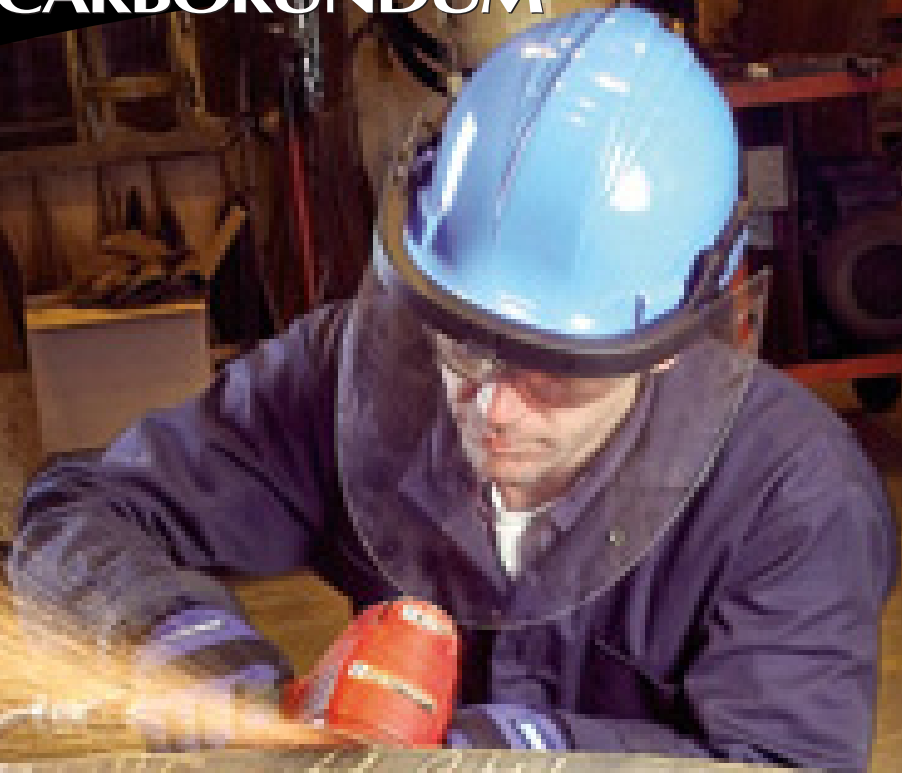
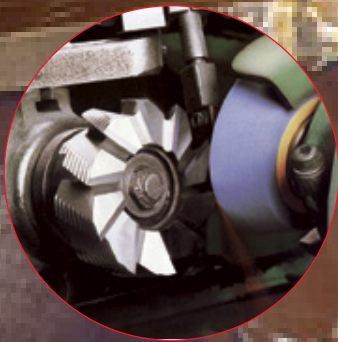


2009-2010



CARBORUNDUM



Abrasives

FOR THE INDUSTRIAL MARKET

COATED ABRASIVE AND NON-WOVEN PRODUCTS

BONDED ABRASIVE PRODUCTS

DIAMOND AND CBN PRODUCTS

Better Abrasives
Better Value

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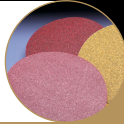
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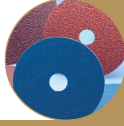
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See your Carborundum/Merit distributor for our complete line of Merit abrasive products



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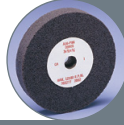
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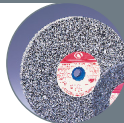
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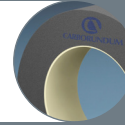
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Carborundum Product Tiering and Color Coding

Carborundum uses BEST/BETTER/GOOD abrasive product tiering - color-coded for easy product selection.

BEST Products - Red

BETTER Products - Gold

GOOD products - Black



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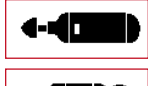
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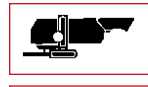
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FastTrack Belt General Information

Carborundum FastTrack Belt Service offers you all of the advantages of a major coated abrasives manufacturer combined with the benefits of a fast coated abrasive belt convertor.

We hold jumbo inventories of our most popular products in our strategically located FastTrack Centers. 24-hour conversion service for narrow belts in 35 eastern U.S. states:

AL, AR, CT, DC, DE, FL, GA, IA, IL, IN, KS, KY, LA, MA, MD, ME, MI, MN, MO, MS, NC, NE, NH, NJ, NY, OH, OK, PA, RI, SC, TN, TX, VA, VT, WI, WV

Lead Times

All FastTrack belts are made-to-order

- 2 days for narrow belts (<= 12" widths)
- 24-hour conversion service for narrow belts in 35 eastern U.S. states
- 5 days for wide belts (>= 14" widths)

Minimum Quantity

- 1 package

Product Availability

Paper Product:

- Aluminum Oxide

Cloth Products:

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

Manufacturing Leeway

- +/-10%

Size Availability

- Maximum width: 52"
- 1/2" and greater widths, for 25" and greater lengths
- Note: 8" x 107" and 9" x 107" belts are exempt from FastTrack Service.

Ordering is Easy!

- Check the FastTrack product availability on the next page
- Include a full description of belt required, including:
 - size
 - specification
 - grit size
 - quantity
- Check splice and flex availability (see pages 4 and 5)
- Verify that the quantity is within FastTrack limits
- Standard flex and splice will be shipped unless you specify otherwise.

FastTrack Packaging Standards

WIDTH	GRIT SIZE	BELTS/PKG.	BELTS/CASE	MAX. QTY.
1/2" - 1"	All	50	200	400
>1" - 4"	50 and coarser	25	50	100
109" - 168" long	60 and finer	50	50	100
All other >1" - 5"	All	10	50	100
>5" - 9"	All	10	20	40
>9" - 14"	All	10	10	20
>14" - 20"	50 and coarser	5	10	20
	60 and finer	10	10	20
>20" - 52"	36 and coarser	2	2	4
	40 - 80	3	3	6
	100 and finer	5	5	10



Spec Check

FASTTRACK BELT APPLICATIONS

F 0714 AO	NARROW AND WIDE BELT SANDING OF SOFTWOODS
F 0915	NARROW AND WIDE BELT SANDING OF HARDWOODS
JCF 0852	NARROW BELT FOR METAL WORKING WHERE FLEXIBLE FINISHING IS REQUIRED; ROLLS
KF376	NARROW BELT FOR METAL CONTOUR FINISHING
MX240	NARROW AND WIDE BELTS, SUITABLE FOR METAL AND WOODWORKING APPLICATIONS
XC 0476	NARROW AND WIDE BELTS FOR GLASS EDGING AND BLENDING, BRASS POLISHING
XC 0776 O	NARROW AND WIDE BELT WOODWORKING APPLICATIONS
XC 0877	NARROW AND WIDE BELT GENERAL PURPOSE SANDING OF METAL; ROLLS
XP 0476 W	NARROW BELTS FOR GLASS, RUBBER AND STEEL
XP 0966 W	INTERMEDIATE GRINDING AND BLENDING OFFHAND, GREAT STARTING SPECIFICATION
XP 1176 W	NARROW AND WIDE BELTS FOR OFFHAND GRINDING AND BLENDING, STAINLESS STEEL GRINDING
YC 0986 AO	NARROW AND WIDE BELT FINISHING OF WOOD
YC 1186 O	NARROW AND WIDE BELT SANDING OF WOOD
YP 0986 W	OFFHAND CONVEYOR, CENTERLESS AND PLATEN GRINDING
YP 1186 W	MOST NARROW AND WIDE BELT METAL AND FOUNDRY APPLICATIONS
YP 1288 R	NARROW AND WIDE BELTS FOR GRINDING STAINLESS STEEL AND TITANIUM
YP 2586 W	NARROW BELT OFFHAND GRINDING AND AUTOMATICS, WIDE BELT METAL APPLICATIONS
YP 2587 R	NARROW AND WIDE BELT HARD-TO-GRIND AND HEAT-SENSITIVE METAL APPLICATIONS



FastTrack Metalworking Belts

Medalist Ceramic Alumina Cloth

Y-Weight

YP 2586 W 36 – 120 Grit Range *Narrow and Wide Belts*

Ceramic alumina abrasive with heavy-duty Y-weight polyester backing for finishing exotic alloys. Maximum grain retention, reduced edge-fray, and better body retention for longer life and product consistency. Waterproof.

Y-Weight with Grinding Aid

YP 2587 R 36 – 80 Grit Range *Narrow and Wide Belts*

Ceramic alumina abrasive on heavy-duty, Y-weight polyester backing with a special grinding aid for hard-to-grind alloyed metal, and heat-sensitive applications. Maximum grain retention, reduced edge-fray, and better body retention for longer life and product consistency.

Zirconia Alumina Cloth

X-Weight

XP 1176 W 60–220 Grit Range *Narrow and Wide Belts*

Zirconia alumina abrasive with X-weight polyester backing for weld removal and finishing ferrous and non-ferrous materials. Waterproof.

Y-Weight

YP 1186 W 24–80 Grit Range *Narrow and Wide Belts*

Zirconia alumina abrasive with heavy-duty Y-weight polyester backing for weld removal and finishing ferrous and non-ferrous materials. Maximum grain retention, reduced edge-fray, and better body retention for longer life and product consistency. Waterproof.

Y-Weight with Grinding Aid

YP 1288 R 24–120 Grit Range *Narrow and Wide Belts*

Zirconia alumina abrasive with heavy-duty Y-weight polyester backing with a grinding aid; best for heat-generating metals: Inconel, titanium, and stainless steel. Maximum grain retention, reduced edge-fray, and better body retention for longer life and product consistency. Green in color.

Silicon Carbide Cloth

X-Weight

XC 0476 24, 36–120, 180, 220, 320 Grit Range *Narrow and Wide Belts*

Silicon carbide abrasive with X-weight cotton backing for general purpose sanding of non-ferrous materials.

Y-Weight

XP 0476 W 80–120 Grit Range *Narrow Belts*

Silicon carbide abrasive with heavy-duty, Y-weight polyester backing for finishing of non-ferrous materials. Maximum grain retention, reduced edge-fray, and better body retention for long life and product consistency. Waterproof.

Aluminum Oxide Cloth

J-Weight

JCF 0852 P80–P320, P400, P600 Grit Range *Narrow Belts, Rolls*

P-graded aluminum oxide abrasive with J-weight orange cotton backing for general purpose sanding of ferrous and non-ferrous materials where a more flexible backing is needed for superior conformability and finish.

KF376

P80–P320, P400, P600 *Narrow Belts*

P-graded, aluminum oxide abrasive with very flexible, J-weight cotton backing for contour finishing.

X-Weight

XC 0877 36–240, 320 Grit Range *Narrow and Wide Belts, Rolls*

Tough, durable, brown aluminum oxide abrasive with X-weight cotton backing for general purpose sanding of ferrous and non-ferrous materials.

MX240

P24, P36–P180 Grit Range *Narrow and Wide Belts*

P-graded, aluminum oxide abrasive with X-weight polyester/cotton backing suitable for metal and woodworking applications.

XP 0966 W

P60–P240, P320, P400 Grit Range *Narrow and Wide Belts*

P-graded, heat-treated aluminum oxide abrasive with X-weight polyester backing for weld removal and finishing ferrous and non-ferrous materials. Waterproof.

Y-Weight

YP 0986 W 24, 36–120 Grit Range *Narrow and Wide Belts*

Heat-treated, aluminum oxide abrasive with a heavy-duty Y-weight polyester backing for weld removal and finishing ferrous and non-ferrous materials. Maximum grain retention, reduced edge-fray, and better body retention for longer life and product consistency. Waterproof.

FastTrack Woodworking Belts

Premier Red Zirconia Alumina Cloth Open

Y-Weight

YC 1186 O 36, 50, 80, 100, 120 Grit Range *Narrow and Wide Belts*

Zirconia alumina abrasive with Y-weight cotton backing for finishing wood and non-metallic materials. Open coat.

Aluminum Oxide Paper

F-Weight

F 0915 P80 – P220 Grit Range *Narrow and Wide Belts*

Tough, P-graded, aluminum oxide abrasive with F-weight paper backing for metalworking and woodworking.

F 0714 AO P80 – P220 Grit Range *Narrow and Wide Belts*

P-graded, light-brown aluminum oxide abrasive and antistatic bond with F-weight paper backing for dust-free woodworking. Open coat.

Aluminum Oxide Cloth Open

X-Weight

XC 0776 O 60 – 220 Grit Range *Narrow and Wide Belts*

Light-brown, aluminum oxide abrasive with X-weight, cotton backing for finishing of wood and non-metallic materials. Open coat.

Y-Weight

YC 0986 AO P60-P180 Grit Range *Narrow and Wide Belts*

P-graded, heat-treated, aluminum oxide abrasive with antistatic Y-weight cotton backing for dust-free finishing of wood and non-metallic materials. Open coat.

See page 44 for the Specification Terminology Key

FastTrack Belt General Information

Flexing

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

- shape control of the product
- flexibility to conform to the workpiece contour
- control of grain breakdown and/or pullout to improve performance

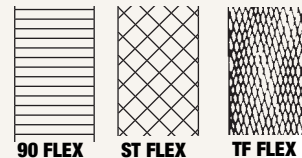
- material handling during the manufacturing operation

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

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

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

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



Belt Splices

There are two basic splice types:

LAP SPLICES

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

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

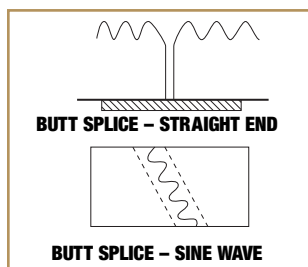
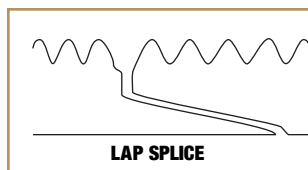
Unskived: no abrasive removed from the top of the splice.

BUTT SPLICES

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

Butt splice – straight end

Butt splice – sine: sine wave ends



Belt Splice Definitions

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

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

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

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

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

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

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

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

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

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

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

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

FastTrack Wide Belt Splice Availability

CAP CODE	40 & C STANDARD	50 – 100 STANDARD	50 – 100 AVAILABLE	120 & F STANDARD	120 & F AVAILABLE
Metal					
YP 2586 W	CB	CB	SW	CB	–
YP 2587 R	CB	CB	SW	–	–
XP 1176 W	–	CB	SW	CB	–
YP 1186 W	CB	CB	SW	–	–
YP 1288 R	CB	CB	SW	CB	–
XC 0877	CB	CB	SW	CB	–
MX240	BT	BT	–	BT	–
XP 0966 W	CB	CB	SW	CB	–
YP 0986 W	CB	CB	SW	CB	–
Non-ferrous					
XC 0476	CB(P)	CB	SW	CB	–
Wood					
YC 1186 O	CB	CB	SW	CB	–
XC 0776 O	CB	CB	SW	CB	–
YC 0986 AO	CB	CB	SW	CB	–
F 0915	–	CJ	CP	CJ	CP
F 0714 AO	–	CJ	CP	CJ	CP

FastTrack Narrow Belt Splice Availability

CAP CODE	40 & C STANDARD	50 - 100 STANDARD	50 - 100 AVAILABLE	120 & F STANDARD	120 & F AVAILABLE
Metal					
YP 2586 W	CB	CB	SW	CB	-
YP 2587 R	CB	CB	SW	-	-
XP 1176 W	-	CB	RG, SW	CB	-
YP 1186 W	CB	CB	SW	-	-
YP 1288 R	CB	CB	SW	CB	-
JCF 0852	-	CB(S)	SW	CB(S)	-
KF376	-	BT	LP, FT	BT	-
XC 0877	CB	CB	SW	CB	-
MX240	BT	BT	WA, DS, FT	BT	-
XP 0966 W	-	CB	RG, SW	CB	-
YP 0986 W	CB	CB	SW	CB	-
Non-ferrous					
XC 0476	CB(P)	CB	SW	CB	-
XP 0476 W	-	CB	RG, SW	CB	-
Wood					
YC 1186 O	CB	CB	-	CB	-
XC 0776 O	-	CB	SW	CB	-
YC 0986 AO	CB	CB	SW	CB	-
F 0915	-	CJ	-	CJ	CP
F 0714 AO	-	CJ	-	CJ	CP

Stock and FastTrack Belt Competitive Cross Reference

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

COATED

5

Portable File Belts

Medalist Ceramic Alumina Resin Cloth with Grinding Aid

Features

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

Benefits

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

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



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
1/2" x 12"				
66261184259	40	YP 2587 R	50	50
66261184260	60	YP 2587 R	50	50
66261184261	80	YP 2587 R	50	50
1/2" x 18"				
66261184262	40	YP 2587 R	50	50
66261184263	60	YP 2587 R	50	50
66261184264	80	YP 2587 R	50	50
1/2" x 24"				
66261184265	40	YP 2587 R	50	50
66261184266	60	YP 2587 R	50	50
66261184267	80	YP 2587 R	50	50



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

Aluminum Oxide Resin Cloth

Features

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

Benefits

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

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



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

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

COATED

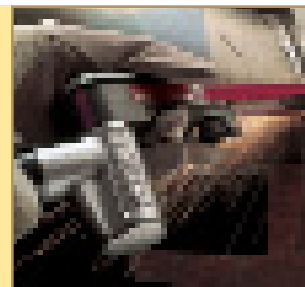
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TechTip

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



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



Premier Red Zirconia Alumina Resin Cloth Open

Features

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

Benefits

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

Excellent for finishing wood and non-metallic materials.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
3" x 21"				
05539563668	36	YC 1186 O	5	25
05539563667	50	YC 1186 O	5	25
05539563666	80	YC 1186 O	5	25
05539563665	120	YC 1186 O	5	25
3" x 24"				
05539563672	36	YC 1186 O	5	25
05539563671	50	YC 1186 O	5	25
05539563670	80	YC 1186 O	5	25
05539563669	120	YC 1186 O	5	25



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

Aluminum Oxide Resin Cloth

Features

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

Benefits

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

Ideal for sanding metal and all species of wood.



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

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

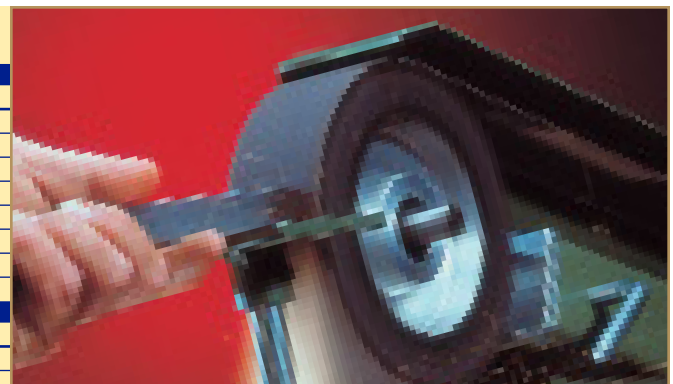
Spec Check

STARTING RECOMMENDATIONS BY MATERIAL

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

RECOMMENDED GRIT SELECTION

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



Narrow Belts

Premier Red Zirconia Alumina Resin Cloth Open

Features

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

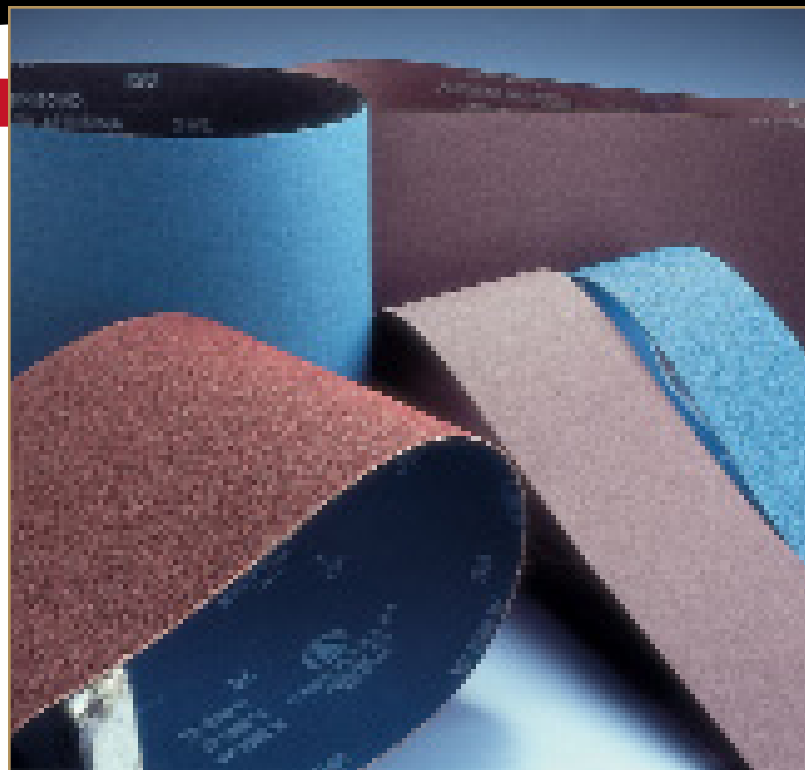
Benefits

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

Excellent for finishing wood and non-metallic materials.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
2" x 48"				
05539563660	36	YC 1186 O	10	10
05539563659	50	YC 1186 O	10	10
05539563658	80	YC 1186 O	10	10
6" x 48"				
05539563664	36	YC 1186 O	10	10
05539563663	50	YC 1186 O	10	10
05539563662	80	YC 1186 O	10	10



Aluminum Oxide Resin Cloth

Features

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

Benefits

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

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



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

See FastTrack Belt Program on pages 2 - 5 for additional specifications and sizes.

Zirconia Alumina Resin Waterproof Cloth

Features

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

Benefits

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

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



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



Aluminum Oxide Resin Cloth

Features

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

Benefits

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

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



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

Belt Cleaning Stick

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

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



24-hour conversion service for FastTrack narrow belts available in 35 eastern U.S. states.

For additional sizes and specifications of belts, refer to FastTrack Belt Service on pages 2 - 5.

Wide Belts

Aluminum Oxide Resin Cloth Open

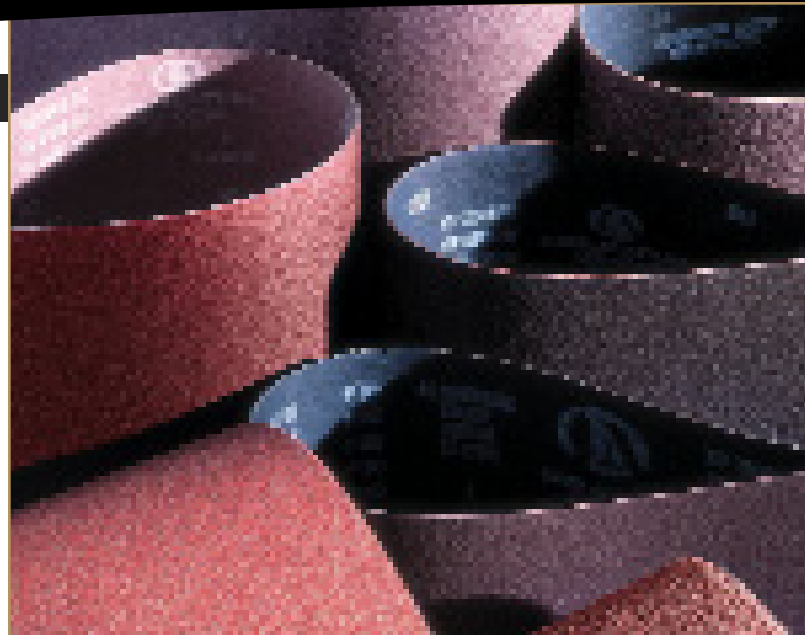
Features

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

Benefits

- Uniform scratch pattern
- Increased strength
- Resists loading

Applications include finishing of wood and non-ferrous metals.



PART NO.	GRADING		BELTS/PKG.	BELTS/CASE
25" x 75"				
05539599963	80	XC 0776 O	3	3
05539599962	100	XC 0776 O	5	5
05539599961	120	XC 0776 O	5	5
37" x 60"				
05539599978	60	XC 0776 O	3	3
05539599977	80	XC 0776 O	3	3
05539599976	100	XC 0776 O	5	5
05539599975	120	XC 0776 O	5	5
05539599974	150	XC 0776 O	5	5
05539599973	180	XC 0776 O	5	5

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



Troubleshooting Guide

PROBLEM	SUGGESTED CORRECTION – CONTACT WHEELS										
	HARDER WHEEL	SOFTER WHEEL	LARGER GROOVE/LAND	SMALLER GROOVE/LAND	DRESS WHEEL	HIGHER SPEED	LOWER SPEED	STANDARD SERRATION	LARGER WHEEL	SMALLER WHEEL	
DULLING	•		•				•			•	
LOADING			•							•	
OVER-AGGRESSIVENESS		•		•				•	•		
SLOW CUTTING	•		•			•				•	
SCRATCHES TOO DEEP		•		•				•	•		
BURNING	•						•				
NON-CONFORMITY		•	•				•		•		
DUBBING EDGES	•										
SHEDDING (ABRASIVES)		•		•	•	•		•	•		
CHATTER		•			•			•	•		
SUGGESTED CORRECTION – GENERAL											
PROBLEM	CORRECTION										
LOADING	DECREASE INFEEED PRESSURE OR BELT SPEED										
SHEDDING	REDUCE APPLIED PRESSURE USE A LESS AGGRESSIVE CONTACT WHEEL DRESS CONTACT WHEEL IF WORN OR DAMAGED USE ENTIRE SURFACE OF BELT										
BELT BREAKAGE	REDUCE BELT TENSION USE LESS AGGRESSIVE CONTACT WHEEL CHECK TRACKING MECHANISM FOR BELTS TRACKING ERRATICALLY										
REDUCED BELT LIFE	USE COARSER GRIT REDUCE PRESSURE										

COATED

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For additional sizes and specifications of belts, refer to FastTrack Belt Service on pages 2 - 5.

