrasive Mineral Type	Zirconia Alumina	Ceramic	Aluminium Oxide	Silicon Carbide	Emery
12.	Workpiece Hardness	Softer				Harder

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CUTTING EFFICIENCY

Although general in nature, this chart can serve as a useful guide as to what effect a change in a single given factor in the specification will have on the cutting efficiency of coated abrasive products. Arrows have been used to signify the trend direction. The length of arrows has no significance. Some important machine and setup parameters have also been included since they do have significant impact on product performance.

	VARIABLE FACTOR	MORE AGGRESSIVE BETTER CUT				SMOOTH SURFACE LOWER RA READING
1.	Workpiece Feed Speed	Slower				Faster
2.	C/A Belt speed (m/s)	Slower				Faster
3.	Abrasive Product Condition	New				Used
4.	Grit Size	Coarse				Fine
5.	Product Durability	Fibre		Cloth		Paper
6.	Abrasive Mineral Type	Zirconia Alumina	Ceramic	Aluminium Oxide	Silicon Carbide	Emery
7.	Adhesive Bond	Resin		Resin/Glue		Glue
8.	Coating Method	Close-Coated				Open-Coated
9.	Contact Wheel Configuration	Serrated				Smooth
10.	Composition	Steel		Rubber		Canvas
11.	Diameter	Smaller				Larger
12.	Pressure	High				Low
13.	Grinding Aid	Oil	Soluble Oil		Water	Dry
14.	Workpiece Hardness	Softer				Harder

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SAFETY ADVICE

SAFETY IN THE STORAGE & USE OF COATED ABRASIVES

TRANSPORT & STORAGE

All coated abrasives should be handled carefully. Damage can be caused by mishandling, which should be avoided.

Coated abrasives should be stored in dry, frost free conditions. They should be kept away from heat sources, cold, damp walls, doors or windows and should not be in direct contact with the floor. Temperatures and humidity should be between 18°C and 22°C and 45%-65% relative humidity. Coated abrasives should not exposed to direct sunlight. Products should be kept in their original packaging until immediately before use. Once unpacked, they should be stored in a way which avoids distortion.

PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if conditions are severe, additional face protection.
Leather aprons and safety shoes must be worn.

Mouth Protection

Wear Gloves

Eye Protection

Ear Protection

Read Instructions

Dry

Wet

GENERAL PRECAUTIONS

Safety instructions provided by the machine manufacturers must be followed. Where fitted, all guards, covers and hoods must be in place on the machine during grinding, and should not be modified in any way. Abrasives should not be used near inflammable material or in an environment where there is a risk of explosion.

Sparks should be directed away from the face and body, if possible towards the floor. Dust extraction equipment must be used whenever it is available. The instructions for use given by the abrasive manufacturer must be followed e.g. 'Not to be used without a support', or 'Not to be used for wet grinding'. The workpiece must be firmly fixed before grinding starts. Check all abrasives visually before use and make certain that the product is suitable for the application. No modifications should be made to abrasive products after delivery.

When using a portable grinder always switch it off and allow the spindle to stop completely before putting the tool down. Wet grinding should only be carried out on machines designed for this purpose and with abrasives designated as suitable for this type of operation.

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SAFETY ADVICE

DOs

TUNGSTEN CARBIDE BURRS

✓	**DO** Always operate the burr within the recommended speed range
✓	**DO** Select the appropriate shape, diameter & cut style for the application
✓	**DO** Ensure the appropriate grinder is used & that it is regularly maintained
✓	**DO** Fix the maximum length of the burr in the collet (recommended max 10mm overhang)
✓	**DO** Check that the burr is running true in the grinder before use
✓	**DO** Securely fix workpiece & hold the grinder firmly
✓	**DO** Use a smooth cutting action with constant movement in both directions. Use light pressure, letting the burr do the work
✓	**DO** For best finish, always end on a reverse stroke

DON'Ts

TUNGSTEN CARBIDE BURRS

✗	**DON'T** Run burr above the Maximum Operating Speed
✗	**DON'T** Run burr too slowly (refer to recommended speed guide)
✗	**DON'T** Allow burr to be exposed to excessive mechanical or thermal shock
✗	**DON'T** Sink the burr to more than one-third of its periphery
✗	**DON'T** Jam the burr into grooves, crevices & cavities
✗	**DON'T** Allow burr to become too hot, causing braze to weaken (applies to burrs where head diameter is greater than shank diameter)
✗	**DON'T** Apply shock or excessive force to the product or let it overheat

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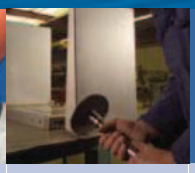
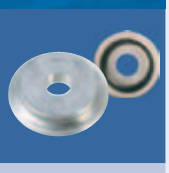
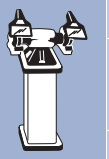
PRODUCT SELECTION - BY MACHINE

STATIONERY MACHINES

Product selection guide & Starting Points recommendation

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
STRAIGHT SHAFT EQUIPMENT						
Bench Grinder		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	n/a
		Convolute Wheels	D19 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Reduction Bushings
		Lap Mops	n/a	F2520 VF A	F2520 VF A	n/a
Pedestal Grinder		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	n/a
		Convolute Wheels	D19 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Reduction Bushings
BELT EQUIPMENT						
Back Stand		Surface Blend Belts	DSB Coa or DSJ Ex Coa	DSJ Med	Superflex Med	n/a
Stroke Grinder		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
Centerless Polisher		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a

VELKOOBCHOD BRUSIVA

STATIONERY MACHINES - CONT...

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
FEED-THROUGH EQUIPMENT						
Sheet/Coil Processing Machine		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
		Convolute Wheels	D18 SF	DCS	DMA 5AM	Reduction Bushings
Rotary Disc/ Planetary Disc Machine		Surface Blend Discs	DSB Coa	DSJ Med	DSJ Med	n/a
AUTOMATED EQUIPMENT						
Rotary Machine		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	n/a
		Convolute Wheels	D18 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings
		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Reduction Bushings
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
Straight-Line Machine		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	n/a
		Convolute Wheels	D18 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings
		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Reduction Bushings
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
Centerless Polisher		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Convolute Wheels	D18 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings

SPEC CHECK

Did you pick the most efficient solution?
The most cost effective method usually involves getting the job done fast and efficiently. The most dramatic savings come from labour expenses, rather than material costs.

STATIONERY MACHINES - CONT...

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
AUTOMATED EQUIPMENT						
Robotic Equipment		Surface Blend Discs	DSB Coa	DSJ Med	DSJ Med	n/a
		Convolute Wheels	D18 SF	DCS	DMA 5AM	Reduction Bushings
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Reduction Bushings
		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Reduction Bushings
		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Reduction Bushings

PORTABLE MACHINES

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
STRAIGHT-SHAFT TOOLS						
Drill		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	Mandrels
		Convolute Wheels	D16 SF	DCS	DMA 5AM	Mandrels
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Mandrels
		Flap Wheels (Spindle)	n/a	F2301 Med A	F2501 VF A	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Mandrels
		RapidStrip Wheels/Discs	n/a	R4101 S Ex Coa	n/a	Mandrels
		Lap Mops	n/a	F2520 VF A	F2520 VF A	XL Mandrels
Straight-Shaft Grinder		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	Mandrels
		Convolute Wheels	D19 SF	DCS	DMA 5AM	Mandrels
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Mandrels
		RapidStrip Wheels	n/a	R4101 S Ex Coa	n/a	Mandrels
		Flap Wheels (Spindle)	n/a	F2301 Med A	F2501 VF A	n/a

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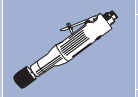
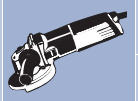
PORTABLE MACHINES - CONT...