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

Features

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

Benefits

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

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



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

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

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

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

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

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

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

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

PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
6" x 0" Individual Tabbed Discs			
05539520296	P1000 B 0712 DO	100	400
05539520295	P1200 B 0712 DO	100	400
05539520294	P1500 B 0712 DO	100	400

PART NO.	GRADING	ROLLS/CASE	MIN. QTY.
8" x 0" Link Disc Rolls			
05539561110	P80 B 0912 DO	4	4
05539561109	P100 B 0912 DO	4	4
05539561108	P120 B 0912 DO	4	4
05539561107*	P150 B 0912 DO	4	60
05539561106	P180 B 0912 DO	4	4
05539561105	P220 B 0912 DO	4	4
05539561104*	P240 B 0912 DO	4	60
05539561103*	P280 B 0912 DO	4	60
05539561102	P320 B 0912 DO	4	4

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

See back-up pads for these discs on page 14.
Disc roll dispenser available on page 16.

Stick-On Paper Discs

Aluminum Oxide Dri-Lube Resin Paper Open Stick-On

Features

- P-graded, sharp light-brown, aluminum oxide abrasive
- Premium B-weight latex-saturated, high-internal-bond paper backing
- PSA (pressure sensitive adhesive) backing and tabbed discs
- Water-based stearate oversize and an open coat
- No pigment in anti-load oversize or bond
- Link disc roll, 4-pack with polybags
- 5" individual PSA discs have a tabbed, white, translucent liner

Benefits

- Fast cut rate, extended life and consistent finish
- Improved resistance to delamination, can be used moist or wet
- Easy application and removal
- Improved load resistance on a broad range of substrates
- No risk of color transfer, stronger bond
- Easy dispensing
- Minimizes storage space
- The PSA adhesive is protected from air-borne contaminants
- The tab allows easier removal of the paper liner

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



PART NO.	GRADING	ROLLS/CASE	MIN. QTY.
5" x 0" Link Disc Rolls			
66623362930	P80 PB273	4	
66623371920*	P100 PB273	4	60
66623362929	P120 PB273	4	
66623362928	P150 PB273	4	
66623362927	P180 PB273	4	
66623362926	P220 PB273	4	
66623362925	P240 PB273	4	
66623362924	P320 PB273	4	
66623362923	P400 PB273	4	
66623362922	P600 PB273	4	
66623362921	P800 PB273	4	

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

PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
5" x 0" Individual Tabbed Discs			
69957348198	P80 PB273	100	400
69957348200	P100 PB273	100	400
69957348201	P120 PB273	100	400
69957348202	P150 PB273	100	400
69957348203	P180 PB273	100	400
69957348204	P220 PB273	100	400
69957348205	P240 PB273	100	400
69957348206	P320 PB273	100	400
69957348207	P400 PB273	100	400
69957348223	P600 PB273	100	400
69957348224	P800 PB273	100	400

PART NO.	GRADING	ROLLS/CASE	MIN. QTY.
6" x 0" Link Disc Roll			
66623362940	P80 PB273	4	
69957352447*	P100 PB273	4	60
66623362939	P120 PB273	4	
66623362938	P150 PB273	4	
66623362937	P180 PB273	4	
66623362936	P220 PB273	4	
66623362935	P240 PB273	4	
66623362934	P320 PB273	4	
66623362933	P400 PB273	4	
66623362932	P600 PB273	4	
66623362931	P800 PB273	4	

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

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

See back-up pads for these discs on page 14.

Disc roll dispenser available on page 16.

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

Features

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

Benefits

- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance
- No pigment transfer
- Easy dispensing
- Minimizes storage space
- Protects individual rolls

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



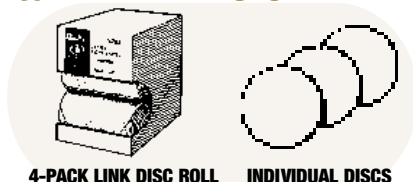
PART NO.	GRADING	ROLLS/CASE	MIN. QTY.
5" x 0" Link Disc Rolls			
77696060029*	P60 C 0712 DO	4	60
05539510555	P80 C 0712 DO	4	4
05539510554	P100 C 0712 DO	4	4
05539510553	P120 C 0712 DO	4	4
05539510552	P150 C 0712 DO	4	4
05539510550	P180 C 0712 DO	4	4
05539510549	P220 C 0712 DO	4	4
05539510548	P240 C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

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

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

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

Types of Disc Packaging



4-PACK LINK DISC ROLL INDIVIDUAL DISCS

Silicon Carbide Dri-Lube Paper Open Stick-On

Features

- Silicon carbide abrasive
- Heavy, B-weight paper
- PSA backing
- Stearate oversize and an open coat
- Link disc roll

Benefits

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

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



PART NO.	GRADING		ROLLS/CASE
5" x 0" Link Disc Rolls			
05539510526	80	B 0411 DO	4
05539510525	100	B 0411 DO	4
05539510523	120	B 0411 DO	4

continued

PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
5" x 0" Link Disc Rolls (continued)				
05539510522	150	B 0411 DO	4	4
05539510521	180	B 0411 DO	4	4
05539510520*	220	B 0411 DO	4	60
05539510519	240	B 0411 DO	4	4
05539510517	320	B 0411 DO	4	4
05539510516	400	B 0411 DO	4	4

6" x 0" Link Disc Rolls

05539510544*	80	B 0411 DO	4	60
05539510543*	100	B 0411 DO	4	60
05539510542*	120	B 0411 DO	4	60
05539510540	180	B 0411 DO	4	4
05539510539	220	B 0411 DO	4	4
05539510535*	320	B 0411 DO	4	24

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

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

Premier Red Zirconia Alumina Resin Paper Open Stick-On

Features

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

Benefits

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

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



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

8" x 0" Individual Discs

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

Carbo Gold Aluminum Oxide Resin Paper Open Stick-On

Features

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

Benefits

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

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



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

8" x 0" Individual Discs

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

Premier Red Aluminum Oxide Resin Paper Stick-On

Features

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

Benefits

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

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



PART NO.	GRADING		ROLLS/CASE
5" x 0" Link Disc Rolls			
05539512549	P60	F 0915	4
05539512550	P80	F 0915	4
05539512551	P100	F 0915	4
05539512552	P120	F 0915	4

6" x 0" Link Disc Rolls

05539512556	P60	F 0915	4
05539512557	P80	F 0915	4

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

Aluminum Oxide Resin Cloth Stick-On

Features

- P-graded, heat-treated, aluminum oxide abrasive

- Resin bond system

- Flexible J-weight backing

- PSA (pressure sensitive adhesive) backing

- 5" individual PSA discs have a tabbed, white, translucent liner

Benefits

- Excellent cut rate, long life

- Increased strength and durability
- Produces fine finishes on soft metals and wood

- Provides flexibility needed for contouring while maintaining grain adhesion

- Easy application and removal

- The PSA adhesive is protected from air-borne contaminants

- The tab allows easier removal of the paper liner

Designed for intermediate/light pressure, dry sanding. Ideal for dimensioning and finishing of contours.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
5" x 0" Individual Tabbed Discs				
66623351358	P80	KJ370	50	250
66623351359	P100	KJ370	50	250
66623351360	P120	KJ370	50	250
66623351361	P150	KJ370	50	250
66623351362	P180	KJ370	50	250
66623351363	P220	KJ370	50	250

Looking for more cloth PSA discs? Ask your Carborundum/Merit distributor about our Merit ShurStick discs, or visit www.meritabrasives.com

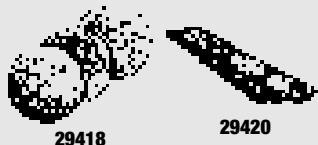
Disc roll dispenser available on page 16.

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



Back-up Pads for Stick-On Discs

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



PSA Conversion Discs and Strips

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

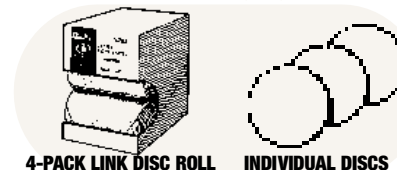
PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
Back-up Pads for Stick-On Discs			
05539599303	3" Low Profile - Soft	12,000	10*
05539599304	5" Low Profile - Soft	12,000	5*
05539599309	5" Low Profile - Medium	15,000	5*
05539512021	5" Tapered - Medium	10,000	1
05539599317	5" Tapered - Medium	15,000	5*
05539599305	6" Low Profile - Soft	12,000	5*
05539599311	6" Low Profile - Medium	15,000	5*
05539512022	6" Tapered - Medium	10,000	1
05539599319	6" Tapered - Medium	15,000	5*
05539512023	8" x 1/2 Tapered - Medium	4,800	1
Stick-On to Grip-On Conversion Discs and Strips			
05539529420	2-3/4" x 16-1/2"		20
05539529418	6"		20

* Packaged in individual clamshells

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Types of Disc Packaging



4-PACK LINK DISC ROLL

INDIVIDUAL DISCS



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

Features

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

Benefits

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

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



PART NO.	GRADING		ROLLS/CASE	MIN. QTY.
5" x 5 Hole Vacuum Link Disc Rolls D-3329				
05539515295	P80	B 0912 DO	4	4
05539515294	P100	B 0912 DO	4	4
05539515293	P120	B 0912 DO	4	4
05539515292	P150	B 0912 DO	4	4
05539515291	P180	B 0912 DO	4	4
05539515287	P220	B 0912 DO	4	4
05539515286	P240	B 0912 DO	4	4
05539515285*	P280	B 0912 DO	4	60
05539515284	P320	B 0912 DO	4	4
05539515282	P400	B 0912 DO	4	4
05539515281	P600	B 0912 DO	4	4
05539515279	P800	B 0712 DO	4	4



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

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

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

See back-up pads for these discs on page 16.

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

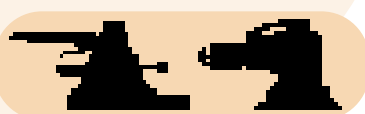
Features

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

Benefits

- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance
- No pigment transfer
- Dust-free sanding environment
- Easy dispensing
- Minimizes storage space
- Reduces cardboard waste
- Protects individual rolls

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



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

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

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

Vacuum Stick-On Paper Discs

Premier Red Zirconia Alumina Resin Paper Open Vacuum Stick-On

Features

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

Benefits

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

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



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
6" x 6 Hole Individual Vacuum Discs D-3371				
05539521307	40	E 1214 O	50	200
PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
8" x 8 Hole Individual Vacuum Discs D-3370				
05539521311	36	E 1214 O	25	100
05539521309	80	E 1214 O	25	100

Back-up Pads for Vacuum Stick-On Discs



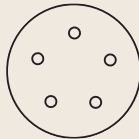
Vinyl-faced pads for use with Stick-On discs with standard vacuum hole patterns. These pads have a riveted 5/16"-24 threaded shank.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
Back-up Pad for Stick-On Vacuum Discs			
05539599310	5" x 5 Hole Low Profile - Medium	15,000	5*
05539512025	5" x 5 Hole Tapered - Medium	10,000	1
05539599318	5" x 5 Hole Tapered - Medium	15,000	5*
05539599312	6" x 6 Hole Low Profile - Medium	15,000	5*
05539599320	6" x 6 Hole Tapered - Medium	15,000	5*

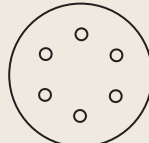
* Packaged in Individual Clamshells

Die Patterns

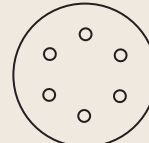
Die pattern numbers showing hole patterns on Vacuum Stick-On Discs.



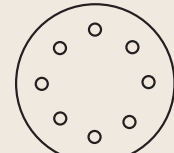
DIE D-3329 – DISCS ROLLS
5" PAD WITH
5 VACUUM HOLES



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

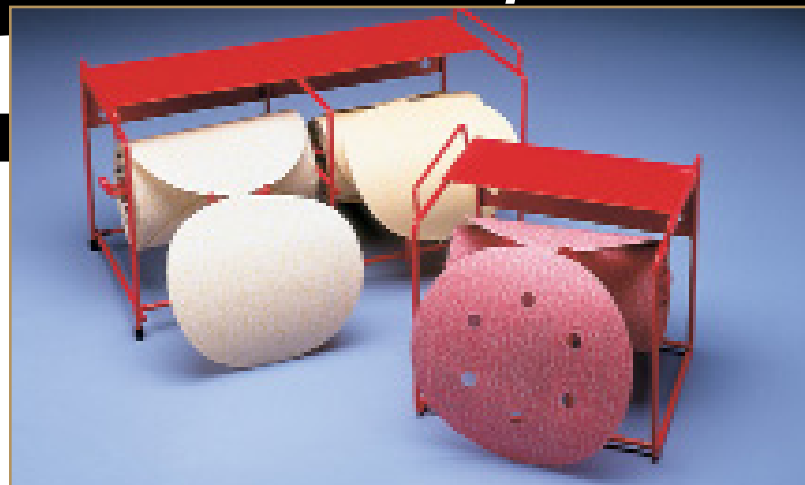


DIE D-3371
6" PAD WITH
6 VACUUM HOLES



DIE D-3370
8" PAD WITH
8 VACUUM HOLES

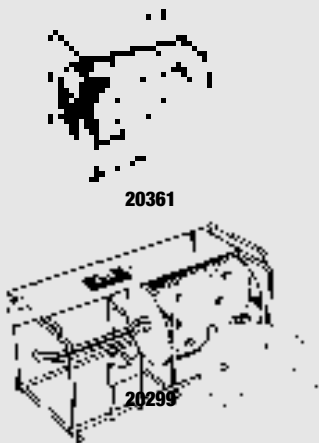
Dispensers



Disc Roll Dispensers

COATED

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

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

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

Features

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

Benefits

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

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



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

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

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
6" x 0" Individual Discs				
05539520289	P80	B 0912 DO	100	400
05539520288	P100	B 0912 DO	100	400
05539520287	P120	B 0912 DO	100	400
05539520285	P150	B 0912 DO	100	400
05539520284	P180	B 0912 DO	100	400
05539520283	P220	B 0912 DO	100	400
05539520282	P240	B 0912 DO	100	400
05539520278	P280	B 0912 DO	100	400
05539520277	P320	B 0912 DO	100	400
05539520276	P400	B 0912 DO	100	400
05539563782	P500	B 0912 DO	100	400
05539520275	P600	B 0912 DO	100	400
05539520274	P800	B 0712 DO	100	400
05539520272	P1000	B 0712 DO	100	400
05539520271	P1200	B 0712 DO	100	400
05539520270	P1500	B 0712 DO	100	400

See back-up pads for these discs on page 19.

Spec Check

PAPER DISC STARTING RECOMMENDATIONS BY MATERIAL/APPLICATION

MATERIAL	BEST PERFORMANCE	GENERAL-DUTY
UNFINISHED METAL	E 1214 O, F 0915	E 0912 O
PRIMED AND PAINTED SURFACES	B 0912 DO / B 0712 DO	C 0712 DO, PB273
FIBERGLASS / COMPOSITES	B 0912 DO / B 0712 DO, E 1214 O	C 0712 DO, PB273, E 0912 O
BARE WOOD	B 0912 DO / B 0712 DO	C 0712 DO, PB273
SEALER SANDING	B 0912 DO / B 0712 DO	B 0411 DO
PAINT STRIPPING	B 0912 DO / B 0712 DO, E 1214 O	C 0712 DO, PB273, E 0912 O



Aluminum Oxide Dri-Lube Resin Paper Open Grip-On

Features

- P-graded, sharp light-brown, aluminum oxide abrasive
- Premium B-weight latex-saturated, high-internal-bond paper backing
- Hook and loop fastening system
- Water-based stearate oversize and an open coat
- No pigment in anti-load oversize or bond
- Link disc roll, 4-pack with polybags

Benefits

- Fast cut rate, extended life and consistent finish
- Improved resistance to delamination, can be used moist or wet
- Neat, clean application and removal
- Can be re-used
- Improved load resistance on a broad range of substrates
- No risk of color transfer, stronger bond
- Easy dispensing
- Minimizes storage space

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



PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
5" x 0" Individual Discs			
66623362950	P80 PB273	100	400
66623365788	P100 PB273	100	400
66623362949	P120 PB273	100	400
66623362948	P150 PB273	100	400

continued

PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
5" x 0" Individual Discs (cont'd)			
66623362947	P180 PB273	100	400
66623362946	P220 PB273	100	400
66623362945	P240 PB273	100	400
66623362944	P320 PB273	100	400
66623362943	P400 PB273	100	400
66261023937	P500 PB273	100	400
66623362942	P600 PB273	100	400
66623362941	P800 PB273	100	400
6" x 0" Individual Discs			
66623362960	P80 PB273	100	400
66623365789	P100 PB273	100	400
66623362959	P120 PB273	100	400
66623362958	P150 PB273	100	400
66623362957	P180 PB273	100	400
66623362956	P220 PB273	100	400
66623362955	P240 PB273	100	400
66623362954	P320 PB273	100	400
66623362953	P400 PB273	100	400
66623362952	P600 PB273	100	400
66623362951	P800 PB273	100	400

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

Features

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

Benefits

- Fast cut, long life
- Durable, high tear resistance
- Neat, clean application and removal
- Excellent load resistance
- No pigment transfer

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



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

continued

PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
5" x 0" Individual Discs (cont'd)			
05539520120	P150 C 0712 DO	100	400
05539520119	P180 C 0712 DO	100	400
05539520118	P220 C 0712 DO	100	400
05539520115	P320 C 0712 DO	100	400
6" x 0" Individual Discs			
05539520134	P80 C 0712 DO	100	400
05539520133	P100 C 0712 DO	100	400
05539520132	P120 C 0712 DO	100	400
05539520131	P150 C 0712 DO	100	400
05539520130	P180 C 0712 DO	100	400
05539520129	P220 C 0712 DO	100	400
05539520126	P320 C 0712 DO	100	400
05539520125	P400 C 0712 DO	100	400

COATED

18 Premier Red Zirconia Alumina Resin Paper Open Grip-On

Features

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

Benefits

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

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



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

Carbo Gold Aluminum Oxide Resin Paper Open Grip-On

Features

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

Benefits

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

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



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
8" x 0" Individual Discs				
05539518836	P80	E 0912 O	25	250

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



20521, 20520

Back-Up Pad

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

Interface Pad

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

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
Back-up Pads for Grip-On Discs			

05539599306	3" Low Profile - Soft	12,000	5*
05539599307	5" Low Profile - Soft	12,000	5*
05539599313	5" Low Profile - Medium	15,000	5*
05539512028	5" Tapered - Medium	10,000	1
05539599321	5" Tapered - Medium	15,000	5*
05539599308	6" Low Profile - Soft	12,000	5*
05539599315	6" Low Profile - Medium	15,000	5*
05539512029	6" Tapered - Medium	10,000	1
05539599323	6" Tapered - Medium	15,000	5*
05539512030	8" Tapered - Medium	4,800	1

Interface Pads for Grip-On Discs

05539520521	5" Interface Pad	—	20
05539520520	6" Interface Pad	—	20

* Packaged in Individual Clamshells

Disc Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	VSM
PAPER DISCS					
B 0411 DO	414N, 415N,	PSF-LL, SA167	PL35	CARAT(B)	CP131A
B 0912 DO, B 0712 DO	216U, 255L, 260L, 334U, 365L	HC133, HCAB	PS33	Q-SILVER, ROYAL	—
PB273	214U, 216U, 236U, 316U, 360L	VC151-LL, HCAB	PS33	BULLDOG GOLD, ROYAL	—
C 0712 DO	236U, 316U	HCAB	PS33, PL36	BULLDOG GOLD	KP911
E 0912 O	245N, 246U, 296O, 251U, 253N, 346U	—	PS23	—	KP510E
E 1214 O	750U, 751U, 740I, 745I	—	—	ROYAL COARSE CUT	KP510E, KP709
F 0915	241, 242, 263U, 360I, 361I, 362I, 363I	BW115	PS20	—	KP709, KP508E
CLOTH DISCS					
XC 0877	241D, 251D, 261D, 248D	RB346MX	CS310X	—	KK511X

Vacuum Grip-On Paper Discs

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

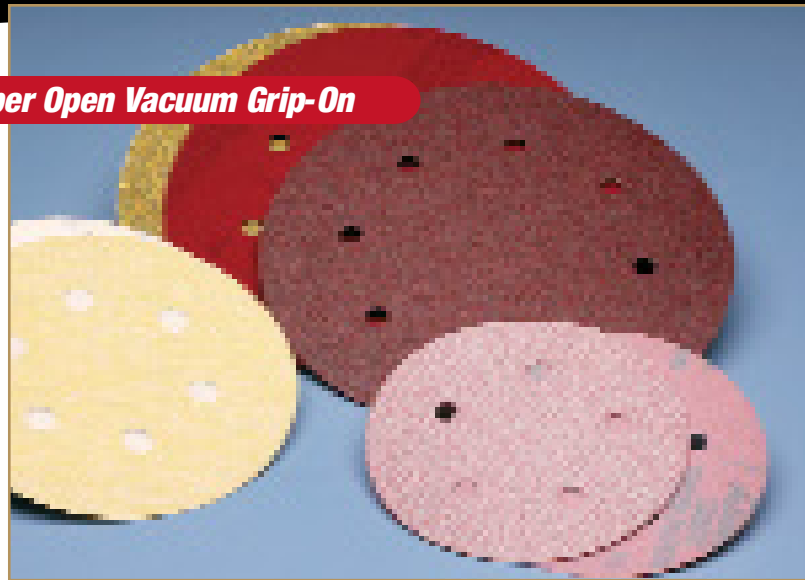
Features

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

Benefits

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

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



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

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

Aluminum Oxide Dri-Lube Resin Paper Open Vacuum Grip-On

Features

- P-graded, sharp light-brown, aluminum oxide abrasive
- Premium B-weight latex-saturated, high-internal-bond paper backing
- Hook and loop fastening system
- Water-based stearate oversize and an open coat
- No pigment in anti-load oversize or bond
- Vacuum holes

Benefits

- Fast cut rate, extended life and consistent finish
- Improved resistance to delamination, can be used moist or wet
- Neat, clean application and removal
- Can be re-used
- Improved load resistance on a broad range of substrates
- No risk of color transfer, stronger bond
- Dust-free sanding environment
- Extended life

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



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
5" x 8 Hole Individual Vacuum Discs D-3392				
66623366071	P80	PB273	100	400
66623366978	P120	PB273	100	400
66623366073	P150	PB273	100	400
66623366074	P180	PB273	100	400
66623366075	P220	PB273	100	400
66623366077	P320	PB273	100	400

See back-up pads for these discs on page 21.

COATED

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

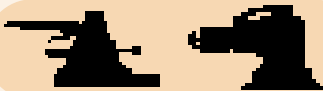
Features

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

Benefits

- Fast cut, long life
- Durable, high tear resistance
- Neat, clean application and removal
- Excellent load resistance
- No pigment transfer
- Dust-free sanding environment

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



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

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

Premier Red Zirconia Alumina Resin Paper Open Vacuum Grip-On

Features

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

Benefits

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

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



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

Back-up Pads for Vacuum Grip-On Discs



20358, 20359

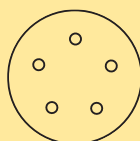
Unique hook and loop fastening system for use with standard 5" and 6" vacuum hole patterns. These pads have a riveted 5/16"-24 threaded shank.

PART NO.	DESCRIPTION	MAX. RPM	PADS/CASE
Back-up Pads for Grip-On Vacuum Discs			
05539599314	5" x 5 Hole Low Profile - Medium	15,000	5*
05539520358	5" x 5 Hole Tapered - Medium	10,000	1
05539599322	5" x 5 Hole Tapered - Medium	15,000	5*
05539599316	6" x 6 Hole Low Profile - Medium	15,000	5*
05539520359	6" x 6 Hole Tapered - Medium	10,000	1
05539599324	6" x 6 Hole Tapered - Medium	15,000	5*

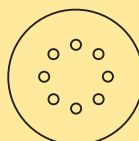
** Packaged in Individual Clamshells*

Die Patterns

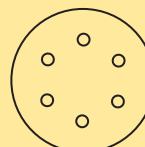
Die pattern numbers showing hole patterns on Vacuum Stick-On Discs.



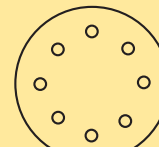
DIE D-3328
5" PAD WITH
5 VACUUM HOLES



DIE D-3392
5" PAD WITH
8 VACUUM HOLES



DIE D-3371
6" PAD WITH
6 VACUUM HOLES



DIE D-3370
8" PAD WITH
8 VACUUM HOLES

Glue-On Paper Discs

Premier Red Zirconia Alumina Resin Paper Open

Features

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

Benefits

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

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

Use disc cement to apply these discs.



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



Carbo Gold Aluminum Oxide Resin Paper Open

Features

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

Benefits

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

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

Use disc cement to apply these discs.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
6" x 0" Individual Discs				
05539512417	P40	E 0912 O	100	400
05539512415	P80	E 0912 O	100	400
8" x 0" Individual Discs				
05539512420	P40	E 0912 O	50	200
05539512419	P80	E 0912 O	50	200

Disc Cement

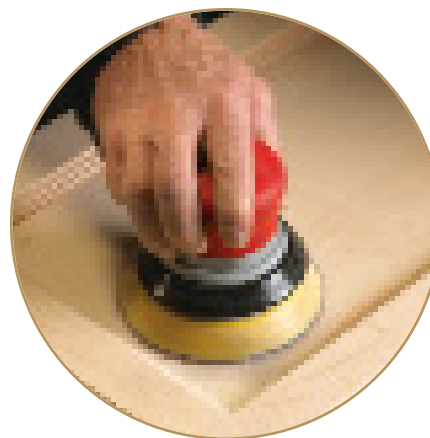
Disc Cement

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



PART NO.	GRADING	TUBE/CAN/CASE
Disc Cement		
05539512009	5 oz. Tube / 148 ml Tube	12
05539512010	16 oz. Can / 500 ml Can	12

**Looking for Flex-Loc cloth discs?
Ask your Carborundum/Merit distributor about our complete line of quality Merit PowerLock discs.**



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Medalist Ceramic Alumina Resin Fiber

Features

- Ceramic alumina abrasive
- Resin bond
- Heavy fiber backing

Benefits

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

The choice for all fiber disc grinding applications requiring aggressive cutting action, cool cut and long life.

For hardest-to-grind materials.



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
4-1/2" x 7/8" Individual Discs				
05539510719	36	V 2547	25	25
05539510717	60	V 2547	25	25
05539510716	80	V 2547	25	25
5" x 7/8" Individual Discs				
05539510732	24	V 2547	25	25
05539510731	36	V 2547	25	25
05539510730	50	V 2547	25	25
05539510728	60	V 2547	25	25
05539510727	80	V 2547	25	25
7" x 7/8" Individual Discs				
05539510742	24	V 2547	25	25
05539510740	36	V 2547	25	25
05539510738	50	V 2547	25	25
05539510736	60	V 2547	25	25
05539510735	80	V 2547	25	25



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
9-1/8" x 7/8" Individual Discs				
05539510782	24	V 2547	25	25
05539510749	36	V 2547	25	25
05539510748	50	V 2547	25	25

See back-up pads for these discs on page 24.

Premier Red Zirconia Alumina Resin Fiber

Features

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

Benefits

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

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



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
4-1/2" x 7/8" Individual Discs				
05539520088	24	V 1247	25	25
05539520087	36	V 1247	25	25
05539520086	50	V 1247	25	25
05539520034	60	V 1247	25	25
05539520019	80	V 1247	25	25

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
5" x 7/8" Individual Discs				
05539510713	24	V 1247	25	25
05539510712	36	V 1247	25	25
05539510711	50	V 1247	25	25
05539520069	60	V 1247	25	25
05539520055	80	V 1247	25	25
7" x 7/8" Individual Discs				
05539510722	24	V 1247	25	25
05539510721	36	V 1247	25	25
05539510720	50	V 1247	25	25
05539520077	60	V 1247	25	25
05539520076	80	V 1247	25	25
9-1/8" x 7/8" Individual Discs				
05539520083	36	V 1247	25	25

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Fiber Disc Competitive Cross Reference

CARBORUNDUM	3M	GEMTEX	HERMES	VSM	KLINGSPOR	SAIT	SIA/SANGAP
V 2547	983C, 984C, 988C	CERAMIX	CB444X, CB444J	ZF713, SF750, SF840	-	-	-
V 1247	501C, 785C	-	RB414X, CB444J, CB444X	KF715	CS565, CS566	-	-
V 0947	281C, 381C, 380C	-	RB314X, RB314J	KF708, KF808	CS561	-	4919

Resin Fiber Discs

Aluminum Oxide Resin Fiber

Features

- Heat-treated, aluminum oxide abrasive
- Resin bond
- Heavy fiber backing

Benefits

- Aggressive yet cool cutting with long life
- Increased strength, durability and grain adhesion
- Strength and tear resistance

Ideal for rust, bare metal, welds, stainless steel and general purpose use.



PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
4" x 5/8" Individual Discs			
05539510595	24 V 0947	25	25
05539510594	36 V 0947	25	25
05539510593	50 V 0947	25	25
05539510592	60 V 0947	25	25
05539510591	80 V 0947	25	25
4-1/2" x 7/8" Individual Discs			
05539510603	24 V 0947	25	25
05539510602	36 V 0947	25	25
05539510601	50 V 0947	25	25
05539510600	60 V 0947	25	25
05539510598	80 V 0947	25	25
05539510597	100 V 0947	25	25
05539510596	120 V 0947	25	25

PART NO.	GRADING	DISCS/PKG.	DISCS/CASE
5" x 7/8" Individual Discs			
05539510684	16 V 0947	25	25
05539510683	24 V 0947	25	25
05539510682	36 V 0947	25	25
05539510680	50 V 0947	25	25
05539510676	60 V 0947	25	25
05539510675	80 V 0947	25	25
05539510674	100 V 0947	25	25
05539510673	120 V 0947	25	25
7" x 7/8" Individual Discs			
05539510693	16 V 0947	25	25
05539510692	24 V 0947	25	25
05539510691	36 V 0947	25	25
05539510690	50 V 0947	25	25
05539510689	60 V 0947	25	25
05539510688	80 V 0947	25	25
05539510686	100 V 0947	25	25
05539510685	120 V 0947	25	25
7" x 7/8" - Flex-Loc Individual Discs			
05539511144	36 V 0947	25	25
9-1/8" x 7/8" Individual Discs			
05539510702	24 V 0947	25	25
05539510701	36 V 0947	25	25
05539510700	50 V 0947	25	25
05539510699	60 V 0947	25	25
05539510695	120 V 0947	25	25

Back-up Pads for Resin Fiber Discs



62582, 12032, 12033

For all-purpose fiber disc sanding. Curved ribs on pad face reduce loading and allow for cooler cut. All pads have a threaded 5/8"-111 female hub.

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

Pad Nut for Resin Fiber Discs



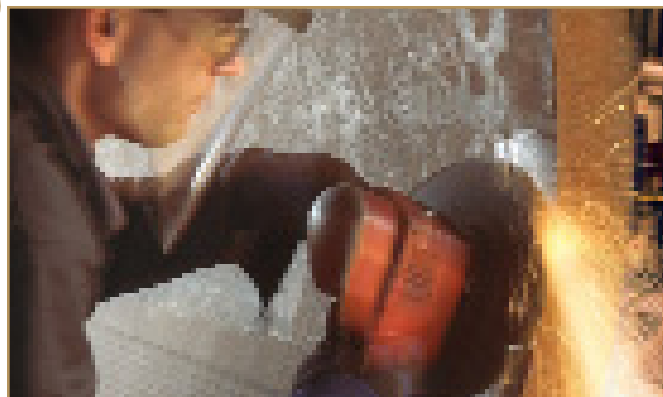
12568

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

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

COATED

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Spec Check

STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	HEAVY-DUTY BEST PERFORMANCE	GENERAL-DUTY
CARBON STEEL	V 2547	V 1247
STAINLESS STEEL/ALLOYS	V 2547, V 1247	
CAST IRON	V 2547	V 1247
BRASS/BRONZE	V 1247	V 0947
ALUMINUM	V 1247	V 0947
FIBERGLASS	V 2547	V 1247
PAINT REMOVAL AND CLEAN-UP	V 1247	V 0947

RECOMMENDED GRIT SELECTION

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



Medalist Ceramic Alumina Resin Fiber

NEW!

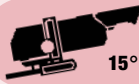
Features

- Ceramic alumina abrasive
- Resin bond
- Heavy fiber backing
- Round edge shape
- Scooped holes
- Flex-Loc mount

Benefits

- Sharper, cooler cutting abrasive continually exposing sharp points
- Fast cut rate with long life
- Increased strength, durability and grain adhesion
- Strength and tear resistance
- Ideal for reaching into grooves, sharp edges, and hard-to-grind corners where work is done at a steeper angle
- Create air flow to remove swarf – preventing loading – and a 30% cooler cutting action than conventional discs
- Quick, tool-free changing of discs

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



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



PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
5" E-ZView Edger Flex-Loc Fiber Individual Discs				
05539562959	24	V2547	10	40
05539562960	36	V2547	10	40

Premier Red Zirconia Alumina Resin Fiber



Features

- Premium ceramic and high performance zirconia alumina abrasive blend
- Resin bond
- Heavy fiber backing
- Round edge shape
- Scooped holes
- Flex-Loc mount

Benefits

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

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



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

PART NO.	GRADING		DISCS/PKG.	DISCS/CASE
4-1/2" E-ZView Edger Flex-Loc Fiber Individual Discs				
05539563969	24	V 1247	10	40
05539563970	36	V 1247	10	40
05539563971	50	V 1247	10	40
5" E-ZView Edger Flex-Loc Fiber Individual Discs				
05539562966	24	V 1247	10	40
05539562967	36	V 1247	10	40
05539562968	50	V 1247	10	40
05539562969	60	V 1247	10	40
05539562970	80	V 1247	10	40
7" E-ZView Edger Flex-Loc Fiber Individual Discs				
05539563828	36	V 1247	10	40
05539563829	50	V 1247	10	40

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

Say Good-bye to Guesswork. Put Your Surface in Easy View.

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



Fibratex E-ZView Edger Flex-Loc Discs

Fibratex A/O Resin E-ZView Edger Flex-Loc Discs

Features

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

Benefits

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

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



Allows operator to see surface being ground!

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

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

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



63975, 63019,
63395



63835, 63836

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

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

IMPROVED!

COATED

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Fibratex Silicon Carbide Surface Strip Discs

Features

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

Benefits

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



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

Major applications include:

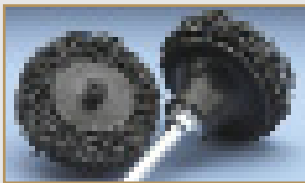
- preparing surfaces before welding
- cleaning and conditioning after welding
- surface preparation before coatings are applied
- paint and epoxy coating removal

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



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

Back-up Pads for Flex-Loc TR Discs



For Flex-Loc TR Discs

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

PART NO.	DIAMETER/DESCRIPTION	MAX. RPM	PADS/CASE
Back-Up Pads for Flex-Loc TR Discs			
66261055103	2" Flex-Loc TR Medium	25,000	10
63642504900	3" Flex-Loc TR Hard	20,000	10
66261055105	3" Flex-Loc TR Medium	20,000	10
77696061650	4" Flex-Loc TR+ Medium	8,000	10

For the complete line of non-woven discs, ask your Carborundum/Merit distributor about our extensive Merit Abrasotex disc offering, or view www.meritabrasives.com

Fibratex Depressed Center Wheels

Surface Strip Depressed Center Wheels

Features

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

Benefits

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

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

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



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



Fibratex Surface Finish Depressed Center Wheels

Features

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

Benefits

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

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

Surface Finish depressed center wheels will work anywhere our Surface Strip products work. Use Surface Finish when a less aggressive product is needed.

Major applications include:

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



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

For the complete line of non-woven wheels ask your Carborundum/Merit distributor about our Merit Abrasotex wheels, or view www.meritabrasives.com

COATED

28

Premier Red Zirconia Alumina Resin Cloth

Features

- Grind and finish at the same time
- Fits same type grinder as resin fiber disc and depressed center wheel
- Type 29 – angled flaps, conical, slightly concaved design
- Increased area of contact

Benefits

- No switching from depressed center wheel to resin fiber disc
- Eliminates need for special tools
- Built-in angle for grinding
- Minimizes workpiece gouging
- Aggressive action, high stock removal rates; durable
- Ideal for flat surfaces
- Excellent on soft metals; increased versatility
- Best choice when speed is the main consideration

- Type 27 – flat face

- More forgiving than Type 29
- Ideal for finishing intricate parts

- Type 27 Plastic – flat face, plastic back
- High performance blend of ceramic and zirconia abrasives

- Plastic back wears away with abrasives for longer life
- Requires less pressure to work at maximum performance
- More forgiving than Type 29 – producing smooth finishes

- Type 27, 27FB, Type 29, and 29FB
- Quality, zirconia alumina abrasive on durable cloth
- Phenolic resin back plate

- High rate of stock removal
- As cloth wears, new sharp grains are exposed
- Will not smear the work piece
- Wears uniformly with flaps

- Fat Boy – thicker with more flaps

- Up to 40% longer life than standard flap discs

- Fat Boy Type 27 **Expanded Offering!**

- Produces a smooth finish on shapes and irregular surfaces

- Fat Boy Type 29

- Aggressive action, high stock removal rates
- Ideal when added performance and longer life are required

- 4-1/2" and 7" available with 5-8"-11 nut

- Less down time for disc changes

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



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

continued

Ask your Carborundum/Merit distributor about our complete line of Merit Grind-O-Flex flap wheels, or visit www.meritabrasives.com



PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
4-1/2" x 7/8" – Type 27				
05539563741	36 XC 1176	13,000	5	5
05539563742	40 XC 1176	13,000	5	5
05539563743	60 XC 1176	13,000	5	5
05539563744	80 XC 1176	13,000	5	5
05539563745	120 XC 1176	13,000	5	5
7" x 5/8"-11 Nut – Type 27				
05539564056	36 XC 1176	8,600	5	5
05539564057	40 XC 1176	8,600	5	5
05539564058	60 XC 1176	8,600	5	5
7" x 7/8" – Type 27				
05539563746	36 XC 1176	8,600	5	5
05539563747	40 XC 1176	8,600	5	5
05539563748	60 XC 1176	8,600	5	5

PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
4-1/2" x 7/8" – Type 27 Plastic				
05539567811	40 XC 1176 Plastic	13,000	10	10
05539567812	60 XC 1176 Plastic	13,000	10	10
05539567813	80 XC 1176 Plastic	13,000	10	10

PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
5" x 7/8" – Type 27 Plastic				
05539570054	40 XC 1176	12,000	10	10
05539570055	60 XC 1176	12,000	10	10
05539570056	80 XC 1176	12,000	10	10

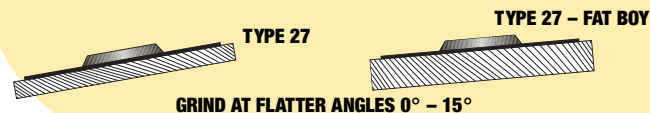
PART NO.	GRADING	MAX. RPM	DISCS/PKG.	DISCS/CASE
7" x 7/8" – Type 27 Plastic				
05539570057	40 XC 1176	8,600	10	10
05539570058	60 XC 1176	8,600	10	10
05539570059	80 XC 1176	8,600	10	10

continued

Two Basic Flap Discs Designs

TYPE 27 FLAT – THE CHOICE FOR THE BEST FINISH

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



TYPE 29 CONICAL – THE MOST AGGRESSIVE CHOICE

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

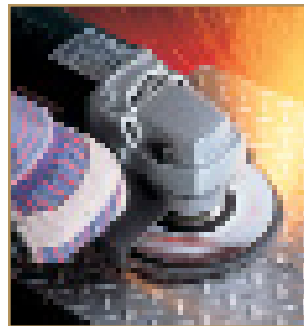


Premier Red Zirconia Alumina Resin Cloth (cont'd)

PART NO.	GRADING		MAX. RPM	DISCS/PKG.	DISCS/CASE
4-1/2" x 5/8"-11 Nut – Type 27 Fat Boy					
66261068838	40	XC 1176	12,000	5	5
66261068846	60	XC 1176	12,000	5	5
66261068848	80	XC 1176	12,000	5	5
4-1/2" x 7/8" – Type 27 Fat Boy					
05539563929	40	XC 1176	12,000	5	5
05539563930	60	XC 1176	12,000	5	5
05539563931	80	XC 1176	12,000	5	5
7" x 5/8"-11 Nut – Type 27 Fat Boy					
05539570542	40	XC 1176	8,600	5	5
05539570543	60	XC 1176	8,600	5	5
05539570544	80	XC 1176	8,600	5	5
4" x 5/8" – Type 29					
05539518617	36	XC 1176	15,000	5	5
05539518616	40	XC 1176	15,000	5	5
05539518615	60	XC 1176	15,000	5	5
05539518613	80	XC 1176	15,000	5	5
05539518610	120	XC 1176	15,000	5	5
4-1/2" x 5/8"-11 Nut – Type 29					
05539520348	36	XC 1176	13,000	5	5
05539520347	40	XC 1176	13,000	5	5
05539520346	60	XC 1176	13,000	5	5
05539520345	80	XC 1176	13,000	5	5
4-1/2" x 7/8" – Type 29					
05539518624	24	XC 1176	13,000	5	5
05539518623	36	XC 1176	13,000	5	5
05539518622	40	XC 1176	13,000	5	5
05539518621	60	XC 1176	13,000	5	5
05539518620	80	XC 1176	13,000	5	5
05539518619	120	XC 1176	13,000	5	5

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

Ask your Carborundum/Merit distributor about our complete line of Merit Grind-O-Flex flap wheels, or visit www.meritabrasives.com



TechTip

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



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

COATED

30 Spec Check

STARTING RECOMMENDATIONS BY MATERIAL

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

Flap Disc Competitive Cross Reference

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

Aluminum Oxide Resin Cloth

Features

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

Benefits

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

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



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



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

TechTip

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

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



FastTrack Roll Service

Product Availability

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

Quantity Availability

WIDTH	MINIMUM QTY.	MAXIMUM QTY.
2" to < 3"	6 rolls	12 rolls
3" to < 4"	4 rolls	8 rolls
4" to < 5"	3 rolls	6 rolls
5" through 6"	2 rolls	4 rolls
> 6" through 12"	1 roll	2 rolls

Conversion Time

- 5 days

Size Availability

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

Ordering is Easy!

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



COATED

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

Features

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

Benefits

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

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



PART NO.	GRADING		ROLLS/PKG.	ROLLS/CASE
2-3/4" x 25 Yards				
05539520340	P80	B 0912 DO	1	5
2-3/4" x 30 Yards				
05539520339	P100	B 0912 DO	1	5
05539520338	P120	B 0912 DO	1	5
2-3/4" x 45 Yards				
05539520337	P150	B 0912 DO	1	5
05539520336	P180	B 0912 DO	1	5
05539520335	P220	B 0912 DO	1	5
05539520334	P240	B 0912 DO	1	5
05539520333	P320	B 0912 DO	1	5
05539520332	P400	B 0912 DO	1	5
77696043558	P600	B 0912 DO	1	5
4-1/2" x 10 Yards				
05539561116	P80	B 0912 DO	1	5
05539561115*	P100	B 0912 DO	1	60
05539561114	P120	B 0912 DO	1	5
05539561113	P150	B 0912 DO	1	5
05539561112	P180	B 0912 DO	1	5
05539561111	P220	B 0912 DO	1	5

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

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

Features

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

Benefits

- Fast cut, long life
- High tear resistance
- Easy application and removal
- Excellent load resistance
- No pigment transfer

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



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

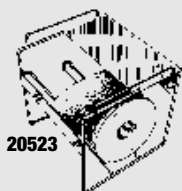
Dispenser and Sanding Block for Stick-On Rolls

Dispenser

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

Sanding Block

Rectangular sanding block for hand sanding with Stick-On rolls.



PART NO.	DESCRIPTION	PRODUCT/CASE
Stick-On Roll Dispenser		
05539520523	Stick-On Roll Dispenser	1
Sanding Block for Stick-On Rolls		
05539512031	2-3/4" x 5-1/2" Sanding Block	1

Premier Red Aluminum Oxide Dri-Lube Resin Paper Open

Features

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

Benefits

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

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



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
3-2/3" x 9"			
05539528325*	P80 B 0912 DO	100	500*
9" x 11"			
05539520538	P80 B 0912 DO	50	250
05539520537	P100 B 0912 DO	100	500
05539520536	P120 B 0912 DO	100	500
05539520535	P150 B 0912 DO	100	500
05539520534	P180 B 0912 DO	100	500
05539520533	P220 B 0912 DO	100	500

continued



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
9" x 11" (continued)			
05539520532	P240 B 0912 DO	100	500
05539520531	P280 B 0912 DO	100	500
05539520530	P320 B 0912 DO	100	500
05539520529	P400 B 0912 DO	100	500
05539563785	P500 B 0912 DO	100	500
05539520528	P600 B 0912 DO	100	500
05539514148	P800 B 0712 DO	100	500
05539520527	P1000 B 0712 DO	100	500
05539520526	P1200 B 0712 DO	100	500
05539520524	P1500 B 0712 DO	100	500

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

Carbo Gold Aluminum Oxide Dri-Lube Paper Open

Features

- P-graded, light brown, aluminum oxide abrasive
- A-weight paper
- Stearate oversize

Benefits

- Fast cut, long life with consistent finish
- Increased flexibility
- Improved load resistance

For hand and machine sanding of paint, primer, plastics and fiberglass, as well as whitewood clean-up and repair.



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
9" x 11"			
05539530479	P80 A 0711 DO	50	250
05539530478	P100 A 0711 DO	100	500
05539530477	P120 A 0711 DO	100	500
05539530480	P150 A 0711 DO	100	500
05539530476	P180 A 0711 DO	100	500
05539530475	P220 A 0711 DO	100	500
05539530474	P240 A 0711 DO	100	500
05539530472	P320 A 0711 DO	100	500
05539530471	P400 A 0711 DO	100	500
05539530470	P600 A 0711 DO	100	500

Silicon Carbide Dri-Lube Paper Open

Features

- Silicon carbide abrasive
- Heavy B-weight paper

Benefits

- Sharp cut, excellent finish
- Strong; minimum edge wear
- Tear resistance

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



PART NO.	GRADING	SHEETS/PKG.	SHEETS/CASE
9" x 11"			
05539510819	80 B 0411 DO	50	250
05539510818	100 B 0411 DO	100	500
05539510817	120 B 0411 DO	100	500
05539510816	150 B 0411 DO	100	500
05539510815	180 B 0411 DO	100	500
05539510814	220 B 0411 DO	100	500
05539510813	240 B 0411 DO	100	500
05539510812	280 B 0411 DO	100	500
05539510810	320 B 0411 DO	100	500
05539510808	400 B 0411 DO	100	500

Waterproof Paper Sheets

NEW!

Premier Red Mirror Finish Aluminum Oxide Waterproof Paper

Features

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

Benefits

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

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



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

Premier Red Mirror Finish Silicon Carbide Waterproof Paper

Features

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

Benefits

- Ultimate finish in wet applications
- Longer life in wet applications
- Ultimate flexibility
- Wet-curl resistance
- Environmentally stable; resists humidity-caused curling

Ideal for producing very fine finishes in wet applications.



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

Red-Back Silicon Carbide Waterproof Paper

Features

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

Benefits

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

Exceptional finishing in wet applications.



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

COATED

34 Silicon Carbide Waterproof Paper

Features

- Silicon carbide abrasive
- Resin bond
- Waterproof paper backing

Benefits

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

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



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



Aluminum Oxide Paper Open

Features

- P-graded, aluminum oxide abrasive

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

Benefits

- Tough and durable



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

PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
9" x 11"				
05539510876	P36	D 0811 O	25	125
05539510875	P40	D 0811 O	25	125
05539510874	P50	D 0811 O	50	250
05539510873	P60	D 0811 O	50	250
05539510872	P80	D 0811 O	50	250
05539510871	P100	C 0811 O	100	500
05539510870	P120	C 0811 O	100	500
05539510868	P150	C 0811 O	100	500
05539510862	P180	A 0811 O	100	500
05539510861	P220	A 0811 O	100	500
05539510860*	P240	A 0811 O	100	500*
05539510859*	P320	A 0811 O	100	500*

*Non-stock. Minimum order quantity is 2000.

Ask your Carborundum representative for current lead times.

Garnet Paper Open

Features

- Natural garnet abrasive
- Unique bond system

For hand and machine sanding of whitewood.

Benefits

- Sharp and consistent cutting action
- Durable



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

*Non-stock. Minimum order quantity is 1000.

Ask your Carborundum representative for current lead times.

Emery Polishing Paper

Features

- Ultra fine emery powder

Ideal for all fine metal polishing applications.

Benefits

- Least aggressive cut



PART NO.	GRADING		SHEETS/PKG.	SHEETS/CASE
9" x 13-3/4"				
05539512325*	0	C 0210	100	1000*
05539512323	2 / 0	C 0210	100	500
05539512322	3 / 0	C 0210	100	500
05539512321	4 / 0	C 0210	100	500

*Non-stock. Minimum order for this non-stock item is 1000.

Ask your Carborundum representative for current lead times.