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
STRAIGHT-SHAFT TOOLS						
Die Grinder		Flap Wheels (Spindle)	n/a	F2301 Med A	F2501 VF A	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Mandrels
		Lap Mops	n/a	F2520 VF A	F2520 VF A	XL Mandrels
Flexible-Shaft Motor e.g. Suhner, Biax		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	Mandrels
		Convolute Wheels	D16 SF	DCS	DMA 5AM	Mandrels
		Polybond Wheels	C150-H10BTM	n/a	C240-D4BTM	Mandrels
		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
		Unitised Wheels	U2301 8AM	U2401 6AF	U4401 2SF	Mandrels
		RapidStrip Wheels	n/a	R4101 S Ex Coa	n/a	Mandrels
		Flap Wheels	n/a	F2301 Med A	F2501 VF A	Mandrels
RIGHT ANGLE TOOLS						
Right Angle Grinder/ Polisher		Surface Blend Discs	DSB Coa	DSJ Med	DSJ Med	Norgrip back up pads
		RapidStrip DPC discs	n/a	R4101 S Ex Coa	n/a	n/a
		RapidFinish DPC discs	U2301 2AM	F2303 HS Med A	U4401 2SF	n/a
		SpeedLok Discs	DSB Coa	R4101 S Ex Coa	DSJ Med	SpeedLok Holders
Vertical Grinder		Surface Blend Discs	DSB Coa	DSJ Med	DSJ Med	Norgrip back up pads
Right Angle Die Grinder/ Mini Grinder		SpeedLok Discs	DSB Coa	R4101 S Ex Coa	DSJ Med	SpeedLok Holders
		Specialised SpeedLok discs	U2301 6AM	F2303 HS Med A	U4401 2SF	SpeedLok Holders
Satinex machine		Satinex Wheels	F2200 A Coa	R4101 S Ex Coa	F2300 Med A	n/a

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PORTABLE MACHINES - CONT...

MACHINES		PRODUCT	DEBURRING	CLEANING	BLENDING & FINISHING	REQUIRED ACCESSORY
BELT TOOLS						
File		Surface blend File belts	DSB Coa	DSJ Med	Superflex Med	n/a
Portable Belt Sander		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
Expander Wheel		Surface Blend Belts	DSB Coa	DSJ Med	Superflex Med	n/a
VIBRATING TOOLS						
Orbital Sander		Plain Discs	n/a	F2303 HS Med A	F2520 VF A	Norgrip back up pads
		Surface Blend Discs	DSB Coa	DSJ Med	DSJ Med	Norgrip back up pads
Straight-Line Sander		Hand Pads	F2302 Extra Cut A	F2504 VF A LL	F4804 UF S	n/a
		Rolls	F2300 Med A	F2504 VF A LL	F4804 UF S	n/a
HAND PAD / MANUAL SANDING						
Hand Applications		Hand Pads	F2302 Extra Cut A	F2504 VF A LL	F4804 UF S	n/a
		Rolls	F2300 Med A	F2504 VF A LL	F4804 UF S	n/a
		Sheets	F2302 Extra Cut A	F2504 VF A LL	F4807 UF S	n/a

Warning - Do not use a product which was not designed specifically for that tool. Always verify that the speed rating of the product meets or exceeds the rating of the tool!

SPEC CHECK

Starting point recommendations can vary depending on the level of aggression required, by choosing a different product grade

Depending upon performance results, other specifications may be substituted on the basis of product testing.

The best practice is to test at least 2 variations of specifications to obtain the desired result.

Ask your Norton contact for more advice

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PRODUCT SELECTION- BY APPLICATION

Shortcut to finding the right product...

For deburring or cleaning/finishing, or on completely new operations, the product specifications listed below are recommended as starting points.

Depending upon performance results, other specifications may be substituted on the basis of product testing.

We believe that the best practice is to test at least 2 variations of specifications to obtain the desired result.

DEBURRING

Medium Burrs	Light Burrs
CONVOLUTE WHEELS	
Series 1000 Long Life 1 - 8 SF C4408	Series 1000 Long Life 1 - 7 SF C4408
or (for extra cut)	
Series 1000 Long Life 1 - 9 SF C4408	
UNITISED WHEELS	
NEX -6AM (or 8AM) U2301	NEX -2SF U4401
Fo Ti and Aerospace Alloys, use 6SF U4401	
RIGHT ANGLE DISCS	
Surface Blending DSJ or DSB	Surface Blending DSJ
Aluminum Oxide 120 Medium	Aluminum Oxide 320 Very Fine
HAND PADS	
F2302 Heavy Duty Extra Cut Tan Pad	F2504 VFA LL Maroon General Purp Pad

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WOOD CONDITIONING

Sanding and Shaping	Finishing and Rubbing
CONVOLUTE WHEELS	
Series 1000 Long Life 1 - 8 SM C4308	F2801 Micro Fine S Gold Pad

CLEANING AND FINISHING

Clean / Medium Grain Finishing	Fine Grain Finishing
CONVOLUTE WHEELS	
DSS Surf Fin S/C Med Wheel C4302	DCS Clean/Finish S/C Fine Wheel C4401
or	or
Series 1000 Long Life 1 - 6 SM, C4308	Series 1000 Long Life 1 - 6 SF C4408
UNITISED WHEELS	
NEX -4AF U2401	NEX -2SF U4401
FLAP WHEELS	
Med Grit Aluminum Oxide F2301	Fine Grit Aluminum Oxide F2401
Medium Density Flap Wheel	Medium Density Flap Wheel
HAND PADS	
F2504 VFA LL Maroon General Purp	F2801 Micro Fine S Gold Pad
or	
F4300 Medium S Pad for stainless steel	

HAND PAD APPLICATIONS

Heavy Duty Cleaning & rust removal	Medium Cleaning	Light Cleaning & Finishing
HAND PADS		
F2302 Heavy Duty Extra Cut Pad	F2504 VFA LL General Purpose Pad	F2801 Mfine S Pad
Tan	Maroon	Gold

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MATERIAL IDENTIFICATION

PRODUCT SHAPE	COLOUR	GRADE	GRIT TYPE	SIZE	FIBRE	STRENGTH
Flastock - Hand Pads - Rolls	White	White Cleaning	None	None	Polyester	Least Aggressive - Most Aggressive
	Green	General Purpose Clean & Scour	Aluminium Oxide	320	Nylon	
	Gold	Micro Fine A	Aluminium Oxide	1000		
	Gray	Ultra Fine S	Silicon Carbide	800		
	Maroon	Very Fine A	Aluminium Oxide	320		
	Maroon	Fine A	Aluminium Oxide	180		
	Maroon	Medium A	Aluminium Oxide	120		
	Brown	Extra Cut	Aluminium Oxide	80		
	Black	Medium S	Silicon Carbide	60		
Bearflex	Gold	Micro Fine A	Fused Alumina	1000	Nylon	
	Maroon	Very Fine A	Aluminium Oxide	600		
	Gray	Ultra Fine S	Silicon Carbide	320		
High Strength	Maroon	Very Fine A	Aluminium Oxide	280	Nylon	
	Maroon	Medium A	Aluminium Oxide	100		
Surface Blending SCM Discs and Belts	Gray	Super Fine	Silicon Carbide	600	Nylon	Least Aggressive - Most Aggressive
	Blue	Very Fine A	Aluminium Oxide	180		
	Maroon	Medium	Aluminium Oxide	100		
	Maroon	Heavy Medium	Aluminium Oxide	80		
	Brown	Coarse	Aluminium Oxide	50		
	Dark Brown	Extra Coarse	Aluminium Oxide	46		
Rapid Strip	Black	Extra Coarse	Silicon Carbide	36	Nylon	
Floor Pads Thick Line General Purpose	White	White Super Gloss	None		Nylon	Least Aggressive - Most Aggressive
	Beige	Beige Polish &Burnish	Aluminium Oxide			
	Maroon	Red Buffer	Aluminium Oxide			
	Blue	Blue Super Clean	Aluminium Oxide			
	Green	Green Super Scrub	Aluminium Oxide			
	Black	Black Super Strip	Aluminium Oxide			
Floor Pads Thin Line General Purpose	White	White	None		Nylon	Least - Most Aggressive
	Tan	Tan	Aluminium Oxide			
	Green	General Purpose Pad	Aluminium Oxide			
	Black	Black Strip	Aluminium Oxide			

Finishing characteristics of non-woven abrasives are determined by many attributes in addition to grain size , the data provided here is for reference only - and cannot be considered as a specification of our products.
Sizes - colours are approximate.

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SAFETY ADVICE - DO'S & DON'TS

FOR YOUR SAFETY YOU SHOULD ENSURE THAT YOU ARE FULLY AWARE OF HOW TO SAFETY USE ABRASIVES.