COATED

35



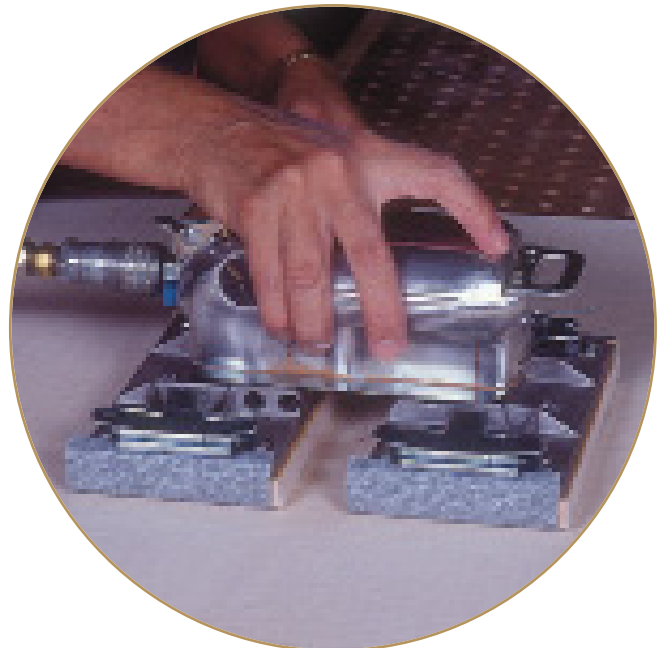
Spec Check

PAPER SHEET STARTING RECOMMENDATIONS BY MATERIAL/APPLICATION

MATERIAL	BEST PERFORMANCE	GENERAL DUTY
UNFINISHED METAL	B 0912 DO / B 0712 DO	A 0711 DO, D 0811 O, C 0811 O, A 0811 O
PRIMED AND PAINTED SURFACES	B 0912 DO / B 0712 DO	A 0711 DO, D 0811 O, C 0811 O, A 0811 O
FIBERGLASS / COMPOSITES	B 0912 DO / B 0712 DO	A 0711 DO
BARE WOOD	B 0912 DO / B 0712 DO, A 0711 DO	A 0311 O, C 0311 O, D 0311 O, D 0811 O, C 0811 O, A 0811 O
CLEAR AND COAT SANDING	AF 0415 W	
SEALER SANDING	B 0912 DO / B 0712 DO, A 0711 DO	B 0411 DO
LACQUER SANDING	AF 0415 W, AF 0416 W	C 0414 W, B 0912 DO / B 0712 DO, BF 0916 W
WET SANDING	AF 0415 W, AF 0416 W	C 0414 W, B 0912 DO / B 0712 DO, BF 0916 W
PAINT STRIPPING	B 0912 DO / B 0712 DO	
DRYWALL SANDING	M 0405 W	
FINE METAL POLISHING	C 0210	

Paper Sheet Competitive Cross Reference

CARBORUNDUM	3M	HERMES	KLINGSPOR	MIRKA	VSM
A 0311 O	110N	-	-	-	-
A 0711 DO	316U	-	PL36	GOLDFLEX	-
A 0811 O	210N, 210U	HFB	PL31	-	-
AF 0415 W	401Q	WSFLEX18B	PS11	WATERPROOF (A)	CP918A
AF 0416 W	413Q	WSFLEX18B	PS11	WATERPROOF (A)	CP918A
B 0411 DO	415U, 415N	-	PL35	CARAT(B)	-
B 0912 DO, B 0712 DO	214U, 216U, 334U, 734U	HC133, HCAB	PS33	ROYAL, ROYAL MICRO	-
BF 0916 W, BF 0716 W	213Q	-	PS12	-	-
C 0210	041N	-	-	-	-
C 0311 O	130N	GCAB	-	-	-
C 0414 W	438Q, 431Q	WSFLEX18C	PS11	-	CP918C
C 0811 O	230N	HFB	PL31	-	KP31B
D 0311 O	140N	GCAB	-	-	-
D 0811 O	230U, 240N, 346U	-	-	-	KP31C



Emery Cloth

Features

- Natural emery abrasive
- Flexible, cotton backing

Benefits

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

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



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

Aluminum Oxide Resin Cloth

Features

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

Benefits

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

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



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

Silicon Carbide Waterproof Sandscreen

Features

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

Benefits

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

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



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

Spec Check

CLOTH SHEET STARTING RECOMMENDATIONS

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

Cloth Sheet Competitive Cross Reference

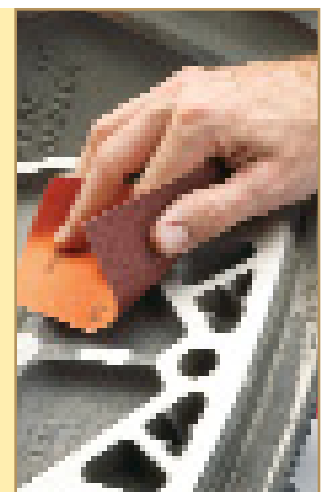
CARBORUNDUM	3M	HERMES	KLINGSPOR	SIA	VSM
JC 0250	011K CRYSTAL BAY		KL371	C680J	-
XC 0851	311T THREE-M-ITE BG 211K ELECTROCUT	RB317LX	CS310X	-	KK504X
JCF 0852	211K THREE-M-ITE 311K THREE-M-ITE	RB232J	KL361	2947J	KK504J KK504X
M 0405 W	481W	-	-	-	-

TechTip

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



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



Fibratex Hand Pads

Hand Pads

Features

- Non-woven nylon, low density pads impregnated with abrasive grain
- Numerous specifications

Benefits

- Excellent conformability and flexibility
- Easy to fold
- Replacement for steel wool and wire brushes

COARSER
ACTING FOR
GENERAL
CLEANING

Brown - 05539574000

A heavy-duty, medium grit aluminum oxide pad for aggressive action where a stiffer, coarser pad is required.

Gray - 05539574600

A medium grit, silicon carbide pad, with an open web structure primarily used for all types of blending applications, especially on stainless steel.

Green - 05539579600

A very fine grit aluminum oxide pad for general clean-up as well as finishing stainless steel.

Maroon - 05539577700

A very fine grit, aluminum oxide pad with a fast initial cut rate for cleaning, deburring, corrosion and oxidation removal.

Maroon - 05539574700 / 05539584700

Very fine, aluminum oxide pads for general cleaning and finishing, removal of rust and oxidation from metals, and lightly sanding old paint or new primers. No color bleeding when working with solvents. 84700 is perforated to create two smaller 4-1/2" x 6" pads.

Light Green - 05539569600

A very fine grit, aluminum oxide pad for general purpose cleaning in food processing plants and sanitary preparations.

Gray - 05539563500

An ultra fine grit, silicon carbide pad for denubbing between finish coats, as well as lacquer rubbing.

Gray - 05539574800 *Improved!*

A micro fine grit, silicon carbide pad for light cleaning steel and non-steel, defuzzing wood and final rubbing. Softer acting, more flexible. Consistent, finer finishes.

Gold - 05539530893 *New!*

Microfine aluminum oxide conformable pad for finest finishes. Scratch pattern equal to 1,200 grit and finer. Also, for scuffing clear coats and gel coats, light cleaning and blemish repair.

White - 05539545600

For general clean-up, light primer rub down and paint overspray removal. Softer acting, more flexible. Non-abrasive.



PART NO.	GRIT/ABRASIVE	COLOR	PADS/CASE
6" x 9"			
05539574000	Medium A/O	Brown	40
05539574600	Medium S/C	Gray	40
05539579600	VF A/O Scouring	Green	60
05539577700	Very Fine A/O Long Life	Maroon	60
05539574700	Very Fine A/O Gen. Purp.	Maroon	BEST 60
05539584700	VF A/O G/P Perforated	Maroon	BEST 60
05539569600	VF A/O Food Pro	Lt. Green	2,880*
05539563500	Ultra Fine S/C	Gray	60
05539574800	Micro Fine S/C	Gray	60
05539530893+	Clean & Blend Prep	Gold	30+
05539545600	Non-Abrasive	White	60

*Supplied in pallet quantity only. +Non-stock. Ask for current lead-times.

PART NO.	DESCRIPTION	HOLDERS/CASE
Hand Pad Holder		
05539562709	Hand Pad Holder	10

COATED

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FINER
ACTING FOR
LIGHT
SCUFFING &
BLENDING



TechTip

Fibratex products are non-metallic, won't rust, and are ideal as replacements for steel wool.



It is the user's responsibility to refer to and comply with all safety regulations.

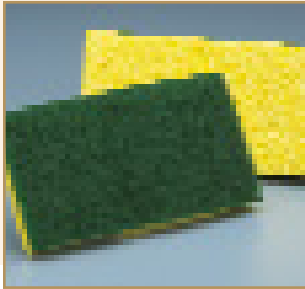
Fibratex Sponge Pads

Features

- Durable hand pad material on one side, top quality sponge on the other

Benefits

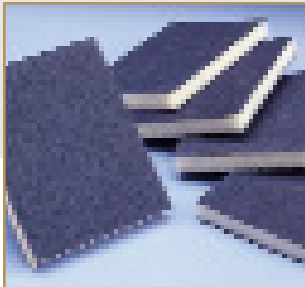
- Allows user to carry fluids to the scrubbing area or pick up liquid after use



Ideal for general clean-up. Mild acting green, or non-abrasive white Fibratex hand pad material is laminated to a top quality sponge, which allows for the convenience of 2 pads in one.

PART NO.	GRIT/ABRASIVE	DESCRIPTION	PADS/CASE
3-1/4" x 6-1/4" x 1"			
05539563538	Non-Abrasive	White Clean-N-Sponge Pad	40
05539563537	Very Fine A/O	Green Scour-N-Sponge Pad	40

Flexible Silicon Carbide Sanding Sponges



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



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

EZ Touch Contour Sponges

Features

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

Benefits

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



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

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

EZ Wipe Micro-Fabric Cloth



Picks up dirt like a magnet with thousands of advanced micro-fabric fibers. Can hold seven times its weight in water. Perfect for fine detailing.



PART NO.	GRADING	WIPES/PKG.	WIPES/CASE
16" x 16"			
05539564024	Micro-Fabric	1	20

Stick-On Marine File Strips

Premier Red Zirconia Alumina Resin Paper Open Stick-On

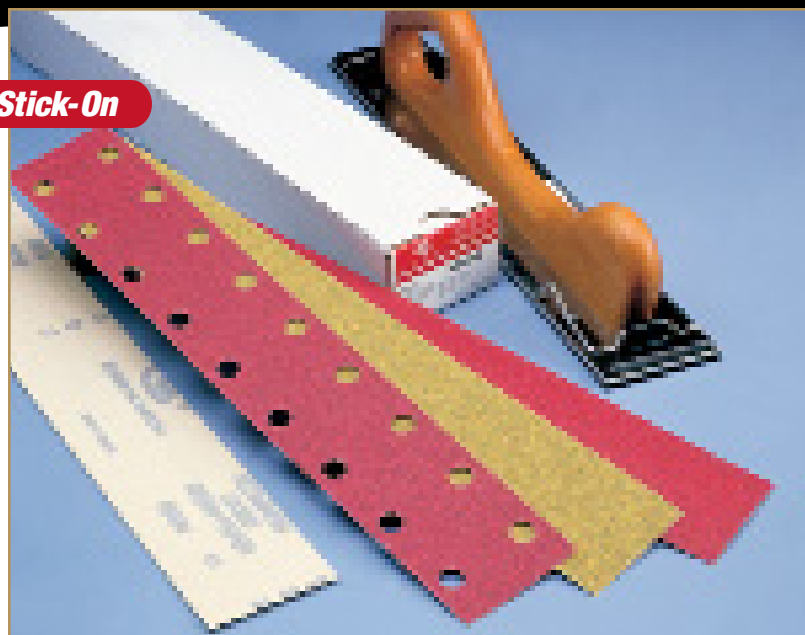
Features

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

Benefits

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

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



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

For use with File Board #05539512013 on page 43.

Carbo Gold Aluminum Oxide Resin Paper Open Stick-On

Features

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

Benefits

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

Ideal for blending and shaping all types of marine fillers.



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

For use with File Board #05539512013 on page 43.

Premier Red Zirconia Alumina Resin Paper Open Vacuum Stick-On

Features

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

Benefits

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

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



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

COATED

40

Premier Red Zirconia Alumina Resin Paper Open Grip-On

Features

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

Benefits

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

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



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

For use with File Board 05539512014 and File Shoe 05539512015 on page 43.

Carbo Gold Aluminum Oxide Resin Paper Open Grip-On

Features

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

Benefits

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

Ideal for blending and shaping all types of marine fillers.



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

For use with File Board 05539512014 and File Shoe 05539512015 on page 43.

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

Features

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

Benefits

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

Blending all paints, primers, plastics and fiberglass.



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

For use with File Board 05539512014 and File Shoe 05539512015 on page 43.

Premier Red Zirconia Alumina Resin Paper Open Vacuum Grip-On

Features

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

Benefits

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

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



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

Clip-On Marine File Strips

Premier Red Zirconia Alumina Resin Paper Open Clip-On

Features

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

Benefits

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

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



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

For use with File Board #05539512013 on page 43.

Carbo Gold Aluminum Oxide Resin Paper Open Clip-On

Features

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

Benefits

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

Ideal for blending and shaping all types of marine fillers.



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

For use with File Board #05539512013 on page 43.

Aluminum Oxide Paper Open Clip-On

Features

- P-graded, brown aluminum oxide abrasive

Benefits

- Tough and durable

For blending and shaping of marine filler.



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

For use with File Board #05539512013 on page 43.

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

Features

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

Benefits

- Fast, aggressive cut and long life
- Durability plus tear resistance
- Excellent load resistance
- No pigment transfer

Ideal for blending and shaping all types of marine fillers.



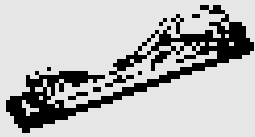
PART NO.	GRADING		STRIPS/PKG.	STRIPS/CASE
2-3/4" x 17-1/2"				
05539510903	P80	C 0712 DO	50	500
05539510902	P100	C 0712 DO	50	500
05539510900	P120	C 0712 DO	50	500
05539510899	P150	C 0712 DO	50	500
05539510898	P180	C 0712 DO	50	500

For use with File Board #05539512013 on page 43.

COATED

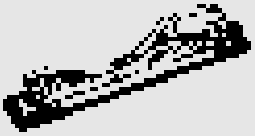
42

Marine Files



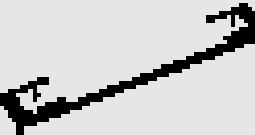
Hand Marine File Board

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



Grip-On Marine File Board

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



Grip-On Marine Air File Shoe

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

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



COATED

43

Coated Abrasive Basics

How to Read a Coated Abrasive Specification

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

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

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

Coated Abrasive Terminology Key

GRADING	GRIT SIZE	BACKING WEIGHT	CLOTH TYPE	BACKING FLEXIBILITY	MINERAL (ABRASIVE)	BACKING	BOND	PERFORMANCE	COATING
P FEPA _ ANSI/CAMI	16 ↕ 2000	PAPER: A B C D E F	B POLY/ COTTON BLEND C COTTON P POLY- ESTER	F FLEXIBLE _ STANDARD	01 CROCUS 02 EMERY 03 GARNET 04 S/C (SILICON CARBIDE) 07 LBA (LIGHT BROWN A/O) 08 A/O (ALUMINUM OXIDE) 09 HT A/O (HEAT-TREATED) 11 ZA (ZIRCONIA ALUMINA) 12 ZA (PREMIUM) 25 CERAMIC ALUMINA	0 MESH 1 PAPER 4 FIBER CLOTH: 5 MOST FLEXIBLE ↕ 8 LEAST FLEXIBLE	0 GLUE 1 U/G 2 U/U FULL RESIN: 4 LEAST DURABLE ↕ 7 MOST DURABLE	A ANTI-STATIC D DRI-LUBE OVERSIZE (ANTI-LOADING) R REACTIVE OVERSIZE (COOLING, GRINDING AID) W WASHABLE OR WATERPROOF	O OPEN COAT _ CLOSED COAT
	CRS MED FINE MICRON	CLOTH: J X Y							
		M MESH V FIBRE							

Abrasive Types

EMERY (02)

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

- for polishing and cleaning metal only

GARNET (03)

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

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

SILICON CARBIDE (04)

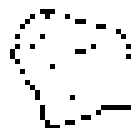
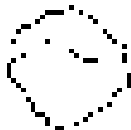
Silicon carbide is the hardest and sharpest of the manufactured abrasives. Because of its extreme sharpness, this bluish-black abrasive grain permits fast stock removal and cool cut.

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

LIGHT BROWN ALUMINUM OXIDE (07)

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

- production wood sanding
- non-ferrous metal finishing



BROWN ALUMINUM OXIDE (08)

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

- ferrous metals
- aluminum
- hardwood

HEAT-TREATED ALUMINUM OXIDE (09)

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

- ferrous metals
- wood sanding

ZIRCONIA ALUMINA (11, 12)

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

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

CERAMIC ALUMINA (25)

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

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



Grit Comparison Chart

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

Backing Types

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

PAPER

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

CLOTH

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

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

FIBER

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

Bond Types

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

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

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

Coating Types

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

OPEN COAT

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



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

CLOSED COAT

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



CLOSED COAT

Depressed Center Wheels for Grinding

Premier Red Zirconia Alumina Abrasive

Features

- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Best performing wheel

Benefits

- 60% faster stock removal and a minimum of 3 times the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Highest productivity; lowest total grinding cost

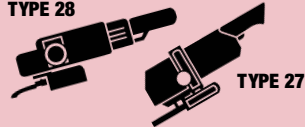
Z24

Outstanding results grinding stainless steel, high alloy steel, and all ferrous metals.

Z24 Long Life

Extended life when grinding stainless steel, high alloy steel and all ferrous metals.

TYPE 28



TYPE 27



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders				
05539502864	3 x 1/4 x 3/8	Z24	18,000	20
05539502867	4 x 1/4 x 3/8	Z24	15,280	20
05539502868	4 x 1/4 x 5/8	Z24	15,280	20
05539502873	4-1/2 x 1/4 x 5/8-11	Z24	13,580	20
05539502872	4-1/2 x 1/4 x 7/8	Z24	13,580	20
05539502877	5 x 1/4 x 5/8-11	Z24	12,225	20
05539502876	5 x 1/4 x 7/8	Z24	12,225	20

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders (continued)				
05539502883	7 x 1/4 x 5/8-11	Z24	8,600	10
05539502884	7 x 1/4 x 5/8-11	Z24 Long Life	8,600	10
05539502881	7 x 1/4 x 7/8	Z24	8,600	20
05539502882	7 x 1/4 x 7/8	Z24 Long Life	8,600	20
05539502889	9 x 1/4 x 5/8-11	Z24	6,600	10
05539502890	9 x 1/4 x 5/8-11	Z24 Long Life	6,600	10
Type 28 - For Right Angle Grinders				
05539502892	7 x 1/4 x 5/8-11	Z24	8,600	10

Gold MaXX Zirconia Alumina/Aluminum Oxide Abrasive Blend

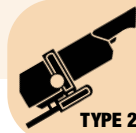
Features

- Premium zirconia alumina and aluminum oxide abrasive blend in a free-cutting bond

Benefits

- Excellent cut rate and long life
- 10% faster cut rate and 30% longer life than standard aluminum oxide wheels
- Smooth grinding action that maximizes productivity and minimizes operator fatigue

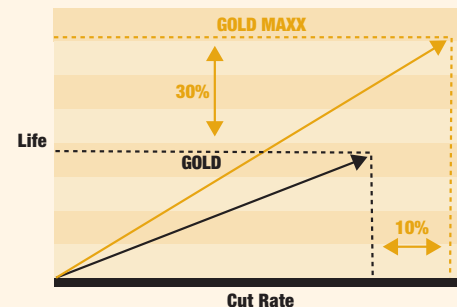
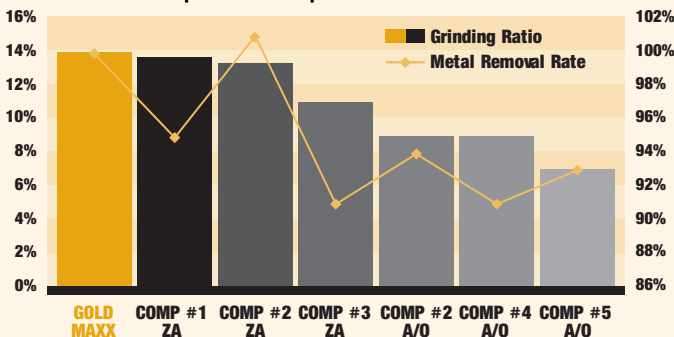
Grinds efficiently on a variety of ferrous metals: from carbon steel to stainless steels and some exotic metals.



TYPE 27

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders				
05539570192	4-1/2 x 1/4 x 5/8-11	ZA24-R	13,580	20
05539570191	4-1/2 x 1/4 x 7/8	ZA24-R	13,580	20
05539570193	5 x 1/4 x 7/8	ZA24-R	12,225	20
66252830562	6 x 1/4 x 7/8	ZA24-R	10,185	20
05539570195	7 x 1/4 x 5/8-11	ZA24-R	8,600	10
05539570194	7 x 1/4 x 7/8	ZA24-R	8,600	20
05539570197	9 x 1/4 x 5/8-11	ZA24-R	6,600	10
05539570196	9 x 1/4 x 7/8	ZA24-R	6,600	20

GOLD MaXX Competitive Comparison



GOLD MaXX outperforms standard GOLD with 10% faster cut and 30% longer life.

BONDED ABRASIVES

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Gold Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Exceptional balance

Benefits

- Fast stock removal
- Free cutting without a reduction in wheel life
- No vibration
- No burning of workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit

A24 Aluminum Oxide Abrasive – For Steel/Metal

The choice for grinding all types of ferrous metals and various alloy steels.

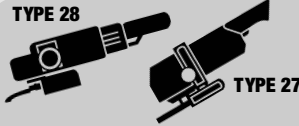
A30 Aluminum Oxide Abrasive – For Stainless Steel

Ideal for grinding all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.

A46 Aluminum Oxide Abrasive – For Aluminum

Engineered for grinding aluminum weld beads and fabricated parts.

FREE OF Fe+S+Cl



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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For Steel/Metal

Type 27 – For Right Angle Grinders

05539502836	4 x 1/4 x 3/8	A24	15,280	20
05539502837	4 x 1/4 x 5/8	A24	15,280	20
05539502843	4-1/2 x 1/4 x 5/8-11	A24	13,580	20
05539502842	4-1/2 x 1/4 x 7/8	A24	13,580	20
05539502847	5 x 1/4 x 5/8-11	A24	12,225	20
05539502846	5 x 1/4 x 7/8	A24	12,225	20
05539502849	6 x 1/4 x 7/8	A24	10,185	20
05539502854	7 x 1/4 x 5/8-11	A24	8,600	10
05539502853	7 x 1/4 x 7/8	A24	8,600	20
05539502858	9 x 1/4 x 5/8-11	A24	6,600	10
05539502857	9 x 1/4 x 7/8	A24	6,600	20

Type 28 – For Right Angle Grinders

05539502860	7 x 1/4 x 5/8-11	A24	8,600	10
05539502859	7 x 1/4 x 7/8	A24	8,600	20
05539502862	9 x 1/4 x 5/8-11	A24	6,600	10
05539502861	9 x 1/4 x 7/8	A24	6,600	20

For Stainless Steel

Type 27 – For Right Angle Grinders

05539561560	4-1/2 x 1/4 x 5/8-11	A30	13,580	20
05539503511	4-1/2 x 1/4 x 7/8	A30	13,580	20

For Aluminum

Type 27 – For Right Angle Grinders

05539508158	4-1/2 x 1/4 x 5/8-11	A46	13,580	20
05539503588	4-1/2 x 1/4 x 7/8	A46	13,580	20
05539503589	5 x 1/4 x 7/8	A46	12,225	20
05539503594	7 x 1/4 x 5/8-11	A46	8,600	10

Carbo Metal Aluminum Oxide Abrasive

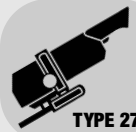
Features

- Quality aluminum oxide abrasive
- Low initial cost per wheel

Benefits

- Quick stock removal on hard metals
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
----------	------------	---------	----------	-------------

For Steel/Metal

Type 27 – For Right Angle Grinders

05539561568	4-1/2 x 1/4 x 5/8-11	A24	13,580	20
05539561567	4-1/2 x 1/4 x 7/8	A24	13,580	20
05539561571	5 x 1/4 x 7/8	A24	12,225	20
05539561576	7 x 1/4 x 5/8-11	A24	8,600	10
05539561575	7 x 1/4 x 7/8	A24	8,600	20
05539561580	9 x 1/4 x 5/8-11	A24	6,600	10



TechTip

Unique, patented mini-mount hub used on 4-1/2" and 5" depressed center wheels provides up to 30% more wheel life because the hub covers just a small surface area, providing maximum grinding area exposure and usage.

Depressed Center Wheels for Light Grinding and Cutting

Premier Red Zirconia Alumina Abrasive

Features

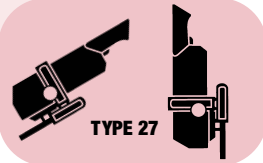
- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Best performing wheel

Benefits

- 60% faster stock removal and a minimum of 3 times the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Highest productivity, lowest total grinding cost

Outstanding results cutting and light grinding stainless steel, high alloy steel and all ferrous metals.

These wheels can be used for both cutting and light grinding.



TechTip

For maximum performance, run the grinder at the "Maximum Operating Speed", which is marked on the wheel.



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

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders				
05539507349	4 x 1/8 x 3/8	Z24	15,280	20
05539504702	4-1/2 x 1/8 x 5/8-11	Z24	13,580	20
05539504701	4-1/2 x 1/8 x 7/8	Z24	13,580	20
05539504703	5 x 1/8 x 7/8	Z24	12,225	20
05539504706	7 x 1/8 x 5/8-11	Z24	8,600	10
05539504708	9 x 1/8 x 5/8-11	Z24	6,600	10

Gold MaXX Zirconia Alumina/Aluminum Oxide Abrasive Blend

Features

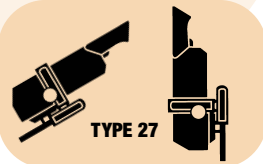
- Premium zirconia alumina and aluminum oxide abrasive blend in a free-cutting bond

Benefits

- Excellent cut rate and long life
- 10% faster cut rate and 30% longer life than standard aluminum oxide wheels
- Smooth grinding action that maximizes productivity and minimizes operator fatigue

Grinds efficiently on a variety of ferrous metals: from carbon steel to stainless steels and some exotic metals.

These wheels can be used for both cutting and light grinding.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders				
66252832395	4-1/2 x 1/8 x 5/8-11	ZA24-R	13,580	20
66252832507	4-1/2 x 1/8 x 7/8	ZA24-R	13,580	20
66252832508	5 x 1/8 x 7/8	ZA24-R	12,225	20
66252830561	6 x 1/8 x 7/8	ZA24-R	10,185	20
66252832396	7 x 1/8 x 5/8-11	ZA24-R	8,600	10
66252832509	7 x 1/8 x 7/8	ZA24-R	8,600	20
66252830879	9 x 1/8 x 5/8-11	ZA24-R	6,600	10

Spec Check

WHEEL TYPE	APPLICATIONS
.045", 1/16" & 3/32" THICK TYPE 27	CUTTING ONLY, WHERE FAST CUTTING AND LOW KERF LOSS ARE DESIRED IDEAL FOR PIPE CUTTING
.125" THICK TYPE 27	CUTTING AND CLEANING ROOT PASS WELDS
1/8" THICK TYPE 27	CUTTING-OFF, NOTCHING AND LIGHT SIDE GRINDING
1/4" THICK TYPE 27	GRINDING WITH LOW HORSEPOWER AIR AND ELECTRIC GRINDERS OR WHERE LOW PRESSURE IS USED
Z24 LONG LIFE 1/4" THICK TYPE 27	GRINDING WITH HIGH HORSEPOWER MACHINES (3 HP OR HIGHER) AND HEAVY PRESSURE; FLAME CUT AND OTHER SEVERE APPLICATIONS
SAUCERS TYPE 28	SMOOTH, GOUGE-FREE GRINDING AT SHALLOW ANGLES
GOLD FLEXIBLE TYPE 29	POLISHING AND BLENDING APPLICATIONS



Depressed Center Wheels for Light Grinding and Cutting

Gold Aluminum Oxide Abrasive

Features

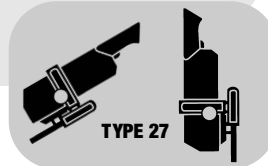
- Quality aluminum oxide abrasive
- Advanced resin bond
- Exceptional balance
- Unique glass cloth reinforcement design
- Value priced

Benefits

- Fast stock removal
- Free cutting without a reduction in wheel life
- No vibration
- No burning of workpiece
- Less grinder maintenance
- Less operator fatigue
- No fraying or spalling of abrasive grit
- Good performance/price ratio

The economical choice for cutting and light grinding all types of ferrous metals and various alloy steels.

These wheels can be used for both cutting and light grinding.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Type 27 - For Right Angle Grinders				
05539504709	4 x 1/8 x 5/8	A24	15,280	20
05539504711	4-1/2 x 1/8 x 5/8-11	A24	13,580	20
05539504710	4-1/2 x 1/8 x 7/8	A24	13,580	20
05539504712	5 x 1/8 x 7/8	A24	12,225	20
05539504714	6 x 1/8 x 7/8	A24	10,185	20
05539504716	7 x 1/8 x 5/8-11	A24	8,600	10
05539504718	9 x 1/8 x 5/8-11	A24	6,600	10
05539504717	9 x 1/8 x 7/8	A24	6,600	20

Carbo Metal Aluminum Oxide Abrasive

Features

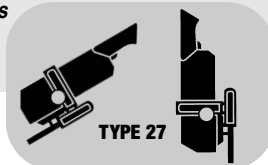
- Quality aluminum oxide abrasive
- Low initial cost per wheel

Benefits

- Quick stock removal on hard metals
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose applications.

These wheels can be used for both cutting and light grinding.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Type 27 - For Right Angle Grinders				
05539561566	4-1/2 x 1/8 x 5/8-11	A24	13,580	20
05539561574	7 x 1/8 x 5/8-11	A24	8,600	10

Depressed Center Cutting-off Wheels

Premier Red Zirconia Alumina Abrasive

Features

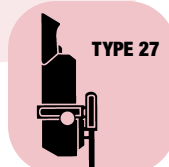
- High-performance zirconia alumina abrasive
- High-performance resin bond
- Exceptional balance
- Best performing wheel

Benefits

- 60% faster stock removal and a minimum of 3 times the life over aluminum oxide wheels
- Enhanced life; exceptional cut rate
- No vibration
- No bouncing on workpiece
- Less grinder maintenance
- Less operator fatigue
- Highest productivity; lowest total grinding cost

Outstanding results cutting stainless steel, high alloy steel and all ferrous metals.

These wheels should be used for cutting only.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
Type 27 - For Right Angle Grinders				
05539502863	3 x .125 x 3/8	Z24	18,000	20
05539502865	4 x .125 x 3/8	Z24	15,280	20
05539502871	4-1/2 x .125 x 5/8-11	Z24	13,580	20
05539502870	4-1/2 x .125 x 7/8	Z24	13,580	20

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal (cont'd)				
Type 27 - For Right Angle Grinders				
05539502874	5 x .125 x 7/8	Z24	12,225	20
05539502879	7 x .125 x 5/8-11	Z24	8,600	10
05539502878	7 x .125 x 7/8	Z24	8,600	20

Depressed Center Cutting-off Wheels

Gold Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Exceptional balance
- Value priced

Benefits

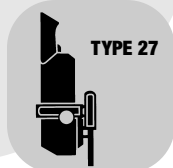
- Fast stock removal
- Free cutting
- No vibration
- No burning of workpiece
- Less grinder maintenance
- Less operator fatigue
- Good performance/price ratio

A24 Aluminum Oxide Abrasive - For Steel/Metal

Ideal choice for cutting all types of ferrous metals and various alloy steels.

A30 Aluminum Oxide Abrasive - For SS

Engineered to cut all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.



These wheels should be used for cutting only.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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For Steel/Metal

Type 27 - For Right Angle Grinders

05539502833	4 x .125 x 3/8	A24	15,280	20
05539502834	4 x .125 x 5/8	A24	15,280	20
05539502839	4-1/2 x .125 x 5/8-11	A24	13,580	20
05539502838	4-1/2 x .125 x 7/8	A24	13,580	20
05539502844	5 x .125 x 7/8	A24	12,225	20
05539502848	6 x .125 x 7/8	A24	10,185	20
05539502851	7 x .125 x 5/8-11	A24	8,600	10
05539502850	7 x .125 x 7/8	A24	8,600	20
05539502856	9 x .125 x 5/8-11	A24	6,600	10
05539502855	9 x .125 x 7/8	A24	6,600	20

For Stainless Steel

Type 27 - For Right Angle Grinders

05539561559	4-1/2 x .125 x 5/8-11	A30	13,580	20
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Gold Aluminum Oxide Abrasive

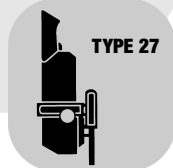
Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Extra thin
- Specially reinforced

Benefits

- Burn-free cutting
- Long life
- Meets nuclear industry standards
- Quick cutting action
- Minimal kerf loss
- Added safety, strength and straight cuts

Engineered for cutting pipe and all types of stainless steel and various hard alloys. Formulated to meet nuclear industry standards; no contamination of workpiece.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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For Steel/Stainless Steel/Metal

Type 27 - For Right Angle Grinders

05539563817	4-1/2 x 3/32 x 7/8	A30	13,580	20
05539563819	5 x 3/32 x 7/8	A30	12,225	20
66252829706	6 x 3/32 x 7/8	A30	10,185	20
05539563821	7 x 3/32 x 7/8	A30	8,600	20

These wheels should be used for cutting only.

GoldCut Aluminum Oxide Abrasive

Features

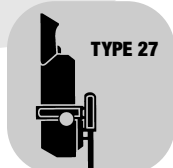
- Quality aluminum oxide abrasive
- Clean bond
- Extra thin depressed center cutting-off wheels
- Specially reinforced
- Hubbed wheels

Benefits

- Burn-free cutting
- Works particularly well on stainless
- No sulphur, iron or chlorine in bond means no contamination of workpiece
- Quick cutting action
- Minimal kerf loss
- Added safety, strength and straight cuts
- Quick, tool-free changes increase productivity

Excellent choice for cutting all types of metals and various alloy steels.

These wheels should be used for cutting only.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
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For Steel/Metal

Type 27 - For Right Angle Grinders

66252830584	4-1/2 x .045 x 5/8-11	A30	13,580	20
05539561551	4-1/2 x .045 x 7/8	A30	13,580	20
05539561553	5 x .045 x 7/8	A30	12,225	20
05539561554	6 x .045 x 7/8	A30	10,185	20
05539561555	7 x 1/16 x 7/8	A30	8,600	20
66252830585	9 x 1/16 x 5/8-11	A30	6,600	10

Depressed Center Wheels for Blending and Polishing

Gold Flexible Aluminum Oxide Abrasive

Features

- Aluminum oxide grain
- Special formulation
- Flexible
- Type 29 conical has nubs on the face; (Use at a 15° angle)
- Type 27 has concentric grooves

Benefits

- Cool cutting; leaves no burn marks
- Prevents loading
- No offensive odors generated while grinding
- Type 27 meets nuclear industry standards; no contamination of workpiece
- Excellent control of finish quality and removal rate in light stock removal applications
- Shallow grinding angle permits larger contact area with less gouging of workpiece
- Nubs/grooves allow more air to circulate in grinding zone, promoting cooler cutting (reducing heat and loading) and better swarf removal
- Ideal for getting into tight spaces, smoothing corners and curves, and polishing and blending welds on flat surfaces

Blending, finishing and polishing of stainless steel, aluminum, structural steel, carbon steel, cast iron welds and burrs.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Stainless Steel/Metal				
Type 27 – For Right Angle Grinders				
05539567289	4-1/2 x 1/8 x 7/8	A60-Medium	13,580	20
05539567287	7 x 1/8 x 5/8-11	A60-Medium	8,600	10
For Steel/Metal				
Type 29 – For Right Angle Grinders				
66252833457	4-1/2 x 1/8 x 7/8	A36	13,580	20
66252833458	5 x 1/8 x 7/8	A36	12,225	20

Metal Adapter Kit



This adapter kit contains the items necessary to mount depressed center wheels with 7/8" center holes on to standard portable right angle or vertical shaft grinders. Adapter hubs are threaded for mounting on to standard 5/8"-11 NCRH spindles. This adapter kit may be used with wheel thicknesses of 1/8" or 1/4". All depressed center wheels must use the proper adapters to securely mount to the spindle.

PART NO.	DESCRIPTION	KITS/BOX
For Depressed Center Wheels		
07660789275	Adapter Kit	1

BONDED ABRASIVES

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Depressed Center Wheels

Spec Check

DEPRESSED CENTER WHEEL STARTING RECOMMENDATIONS BY MATERIAL

MATERIALS:	HEAVY-DUTY GRINDING BEST PERFORMANCE	GENERAL-DUTY GRINDING	BLENDING AND FINISHING	CUTTING	SURFACE PREPARATION
ANGLE / CHANNEL IRON BAR STOCK / I-BEAMS CARBON / HIGH TENSILE STEEL METAL STUDS / TUBING CAST IRON / PIPE	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD TYPE 27	FIBRATEX SURFACE STRIP FIBRATEX SURFACE FINISH
STAINLESS / ALLOYS	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD SS TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD SS TYPE 27	FIBRATEX SURFACE STRIP FIBRATEX SURFACE FINISH
ALUMINUM / BRASS / BRONZE	PREMIER RED TYPE 27	GOLD MAXX TYPE 27 GOLD ALU TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD ALU TYPE 27	FIBRATEX SURFACE STRIP FIBRATEX SURFACE FINISH
FIBERGLASS / PLASTIC	-	GOLD FLEXIBLE TYPE 27	GOLD FLEXIBLE TYPE 27, 29	GOLD TYPE 27	FIBRATEX SURFACE STRIP FIBRATEX SURFACE FINISH
PAINT / RUST	-	GOLD TYPE 27	-	-	-

Depressed Center Wheel Competitive Cross Reference

CARBORUNDUM	FLEXOVIT	METABO	PFERD	SAIT	TYROLIT	WALTER
PREMIER RED LONG LIFE Z24LL	FLEXON ZA-24P		ZA-SG	ATTACKER		A-20-XX
PREMIER RED Z24	FLEXON ZA-20Q	ZA24	ZA-SG	Z-TECH	1ZA30QBFX	A-20-XX
GOLD MAXX ZA24-R	FLEXON	ZA24	ZA-SG	Z-TECH	1ZA30QBFX	A-20-XX
GOLD A24	A24/A30T	A24R/T	A-SG	A24R, A24T	A30RBF	A-24-HPS
GOLD ALUMINUM A46	A24ALU	A36M	A-W-ALU	A46N	A36NBFX	A-24-ALU
GOLD FLEXIBLE	FLEXCEL			CHALLENGER	RONDELLER	ROTELLER
CARBO METAL A24	A30S	A24N		A24N		



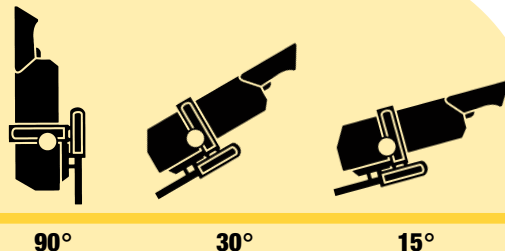
TechTip

For best results, hold your right angle grinder at a:

- 30° angle with 1/4" and 1/8" thick Type 27 wheels
- 90° angle with .045", 1/16", 3/32", .125" and 1/8" thick Type 27 wheels
- 15° angle with saucers (Type 28) and Gold Flexible (Type 29) Wheels



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



Knotted Wire Cup Brushes

Features

- Rigid structure
- Available with or without plastic guard
- Protective guard opens up into a shield

Benefits

- High impact cutting and cleaning
- Application-specific
- Prevents wire, dust and any kind of projection from reaching the end-user during work
- Provides for a friendly handling of the brush, preventing potential pricking caused by the wire ends, for safety before, during and after work

Knotted Cup – Single Row

- Single row, twist knot construction

- Limits flaring of the brush on corners and angles

Knotted Cup – Double Row

- Double row, twist knot construction

- More aggressive; provides twice the cutting points of a single row cup brush



WITH PROTECTIVE GUARD



RED COLOR-CODED FOR STEEL



BLUE COLOR-CODED FOR STAINLESS

High-impact cutting and cleaning on more demanding applications such as heavy deburring, weld cleaning and cleaning larger surfaces.

Use Double Row Knotted Cup brushes for heavy-duty, aggressive action in very severe applications.



Powder-coated and color-coded hubs prevent cross-contamination and rust.

Red = for steel use

Blue = for stainless steel use



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
For Stainless Steel				
Knotted Cup – Single Row				

69936653340	2-3/4 x .020 x 5/8-11	Stainless	15,000	5
66252833947	4 x .020 x 5/8-11	Stainless	9,000	5

For Steel				
Knotted Cup with Protective Guard – Single Row				

66252833492	2-3/4 x .020 x 5/8-11	Carbon	15,000	5
66252833496	4 x .020 x 5/8-11	Carbon	9,000	5
66252833497	5 x .020 x 5/8-11	Carbon	6,500	5

Knotted Cup – Single Row				
69936653336	2-3/4 x .020 x 5/8-11	Carbon	15,000	5
69936653338	2-3/4 x .020 x M10-1.25 / 1.50	Carbon	15,000	5

69936653345	4 x .020 x 5/8-11	Carbon	9,000	5
69936605965	6 x .020 x 5/8-11	Carbon	6,000	5
69936602003	6 x .035 x 5/8-11	Carbon	6,000	5

Knotted Cup – Double Row				
69936653346	6 x .020 x 5/8-11	Carbon	6,000	1*

*All brushes are individually clamshell packaged unless otherwise noted. *These brushes are bulk packed.*

High Performance (HP) Cable Crimped Wire Cup Brushes with Protective Guard

Features

- 12 wires of .009" brass-coated steel (12 x .009) are bundled together into a group then crimped
- Cable crimped wire breaks down in smaller pieces than standard crimped brushes

Benefits

- Provides for a 50% longer lasting brush compared to standard crimped brushes
- Better flexibility on irregular surfaces
- Safer wire to use

For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing.



RED COLOR-CODED FOR STEEL



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/ BOX
For Steel				
Crimped Cup with Protective Guard – Single Row				

66252833493	3 x (12 x .009) x 5/8-11	Carbon	13,000	5
66252833494	4 x (12 x .009) x 5/8-11	Carbon	9,000	5
66252833495	5 x (12 x .009) x 5/8-11	Carbon	6,500	5

All these brushes are individually clamshell packaged.

Crimped Wire Cup Brushes

Features

- Highly flexible
- Heavy wire fill

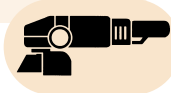
Benefits

- Fast cutting



RED COLOR-CODED FOR STEEL

For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing.



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
For Steel				
69936653341	3 x .014 x 5/8-11	Carbon	13,000	5
69936653347	4 x .014 x 5/8-11	Carbon	9,000	5
69936653348	6 x .014 x 5/8-11	Carbon	6,000	5
69936653349	6 x .020 x 5/8-11	Carbon	6,000	1*

All brushes are individually clamshell packaged unless otherwise noted.
*These brushes are bulk packed.

Wire Saucer Cup Brushes

EXPANDED OFFERING!

Features

- Twist knot style
- Crimped style

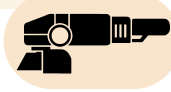
Benefits

- For heavy-duty cleaning
- For light- to medium-duty cleaning



RED COLOR-CODED FOR STEEL

Ideal for cleaning corners and other hard to reach areas.



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
For Stainless Steel				
Twist Knot Saucer Cup				
66252835586	5 x .020 x 5/8-11	Stainless	12,500	5
For Steel				
Twist Knot Saucer Cup				
66252833483	4 x .020 x 5/8-11	Carbon	9,000	5
66252835585	5 x .020 x 5/8-11	Carbon	12,500	5
Crimped Saucer Cup				
66252833485	4 x .014 x 5/8-11	Carbon	9,000	5

All these brushes are individually clamshell packaged.

End Brushes

Features

- Knot Wire End Brushes
- Crimped Wire End Brushes

Benefits

- For more aggressive cutting
- For lighter brushing action and contoured surfaces



KNOTTED

CRIMPED

For use on die grinders to clean and deburr a recessed area or the inside diameter of a tube or pipe.



Powder-coated and color-coded hubs prevent cross-contamination and rust.

Red = for steel use

Blue = for stainless steel use

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
For Stainless Steel				
Stem Mounted Crimped				
66936606145	3/4 x .006 x 1/4 Shank	Stainless	20,000	10*
For Steel				
Stem Mounted Knotted				
69936653316	3/4 x .020 x 1/4 Shank	Carbon	20,000	10*
69936606279	1 x .014 x 1/4 Shank	Carbon	20,000	10*
69936653310	1 x .020 x 1/4 Shank	Carbon	20,000	10*
Stem Mounted Crimped				
69936653317	3/4 x .014 x 1/4 Shank	Carbon	20,000	10*
69936653309	1 x .020 x 1/4 Shank	Carbon	20,000	10*
Copper Center				
69936653320	2-1/2 x .014 x 1/2-3/8	Carbon	20,000	12*

* All end brushes are bulk packed.

BONDED ABRASIVES

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TechTip

- Stainless brushes are made of 304L stainless steel with high chromium content to resist corrosion, high tensile resistance and lower carbon content.
- These brushes are suitable for all applications requiring corrosive resistance like the dairy, food processing, chemical processing and aircraft industries, among others.



It is the user's responsibility to refer to and comply with ANSI B165.1



Crimped Wire Wheel Brushes

Features

- Dense, high-quality, tempered crimped wire construction



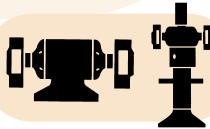
RED COLOR-CODED FOR STEEL

Benefits

- Offers excellent performance for deburring, removing rust, corrosion and dirt, or for surface preparation

Narrow-faced brushes are ideal for general purpose brushing of uneven or difficult-to-reach surfaces. Medium-faced brushes clean larger areas and have longer life.

Brushes may be used individually or stacked on a shaft.



PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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For Steel

Crimped Narrow 1/2" Face

69936653306	6 x .014 x 1/2-2**	Carbon	6,500	1
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Crimped Medium 3/4" Face

69936653324	6 x .014 x 1/2-2**	Carbon	6,500	1
69936653326	8 x .014 x 1/2-2**	Carbon	4,500	1

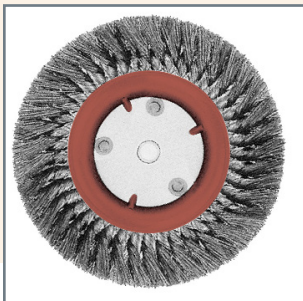
All these brushes are individually clamshell packaged.

***7 bushing sizes are included with each brush.*

Standard Twist Knot Wire Wheel Brushes

Features

- Knotted wire design
- Application-specific sizes



Benefits

- Provides added rigidity for extra cutting power
- Use 3" wheels on die grinders
- Use 4" on right angle grinders
- Use 6" wheels on bench grinders

Knot wire brushes are ideal for welding and metal fabrication applications such as removing weld scale and spatter, removing extra-heavy rust and corrosion, or surface roughening.

Small diameter wheels are used for small- to medium-duty jobs requiring flexibility and lighter brushing action.

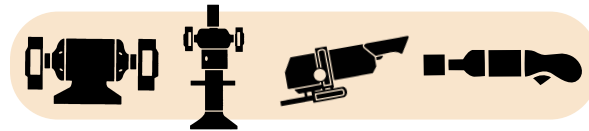
PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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For Steel

69936653314	3 x .015 x 3/8-1/2	Carbon	20,000	5
69936606275	4 x .020 x 5/8-11	Carbon	15,000	5
69936653327	6 x .020 x 1/2-2**	Carbon	12,500	5

All these brushes are individually clamshell packaged.

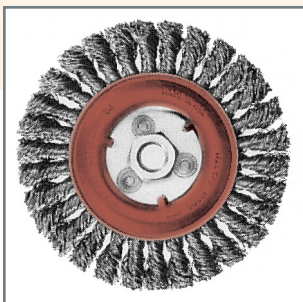
***7 bushing sizes are included with each brush.*



Full Cable Twist Knot Wire Wheel Brushes

Features

- Full cable twist knot brushes



Benefits

- Provide very low flex and high impact cutting and cleaning

For the tougher applications, especially for weld passes or other demanding applications.



Powder-coated and color-coded hubs prevent cross-contamination and rust.

Red = for steel use

Blue = for stainless steel use

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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For Stainless Steel

69936653333	4 x .020 x 5/8-11	Stainless	20,000	5
69936653334	4 x .020 x M10-1.25/1.50	Stainless	20,000	5
66252833488	5 x .020 x 5/8-11	Stainless	12,500	5

For Steel

69936653331	4 x .020 x 5/8-11	Carbon	20,000	6*
66252833487	5 x .020 x 5/8-11	Carbon	12,500	5
69936653352	6 x .020 x 5/8-11	Carbon	12,500	5

All brushes are individually clamshell packaged unless otherwise noted.

** These items are bulk packed*

Stringer Bead Knot Wire Brushes

Features

- Narrow face stringer bead wire
- Joint/Crack cleaning wire wheel brushes

Benefits

- Delivers high-impact cutting and cleaning for toughest applications
- Used for brushing joints, cleaning cracks in concrete and asphalt, and preparing expansion joints for filling and scaling

Specially suited for groove and weld bead, corners and t-connections.



BLUE COLOR-CODED FOR STAINLESS



RED COLOR-CODED FOR STEEL

PART NO.	BRUSH SIZE DIA. X WIRE SIZE X ARBOR HOLE	WIRE TYPE	MAX. RPM	BRUSHES/BOX
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For Stainless Steel

For Right Angle Grinders

69936606278	4 x .020 x 5/8-11	Stainless	20,000	5
66252833491	5 x .020 x 5/8-11	Stainless	12,500	6*
69936653351	6 x .023 x 5/8-11	Stainless	9,000	5

For Steel

For Right Angle Grinders

69936606277	4 x .020 x 5/8-11	Carbon	20,000	5
66252833489	4 x .020 x 5/8-11	Carbon	20,000	6*
66252833490	5 x .020 x 5/8-11	Carbon	12,500	6*
69936653350	6 x .020 x 5/8-11	Carbon	12,500	10*
69936653329	6-7/8 x .020 x 5/8-11	Carbon	9,000	10*

For Walk-Behind Machines - Joint/Crack Cleaning Brushes

69936606280	12 x .035 x 1 - DP	Carbon	4,500	2*
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All brushes are individually clamshell packaged unless otherwise noted.

* These items are bulk packed

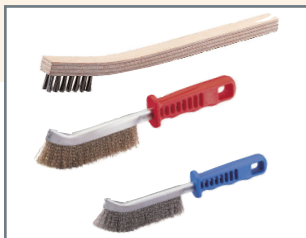
Hand Brushes

Features

- Plastic handle scratch brush
- Long handle and shoe handle brushes

Benefits

- Ergonomic handle
- Crimped wire for longer life; all other scratch brushes are straight wire
- Wires are wrapped up and around the metal post so they never come out
- Steel scratch brushes are made with high carbon brass coated steel; stainless brushes are made with a 304L stainless steel



Narrow brush allows access into tight areas and slots. Curved face for hard-to-reach places.



PART NO.	BRUSH SIZE DESCRIPTION/SIZE	WIRE TYPE	BRUSHES/BOX
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Hand Brushes - For Stainless Steel

66252833950	Scratch Brush 3 x 19 Long Handle	Stainless	12
66252833951	Scratch Brush 4 x 16 Shoe Handle	Stainless	30
66252833953	Scratch Brush Plastic Handle	Stainless	24
66252833952	Inspection Brush 3 x 7	Stainless	36

Hand Brushes - For Steel

66252833948	Scratch Brush 3 x 19 Long Handle	Carbon	12
66252833949	Scratch Brush 4 x 16 Shoe Handle	Carbon	30
66252833954	Scratch Brush Plastic Handle	Carbon	24

All brushes are individually clamshell packaged unless otherwise noted.