DO	Read the safety instructions provided by the abrasives and eqipment supplier
DO	Store abrasives in dry, frost-free conditions avoiding wide variations in temperature
DO	Ensure that the product is suitable for its purpose
DO	Handle, store and transport products with care
DO	Disconnect the power to the machine before fitting the product
DO	Examine all products before mounting and periodically during use for possible defects or damage
DO	(core flatness, fatigue cracks, undercutting, arbor hole damage...)
DO	Check that correct mounting devices are used and that they are clean, undistorted and free from burrs
DO	Ensure that work rests are properly adjusted and secure
DO	Always use a correctly designed and adjusted guard (on belts)
DO	Ensure that the workpiece is secure
DO	Wear appropriate personal protective equipment at all times
DO	Avoid clogging and uneven wear to ensure that the product is working efficiently
DO	Ensure accordance between product direction arrow / machine rotation
DO	Ensure that all machines using abrasives meet the requirements of the current european machinery directives-CE
DO	Be aware of the hazards likely during the use of abrasives and observe the recommended precautions to be taken: - Bodily contact with the abrasive product at operating speed - Injury resulting from product breakage during use - Grinding debris, sparks, fumes and dust generated by the grinding process - Noise - Vibration

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SAFETY ADVICE - DO'S & DON'TS

FOR YOUR SAFETY YOU SHOULD ENSURE THAT YOU ARE FULLY AWARE OF HOW TO SAFETY USE ABRASIVES.

DON'T	Allow untrained people to use abrasives
DON'T	Use a product that is damaged
DON'T	Use a product if it cannot be properly identified
DON'T	Use a machine that is not in good working order or one with defective parts
DON'T	Force the abrasive onto the mounting device or modify the size of the mounting hole
DON'T	Exceed the maximum operating speed marked on the product
DON'T	Apply shock or excessive force to the product or let it overheat
DON'T	Use mounting flanges which are not clean and flat
DON'T	Tighten the mounting device excessively
DON'T	Start the machine until the guard is in place and fastened securely
DON'T	Continue to use a product if vibration occurs. True or replace it
DON'T	Grind on the part of the product which is not designed for the operation
DON'T	Start the machine with the workpiece in contact with the abrasive product
DON'T	Grind material for which the product is not designed
DON'T	Stop the abrasive by applying pressure to its surface, let it stop naturally
DON'T	Wear loose clothing, ties and jewellery
DON'T	Use abrasive products near flammable materials

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TECHNICAL INFORMATION

WHAT IS A GRINDING WHEEL?

A grinding wheel is a precision tool with thousands of cutting points. It consists of abrasive grains held in a matrix of bond and separated by pores. The abrasive grains are the cutting points while the purpose of the bond is to hold the individual grains together. The pores (hollow spaces between adjacent abrasive grains and the bond) serve to provide clearance for coolant penetration and metal chips removed in the grinding process.

When the wheel is rotated at grinding speed and applied to the workpiece, the abrasive grains cut the material that is being ground, removing the material in small chips.

Under the action of the forces imposed during grinding the abrasive cutting points are worn flat, resulting in the points becoming blunt. This causes an increase in friction, and a build up of heat.

The increase in grinding forces causes either the abrasive to fracture, exposing new cutting edges, or fractures the bond bridges holding the abrasive grains. In the latter case fresh abrasive grains are exposed to cut the workpiece.

In normal vitrified grinding applications the wheel has to be dressed.

By varying the properties of the abrasive, the type of bond, the make-up of the wheel, it is possible to produce grinding wheels with a vast range of different grinding characteristics.

ABRASIVES

Modern synthetic abrasives allow accurate control over the physical properties and form of the abrasive grain. This helps to ensure that grinding wheels can be manufactured with consistent cutting properties.

Norton offers a comprehensive selection of abrasive types to provide a wide range of specific grinding characteristics. This is necessary for maximum efficiency in the large variety of operations demanded by the industry today.

Abrasive Grain Size
The grain or grit size is most important in determining a wheel's ability to achieve the required surface finish and remove stock. The size is designated by a number which increases as grain size decreases. For example 10 grit has a median size of about 2,0mm and 60 grit 0,25mm.

Standard sizes are used in all Norton wheels as specified in the European Standards laid down by FEPA.

An ideal grinding abrasive has the ability to stay sharp with minimum point dulling, and when dulling begins it fractures revealing new sharp cutting edges. Abrasive grains used in the manufacture of bonded abrasives come in three main categories.

UNDERSTANDING THE SPECIFICATION

ABRASIVE			GRIT SIZE			GRADE			STRUCTURE		BOND
ALUMINIUM OXIDE	SILICON CARBIDE	CERAMIC ALUMINIUM OXIDE	COARSE	MEDIUM	FINE	SOFT	MEDIUM	HARD	CLOSED	OPEN	
A	37C	SGB	12	30	80	E	I	Q	5	10	VS
19A	39C	3SG	16	36	90	F	J	R		11	VXP
25A		5SG	20	46	100	G	K	S		12	VXPM
38A		1TGP	24	54	120	H	L	T			VTECH
40A				60			M				
57A				70			N				
86A							O				
IPA				60				EH		17	VTX
								XH		20	
		ES5		60	80		J	L			VX
							K				

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ABRASIVE TYPES

ABRASIVE TYPE	DESCRIPTION
A	This is a particularly tough form of aluminium oxide. Its toughness is due to the presence of 3% of titanium oxide in the abrasive. Fired at low temperature the abrasive retains its natural brown colour. Fired at high temperature further oxidation of the titanium oxide takes place which changes the normal brown colour to a grey-blue. Because of its toughness, regular brown alumina is suitable for grinding high tensile strength materials, specifically off-hand grinding (bench grinding wheels) & sharpening stones.
19A	A blend of A & 38A abrasives. This abrasive gives a grinding action that can be compared to the average of its components. It is supplied in some standard tool room wheels, used for surface, cylindrical, centreless & miscellaneous grinding on less heat sensitive steels.
38A	White fused aluminium oxide (99,8% pure). The most friable & cool cutting of the aluminium oxides. This abrasive is supplied in all types of standard range wheels ideal for use on hard & heat sensitive steels & alloys. It has traditionally been used for sharpening high-speed steel & cast alloy tools & cutters. 38A is used for cylindrical, surface & internal grinding of tools, dies & gauges.
57A	Semi-pure brown fused aluminium oxide (98% pure). The higher purity of 57A makes it a good general purpose abrasive. Its versatility enables it to be used for grinding steel parts in both soft & hard states, especially on large cylindrical & centreless operations. U Treatment (U57A) is a ceramic coating applied to this abrasive to increase its durability in resin bonded cutting-off wheels. It is used in the advanced range resinoid cut-off wheels.
86A	Pink aluminium oxide is a highly refined form of alumina containing a small proportion of chromium oxide. This addition makes 86A a little tougher than pure white, increasing the strength along the shear planes. This abrasive is available in a range of mounted points & wheels.
SGB	A blend of premium abrasives that include a medium concentration of ceramic Norton SG.
3SG	A blend of premium abrasives that include a high concentration of ceramic Norton SG.
5SG	A blend of premium abrasives that include a very high concentration of ceramic Norton SG.
37C	Crystolon silicon carbide abrasive. Supplied mainly in the resin bonds of advanced wheels used for grinding grey iron, non-ferrous metals & in vitrified bonds for grinding non-metallic materials, such as rubber & stone.
39C	Crystolon is the highest purity silicon carbide abrasive. It is ideal for grinding cemented carbide cutting tools, fired ceramics & glass, where it provides advanced performance.