TechTip

Observe Wire Brush Safety Warnings to Avoid Injury

- 1 Safety Goggles: Safety goggles or full face shields worn over safety glasses with side shields must be worn by all operators and others in the area of power brush operations. Comply with the requirements of ANSI Z87.1 "Occupational Eye and Face Protection".
- 2 Guards: Keep all machine guards in place.
- 3 Speeds: Observe all speed restrictions indicated on the brushes, containers, labels, or printed in pertinent literature. "MSFS" means Maximum Safe Free Speed (RPM) - free spinning wheel with no work applied. For reasons of safety, the MSFS should not be exceeded under any circumstance.
- 4 Safety Standard: Comply with the safety Standards of the Industrial Division of the American National Standards Institute ANSI B165.1 "Safety Requirements - Power Brushes" and refer to the "Safety" section in the carborundumabrasives.com web site.
- 5 Protective Equipment: Appropriate protective clothing and equipment (such as gloves, respirator, etc.) must be used.

Warning: In normal power brushing operations, the material being removed, such as burrs, scale, dirt, weld slag, or other residue, will fly off the brush with considerable force along with the brush filaments which break off due to fatigue.

The potential of serious injury exists for both the brush operator and others in the work area (possibly 50 or more feet from the brush). To protect against this hazard, before rotating the brush, operators and others in the area must wear SAFETY GOGGLES or FULL FACE SHIELDS WORN OVER SAFETY GLASSES WITH SIDE SHIELDS, along with PROTECTIVE CLOTHING.



It is the user's responsibility to refer to and comply with ANSI B165.1

Cut-off Wheels for Precision Toolroom Applications

Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High strength, reinforced construction
- BFTK - side reinforced, rough sides
- Decimal thickness
- BFW - side reinforced, rough sides

Benefits

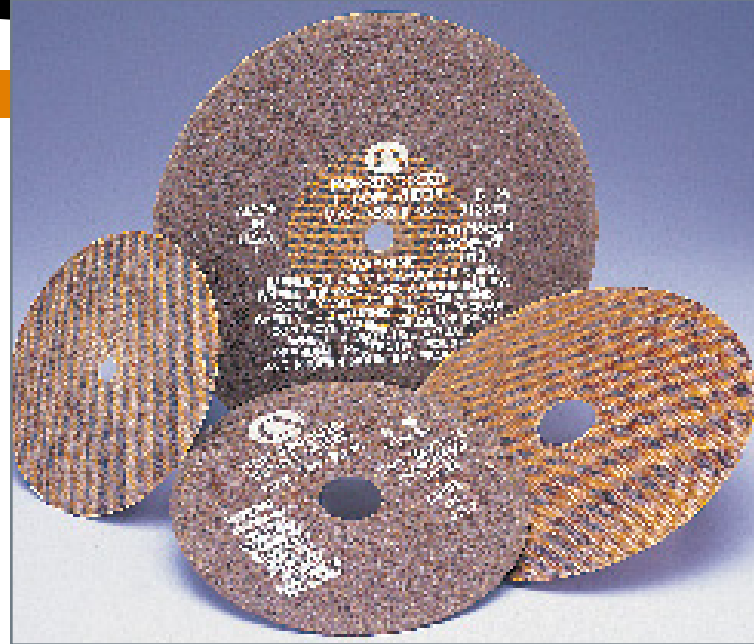
- Fast cut rate and long life
- Free cutting action
- Burn-free cutting
- Resists breakage and provides straight cuts
- Maximum cut rate
- Very narrow cuts; minimum kerf loss
- Versatile; durable free cutting

Used primarily for cutting off high speed steel drill bits and end mills, as well as slotting dies.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For High-Speed Steel and Tool Steels				
05539518986	6 x .060 x 1-1/4	A60-OBFTK	10,190	10
05539509197	7 x .035 x 5/8	A60-OBFTK	8,730	10
05539509196	7 x .035 x 1-1/4	BA60-OBFTK	8,730	10
05539509195	7 x .060 x 5/8	A60-OBFTK	8,730	10
05539509194	7 x .060 x 1-1/4	BA60-OBFTK	8,730	10
05539562844	7 x 1/16 x 1-1/4	A36-TBFW	8,730	10

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For High-Speed Steel and Tool Steels				
05539501911	8 x .035 x 5/8	A60-OBFTK	7,640	10
05539501912	8 x .060 x 5/8	A60-OBFTK	7,640	10
05539509192	8 x .060 x 1-1/4	A60-OBFTK	7,640	10

Non-Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond

Benefits

- Fast cut rate and long life
- Free cutting action
- Burn-free cutting
- Long life

For use on machines where the work is rigidly clamped and the wheel operates on a controlled cutting plane with no twisting or lateral stresses. Ideal for slotting dies or cutting off high-speed steel drills and end mills.



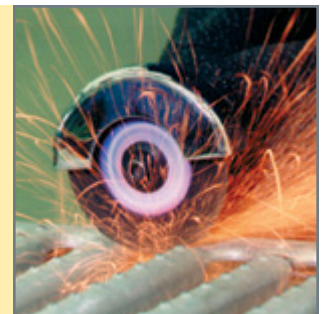
PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For High-Speed Steel and Tool Steels				
05539509188	6 x 1/16 x 1-1/4	A60-OB5SW	7,640	10
05539501923	7 x 1/32 x 1-1/4	A60-MB5SW	5,460	10
05539509187	7 x 1/32 x 1-1/4	A60-OB5SW	5,460	10
05539509186	7 x 1/32 x 1-1/4	A70-QB5SW	5,460	10
05539509185	7 x 1/16 x 1-1/4	A46-OB5SW	6,550	10
05539509184	7 x 1/16 x 1-1/4	A60-OB5SW	6,550	10
05539509183	8 x 1/16 x 1-1/4	A46-OB5SW	5,730	10
05539501926	8 x 1/16 x 1-1/4	A60-MB5SW	5,730	10
05539562839	10 x 1/16 x 5/8	A46-QB5RW	4,585	10
05539509181	10 x 1/16 x 5/8	A60-OB5SW	4,585	10

TechTip

- Reinforced cut-off wheels are designed to resist breakage caused by severe cross-bending and are required on any operation where the work is not securely clamped.
- Non-reinforced cut-off wheels are designed for use on "fixed-base" types of machines where the work is securely clamped, guarded, and where the wheel operates on a controlled cutting plane.



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



Non-Reinforced Cut-off Wheels for MetLab Applications

Non-Reinforced Aluminum Oxide and Silicon Carbide Abrasives

Features

- Developed specifically for microscopic metal analysis
- Available in silicon carbide abrasive
- Available in aluminum oxide abrasive
- Superior bond system
- Used wet

Benefits

- Burr-free cutting and minimal distortion of metallurgical samples
- Ideal for titanium and other non-ferrous metals
- Engineered for hard, medium and soft metals, ferrous alloys and tool steels
- Generates pure cuts while minimizing wheel wear and odor
- More cuts/wheel and minimal downtime to change wheels
- Minimal burn

Developed specifically for sectioning and sample preparation for metallurgical lab analysis.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Rc 55-68 Steel				
66253060544*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 901	4,025	10
66253060553*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 101	3,500	10
66253060560*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 121	3,820	10
66253060690*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 141	2,770	10
For Rc 40-55 Steel				
66253060546*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 902	4,025	10
66253060554*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 102	3,500	10
66253060562*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 122	3,820	10
66253060691*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 142	2,770	10

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Rc 30-40 Steel				
66253060547*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 903	4,025	10
66253060555*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 103	3,500	10
66253060563*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 123	3,820	10
66253060692*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 143	2,770	10
For Rc 20-30 Steel				
66253060548*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 904	5,085	10
66253060556*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 104	4,585	10
66253060681*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 124	3,820	10
66253060712*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 144	3,330	10
For Non-ferrous Materials				
66253060550*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 905	5,085	10
66253060557*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 105	4,585	10
66253060683*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 125	3,820	10
66253060713*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 145	3,330	10
For Titanium				
66253060552*	9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	METLAB 906	5,085	10
66253060558*	10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	METLAB 106	4,585	10
66253060684*	12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	METLAB 126	3,820	10
66253060714*	13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	METLAB 146	3,330	10

*All MetLab wheels are non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

BONDED ABRASIVES

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Reinforced Cut-off Wheels for Portable Machines

Premier Red Reinforced Ceramic Alumina/Zirconia Alumina Abrasive Blend

Features

- An exclusive blend of high-performance ceramic alumina and zirconia alumina abrasives
- Advanced grain and bond technology
- 1/32" & .035 thick – fastest initial cut rate
- 1/16" thick
- 1/8" & 3/16" thick – exceptional control
- Smaller blotters

Benefits

- Up to 50% added wheel life
- Up to 5 times the life versus A/O wheels on carbon steel, cast iron, stainless steel and exotic metals
- Substantially longer wheel life; fastest cut rate
- Minimum kerf loss
- For demanding applications
- Longest lasting
- Faster, freer cutting

Ideal for cutting all types of stainless steel and steel alloys.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal				
05539503861	3 x 1/32 x 3/8	MZ60-T	25,445	50
05539503863	3 x 1/16 x 3/8	MZ36-T	25,445	50
05539504270	3 x 3/16 x 3/8	MZ36-T	25,445	50

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Stainless Steel/Metal (continued)				
05539503507	4 x .035 x 3/8	MZ60-T	19,100	25
05539503508	4 x 1/16 x 3/8	MZ36-T	19,100	25
05539503509	4 x 1/8 x 3/8	MZ36-T	19,100	25

Gold Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction
- BFTK - side reinforced, rough sides
- BFW - side reinforced, rough sides

Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cutting
- Maximum cut rate; minimum kerf loss
- Versatile, durable free cutting

For cutting off ferrous metals, alloy steels and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
05539509277	2 x .035 x 1/4	A60-OBFTK	30,560	25
05539509276	2 x .035 x 3/8	A60-OBFTK	30,560	25

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal (continued)				
05539509275	2 x 1/16 x 1/4	A36-TBFW	30,560	25
05539509269	3 x .035 x 1/4	A60-OBFTK	25,445	25
05539509268	3 x .035 x 3/8	A60-OBFTK	25,445	25
05539509267	3 x .060 x 1/4	A60-OBFTK	25,445	25
05539509266	3 x .060 x 3/8	A60-OBFTK	25,445	25
05539509265	3 x 1/16 x 1/4	A36-TBFW	25,445	25
05539509264	3 x 1/16 x 1/4	A60-TBFW	25,445	25
05539509263	3 x 1/16 x 3/8	A36-TBFW	25,445	25
05539509262	3 x 1/16 x 3/8	A60-TBFW	25,445	25
05539509261	3 x 1/8 x 1/4	A36-TBFW	25,445	25
05539509260	3 x 1/8 x 3/8	A36-TBFW	25,445	25
05539509258	4 x .035 x 1/4	A60-OBFTK	19,100	25
05539509257	4 x .035 x 3/8	A60-OBFTK	19,100	25
05539509255	4 x 1/16 x 1/4	A36-TBFW	19,100	25
05539509254	4 x 1/16 x 3/8	A36-TBFW	19,100	25
05539509252	4 x 1/8 x 3/8	A36-TBFW	19,100	25

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	CORRECTION
NON-SQUARE CUTS	WORK NOT CLAMPED PROPERLY MISALIGNED SPINDLE BEARINGS POOR COOLANT DISTRIBUTION WHEEL IS TOO HARD	CHECK CLAMP AND CLEAN TO REMOVE SWARF CHECK FOR BEARING TRUTH AND ALIGNMENT ENSURE EQUAL VOLUME OF COOLANT TO EACH WHEEL SIDE USE SOFTER ACTING WHEEL - SOFTER GRADE/FINER GRIT
WORKPIECE BURN	INSUFFICIENT FEED RATE POOR COOLANT FLOW WHEEL IS TOO COARSE WHEEL IS TOO HARD WHEEL IS RUNNING OUT WHEEL SPEED IS TOO SLOW	WORK MACHINE TO MAXIMUM POWER AVAILABLE INCREASE VOLUME AND DIRECT AT CUTTING POINT USE FINER WHEEL OR MORE MACHINE POWER USE SOFTER GRADE WHEEL CHECK SPINDLE AND FLANGES ENSURE TIGHT FLANGES AND MAXIMUM SPEED MARKED ON WHEEL BEING USED
POOR FINISH	TOO MUCH BURR WHEEL TOO COARSE	USE FINER GRIT OR SOFTER WHEEL USE FINER GRIT



BONDED ABRASIVES

Reinforced Cut-off Wheels for Portable Circular Saws

Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

Used on hand-held portable circular saws to cut steel and all types of metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Fast Cut				
05539509243	7 x 1/16 x 5/8	A36-TBFW	8,730	10
05539509240	7 x 3/32 x D.M.	A24-T	8,730	20
05539509238	8 x 1/16 x 5/8	A36-TBFW	7,640	10
For Stainless Steel				
05539509249	7 x 3/32 x 5/8	A36-XBFW	8,730	10

Cut-off Wheel Competitive Cross Reference

CARBORUNDUM	FLEXOVIT	METABO	SAIT	3M	WALTER
FOR SMALL STRAIGHT OR IN-LINE PORTABLE GRINDERS (2" - 4")					
PREMIER RED	FLEXON	-	SAITECH	GREEN CORPS	-
GOLD	A46T/A36-R	A 60 TZ	A36T/A24R	-	A24-ZIP, A60-ZIP
FOR RIGHT ANGLE GRINDERS (4" - 9")					
PREMIER REDCUT	-	-	SAITECH .045	-	A30-ZIP
GOLDCUT	RAZORBLADE	SLICER	0.045	-	A30-ZIP
CARBO METAL	-	SLICER	-	-	-
FOR CIRCULAR SAWS (7" - 8")					
METAL	A36TB38	A 30 S	-	-	A30-ZIP
FOR PORTABLE GAS OR ELECTRIC SAWS (12" - 16")					
GOLD METAL	A24TB	A 24 N	BRUTE	-	A24 PORTACUT
GOLD CONCRETE	AC24SB	C 24 N	C24R	-	C24 PORTACUT
GOLD DUCTILE	AC24SB	AC 24 R	DUCTILE	-	-
FOR STATIONARY SAWS (10" - 20")					
PREMIER RED	-	-	-	-	-
GOLD FAST CUT	A30RB	A 30 R	A24N	-	A24-FC RIPCUT
GOLD LONG LIFE	A30SB	A 30 N	A24R	-	A24-RIP
FOR CHOP SAWS (10" - 16")					
PREMIER RED FAST CUT	-	-	SAITECH STEEL WORKER-	-	-
PREMIER RED LONG LIFE	-	-	-	-	-
GOLD FAST CUT	A30RB	A 30 R	EZ-CHOP	-	A30 CHOPCUT II
GOLD LONG LIFE	A30SB	A 30 S	IRON WORKER	-	A30-HC CHOPCUT
CARBORUNDUM	DEWALT	CONTINENTAL	MAKITA	PEARL	TYROLIT
FOR CHOP SAWS (14")					
CARBO METAL	COMPARABLE TO COMPETITIVE BRANDS' GENERAL PURPOSE LINES				

Reinforced Cut-off Wheels for Right Angle Grinders

Premier RedCut Reinforced Zirconia Alumina/Aluminum Oxide Abrasive Blend

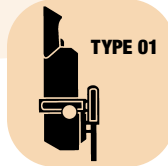
Features

- Premier performing zirconia alumina/aluminum oxide abrasive blend in a free cutting bond
- Unique, high-strength, reinforced construction
- Extra thin

Benefits

- 3 times the life and 2 times the cut rate of standard A/O wheels
- Smooth cutting action that minimizes burn and burrs and operator fatigue
- Maximum productivity; lowest total grinding costs
- Provides strength for use on right angle grinders
- Flexible, resilient; resists breakage
- Less binding; quick cutting action

Excels on a broad range of materials, from alloys and stainless to gray iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Stainless Steel/Metal				
Type 01 – For Right Angle Grinders				
05539566206	4-1/2 x 1/16 x 7/8	ZA60-Q	13,580	25
05539566207	5 x 1/16 x 7/8	ZA60-Q	12,225	25
05539566208	6 x 1/16 x 7/8	ZA60-Q	10,185	25

Safety Tip

- Contact your machine vendor for proper flanges and guards when using Type 01 wheels on right angle grinders.
- Use Type 01 when proper cut-off guard and equal size flanges are available.



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

GoldCut Reinforced Aluminum Oxide Abrasive

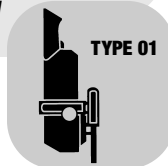
Features

- Quality aluminum oxide abrasive
- Advanced resin bond
- Unique, high-strength, reinforced construction
- Extra thin

Benefits

- Fast stock removal
- Free cutting action
- Long life, with no bounce
- Provides strength for use on right angle grinders
- Flexible, resilient; resists breakage
- Less binding; quick cutting action

For general purpose cutting of stainless steel, steel and metal material with a right angle grinder.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Type 01 – For Right Angle Grinders				
05539563951	4 x .045 x 5/8	A46-Q	15,280	25
05539527224	4 x 3/32 x 5/8	A36-Q	15,280	25
05539563952	4-1/2 x .045 x 7/8	A60-Q	13,580	25
05539527225	4-1/2 x 3/32 x 7/8	A60-Q	13,580	25
05539563953	5 x .045 x 7/8	A60-Q	12,225	25
05539527226	5 x 3/32 x 7/8	A60-Q	12,225	25
05539509199	6 x .040 x 5/8	A60-Q	10,185	25
05539563954	6 x .045 x 7/8	A46-Q	10,185	25
05539527228	6 x 3/32 x 7/8	A60-Q	10,185	25
66252832324	7 x 1/16 x 7/8	A46-Q	8,600	25

Carbo Metal Reinforced Aluminum Oxide Abrasive

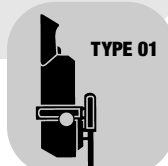
Features

- Quality aluminum oxide abrasive
- Extra thin
- Low initial cost per wheel

Benefits

- Quick cutting action
- Low kerf loss
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Type 01 – For Right Angle Grinders				
05539561584	4-1/2 x .040 x 7/8	A60	13,580	25
05539561585	5 x .040 x 7/8	A60	12,225	25
05539561586	6 x .040 x 7/8	A60	10,185	25

BONDED ABRASIVES

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Reinforced Cut-off Wheels for Right Angle Grinders

GoldCut Reinforced Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Clean bond
- Extra thin, depressed center cutting-off wheels
- Specially reinforced
- Hubbed wheels

Benefits

- Burn-free cutting
- Works particularly well on stainless
- No sulphur, iron or chlorine in bond means no contamination of workpiece
- Quick cutting action
- Minimal kerf loss
- Added safety, strength and straight cuts
- Quick, tool-free changes increase productivity

Excellent choice for cutting all types of metals and various alloy steels.



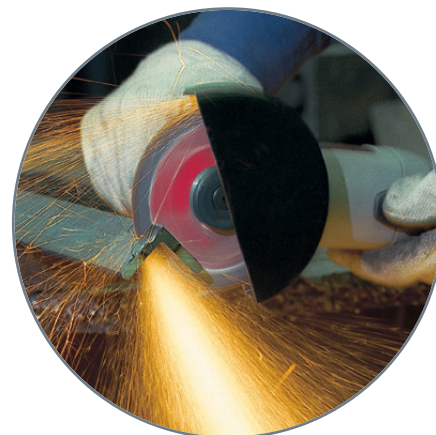
These thin, depressed center wheels should be used for cutting only.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Type 27 - For Right Angle Grinders				
66252830584	4-1/2 x .045 x 5/8-11	A30	13,580	20
05539561551	4-1/2 x .045 x 7/8	A30	13,580	20
05539561553	5 x .045 x 7/8	A30	12,225	20
05539561554	6 x .045 x 7/8	A30	10,185	20
05539561555	7 x 1/16 x 7/8	A30	8,600	20
66252830585	9 x 1/16 x 5/8-11	A30	6,600	10

Spec Check

CUT-OFF WHEEL STARTING RECOMMENDATIONS BY MATERIAL

MATERIAL	IN-LINE GRINDERS	RIGHT ANGLE GRINDERS	CIRCULAR SAWS	PORTABLE GAS / ELECTRIC SAWS	STATIONARY SAWS	CHOP SAWS
ANGLE / CHANNEL IRON BAR / SHEET STOCK	PREMIER RED GOLD	PREMIER REDCUT	METAL	GOLD METAL	PREMIER RED GOLD LONG LIFE	PREMIER RED LONG LIFE GOLD LONG LIFE
METAL STUDS / TUBING	-	GOLDCUT	METAL	GOLD METAL	GOLD LONG LIFE	GOLD LONG LIFE
CAST IRON / PIPE	GOLD	GOLDCUT	METAL	GOLD METAL	GOLD FAST CUT	GOLD FAST CUT
STAINLESS / ALLOYS	PREMIER RED	PREMIER REDCUT	STAINLESS	GOLD METAL	PREMIER RED	PREMIER RED FAST CUT
ALUMINUM / BRASS / BRONZE	GOLD	GOLDCUT	METAL	GOLD METAL	GOLD FAST CUT	GOLD FAST CUT
CONCRETE / BRICK / BLOCK ASPHALT / GREEN CONCRETE	-	-	-	GOLD CONCRETE		
DUCTILE				GOLD DUCTILE		
PAINT / RUST / FIBERGLASS / PLASTIC	GOLD	GOLDCUT	METAL	-	GOLD FAST CUT	GOLD FAST CUT



Reinforced Cut-off Wheels for Stationary Machines

Premier Red Reinforced Zirconia Alumina Abrasive

Features

- Premium, zirconia alumina abrasive
- Resin bond
- High-strength, externally reinforced construction

Benefits

- Fastest cut rate on steel/metal
- Ideal for cutting stainless and high alloy steels
- Works best on dry cuts
- Most free cutting
- Longest wheel life
- Greatest productivity
- Resists breakage and provides straight cuts

For use on fixed-base machines.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Stainless Steel/Metal				
05539507054	16 x 5/32 x 1	2ZA30-YB35FW	3,820	10
05539507061	20 x 5/32 x 1	2ZA30-TB35FW	2,710	5



Gold Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, externally reinforced construction

Benefits

- Fast cut rate on metal or steel
- Burn-free cutting
- For dry cuts
- Long life
- Resists breakage and provides straight cuts

For use on fixed-base machines.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Fast Cut				
05539509216	10 x 3/32 x 5/8	A30-RBFW	6,110	10
05539507069	12 x 1/8 x 1	A30-RBFW	5,095	10
05539507070	14 x 1/8 x 1	A30-RBFW	4,365	10
05539507071	16 x 5/32 x 1	A30-RBFW	3,820	10
05539507072	20 x 5/32 x 1	A30-RBFW	2,710	5
05539509204	20 x 3/16 x 1	A30-RBFIW+	2,710	5
Long Life				
05539507063	10 x 3/32 x 5/8	A24-TBFW	6,110	10
05539507065	14 x 1/8 x 1	A24-TBFW	4,365	10
05539507066	16 x 5/32 x 1	A24-TBFW	3,820	10
05539507067	20 x 5/32 x 1	A24-TBFW	2,710	5
05539507068	20 x 3/16 x 1	A24-TBFIW+	2,710	5

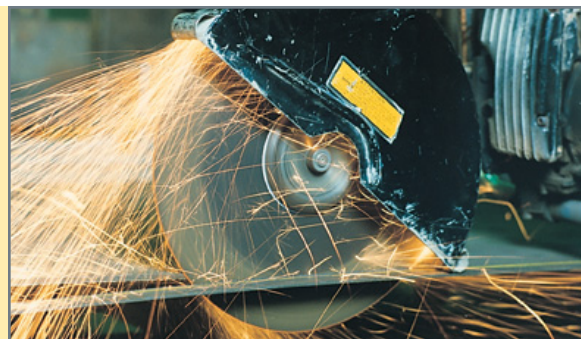
+ These wheels are internally reinforced.

TechTip

- Run the cut-off machine at the "Maximum Operating Speed" marked on the wheel.
- A cut-off machine should have 1 horsepower for every inch of wheel diameter.
- With a less powerful machine, we recommend starting with a Fast Cut specification.
- Use Long Life wheels in high horsepower, aggressive applications.



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



Reinforced Cut-off Wheels for Chop Saws

Premier Red Reinforced Zirconia Alumina Abrasive

Features

- Premium zirconia alumina abrasive
- High performance resin bond
- High-strength, externally reinforced construction

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide wheels
- Ideal for cutting stainless steel
- Works best on dry cuts
- Most free cutting
- Long life; highest productivity
- Resists breakage and provides straight cuts

For use on table-top machines. Best choice for cutting light tubing, angle iron, exhaust pipes, steel extrusions, stainless, alloyed steel and many non-ferrous metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Stainless Steel/Metal				
Fast Cut				
05539507079	12 x 7/64 x 1	2ZA36-NB35FW	5,095	10
05539507080	14 x 7/64 x 1	2ZA36-NB35FW	4,365	10
05539507083	16 x 7/64 x 1	2ZA36-NB35FW	3,820	10
Long Life				
05539507082	14 x 7/64 x 1	2ZA36-PB35FW	4,365	10



TechTip

- Use Long Life chop saw wheels on machines rated 15 amps or higher.
- Use Fast Cut chop saw wheels on older, lower-powered machines.



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

Gold Reinforced Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Resin bond
- High-strength, externally reinforced construction

Benefits

- Fast cut rate
- Burn-free cutting
- Resists breakage and provides straight cuts

For use on table-top machines. Ideal for cutting light tubing, angle iron, exhaust pipes and steel extrusions.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Fast Cut				
05539507087	14 x 7/64 x 1	A36-NBFW	4,365	10
Long Life				
05539567290	10 x 1/8 x 1	A30-S	6,110	10
05539507085	12 x 7/64 x 1	A36-PBFW	5,095	10
05539507086	14 x 3/32 x 1	A36-PBFW	4,365	10
05539507088	16 x 7/64 x 1	A36-PBFW	3,820	10

Carbo Metal Reinforced Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Low initial cost per wheel

Benefits

- Designed for cutting alloys, steels and ferrous metals
- Ideal for on-site and small-unit jobs

Economical choice for initial-price-conscious customers with general purpose cut-off applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
05539561582	14 x 3/32 x 1	A36-P	4,365	10

Reinforced Cut-off Wheels for High-Speed Gas/Electric Saws

Gold Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut metal or steel.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
05539565124	12 x 1/8 x 20mm	A24	6,360	10
05539565125	12 x 1/8 x 1	A24	6,360	10
05539565126	14 x 1/8 x 20mm	A24	5,400	10
05539565127	14 x 1/8 x 1	A24	5,400	10



Gold Reinforced Silicon Carbide/Aluminum Oxide Abrasive Blend

Features

- Silicon carbide/aluminum oxide abrasive blend
- Resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut ductile iron, ultra-hard metals, hydraulic hose, and PVC pipe.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Ductile Iron				
05539565134	12 x 1/8 x 20mm	CA24	6,360	10
05539565136	14 x 1/8 x 20mm	CA24	5,400	10
05539565137	14 x 1/8 x 1	CA24	5,400	10
05539565138	16 x 1/8 x 1	CA24	4,700	10

Gold Reinforced Silicon Carbide Abrasive

Features

- Sharp, silicon carbide abrasive
- Resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- Free cutting action
- Burn-free cutting
- Long life
- Resists breakage and provides straight cuts

For use on high-speed gas and electric saws to cut concrete and masonry.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Concrete/Masonry				
05539565129	12 x 1/8 x 20mm	C24	6,360	10
05539565130	12 x 1/8 x 1	C24	6,360	10
05539565131	14 x 1/8 x 20mm	C24	5,400	10
05539565132	14 x 1/8 x 1	C24	5,400	10



BONDED ABRASIVES

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Reinforced Cut-off Wheels for Foundry Applications

Premier Red Reinforced Zirconia Alumina Abrasive

Features

- Premium zirconia alumina abrasive
- Resin bond
- Internally reinforced wheels

Benefits

- Fastest cut rate on high alloy steels, stainless steel, steel/metal
- Works best on dry cuts
- Most free cutting
- Longest wheel life
- Highest productivity
- High strength; less kerf loss and provide straight cuts

Foundry cut-off wheels are used on chop stroke and locked-head push-through applications. Ideal for cutting off casting gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Stainless Steel/Metal				
66253060317*	12 x 1/8 x 1	2ZA30-VB35FW	5,090	10
66253060319*	14 x 1/8 x 1	2ZA30-VB35FW	4,365	10
66253060323*	16 x 5/32 x 1	2ZA30-VB35FW	3,820	10
66253060325*	20 x 5/32 x 1	2ZA24-TB35FW	2,710	10
66253060328*	20 x 5/32 x 1	2ZA24-VB35FW	2,710	10
66253060329*	20 x 5/32 x 1	2ZA24-YB35FW	2,710	10
66253060330*	20 x 5/32 x 1	2ZA24-TB35FIW+	2,710	10
66253060334*	20 x 3/16 x 1	2ZA24-TB35FIW+	2,710	10
66253060335*	20 x 3/16 x 1	2ZA24-VB35FIW+	2,710	10

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Stainless Steel/Metal				
66253060336*	20 x 3/16 x 1	2ZA24-YB35FIW+	2,710	10
66253062169*	24 x 7/32 x 1-3/4	2ZA24-TB35FIW+	2,260	5
05539528045	24 x 7/32 x 1-3/4	2ZA24-VB35FIW+	2,260	5
66253062170*	24 x 7/32 x 1-3/4	2ZA24-YB35FIW+	2,260	5

+Wheels with FIW grading are internally reinforced.

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Gold Reinforced Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Resin bond
- Internally reinforced wheels

Benefits

- Fast cut rate on ferrous and non-ferrous metals
- Free cutting action
- For dry cuts
- Long life
- High strength; less kerf loss and provide straight cuts

Used on chop stroke and locked-head push-through applications. Ideal for cutting off casting gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
66253060313*	12 x 1/8 x 1	RGA244-TB35FW	5,090	10
66253060318*	14 x 1/8 x 1	RGA244-TB35FW	4,365	10
66253060322*	16 x 5/32 x 1	RGA244-RB35FW	3,820	10
66253060324*	20 x 5/32 x 1	RGA244-TB35FW	2,710	10
66253060331*	20 x 3/16 x 1	RGA244-RB35FIW+	2,710	10
66253060332*	20 x 3/16 x 1	RGA244-TB35FIW+	2,710	10
66253060333*	20 x 3/16 x 1	RGA244-VB35FIW+	2,710	10
05539528046	24 x 3/16 x 1-3/4	RGA244-RBFIW+	2,260	5
66253062165*	24 x 7/32 x 1-3/4	RGA244-RB35FIW+	2,260	5
66253062166*	24 x 7/32 x 1-3/4	RGA244-TB35FIW+	2,260	5
66253062167*	24 x 7/32 x 1-3/4	RGA244-VB35FIW+	2,260	5
05539528047	26 x 7/32 x 1-3/4	RGA244-YB35FIW+	2,090	5

+Wheels with FIW grading are internally reinforced.

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

BONDED ABRASIVES

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Premier Red Reinforced Zirconia Alumina Abrasive

Features

- Premium zirconia alumina abrasive
- High-performance resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide
- Greatest productivity
- Free cutting action
- Long life
- Resists breakage

Use when grinding with a hand-held machine. Best choice for grinding steel, steel alloys and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 01 - For Portable Grinders				
66253060939*	3 x 1/4 x 3/8	2ZA24-RBFF	18,080	10
66253060940*	3 x 3/8 x 3/8	2ZA24-QBFF	18,080	10
66253060953*	6 x 1 x 5/8	2ZA14-QBF64	8,000	5
05539509169	6 x 1 x 5/8	2ZA14-RBF64	8,000	5
66253060957*	8 x 3/4 x 5/8	2ZA14-QBF64	6,000	5
66253060958*	8 x 3/4 x 5/8	2ZA14-RBF64	6,000	5
05539509167	8 x 1 x 5/8	2ZA14-RBF64	6,000	5
66253060960*	8 x 1 x 5/8	2ZA16-QBF64	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.



Gold Reinforced Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond
- High-strength, reinforced construction

Benefits

- Fast cut rate
- Free cutting action
- Long life
- Resists breakage

Use when grinding with a hand-held machine. The economical choice for grinding steel, steel alloys and cast iron.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 01 - For Portable Grinders				
05539507346*	6 x 1 x 5/8	GA16-P5BF5	6,000	5
05539507347	8 x 1 x 5/8	GA16-P5BF5	4,540	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Reinforced Aluminum Oxide Abrasive

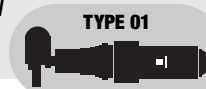
Features

- Aluminum oxide abrasive
- Reinforced

Benefits

- Fast cut rate and long life
- Durable, yet cool cutting

Use when grinding with a hand-held machine. Ideal for grinding parting lines, gates and risers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 01 - For Portable Grinders				
66253060936*	3 x 1/4 x 3/8	A24-TBFF	18,080	10
05539506618	3 x 1/2 x 3/8	GA24-PBFF	18,080	10

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Portable Snagging Wheels

Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High-performance resin bond

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Soft Metals				
Type 01 – For Portable Grinders				
66253060956*	6 x 1 x 5/8	2ZC14-QBF64	8,000	5
66253060961*	8 x 1 x 5/8	2ZC16-QBF64	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Gold Aluminum Oxide/Silicon Carbide Abrasive Blend

Features

- Quality aluminum oxide/silicon carbide abrasive blend
- Resin bond

Benefits

- Fast cut rate
- Free cutting action

Economical choice for grinding dirty, scale-covered castings, aluminum and other soft metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Soft Metals				
Type 01 – For Portable Grinders				
66253061064*	8 x 1 x 5/8	CGA16-P5BF5	4,540	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Premier Red Zirconia Alumina Abrasive

Features

- Premium zirconia alumina abrasive
- High-performance resin bond

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide abrasive; greatest productivity
- Free cutting action

Best choice for grinding steel, steel alloys and cast iron. Used for grinding weld seams, cleaning metal before welding, grinding off fins and parting lines, smoothing surfaces on castings, and smoothing surfaces before painting or plating.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 11 – For Portable Cup Grinders				
Full Steel Back Bushing				
66253060844*	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	2ZA16-QB64	9,070	10
66253060847*	5 / 3-13/16 x 2 x 5/8-11 Rim 1, Back 3/4	2ZA16-QB64	7,260	5
66253060852*	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA14-RB64	6,000	5
05539500694	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-QB64	6,000	5
Standard Back Bushing				
05539563938	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	2ZA16-QB64	9,070	10
05539509156	5 / 3-3/4 x 2 x 5/8-11 Rim 1, Back 3/4	2ZA16-QB64	7,260	5
05539508397	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA14-RB64	6,000	5
05539509155	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-PB64	6,000	5
05539507176	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZA16-QB64	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Aluminum Oxide Abrasive

Features

- Quality aluminum oxide abrasive
- Resin bond

Benefits

- Fast cut rate
- Free cutting action

Economical choice for grinding steel, steel alloys and all ferrous metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Iron/Steel/Metal				
Type 11 – For Portable Cup Grinders				
Full Steel Back Bushing				
05539563936*	5 / 3-13/16 x 2 x 5/8-11 Rim 1, Back 3/4	A24-PB5	7,260	5
05539507182	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	A16-PB5	6,000	5

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Iron/Steel/Metal				
Type 11 – For Portable Cup Grinders				
Standard Back Bushing				
05539509166	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	A16-PB5	9,070	10
66253060855*	5 / 3-3/4 x 2 x 5/8-11 Rim 1, Back 3/4	A16-PB5	7,260	5
05539509162	5 / 3-3/4 x 2 x 5/8-11 Rim 1, Back 3/4	A24-PB5	7,260	5
05539509160	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	A16-PB5	6,000	5
05539563989	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	A16-QB5	6,000	5
05539509159	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	A24-PB5	6,000	5
05539507180*	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	A24-RB5	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High performance resin bond

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Soft Metals				
Type 11 – For Portable Cup Grinders				
Full Steel Back Bushing				
05539507178*	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZC16-QB64	6,000	5
Standard Back Bushing				
05539507177	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	2ZC16-QB64	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Aluminum Oxide/Silicon Carbide Abrasive Blend

Features

- Quality aluminum oxide/silicon carbide abrasive blend
- Resin bond

Benefits

- Fast cut rate
- Free cutting action

Economical choice for grinding dirty, scale-covered castings, aluminum and other soft metals.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Soft Metals				
Type 11 – For Portable Cup Grinders				
Full Steel Back Bushing				
05539507183	6 / 4-13/16 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	CGA16-QB5	6,000	5
Standard Back Bushing				
66253060740*	4 / 3 x 2 x 5/8-11 Rim 3/4, Back 3/4	CGA16-PB5	9,070	10
05539507181	6 / 4-3/4 x 2 x 5/8-11 Rim 1-1/2, Back 3/4	CGA16-QB5	6,000	5

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Portable Snagging Cones and Plugs

Premier Red Zirconia Alumina Abrasive

Features

- Premium zirconia alumina abrasive
- High-performance resin bond

Benefits

- Fastest cut rate
- 3 times the life of aluminum oxide abrasive: greatest productivity
- Free cutting action

The best choice for grinding steel, steel alloys and cast iron, for removing burrs and flash and finishing any type of metal surface in a confined area.



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 16 Cones (Round End)				
66253060513*	1-1/2 x 3 x 3/8-24	2ZA20-R	24,190	10
66253060541*	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520886	2 x 3 x 5/8-11	2ZA20-R	18,145	10
05539520887	2-3/4 x 3-1/2 x 5/8-11	2ZA20-R	13,195	10
Type 17R (Round End)				
66253060533*	2 / 3/4 x 3 x 5/8-11	2ZA20-R	18,145	10
Type 18 Plugs (Square End)				
66253060510*	1-1/2 x 2-1/2 x 5/8-11	2ZA20-R	24,190	10
66253060516*	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520889	2 x 3 x 5/8-11	2ZA20-R	18,145	10
66253060540*	2 x 3 x 5/8-11	2ZA24-R	18,145	10
Type 18R Plugs (Round End)				
05539520893	1-1/2 x 3 x 5/8-11	2ZA20-R	24,190	10
05539520891	2 x 3 x 5/8-11	2ZA20-R	18,145	10

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.



Cone and Plug Shapes



Gold Zirconia Alumina/Aluminum Oxide Abrasive Blend

Features

- Performance, zirconia alumina/aluminum oxide abrasive blend
- Resin bond

Benefits

- Fast cut rate
- Easily grinds scale-covered parts
- Long life

Excellent for grinding steel, steel alloys and cast iron, for removing burrs and flash and finishing any type of metal surface in a confined area.



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 16 Cones (Round End)				
05539563710	1-1/2 x 3 x 3/8-24	3ZA24-R	24,190	10
05539563711	1-1/2 x 3 x 5/8-11	3ZA20-R	24,190	10
Type 18 Plugs (Square End)				
05539563715	2 x 3 x 5/8-11	3ZA20-R	18,145	10

BONDED ABRASIVES

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Aluminum Oxide Abrasive

Features

- Quality, aluminum oxide abrasive
- Resin bond

Benefits

- Fast stock removal
- Free cutting action

The economical choice for grinding steel or iron castings, removing burrs and flash and finishing metal surfaces in confined areas.



PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 16 Cones (Round End)				
66253060500*	1 x 3 x 3/8-24	A24-R	36,290	10
05539564069*	1-1/2 x 2 x 3/8-24	A24-R	24,190	10
05539564068*	1-1/2 x 2-1/2 x 3/8-24	A24-R	24,190	10
05539509154	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
66253060517*	1-3/4 x 3 x 3/8-24	A24-R	20,735	10
66253060523*	1-3/4 x 3 x 5/8-11	A24-R	20,735	10
05539564070	2 x 3 x 3/8-24	A24-R	18,145	10
05539509153	2 x 3 x 5/8-11	A24-R	18,145	10
05539509152	2-3/4 x 3-1/2 x 5/8-11	A24-R	13,195	10
05539564073*	3 x 3 x 5/8-11	A24-R	12,100	10
05539564071*	3 x 4 x 5/8-11	A24-R	12,100	10

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

PART NO.	SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
Type 17 Cones (Square End)				
05539509150	1-1/2 / 1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509149	2 / 1/2 x 3 x 5/8-11	A24-R	18,145	10
Type 17R Cones (Round End)				
05539564076*	1-1/2 / 3/4 x 3 x 3/8-24	A24-R	24,190	10
Type 18 Plugs (Square End)				
66253060512*	1-1/2 x 2-1/2 x 3/8-24	A24-R	21,490	10
05539509145	1-1/2 x 2-1/2 x 5/8-11	A24-R	24,190	10
05539509144	1-1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509143	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
66253060524*	2 x 2 x 3/8-24	A24-R	18,145	10
05539509142	2 x 3 x 3/8-24	A24-R	18,145	10
05539509141	2 x 3 x 5/8-11	A24-R	18,145	10
05539509139	3 x 4 x 5/8-11	A24-R	12,095	10
Type 18R Plugs (Round End)				
05539564074*	1-1/2 x 2-1/2 x 3/8-24	A24-R	24,190	10
05539509138	1-1/2 x 3 x 3/8-24	A24-R	24,190	10
05539509137	1-1/2 x 3 x 5/8-11	A24-R	24,190	10
05539509136	2 x 3 x 5/8-11	A24-R	18,145	10
05539509134	3 x 4 x 5/8-11	A24-R	12,095	10

Foundry Floorstand Snagging Wheels

Premier Red Zirconia Alumina/Aluminum Oxide Abrasive Blend

Features

- Premium zirconia alumina abrasive
- High performance resin bond

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide
- Greatest productivity
- Free cutting action

Castings small enough to be carried to the grinder are ground using a floorstand wheel. Best choice for grinding all types of metals, cast iron and cast steel.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
66253061609*	30 x 2 x 12	AZA14-QBF68	1,595	1
66253061610*	30 x 2 x 12	AZA14-RBF68	1,595	1
66253061590*	30 x 2 x 12	2ZA14-RBF68	1,595	1
66253061589*	30 x 2 x 12	2ZA16-QBF68	1,595	1

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.



BONDED ABRASIVES



TechTip

- Always ensure proper mounting of floorstand wheels by mounting with arrow as marked on wheel.
- Always use a safety guard.
- Always run the wheel for 1 minute before grinding.
- For optimum performance, ensure adequate air pressure and air volume when using pneumatic machines.
- Avoid loading or glazing by changing the contact angle.



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

Foundry Floorstand Snagging Wheels

Gold Zirconia Alumina/Aluminum Oxide Abrasive Blend

Features

- Performance zirconia alumina/aluminum oxide abrasive blend
- Resin bond
- High-strength, safety web construction
- Convenient 10 wheels/pallet packaging available

Benefits

- Fast cut rate
- Easily grinds scale-covered parts
- Extended wheel life
- Resists breakage
- Economical; environmentally-friendly
- Easy storage and handling

Castings small enough to be carried to the grinder are ground using a floorstand wheel. Ideal for grinding all types of metals, cast iron and cast steel.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
66253061451*	24 x 2-1/2 x 12	3AZA14-RBF68	1,990	1
66253061570*	24 x 3 x 12	3AZA14-RBF68	1,990	1
05539562953	30 x 2 x 12	3AZA14-SBF68	1,595	1
05539562952	30 x 2 x 12	3AZA16-QBF68	1,595	1

Special Pallet Pack of 10 Wheels

05539563986*	30 x 2 x 12	3AZA14-SBF68	1,595	10
05539563987	30 x 2 x 12	3AZA16-QBF68	1,595	10

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Zirconia Alumina/Aluminum Oxide Abrasive Blend

Features

- Unique zirconia alumina/aluminum oxide abrasive blend
- Resin bond
- High-strength, safety web construction

Benefits

- Competitive performance/price ratio
- Ideal for medium to low pressure applications
- Long life
- Resists breakage

Castings small enough to be carried to the grinder are ground using a floorstand wheel. The choice for medium to low pressure cast iron and metal applications - when initial-price is the main purchasing consideration.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Iron/Steel/Metal				
05539563988	30 x 2 x 12	AZ All Purpose	1,595	1

Special Pallet Pack of 10 Wheels

05539563990*	30 x 2 x 12	AZ All Purpose	1,595	10
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* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Premier Red Zirconia Alumina/Silicon Carbide Abrasive Blend

Features

- Premium zirconia alumina/silicon carbide abrasive blend
- High-performance resin bond

Benefits

- Fast cut rate
- 3 times the life of aluminum oxide/silicon carbide abrasive blend
- Free cutting action

Best choice for grinding dirty, scale-covered castings, aluminum and other soft metal castings.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Soft Metals				
66253061611*	30 x 2 x 12	2ZC14-RBF68	1,595	1

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

Tool Post Wheels

Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive
- Resin bond

Benefits

- Tough and durable, yet cool cutting
- High-strength and long life

Tool post wheels provide the first step in reconditioning heavily damaged high speed tool steel on post grinders and universal attachments on cylindrical grinders.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Steel/Metal				
Type 01 - For Tool Post Grinders				
05539509907	2 x 1/2 x 3/8	A36-P5B6	18,145	10
66253060947*	3 x 1/2 x 3/8	GA24-R5B6	12,095	10

* Non-stock. Ask your Carborundum representative for current lead times and minimum order quantities.

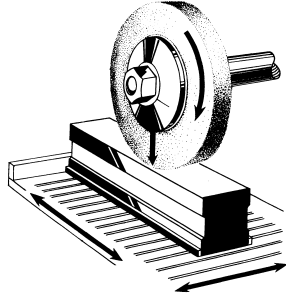


Toolroom Grinding Applications

Toolrooms are found in almost every manufacturing plant throughout the country. They may be called by other names such as machine shops, maintenance shops or repair shops, however the work done is virtually the same. Toolroom grinding involves the production, maintenance and repair of cutting tools and machinery parts used in all types of manufacturing operations.

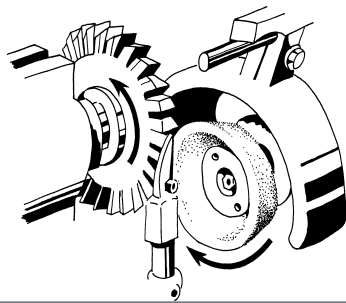
Surface Grinding

The grinding of flat, contoured or angular surfaces on a workpiece which is passed in a horizontal plane against a revolving grinding wheel. Surface grinding applications range from heavy, rapid stock removal operations to precision contouring.

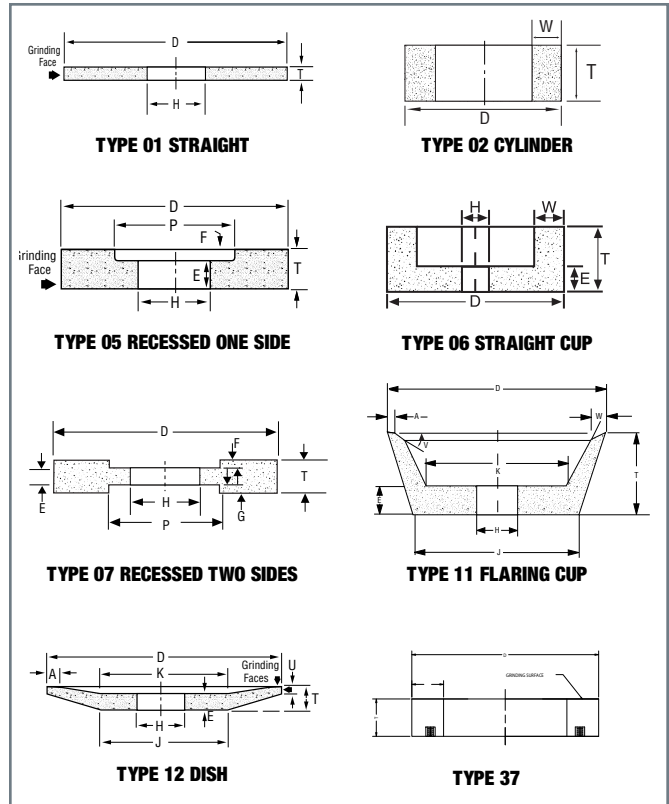


Tool and Cutter Grinding

The grinding or resharpening of milling cutters, reamers, drills or end mills for the purpose of restoring keen cutting edges or exact cutting angles.



Wheel Shapes



Toolroom Basics Selection Guide

PRODUCTIVITY	DURABILITY	ABRASIVE	COLOR	GRIT	GRADE	NARROW CONTACT FORM HOLDING BOND	MEDIUM/WIDE CONTACT AREA POROUS BOND	DRESSING TOOL
Highest	More Durable	Medalist	Blue	46 (Coarse)	F (Soft)	VL	VLP	SG Tool
↕	↕	Medalist R	Purple	↕	↕	-	VPP	SG Tool
		32AR	Gray/Purple			V40	V40P	Conventional Tool
↕	↕	AR	Ruby	↕	↕	V40	VPP	Conventional Tool
		PA	Pink			V40	VPP	Conventional Tool
Standard	More Friable	AA	White	220 (Fine)	Q (Hard)	V40	V40P, VPP	Conventional Tool

Abrasive: Select abrasive type based on required performance, stock removal rate, and material to be ground.

Grit Size: Select the grit size depending on finish required, stock removal rate needed, and corner/form holding requirements.

Grade: Select the grade based on contact area*, and heat sensitivity/thickness of material to be ground.

Bond: Select the appropriate bond based on the abrasive selected and the contact area.*

Grit Selection

GRIT	REQUIREMENTS	FINISH	MINIMUM CORNER RADIUS
46	General purpose	32 Ra and rougher	0.020"
60	Commercial finish	32 Ra and better	0.016"
80, 100	Fine finish	20 Ra and better	0.0105"
120	Very fine finish	10 Ra and better	0.006"
150	Corner/form holding		0.005"
180	Corner/form holding		0.0035"
220	Corner/form holding		0.002"

Grade/Bond Selection

GENERAL CONDITIONS AND NEEDS	NORMAL GRADE RANGE	STARTING GRADE	BOND
Narrow* contact area or form holding	K - L	K	VL, V40
General surface grinding	H - K	J	VL, V40
Medium/Wide* contact area, cooler grind	F - H	H	VLP, V40P, VPP

*Definitions of Contact Area:

Narrow: The contact area of the grind is less than 25% of the wheel width, or less than 1/4" wide.

Medium: The contact area of the grind is 25% - 50% of the wheel width, or over 1/4" - 1/2" wide.

Wide: The contact area of the grind is greater than 50% of the wheel width, or over 1/2" wide.