BOND TYPES

VITRIFIED

Vitrified bonds are the most common precision grinding bond. Porosity and strength of the wheels made with this bond give high stock removal along with their rigidity helping to attain high precision. Not affected by water, acid, oils or ordinary temperature variations. The most common vitrified bonds are:

V	V is the original high temperature vitrified bond, usually used where tougher acting wheels are required
VS	VS is a very versatile, low temperature, high performance vitrified bond system used in almost all applications but predominately for tool room, centreless, cylindrical, & surface grinding
VTECH	Low temperature, very technical bond, used with conventional abrasives & recommended for high tech applications to maximise performance & dressing parameters
VX	VX bond provides improved corner/form holding for most applications – it is the first choice bond for our premium abrasives
VXP	Induced porosity VX bond suitable for large contact areas & surface grinding

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BOND TYPES

ORGANIC

These bonds are used in two types of wheels. Firstly, wheels used on portable or fixed machines for the rapid removal of metal. Secondly, cutting-off wheels either un-reinforced or reinforced, for use on portable or fixed machines. The most common organic bonds are:

SNAGGING WHEELS & CUPS	
B & B3	Foundry wheels: multi-purpose bond that gives satisfactory results on most applications
B28	Foundry wheels: high level bond suitable for most technical applications requiring high powered machines
CUTTING-OFF WHEELS	
BF1	Specific bond ensuring the best quality of cut in dry or wet conditions
BF3	New generation bond assuring the best wheel life in dry cutting operations; versatile & long wheel life. Ideal for heavy duty operations
B24	New generation bond used on silicon carbide cut-off wheels that gives the best performance & the ultimate cut quality on non-ferrous metals in wet conditions
B25	Standard multi-purpose bond that offers durability & freeness of cut in a wide variety of materials & applications. Can also be used in wet cutting on softer grades
B26	New generation bond used on aluminium oxide cut-off wheels that gives the best performance & the ultimate cut quality on ferrous metals in wet conditions
B65	Traditional bond gives good performance & long wheel life in dry cutting conditions

WHEEL GRADES

The grade indicates the relative holding power of the bond, which holds abrasive grains in a wheel. This is represented in the specification by letters running through the alphabet from hardest to softest. The following rules should be followed with regard to grade:

USE SOFT GRADE

- For hard materials such as hard tool steels & carbides
- For large areas of contact
- For rapid stock removal

USE HARD GRADE

- For soft materials
- For small or narrow areas on contact
- For longer wheel life

COMMON RANGE OF GRADES

E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T	U
					CYLINDRICAL/CENTRELESS											
SURFACE GRINDING																
					ID GRINDING											
				TOOL GRINDING												
						THREAD GRINDING										
	NON-REINFORCED ORGANIC															
											REINFORCED ORGANIC					

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AVAILABILITY SUMMARY

ABRASIVE TYPE	BOND	ABRASIVE COLOUR
IPA	VTX	White
SGB-3SG-5SG-ES5-1TGP	VX-VXP	Blue
A–19A	VS	Brown
86A	VS-VXP-VTECH	Ruby
38A	VS	White
37C	V-VP	Black
39C	V-VS	Green

SELECTING THE RIGHT PRODUCT

There are nine main factors to be considered when selecting a grinding wheel for any application:

- The material to be ground – its type & hardness
- The stock to be removed
- The workpiece geometry & surface finishes required
- The grinding machine, the type of machine, the power available & its conditions
- Wheel speeds & feeds
- Grinding contact area
- Grinding fluid – whether the operation is wet or dry
- The severity of the grinding operation
- The dressing method

MATERIAL TO BE GROUND

The type of material affects the selection of abrasive, grit size and grade. Alumina type abrasives are the most suitable for grinding high tensile materials such as steel and ferritic cast irons. The more friable types of alumina are preferred on harder steels and applications having large arcs of contact.

Low tensile strength materials and non-metallic materials are most efficiently ground or cut with silicon carbide abrasive.

The hardness of the material governs the amount of penetration that can be achieved by the abrasive. For this reason finer grit size wheels are required to grind hard materials and soft materials are best ground with medium to coarse grit size wheels.

For most efficient operation, the grade must be adjusted to suit the hardness of the material. As a general guide, the harder the material, the softer the grade of wheel required.

STOCK TO BE REMOVED

This affects the choice of abrasive size and bond type.

High stock removal rates, as in fettling operations, require coarse grit wheels, typically 12 to 24 mesh. Fine finishes and tight limits on finished workpiece geometry require finer grit sizes.

Final surface finish is often achieved by 'spark out'. No further infeed is applied and the wheel is allowed to grind until the majority of the grinding sparks cease.

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SURFACE FINISH

The achievable surface finish in any grinding operation is highly dependent upon the grit size of the grinding wheel. The following chart shows the range of surface finishes achievable when using grinding wheels of different grit sizes on conventional precision grinding applications, together with the minimum form radius that can be ground using each grit size.

Other factors can affect the surface finish achieved. In particular:

- Production grinding applications, with higher stock removal ranges, will give surface finishes at the coarser end of the range
- Plunge grinding applications will often require the selection of a grit size one size finer than shown
- Dressing techniques & the type of material can also affect the surface finish achieved

USAGE KEY
▰ Highly recommended

SURFACE FINISH & GRIT SIZE									
SURFACE	FINISH	GRAIN SIZE							
µ in CLA	µ m Ra	46	60	80	100	120	150	180	220
42	1,10	▰							
32	0,80	▰							
26	0,70	▰							
21	0,50		▰						
16	0,40		▰						
14	0,35		▰	▰					
11	0,25		▰	▰					
8	0,20			▰	▰				
7	0,17			▰	▰	▰			
6	0,14				▰	▰	▰		
5	0,12					▰	▰	▰	
4	0,10						▰	▰	▰
3	0,08							▰	▰
2	0,05								▰
MIN FORM RADIUS	METRIC (mm)	0,75	0,50	0,40	0,25	0,20	0,18	0,13	0,10
	IMP INS	,030	,020	,015	,010	,008	,007	,005	,004

Achieving Improved Surface Finishes

By changing the wheel dressing technique, it is possible to achieve finer surface finishes than those shown. As well as reducing the dresser infeed per revolution of the grinding wheel, it is also possible to reduce the infeed and traverse rate when grinding, thus reducing the stock removal rate. Obviously this approach will have limited application in production grinding but it can be very useful in tool room work.

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THE GRINDING MACHINE

The type of machine can effectively define the grinding contact area and the ease with which grinding fluid can be applied to the grinding zone.

The power available on the machine governs the stock removal rate. The greater the power available, the harder the grade of wheel that is required for efficient operation.

Any deterioration in the condition of machine bearings and slideways will lead to vibration and, consequently, premature wheel breakdown. This can, in part, be overcome by using a harder grade wheel and/or a tougher abrasive but the only effective solution is to maintain the machine as recommended by the machine manufacturer.

SPEEDS & FEEDS

The effect of speeds and feeds on grinding action and, hence, the selection of wheel, can best be summarised in the following table:

EFFECT ON GRINDING ACTION		
SPEED	INCREASED	DECREASED
Wheel speed*	Harder	Softer
Work speed	Softer	Harder
Traverse speed	Softer	Harder
Infeed rate	Softer	Harder

*The maximum peripheral speed (m/s) specified for the wheel must never be exceeded

GRINDING CONTACT AREA

The contact area affects the selection of wheel grade and structure. Large contact areas, as on segmental grinders, generally produce low grinding pressures and require soft grade, open structure wheels. Induced porosity wheels are most efficient for grinding very large contact areas. Conversely, small contact areas, as on cylindrical grinding machines, require harder grade and/or closer structure wheels.

The size of workpiece can also affect the grinding contact area. In general, the larger the workpiece, relative to the grinding wheel diameter, the larger the contact area, requiring softer grade wheels.

GRINDING FLUID

Dry grinding with vitrified wheels require wheels one or two grades softer than when wet grinding.

SEVERITY OF THE GRINDING OPERATION

This can affect the choice of abrasive type, grade and even bond type. Where the wheel is subjected to shock loads, as in fettling operations, a resinoid bond should be used. In general, the more severe the grinding operation, the harder the grade of wheel required and the tougher the abrasive that can be used. Severity of grinding operation can be due to heavy infeeds, high work speeds and traverse rates or intermittent grinding contact. The latter is usually due to workpiece geometry, resulting in a dressing action on the wheel.

GRINDING WHEEL DRESSING & TRUING

Truing and dressing of grinding wheels are often considered to be the same thing, since they are frequently performed as one operation. Truing is performed to ensure concentricity and introduce any profile that may be required on the wheel face. Dressing conditions the wheel surface to give the desired cutting action.

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SINGLE & MULTI-POINT DIAMONDS

Diamonds are the first choice where close tolerances, fine finishes, speed and flexibility are required. Since diamond dressing is primarily a machining operation rather than a crushing operation, the surface formed on the wheel is closer than that obtained from mechanical dressers. This results in a slower cutting wheel with better form holding characteristics and superior finish control.

By varying the depth of cut per pass made by the diamond and changing the traverse rate, different wheel surfaces, and hence different cutting actions, can be achieved.

The following are general recommendations for dressing with single-point diamonds.

	ROUGHING	FINISHING
Diamond infeed mm per pass	0,025mm	0,012-0,020mm
Diamond traverse rate mm/wheel rev.	0,18mm	0,10mm

The diamond should always be applied at the centreline of the wheel with a 5°-15° drag angle.

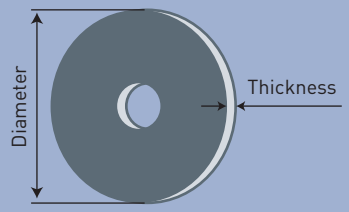
DIAMOND SIZE

The size of diamond is important when selecting a dressing tool and several factors are relevant in this selection, e.g. large, coarse grit wheels require a larger diamond than smaller, fine grit wheels. If a fine finish is required, the use of a diamond which is too large can adversely affect the finish and cancel the effect of fine grit selection. The trend today is away from single-point dressers and towards multi-point dressers employing a matrix shape to suit the form required.

A useful formula for determining single-point & multi-point diamond size is:

Wheel diameter (mm) x Wheel thickness (mm)

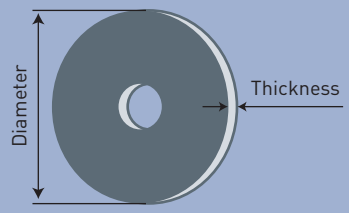
SINGLE-POINT — MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
<6000	0,33 Carat
6000-18000	0,50 Carat
>18000	1,0 Carat

For best results, always use a coolant when dressing

MULTI-POINT — MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
<30000	1,3 Carat
30000-60000	2,5 Carat
>60000	5,0 Carat

For best results, always use a coolant when dressing

COOLANT

Dressing with diamonds should always be carried out using a copious supply of coolant. The coolant should always be turned on fully before the diamond touches the wheel. The diamond life will deteriorate rapidly if it is allowed to become hot and then cooled rapidly as can be experienced with an intermittent coolant flow.

ROTATION OF THE DRESSING TOOL

To ensure maximum diamond life, single-point and conical cluster diamond dressing tools should be systematically rotated after every four or five dressings to ensure that the keen edge generated from the drag angle is constantly presented to the wheel.

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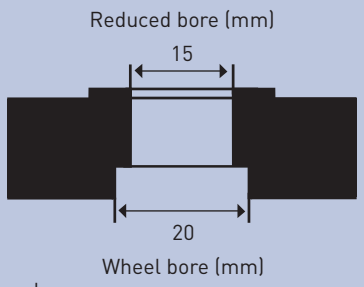
REDUCTION RINGS

REDUCTION RINGS

Plastic reduction rings may be used to adapt grinding wheels to fit on various spindle sizes. These rings reduce the bore hole size, allowing the wheel to be safely mounted on a spindle with a smaller diameter.

- Reduction rings should never come in contact with the flange
- Reduction rings should not be used on wheels of thicknesses less than 6mm, nor greater than 50mm
- Always use one reduction ring on each side of the wheel when the wheel is thick enough to allow correct seating
- Never use reduction rings to reduce the hole below the minimum specified in the FEPA safety code



WHEEL BORE (mm)	REDUCED TO (mm)	REDUCTION RING
50,8	35	07660**04766**
32	25	07660**17540**
32	20	07660**17538**
31,75	15,88	07660**04757**
31,75	12,7	07660**04755**
20	16	07660**17530**
20	15	07660**17529**
20	13	07660**17527**
20	12	07660**17525**
20	10	07660**17524**
16	6	00510**08919**

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MOUNTING

A wheel should only be mounted onto the machine for which it was intended. The speed of the spindle on which the wheel is mounted should not under any circumstances exceed the maximum RPM speed specified for the wheel when it is full size. The wheel should fit freely, but not loosely, onto the spindle or spigot diameter of the flange plates. Wheels, blotting paper washers and flanges should be free from foreign matter. Certain wheels have a positioning mark (Mount Down or Mount Up) marked on them.
Care must be taken to ensure that this mark occupies the position stated by the manufacturer.

REDUCING BUSHES

Where a removable bush is used as a means of reducing the bore of an abrasive wheel, care must be taken to ensure the bushes should not project beyond the side of the wheel and the wheel blotter. The clamping faces of the flange plates MUST clamp on the mounting washers attached to the wheel and not on any part of the reducing bush. Reducing bushes should never be used on wheels less than 6mm thick or on products with a back or web of less than 6mm. Never use plastic bushes on wheels used with portable grinding equipment.

MOUNTING WASHERS

Blotters should be used with all grinding wheels unless there is a specific exemption. Blotters should be slightly larger in diameter than the mounting flanges and free from any scuffs, wrinkles or other damage.

MOUNTING FLANGES

Mounting flanges are designed to clamp the wheel to the machine and transfer the driving forces from the machine spindle to the grinding wheel. They should be designed to take the driving forces away from the area around the grinding wheel bore and generally should be not less than one third of the grinding wheel diameter.

Flange surfaces should be flat, free from burrs, bumps, bruises and other damage. Flanges should be of equal diameter, have equal bearing surfaces and be properly recessed or undercut.

The rear flange must be positively driven by the machine spindle, being either keyed or shrunk onto the spindle.

Flanges must run true to the machine spindle.

Clamping nuts (centre nut locking) should only be tightened sufficiently to hold the wheel securely without slippage and must not be over-tightened. When flanges are clamped by a series of screws, they should be tightened in stages uniformly in a diametric sequence.

In most instances it is appropriate to tighten the nut or screws by hand with the correct tool (spanner or hexagonal socket key) until they stop turning. By adopting this technique it is very rare that the wheel would be under-tightened and impossible to over-tighten the wheel. Bolts for mounting wheels with inserted nuts should be long enough to engage an adequate length of thread, i.e. equal to the thread diameter, but must not protrude through the nut insert.

For recommended designs of flanges, refer to the FEPA Safety Guidelines.

CAUTION

After mounting or re-mounting a grinding wheel on a machine, stand well clear, ensuring that there are no persons in line with the wheel and allow the wheel to run free for two minutes. A re-mounted wheel should always be treated as if it were a new wheel.

TYPE 06 CUP WHEELS – FIXED MACHINES

The diameter of the flange and paper washer inside the cup must be smaller than the diameter of the cup recess to avoid any risk of radial pressure on the wheel. When used for work heavier than light tool and cutter grinding, the back flange may be larger than that inside the cup but the recess diameter of both flanges must be equal.

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MOUNTED POINTS & WHEELS

The spindle dimensions of the mounted point must be suitable for the collet being used, and the spindle overhang corresponding to the machine speed should be observed.

TYPE 31 GRINDING SEGMENTS

Segments are held by special chucks with suitable provision for adjustment to compensate for segment wear. To prevent breakages segments should not protrude more than 1,5 times their thickness from the clamping chuck face, and should be mounted with markings uppermost.

WHEEL BALANCE

Most Norton grinding wheels are balance corrected to a minimum of ISO Standards. Precision grinding machines usually provide methods of accurately balancing the complete wheel and flange assembly. Modern production machines are now supplied with automatic balancing systems, whereas, tool room and older production machines still have to be manually balanced, ensuring the best possible grinding performance from the wheel. The balancing procedure can be carried out either on a special balancing stand or in-situ on the machine. The machine manufacturer's instructions should be closely followed. There are many methods of manually balancing the wheel assembly, depending upon the number of balance weights in the wheel arbour. A typical 'two weight' balancing system technique is described below:

TWO WEIGHT SYSTEMS

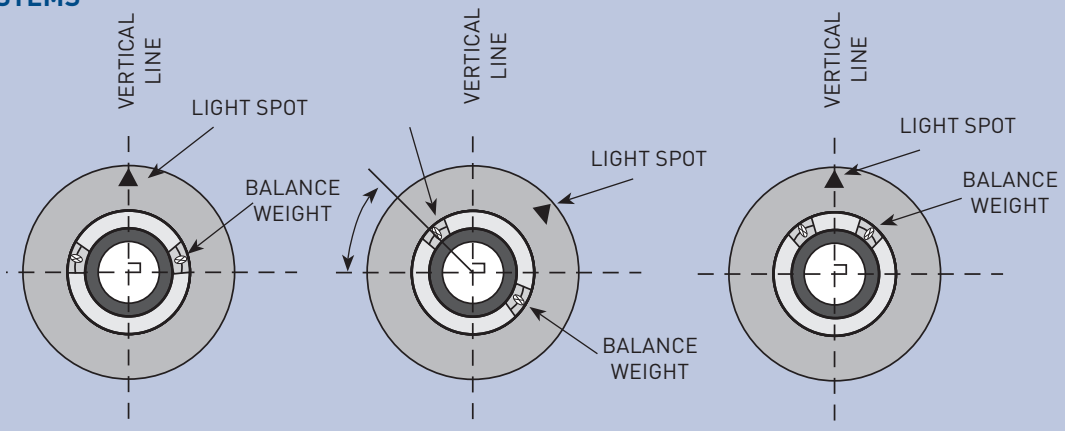

FIG 1A FIG 1B FIG 1C

- Mount wheel between flange plates
- Remove balance weights from annular groove on mounting flange (can also be set diametrically opposite if preferred – ensuring the weights cancel each other out)
- Dress periphery of wheel until running in perfect truth
- Remove complete wheel assembly from the machine (after allowing sufficient time for the coolant to spin out) & fix assembly onto the balancing mandrel
- Place on balancing unit & allow to turn freely. When stationary, mark top centre (light spot) with chalk
- Re-position the balance weights so that the bottom side face of each weight, that is furthest from the light spot, forms a right angle i.e. 90°. See illustration 1A
- Turn wheel assembly so that one balance weight is approximately 45 degrees from the horizontal line & release the wheel. Note the direction in which wheel rotates, the weight may revolve upwards towards the vertical line. In this instance the weight should be moved down away from the light spot (always adjust the weights in the opposite direction of rotation) to begin bringing the wheel into balance. See illustration 1B
- Continue checking the weights, alternating between the left & right hand balance weights in turn. Repeat until the wheel remains stationary in all positions. Move the weights a maximum of 3mm at a time, reducing this amount as the wheel rotates slower. See illustration 1C
- Continue until assembly remains static in all positions. Lock balancing weights in position & remount assembly onto the machine spindle
- Important: – Ensure the balancing ways (knife edges or rollers) on the balancing stand are level in all directions. Care must be taken to initially find the true light spot of the wheel

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TROUBLESHOOTING

SOLVING SURFACE FINISH PROBLEMS

Many problems associated with grinding relate to surface finish defects. The following chart describes some common surface finish problems, shows the probable causes and suggests remedies to cure the problem.

REGULAR SPACED CHATTER MARKS Immediately after dressing	
Cause	Machine vibration
Solution	Check for wear in machine bearings
REGULAR SPACED CHATTER MARKS After a period of time	
Cause	Wheel too hard
Solution	Use softer grade of wheel
CHEQUERED PATTERN	
Cause	Wheel out of balance
Solution	Balance wheel
CHATTER MARKS	
Cause	Wheel out of truth
Solution	Re-dress wheel
IRREGULAR CHATTER MARKS	
Cause	Wheel mounting insecure
Solution	Tighten wheel mounting
Cause	Workpiece centres loose
Solution	Adjust centres
SPIRAL MARKS	
Cause	Dressing techniques
Solution	Check diamond is sharp & secure
Cause	Dressing techniques
Solution	Check dress is parallel
FINISH TOO COARSE	
Cause	Grit size too coarse
Solution	Use fine, slow traverse dress
Cause	Wheel too soft
Solution	Decrease workspeed. Use harder grade wheel
Cause	Metal pick-up on wheel
Solution	Dress more frequently. Use more open, softer grade wheel

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SAFETY ADVICE

SAFETY IN THE STORAGE & USE OF GRINDING WHEELS

Stringent safety standards are maintained throughout the manufacture of Norton Grinding Wheels. To reduce the risk of accidents further, the law requires that certain basic precautions are taken in the storage and use of abrasive wheels.

RECEIPT

On receipt, grinding wheels should be thoroughly examined to see if they show any signs of damage, such as chips, cracks or discolouration. Damaged wheels must not be used.

HANDLING

Any mishandling that results in the wheel being subjected to any shock loading can damage all grinding wheels. This can occur if the wheel is inadvertently dropped, knocked over or banged against any other object. This is equally true if the wheel is secured on a pallet, which has been dropped heavily from a forklift truck.

Any grinding wheel subjected to such mishandling should be carefully examined for signs of damage. If in any doubt – do not use.

STORAGE

Small wheels up to 80mm diameter, together with cones, plugs, mounted points and wheels may be stored in suitable bins, drawers or boxes. Type 02 cylinder wheels, type 06 straight cup wheels, type 12 dish wheels and type 13 saucer wheels should normally be stacked on flat sides with cushioning material between them. Thick rim and hard grade cylinder and straight cup wheels may be stored on their periphery as for plain wheels. Soft grade, straight cup wheels, and all type 11 taper cup wheels, should be stored base to base and rim to rim, to prevent chipping of edges and cracking of walls. Thin plain wheels, such as cutting-off wheels or saw sharpening wheels should be stacked on a flat surface of steel, or similar rigid material. Other plain or shaped wheels of appreciable thickness, are best supported on their periphery in racks. The racks should provide cushioned, two point, cradle support to prevent the wheels from rolling.

STORAGE CONDITIONS

During storage, grinding wheels must not be subjected to:

- Exposure to humidity, water or other liquids
- Freezing temperatures
- Any temperature low enough to cause the formation of condensation on the wheels when moving from storage to an area of high temperature

SHELF LIFE OF RESINOID & VITRIFIED BONDED WHEELS

The outer surfaces of certain organically bonded wheels may be affected by oxidation if they are stored for long periods. These types of wheel should not be stored for more than three years and proper stock control should ensure that older wheels are used first. In use, a three year old Resinoid product will act considerably softer than a brand new wheel (wheel will wear away more quickly).

The glass bonding system used in vitrified wheels is very inert and generally only attacked by certain acids. Cold temperatures can result in a vitrified wheel cracking if wheels are put away wet and are subjected to freezing temperatures. It must be remembered that the longer a product is in storage the chances of it becoming damaged increases. Provided vitrified wheels are stored correctly, thoroughly examined and mounted correctly they will last for many years.

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RING TEST

The ring test depends upon the damping characteristics of a cracked wheel to alter the sound emitted when it is lightly tapped. The test is applicable only to vitrified bonded wheels.

To perform the ring test; support the wheel gently with a finger through the bore section. Using a light non-metallic implement (a file handle is ideal), gently tap the wheel about 45° each side of the vertical centre line. Rotate the wheel 45° and repeat the test.

The sound and undamaged wheel will omit a clear tone. If cracked, there will be a dead dull sound – not a clear ring – and the wheel should NOT be used. The ring test should be carried out in a place where the ring can easily be heard.

SAFE WORKING PRACTICES

PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if conditions are severe, additional face protection. Leather aprons and safety shoes must be worn.

Mouth Protection | Wear Gloves | Eye Protection | Ear Protection | Read Instructions | Damaged Wheel | Dry | Wet

TRAINING OF OPERATORS

Grinding operators should be trained in the safe use of each machine they operate.

SPEEDS

No abrasive wheel should be operated at a speed in excess of the maximum permissible speed marked on the wheel in RPM when the wheel is new and full size. It is permissible, however, to increase the spindle speed of the machine beyond the RPM stated on the wheel provided the increase is in proportion to the reduction in diameter and that the original peripheral speed is not exceeded (quoted on the wheel in metres/sec). In high production areas it is now normal for machines to have constant peripheral speed spindles. This is an electronic device that automatically increases the spindle speed of the machine as the wheel diameter wears down and prevents most of the reduction in wheel performance that is experienced when the wheel becomes smaller.

COOLANTS

The strength of resin bonded grinding wheels can be reduced by coolants. The concentration and alkalinity of coolants should be regularly checked and a pH value of 8 should not be exceeded. Prolonged immersion of a stationary wheel in coolant can produce an out of balance condition. Coolant should be shut off before stopping a wet grinding wheel, and the wheel allowed to run free until all the coolant has been spun out.

WORK RESTS

Work rests should be kept adjusted as close as possible (gap between wheel and work rest should not exceed 3mm) to the wheel and maintained in good condition.

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TRUING & DRESSING

Re-dressing of wheels that have become malformed and out of truth in off-hand operations must only be performed by a competent person.

If an out of balance condition, due to the wheel wearing excessively out-of-round, cannot be corrected by truing, the wheel should be removed from the machine.

Wheels should be dressed regularly to avoid loading.

SIDE GRINDING

Side grinding should only be performed with wheels designed for this purpose (straight cups etc.).

Grinding on the flat sides of wheels designed for peripheral grinding may be dangerous and cause a wheel breakage. This does not preclude their use for certain precision applications such as shoulder and form grinding, where it is recognised that a limited amount of side grinding is performed; however, in these operations the operator has control of the pressure through the hand wheels of the machine whereas with bench grinding and off-hand machines the pressure is uncontrolled. Extreme caution should be exercised not to use excessive pressure.

As a general guide, do not use a straight wheel which has a thickness of less than 10% of the wheel diameter for side grinding.

ORGANIC CUTTING-OFF WHEELS

'Non-reinforced' cutting-off wheels should never be used:

- On a portable grinding machine
- On any machine where the workpiece is fed into the wheel by hand

Cutting-off wheels should only be mounted on machines designed for their use.

Cutting-off wheels should be inspected for warping before use. Warped wheels should not be used.

When grinding, twisting or the exertion of any pressure on the side of the wheel should be avoided.

Workpieces should be rigidly supported and firmly clamped wherever possible.

STOPPING WHEELS

Wheels should not be brought to rest by applying pressure to the periphery or face of the wheel.

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TECHNICAL INFORMATION

DESIGNATION OF GRIT SIZES

FEPA MICRONS	US MESH	JIS	DWMI	DIAMOND	CBN	Ra (µm) SURFACE FINISH CARBIDE	RA (µm) SURFACE FINISH STEEL PLUNGE	RA (µm) SURFACE FINISH STEEL OSCILLATING
1181	16/18							
1182	16/20			16				
1001	18/20							
851	20/25							
852	20/30	20		24	24			
711	25/30							
601	30/35							
602	30/40	30		36	36			
501	35/40							
426	40/45							
427	40/50	40		46	46			
356	45/50							
301	50/60	50		50	50			
	50/80							
251	60/70			60	60			
252	60/80	60	60	80c	80c	0,6-0,9		
213	70/80			80	80			
181	80/100	80	80	100	100	0,4-0,7	1,0-1,1	0,9-1,1
	80/120			110c				
151	100/120	100	100	110	120		0,9-1,0	0,8-0,9
126	120/140	120	120	120	150	0,4-0,5	0,8-0,9	0,6-0,8
107	140/170	140	150	150	180		0,6-0,8	0,5-0,6
91	170/200	170	180	180	220	0,3-0,4	0,5-0,6	0,4-0,5
76	200/230	200	220	220	230			
64	230/270	230	240	240	240	0,2-0,3	0,4-0,5	
54	270/325	270	320	320	320			
46	325/400	325	400	400	400	0,1-0,2		
	400/500	400		500	500			
M63	40/60							
M40	30/40	500		500				
M25	20/30	700						
	15/25	800						
M16	*10/20*	1000		600				
	8/16	1500						
M10	*6/12*	2000		800				
M6.3	*4/8*	2500						
	3/6	4000						
M4	*2/4*	5000						
M1	*0/2*	15000						

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CONCENTRATION

The concentration is defined by a standard and indicates the weight of abrasive (in carats) contained in 1cm^3 of abrasive strip – 1 carat = 0,2 grams.

CONCENTRATION*			NUMBER OF CARATS/cm^3		ABRASIVE WEIGHT PER cm^3
DIAMOND ABRASIVE		CBN ABRASIVE*			
100	=	W	4,4	=	0,88g/cm^3
75	=	T	3,3	=	0,66g/cm^3
50	=	Q	2,2	=	0,44g/cm^3

* Other concentrations available upon request

SELECTION OF CONCENTRATION

The choice of concentration depends on the machining parameters:

HIGH CONCENTRATION	MEDIUM OR LOW CONCENTRATION
Roughing operations	Finishing operation
Powerful machine	Low power machine
Small contact area	Large contact area
Retention of profile or sharp edges of wheel	Cutting without temperature rise

OPERATION	INTERNAL GRINDING	EXTERNAL GRINDING	SURFACE GRINDING	SHARPENING
Diamond	100	75	50	50/75
CBN	W	T	Q	Q/T

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COOLANT

Generally speaking, working with coolant is preferable to working without coolant because the coolant reduces friction and dissipates heat generated by machining.

However, many sharpening operations are performed without coolant under good conditions and with appropriate bonds.

Choice of coolant:

- DIAMOND wheel = pure water + 1,5% rust inhibitor or soluble oil
- CBN wheels = pure oil or water, always with 5 to 10% soluble oil
- For CBN wheels, changing from soluble oil to pure oil increases the service life of the wheel

MOUNTING, TRUING & DRESSING

To achieve the best results using Norton Diamond and CBN products, the following steps for mounting, truing and dressing should be practised:

MOUNTING – PUTTING WHEEL ON MACHINE SPINDLE

- Examine wheel flanges & spindle carefully
- Be sure flanges' surfaces are clean & free of damage
- Ensure that the mounting flanges are flat & of equal diameter, especially on wheels with rigid centres, such as vitrified bond wheels
- Inspect machine spindle for excessive runout
  - TIR (Total Indicated Runout) should be no greater than 5 microns
- Mount wheel between hand-tightened flanges
- Using a dial indicator, tap the wheel lightly with a rubber or wooden block to minimize runout to less than 25 microns
- Tighten flange securely & recheck with indicator
- Allow a newly mounted wheel to operate for one full minute before grinding
- The use of one permanent mounting for the life of the wheel is recommended whenever possible:
  - If the grinding machine has a tapered spindle, mount each straight, flaring cup or dish wheel on a separate collet or adapter
  - When changing wheels the entire unit is removed, keeping the wheel in running truth
  - When needed again, the entire unit can be placed directly on the spindle or arbor, thereby eliminating the time & abrasive lost in retruing

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TRUING – MAKING WHEEL ROUND & CONCENTRIC WITH THE SPINDLE AXIS

- Prior to truing the wheel, run a wax crayon over the wheel face. Important: do not use any liquid based ink on super abrasive wheels
- Any crayon left on the wheel face after truing will reveal untrued areas
- Norton Brake Controlled Truing Devices are most commonly used to true Diamond & CBN straight, cup & cylinder wheels
  - Always use Brake Controlled Truing Device dry
  - Bring the Diamond/CBN wheel & the truing wheel together until they almost touch
  - Start the Diamond/CBN wheel to normal speed; start the truing wheel in the same direction
  - Bring the two wheels together until they touch
  - Make sure the truing wheel is spinning at time of contact
  - Traverse the wheel back & forth at 10-20mm/s
  - Downfeed 0,01-0,02mm at the end of each traverse
  - At the end of truing, the Diamond/CBN wheel should be smooth & in truth

DRESSING - OPENING THE FACE OF A TRUED WHEEL

The core material (the part of the wheel that holds and supports the abrasive-bearing section) should never contact the workpiece during grinding; rubbing will generate excessive heat. As the abrasive section of a cup wheel wears, the core material may become exposed - necessitating dressing.

- Use a single-point carbide or steel tool to dress an exposed resaloy core
- Clamp the tool in a vice
- Direct the cutting edge accurately to leave a 1,5mm of abrasive section exposed

DRESSING THE ABRASIVE TO EXPOSE THE GRITS

Purpose: to expose the grinding stone face to give a better cut

After each truing operation, dressing is necessary to give a more precise cut to the wheel. This operation consists of highlighting the grits by eliminating part of the bond and is generally carried out using vitrified bonded abrasive sticks.

Selection of the stick specification depends mainly on the nature of the bond of the super abrasive grinding stone and its grit size.

STICKS RECOMMENDED

BOND	GRIT SIZE	TRUING STICKS
Resin	126 & bigger	38A 150 HVBE
	107 - grit - 64	38A 220 HVBE
	54 & finer	38A 320 HVBE

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TROUBLESHOOTING

USE RIGID WORK SUPPORT

- All workpieces should be supported firmly during the grinding process. Any amount of vibration will cause wheel wear & produce chatter or wave marks on the ground surface
- On work ground between centres, centreholds should be properly prepared
- Minimise work overhang
- If the ground work is supported by a work finger, ensure the finger is strong enough to provide vibration-free support

AVOID EXCESSIVE FEEDS

- Excessive feeds will result in premature wheel wear. Excessive feed rates are characterised by:
  - A hard grinding sound
  - Chatter
  - Burn
  - High wheel wear rate
  - Vibration

DRY GRINDING

Problem	Possible causes	Suggested correction
Burning (excessive heat)	Wheel loaded or glazed	Dress wheel with a dressing stick
	Excessive feed rate	Reduce infeed of wheel or workpiece
	Wheel too durable	Use freer cutting specification or slow down wheel speed
	Wheel speed too high	Slower wheel speed
Poor finish	Grit size too coarse	Select a finer grit size
	Excessive feed rate	Reduce infeed of wheel or workpiece
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount
	Wheel too hard	Check specification

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WET GRINDING

Problem	Possible causes	Suggested correction
Burning (excessive heat)	Wheel glazed or loaded	Re-dress wheel
	Poor coolant placement	Apply coolant directly to wheel/workpiece interface
	Excessive material removal rate	Reduce downfeed &/or crossfeed
	Wheel speed too high	Slower wheel speed
Poor finish	Excessive dressing	Use lighter dressing pressure Stop dressing as soon as wheel starts to consume stick rapidly
	Grit size too coarse	Select a finer grit size
	Poor coolant flow or location	Apply heavy flood so it reaches wheel/work interface
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount
	Wheel too hard	Check specification
Wheel will not cut	Glazed by truing	Dress lightly until wheel opens up
	Wheel loaded	Dress lightly until wheel opens up Increase coolant flow to keep wheel surface clean Never run wheel with coolant turned off
	Grit size too fine	Check specification
Slow cutting	Low feeds & speeds	Increase feed rate; increase wheel speed (observe maximum wheel speed)
Short wheel life	Incorrect coolant flow	Apply coolant to flood wheel/work surface
	Low wheel speed	Increase wheel speed (observe maximum operating speed)
	Excessive dressing	Use lighter dressing pressure
	Wheel too soft or too hard	Change grit or grade; use higher concentration

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TECHNICAL INFORMATION

OPERATING SPEEDS

MAXIMUM OPERATING SPEED		
DIAMETER (mm)	MAX M/S	MAX RPM
100	80	15300
115	80	13300
125	80	12250
150	80	10200
180	80	8500
200	80	7650
230	80	6650
250	80	6100
300	100	6400
350	100	5500
400	100	4800
450	63	2700

Never exceed the Maximum Operating Speeds:
- Hand held blades ø < 230mm: 80m/s
- Hand held blades ø > 230mm: 100m/s
- Others: 63m/s

PERSONAL PROTECTION

Safety goggles, ear defenders, safety gloves, dust masks and, if conditions are severe, additional face protection.
Leather aprons and safety shoes must be worn.

Mouth Protection

Wear Gloves

Eye Protection

Ear Protection

Read Instructions

Not for Side Grinding

Dry Cutting

Wet Cutting

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TROUBLESHOOTING

DIAMOND BLADE DOES NOT CUT	
Cause	The segments are too hard for the material
Solution	Check if the blade is suitable for the material
Cause	The segments have become blunt
Solution	Sharpen the segments by cutting an abrasive material (e.g. sandstone)
Cause	Insufficient machine power
Solution	Check the voltage, machine power & filters
EXCESSIVE WEAR	
Cause	The segment is too soft for the material (e.g. if a blade for hard material is used to cut abrasive material)
Solution	Check if the diamond blade is suitable for the material
CRACKING OF STEEL CENTRE	
Cause	The segments are too hard for the material
Solution	Check if the blade is suitable for the material
Cause	Excessive cutting pressure, overheating, material slippage, twisting or jamming in the cut
Solution	Leave the blade to do the work, do not exert too much pressure & allow the blade to cool regularly by leaving it to rotate away from the workpiece for a few seconds
LOOSENING OR CRACKING OF SEGMENTS	
Cause	The segments are too hard for the material. This results in the diamond blade bouncing in the cut resulting in cracking segments
Solution	Check if the diamond blade is suitable for the material
SCORCHING OF SEGMENTS	
Cause	Excessive cutting pressure causing overheating. This is easily recognisable from the blue colouring where the segments & the steel core are welded together
Solution	Allow the diamond blade to cool regularly by rotating the blade away from the workpiece for a few seconds
Cause	The segments are too hard for the material
Solution	Check if the diamond blade is suitable for the material. Alternatively use less cutting pressure & let the blade do the work
UNDERCUTTING	
Cause	Undercutting occurs when the steel core wears faster than the segment, i.e. where the segment & steel core meet. This is usually caused by materials that are highly abrasive. The cutting debris is not removed sufficiently & the steel core is affected. Undercutting is certain to occur if a diamond blade for hard materials is used to cut abrasive materials
Solution	Use a diamond blade suitable for the specific material

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SAFETY ADVICE

SAFETY DOs

For your safety you should ensure that you are fully aware of how to safely use diamond blades

✓	**DO** Read the safety instructions provided by the abrasives & equipment supplier
✓	**DO** Store abrasives in dry, frost-free conditions avoiding wide variations in temperature
✓	**DO** Ensure that the product is suitable for its purpose
✓	**DO** Handle, store & transport products with care
✓	**DO** Disconnect the power to the machine before fitting the product
✓	**DO** Examine all products before mounting & periodically during blade use for possible defects or damage (core flatness, fatigue cracks, undercutting, arbor hole damage...)
✓	**DO** Check that correct mounting devices are used & that they are clean, undistorted and free from burrs
✓	**DO** Ensure that work rests are properly adjusted & secure
✓	**DO** Always use a correctly designed & adjusted guard (on the blade and belts)
✓	**DO** Ensure that the workpiece is secure
✓	**DO** Wear appropriate personal protective equipment at all times
✓	**DO** Avoid clogging & uneven wear to ensure that the product is working efficiently
✓	**DO** Ensure accordance between product direction arrow / machine rotation
✓	**DO** Ensure that all machines using abrasives meet the requirements of the current European machinery directives-CE
✓	**DO** Be aware of the hazards likely during the use of abrasives & observe the recommended precautions to be taken: – Bodily contact with the abrasive product at operating speed – Injury resulting from product breakage during use – Grinding debris, sparks, fumes & dust generated by the grinding process – Noise – Vibration

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SAFETY DON'Ts

For your safety you should ensure that you are fully aware of how to safely use diamond blades

✗	**DON'T** Allow untrained people to use abrasives
✗	**DON'T** Use a product that is damaged or one which has been dropped
✗	**DON'T** Use a product if it cannot be properly identified
✗	**DON'T** Use a machine that is not in good working order or one with defective parts
✗	**DON'T** Force the abrasive onto the mounting device or modify the size of the mounting hole
✗	**DON'T** Exceed the maximum operating speed marked on the product
✗	**DON'T** Apply shock or excessive force to the product or let it overheat
✗	**DON'T** Use mounting flanges which are not clean & flat
✗	**DON'T** Tighten the mounting device excessively
✗	**DON'T** Start the machine until the guard is in place & fastened securely
✗	**DON'T** Continue to use a product if vibration occurs. True or replace it
✗	**DON'T** Grind on the part of the product which is not designed for the operation
✗	**DON'T** Start the machine with the workpiece in contact with the abrasive product
✗	**DON'T** Grind material for which the product is not designed
✗	**DON'T** Stop the abrasive by applying pressure to its surface, let it stop naturally
✗	**DON'T** Exceed permissible rotation speeds: refer to values engraved on product
✗	**DON'T** Use blades with missing segments or core cracks
✗	**DON'T** Use dry products marked for wet use
✗	**DON'T** Wear loose clothing, ties & jewellery

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