Toolroom Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	CORRECTION
WHEEL CORNER BREAKDOWN	POOR WHEEL DRESSING WHEEL TOO COARSE WHEEL TOO SOFT WORN MACHINE BEARINGS WRONG WHEEL STRUCTURE	DRESS WHEEL FINER USE FINER GRIT USE HARDER GRADE CHECK FOR RUN-OUT AND CORRECT USE NON-POROUS WHEEL
BURNING OF WORKPIECE	WORN DRESSING TOOL POOR COOLANT FLOW WHEEL ACTING HARD WORK SPEED TOO SLOW INFEED TOO FAST	ROTATE OR REPLACE DRESSING TOOL INCREASE/DIRECT COOLANT FLOW TO CONTACT AREA DRESS WHEEL COARSER, USE SOFTER GRADE WHEEL OR USE A POROUS WHEEL INCREASE WORK SPEED REDUCE STOCK REMOVED PER PASS OR UPGRADE TO MEDALIST OR 32AR
POOR SURFACE FINISH	POOR WHEEL DRESSING DIRTY COOLANT WHEEL TOO COARSE WHEEL TOO HARD	REDRESS MORE FREQUENTLY OR DECREASE DRESS TRAVERSE RATE FILTER COOLANT OR REPLACE WITH NEW USE FINER GRIT USE SOFTER GRADE WHEEL

Toolroom Wheel Dressing: Single Point Dressing Tool Starting Recommendations

WHEEL SIZES	SHANK DIAMETER	DISPOSABLE SINGLE POINT DRESSING TOOL			
		FOR MEDALIST & SILICON CARBIDE WHLS AMPLEX PART NO.	AMPLEX UPC NO.	FOR ALL ALUMINUM OXIDE WHEELS AMPLEX PART NO.	AMPLEX UPC NO.
UP TO 7"	3/8	T2SGUA	66260303333	T2UA	66260357634
	7/16	T2SGUB	66260303334	T2UB	66260357635
8" TO 10"	3/8	T3SGUA	66260303335	T3UA	66260357678
	7/16	T3SGUB	66260303336	T3UB	66260357679
12" TO 14"	3/8	T4SGUA	66260303338	T4UA	66260368027
	7/16	T4SGUB	66260303337	T4UB	66260357714

These tools are a standard recommendation. Refer to the Amplex Diamond and CBN Product Catalog or call your Carborundum distributor for additional tools.



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

TechTip

Wheel Dressing with Single Point Diamond Tools

- Rigidly mount single point tools at a 10°-15° angle to the wheel centerline with a line drawn through the center of the wheel, pointing in the direction of wheel travel.
- Point of contact should be slightly below centerline of wheel.
- Use coolant whenever possible.
- Normal infeed is .001" per pass.
- Lead selections range from .002" - .010" per wheel revolution.
- Rotate the tool 1/4 turn periodically to maintain a sharp point.

Wheel Dressing with Multi-Point Diamond Tools

- Most multi-point tools are used for straight face dressing.
- Tool should have full face contact with the wheel.
- With new tool, 3-5 passes at .005" per pass should be taken to expose diamonds.
- Infeed per pass .001" - .002"
- Use coolant whenever possible.
- Use appropriate lead (and traverse rate).

Dressing Medalist (ceramic) Wheels

- Use our specially designed Amplex SG diamond tools when dressing Carborundum Medalist ceramic wheels.
- When first using an Amplex SG tool, make 3 to 5 passes at .005" infeed to ensure full face contact between the dressing tool and wheel face.
- Reduce normal dressing infeed by half. Do not exceed infeed of .002" per pass.
- The lead selection should be between .006" - .030" per wheel revolution. Faster traverse with an Amplex SG tool generally provides an open wheel face that can maximize productivity of the Carborundum Medalist ceramic abrasive.

To optimize applications using ceramic abrasives and/or tools, normal dressing parameters must change. Reduce infeed by 25%. Significant reductions in the amount of infeed and frequency of dress will result in substantially lower cost per part ground.

Toolroom Wheel Starting Recommendations

APPLICATION/MATERIAL	PERFORMANCE/PRODUCTIVITY			PERFORMANCE/PRODUCTIVITY			PERFORMANCE/PRODUCTIVITY		
	BEST	BETTER	GOOD	BEST	BETTER	GOOD	BEST	BETTER	GOOD
	NARROW CONTACT AREA			MEDIUM CONTACT AREA			WIDE CONTACT AREA		
TOOL RESHARPENING									
HEAVY STOCK REMOVAL (> .004)									
- HSS & TOOL STEEL RC 50-68	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	32AR46-GV40P	AA46-HV40
MODERATE STOCK REMOVAL (.002-.004)									
- HSS & TOOL STEEL RC 50-68	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32A60-HV40P	AA60-HV40
- CARBIDE			GC60-IVGC			GC60-IVGC			GC60-IVGC
SURFACE GRINDING									
HEAVY STOCK REMOVAL (> .004)									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-IVL	32AR46-IV40	AA46-IV40	MEDALIST46-GVLP	32AR46-GV40P	PA46-GVPP
- SOFT STEELS RC 30-45 300 SERIES STAINLESS	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	AR46-HVPP	PA46-HVPP
- CAST IRON: DUCTILE & GRAY	MEDALIST46-KVL	32AR46-KV40	AA46-KV40	MEDALIST46-JVL	32AR46-JV40	AA46-JV40	MEDALIST46-GVLP	32AR46-HV40P	AA466-HV40
- NON-FERROUS ALLOYS			GC60-IVGC			GC60-IVGC			GC60-IVGC
MODERATE STOCK REMOVAL (.002-.004)									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-IVL	32AR60-IV40	AA60-IV40	MEDALIST60-GVLP	32AR60-GV40P	AA60-HV40
- SOFT STEELS RC 30-45 300 SERIES STAINLESS	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32AR60-HV40P	AA60-HV40
- CAST IRON: DUCTILE & GRAY	MEDALIST60-KVL	32AR60-KV40	AA60-KV40	MEDALIST60-JVL	32AR60-JV40	AA60-JV40	MEDALIST60-GVLP	32AR60-HV40P	AA60-IV40
- NON-FERROUS ALLOYS			GC60-IVGC			GC60-IVGC			GC60-IVGC
LIGHT STOCK REMOVAL AND FINISHING (<.001)									
- HSS & TOOL STEEL RC 50-68 400 SERIES STAINLESS		32AR80-JV40	AA80-JV40		32AR80-IV40	AA80-IV40		32AR80-HV40	AA80-HV40
- SOFT STEELS RC 30-45 300 SERIES STAINLESS		32AR80-KV40	AA80-KV40		32AR80-JV40	AA80-JV40		32AR80-IV40	AA80-IV40
- CAST IRON: DUCTILE & GRAY		32AR80-KV40	AA80-KV40		32AR80-JV40	AA80-JV40		32AR80-IV40	AA80-IV40
- NON-FERROUS ALLOYS			GC80-IVGC			GC80-IVGC			GC80-IVGC

Toolroom Competitive Cross Reference

CARBORUNDUM	BAY STATE	CAMEL	CINCINNATI	COLONIAL	RADIAC
32AR	7A, 17A	AZ	4A, 12A, 29A, 32A		32A, WRA
AA	9A, 48A	83A, WA, AZ (BLUE)	9A, 10A, 11A, 82A	20A	WA, 9A
AR				25A	RA
C	C		6C	C	C
DA	2A, 3A, 6A, 8A	91A, DA	29A, 97A	10TA	43A, 45A, 97A, WPA
GA	TA	94A, CGW, A	A, AK	TA	A
GC	1C		5C	GC	GC
MEDALIST, MEDALIST R	3GA	AS3	3MSB	20A/VG3	7BP, 8BP
PA		PA	12A	24A	RAA



BONDED ABRASIVES

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Toolroom Wheels

Medalist Ceramic Alumina / Aluminum Oxide Abrasive Blend

Features

- High-performance ceramic alumina / aluminum oxide abrasive blend – blue
- Self-sharpening abrasive
- High-performance vitrified bond
- VLP bond: induced porosity
- Best performance

Benefits

- Fast stock removal on moderate to very heavy stock removal applications
- Cool cutting
- Less burn on part
- Dressing frequency reduced
- Enhanced wheel life
- Superior form and corner holding
- Load resistant
- Highest productivity, lowest total grinding cost

The best choice for grinding all high speed tool steels. Medalist has the versatility to grind easy-to-difficult-to-grind steels.

Use VL bond for general purpose applications or medium contact areas.

Use VLP and VPP bonds on wide contact areas where heat is an issue.



TechTip

Key Operating Tips for Maximizing Grinding Performance with Medalist Wheels

Change one parameter at a time:

- 1** Increase infeed 50%
- 2** Increase traverse rate 25%
- 3** Reduce dressing infeed 25%

Gold 32AR Aluminum Oxide Abrasive

Features

- High-performance aluminum oxide abrasive - gray/purple
- Strong, sharp monocrystalline grain blend
- Tough, yet friable grain
- Strong vitrified bond
- V40P bond: induced porosity

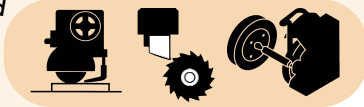
Benefits

- Exceptionally cool, fast cutting on medium to heavy stock removal operations
- Excellent resistance to point wear
- Good penetration on tough alloy steels
- Holds form well
- Requires less dressing
- Long wheel life
- Load resistance

Ideal for moderate to heavy infeed rates, rapid stock removal and precision contouring – for all types of tool steels.

Use V40 bond for general purpose applications or medium contact areas.

Use V40P bond on wide contact areas where heat is an issue.



AR Aluminum Oxide Abrasive

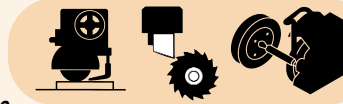
Features

- Durable aluminum oxide abrasive – ruby
- Durable vitrified bond

Benefits

- Extremely cool cutting
- Good form holding
- Maximum grain retention
- Less dressing; longer wheel life

Engineered for medium to heavy stock removal at moderate to heavy feed rates on a wide variety of tool steels.



Use V40 bond for general purpose applications or medium contact areas.

Use VPP bond on wide contact areas where heat is an issue.



AA Aluminum Oxide Abrasive

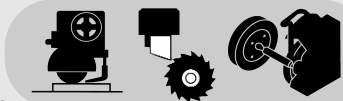
Features

- Aluminum oxide abrasive – white
- Excellent friability
- Durable, vitrified bond
- V40P bond: induced porosity

Benefits

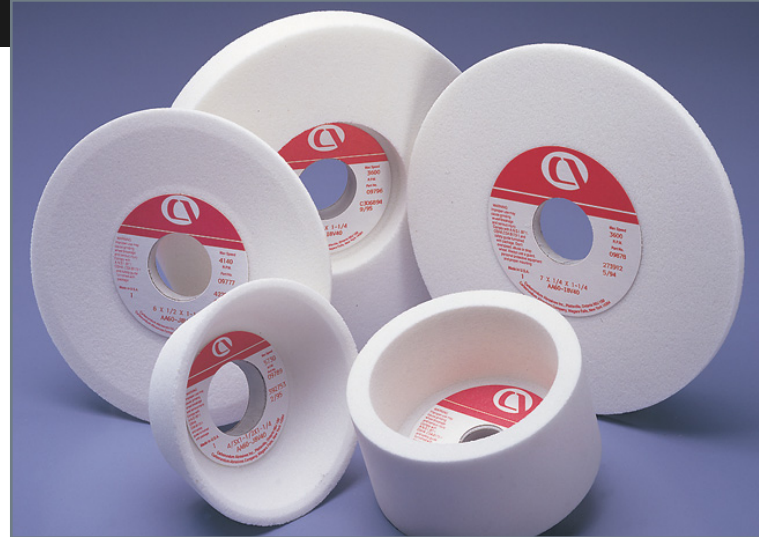
- Fast stock removal for light to medium stock removal operations
- Cool cutting action
- Long wheel life
- Load resistant

AA is ideal for grinding heat sensitive steels, as well as easy- and medium-to-grind high-speed steels and cast, alloy steels.



Use V40 bond for general purpose applications or medium contact areas.

Use V40P and VPP bonds on wide contact areas where heat is an issue.



PA Aluminum Oxide Abrasive

Features

- Friable, aluminum oxide abrasive – pink
- Durable vitrified bond

Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal applications at light to moderate feed rates on tool steels (hardened, forged and stainless) and cast iron.



Use V40 bond for general purpose applications or medium contact areas.

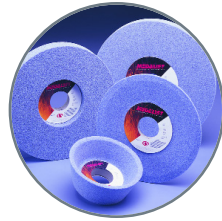
Use VPP bond on wide contact areas where heat is an issue.



See Carbo Cool wheel listings for additional porous specifications on pages 85-87.

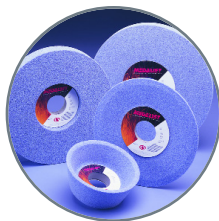
BONDED ABRASIVES

Toolroom Wheels



WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 01 – For Internal Grinding								
1/2 x 1/2 x 1/4	64,935	40					66253062129*	PA60-KV40
3/4 x 1 x 1/4	43,240	40					66253062131*	PA60-KV40
1 x 1/4 x 1/4	32,470	40					66253062132*	PA60-IV40
1 x 3/4 x 1/4	32,470	40					66253062133*	PA60-IV40
1 x 1 x 3/8	32,470	40					66253062138*	PA60-KV40
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders								
6 x 1/4 x 1-1/4	4,140	10	05539562350	80-KVL	05539527691*	32AR60-KV40		
6 x 1/2 x 1-1/4	4,140	10			66253051313*	32AR46-JV40	05539509882*	AA60-JV40
	4,140	10			05539527692	32AR60-JV40		
	4,140	10			05539562244*	32AR60-KV40		
6 x 3/4 x 1-1/4	4,140	10			66253051315*	32AR80-KV40		
	4,140	10			66253051675*	32AR46-JV40		
	4,140	10			66253051677*	32AR60-JV40		
6 x 1 x 1-1/4	4,140	10			66253051683*	32AR46-JV40		
	4,140	10			66253051684*	32AR60-JV40		
7 x 1/8 x 1-1/4	3,600	10					05539562175*	AA100-KV40
7 x 1/4 x 1-1/4	3,600	10	05539562351 B	46-JVL	05539527686	32AR46-HV40	66253051696	AA46-IV40
	3,600	10	05539527241	60-IVL	66253051861*	32AR46-IV40	05539509875*	AA60-JV40
	3,600	10	05539527242 B	60-JVL	05539527688	32AR46-JV40	05539509874	AA60-KV40
	3,600	10	05539527243	60-KVL	66253051862*	32AR60-HV40	66253051698	AA80-JV40
	3,600	10	05539527244	80-JVL	05539527689	32AR60-IV40	05539509871*	AA80-KV40
	3,600	10	05539527245	80-KVL	05539527311 B	32AR60-JV40	05539509870*	AA100-IV40
	3,600	10	05539527247	100-KVL	05539527312	32AR60-KV40	05539509869*	AA100-JV40
	3,600	10			05539527313*	32AR80-IV40	05539527714	AA100-KV40
	3,600	10			05539527314	32AR80-JV40	05539562176*	AA120-JV40
	3,600	10			05539527315 B	32AR80-KV40	05539509866	AA150-KV40
	3,600	10			66253051867*	32AR100-IV40	05539562177*	AA150-LV40
	3,600	10			05539562246 B	32AR100-JV40	66253051859*	AA220-KV40
	3,600	10			05539562249	32AR120-KV40	05539569194*	PA46-JV40 New!
	3,600	10					05539569199*	PA60-JV40 New!
	3,600	10					05539569200*	PA120-HV40 New!
	3,600	10					05539569207*	PA120-JV40 New!
	7 x 3/8 x 1-1/4	3,600	10			66253051936*	32AR60-HV40	
3,600		10			66253051937*	32AR60-JV40		
7 x 1/2 x 1-1/4	3,600	5	05539527248*	46-GVLP	05539527316*	32AR46-FV40P	05539509865	AA46-HV40
	3,600	5	66253051963*	46-HVL	05539527317	32AR46-GV40P	05539507039*	AA46-HV40P
	3,600	5	05539527250	46-IVL	05539527319	32AR46-HV40	05539509864	AA46-IV40
	3,600	5	05539527249 B	46-IVLP	05539527318 B	32AR46-HV40P	05539509863	AA46-JV40
	3,600	5	05539527251	46-JVL	05539527321	32AR46-IV40	05539509862*	AA46-KV40
	3,600	5	05539527252	46-KVL	05539527320*	32AR46-IV40P	66253051967	AA60-HV40
	3,600	5	05539527253*	60-GVLP	05539527322	32AR46-JV40	05539509860	AA60-IV40
	3,600	5	66253051965*	60-HVL	05539527323	32AR46-KV40	05539509859	AA60-JV40
	3,600	5	05539527255 B	60-IVL	05539527326	32AR60-HV40	05539509858	AA60-KV40
	3,600	5	05539527254*	60-IVLP	05539527325*	32AR60-HV40P	66253051969	AA80-HV40
	3,600	5	05539527256	60-JVL	05539527327	32AR60-IV40	05539509857*	AA80-IV40
	3,600	5	05539527257 B	60-KVL	05539527328	32AR60-JV40	05539509856*	AA80-JV40
	3,600	5	05539527259*	80-IVL	05539527329	32AR60-KV40	05539509854	AA80-KV40
	3,600	5	05539527260	80-JVL	05539527330*	32AR80-IV40	05539509852	AA100-IV40
	3,600	5	05539527261 B	80-KVL	05539562257*	32AR80-JV40	05539509850*	AA100-JV40
	3,600	5			05539527331	32AR80-KV40	05539562180	AA120-KV40
	3,600	5			05539562253*	32AR100-IV40	66253054721*	AA150-KV40
	3,600	5			66253061619*	AR46-HV40	66253061613*	PA46-HV40
	3,600	5			66253061620*	AR46-IV40	66253061614*	PA46-IV40
	3,600	5			66253061621*	AR60-IV40	05539566899*	PA46-JV40 New!
	3,600	5			66253061622*	AR60-JV40	05539569213*	PA46-KV40 New!
3,600	5					66253061615*	PA60-IV40	
3,600	5					05539569217*	PA60-JV40 New!	
3,600	5					05539569218*	PA60-KV40 New!	
3,600	5					05539569222*	PA80-KV40 New!	

BONDED ABRASIVES



WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders								
7 x 3/4 x 1-1/4	3,600	5	05539527262 B	46-KVL	66253054729*	32AR46-HV40	05539562185*	AA46-KV40 New!
	3,600	5	05539527263*	60-KVL	05539527334*	32AR46-IV40	05539509848	AA60-IV40
	3,600	5			05539527335*	32AR46-KV40	05539569233*	PA46-JV40 New!
	3,600	5			05539527336*	32AR60-IV40	05539569234*	PA60-JV40 New!
	3,600	5			05539527337 B	32AR60-KV40		
	3,600	5						
	3,600	5						
7 x 1 x 1-1/4	3,600	5	05539527264	46-JVL	05539509861*	32AR60-IV40 New!		
	3,600	5	05539562356*	60-KVL	05539562261*	32AR60-KV40		
8 x 1/4 x 1-1/4	•	5			05539562263*	32AR46-HV40	05539562188*	AA60-IV40
	3,600	5			66253054775*	32AR46-KV40	05539509844 B	AA80-JV40
	3,600	5			66253054776*	32AR60-HV40	66253054773*	AA100-KV40
	3,600	5			66253054778*	32AR60-IV40	66253054774*	AA120-KV40
	3,600	5			05539562264	32AR60-JV40		
	3,600	5			05539527338	32AR60-KV40		
	3,600	5			66253054780*	32AR80-IV40		
	3,600	5			05539527339	32AR80-KV40		
8 x 1/2 x 1-1/4	3,105	5	05539527267*	46-GVLP	05539527340 B	32AR46-GV40	05539509841	AA46-HV40
	3,105	5	05539527268	46-IVL	05539527342	32AR46-HV40	05539509840*	AA46-IV40
	3,600	5	05539527269	46-JVL	05539527341†	32AR46-HV40P	05539509839	AA46-JV40
	•	5	05539527270	46-KVL	05539527343 B	32AR46-IV40	05539509838*	AA46-KV40
	3,600	5	05539527271	60-IVL	05539527344	32AR46-JV40	05539509836	AA60-IV40
	3,600	5	05539527272	60-JVL	05539527345	32AR46-KV40	05539562190	AA60-JV40
	3,600	5	05539527273	60-KVL	05539527347	32AR60-HV40	66253052850	AA60-KV40
	3,600	5	05539562363*	80-JVL	05539527348	32AR60-IV40	05539527716*	AA80-JV40
	3,600	5			05539527349 B	32AR60-JV40	05539509831*	AA80-KV40
	3,600	5			05539562271*	32AR80-IV40	66253052540*	AA100-JV40
	3,105	5			66253061627*	AR46-HV40	66253061623*	PA46-HV40
	3,105	5			66253061628*	AR46-IV40	66253061624*	PA46-IV40
	3,600	5			66253061629*	AR60-IV40	05539569237*	PA46-JV40 New!
	3,600	5			66253061630*	AR60-JV40	66253061625*	PA60-IV40
	3,600	5					66253061626*	PA60-JV40
8 x 3/4 x 1-1/4	•	5	05539527274	46-IVL	66253052537*	32AR46-HV40	05539509827	AA46-JV40
	3,600	5	05539527275	46-JVL	05539527351*†	32AR46-HV40P	66253052539*	AA80-JV40
	•	5	05539527276	46-KVL	05539527353	32AR46-IV40		
	3,600	5	05539527277	60-JVL	05539527354	32AR46-JV40		
	3,600	5			05539527355	32AR60-IV40		
	3,600	5			05539527356	32AR60-JV40		
8 x 1 x 1-1/4	3,105	5	05539562365*	46-IVL	05539527358*	32AR46-IV40	05539562193*	AA46-IV40
	3,600	5	05539562379*	60-KVL	05539562272	32AR60-IV40		
	3,600	5			05539562318*	32AR60-KV40		

* Non-stock. See your Carborundum Representative for current lead times.

Minimum quantity for all toolroom wheels equals box quantity.

† See 8" Max. RPM Tech Tip below.

B = Best seller

TechTip

- 8" Type 01 and Type 05 Vitrified Toolroom Wheels' Maximum Operating Speeds:
- 46 grit, J grade and harder = 3,600 RPMs
- 54 grit, I grade and harder = 3,600 RPMs
- 60 grit and finer, H grade and harder = 3,600 RPMs
- † exceptions to the rule: speed-tested to 3,600 RPMs
- all other specifications = 3,105 RPMs



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

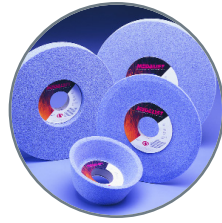


Refer to pages 74, 101 and 104 for truing and dressing products.

See Carbo Cool Wheel listings on pages 85-87 for additional porous specifications.

BONDED ABRASIVES

Toolroom Wheels



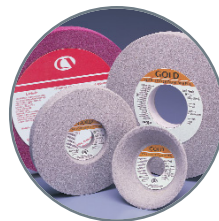
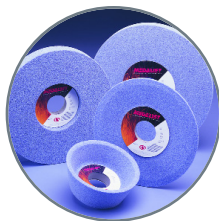
WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders								
10 x 1/2 x 3	2,485	5					66253052916*	AA46-HV40
	2,485	5					05539569344*	AA60-JV40
10 x 3/4 x 3	2,485	2			66253052918*	32AR46-HV40		
	2,485	2			05539562201	32AR46-IV40		
	2,485	2			New! 05539562202*	32AR60-IV40		
	2,485	2			05539527696	32AR60-JV40		
10 x 1 x 2	2,485	2					66253053091*	AA46-HV40
	2,485	2					66253053090*	AA46-IV40
10 x 1 x 3	2,485	2	05539527278	46-GVLP	05539527697*	32AR46 GV40P	05539569070*	AA46-HV40 New!
	2,485	2	05539527279	46-IVL	66253054449*	32AR46-HV40	66253054439*	AA46-IV40
	2,485	2	05539527280	46-JVL	New! 05539569253*	32AR46-HV40P	05539509814	AA46-JV40
	2,485	2	05539527282	60-JVL	05539527359	32AR46-IV40	66253054445*	AA60-HV40
	2,485	2			New! 05539567967*	32AR46-JV40	66253054446*	AA60-IV40
	2,485	2			05539527360	32AR60-IV40	66253054447*	AA60-JV40
	2,485	2			05539562204	32AR60-KV40	66253054448*	AA80-JV40
	2,485	2					05539569240*	PA46-IV40 New!
	2,485	2					05539569242*	PA60-IV40 New!
	12 x 3/4 x 1-1/4	2,070	1	05539562382	46-OVL			
12 x 3/4 x 3	2,070	2			05539562210*	32AR46-HV40P	66253054540*	AA46-HV40
	2,070	2			New! 05539562211*	32AR46-IV40	66253054541*	AA46-IV40
	2,070	2			66253054542*	32AR46-JV40	05539569054*	AA60-IV40 New!
	2,070	2			66253054544*	32AR60-JV40		
12 x 3/4 x 5	2,070	2				66253054552*	AA60-JV40	
12 x 1 x 3	2,070	2	05539562325*	46-HVLP	05539527361	32AR46-HV40	66253054555*	AA46-HV40
	2,070	2	05539527283	46-IVL	05539562216 B	32AR46-IV40	66253054556*	AA46-IV40
	2,070	2	05539527284	46-JVL	05539527362	32AR46-JV40	05539509810*	AA46-JV40
	2,070	2	05539562328*	60-GVLP	05539527363*	32AR60-IV40	66253054557*	AA46-KV40
	2,070	2	05539527285*	60-IVL	05539527364	32AR60-JV40	05539569246*	PA46-KV40 New!
	2,070	2			66253054558*	32AR60-KV40		
	2,070	2						
12 x 1 x 5	2,070	2	05539562332*	46-IVL	05539527365	32AR46-IV40	05539524572*	AA46-HV40
	2,070	2	05539527287	46-JVL	66253053098*	32AR60-IV40	05539501900	AA46-IV40
	2,070	2	05539527290	60-JVL	66253053100*	32AR60-JV40	66253053092*	AA46-JV40
	2,070	2			66253053101*	32AR60-KV40	66253053094*	AA46-KV40
	2,070	2					05539562163*	AA60-IV40
	2,070	2					05539509807	AA60-JV40
	2,070	2					66253053096*	AA60-KV40
2,070	2					60253053097*	AA80-JV40	
12 x 1-1/4 x 3	2,070	2			05539562221	32AR46-IV40		
12 x 1-1/2 x 3	2,070	2			05539562222*	32AR60-JV40		
12 x 1-1/2 x 5	2,070	2	05539562337 B	60-GVLP	05539562223*	32AR46-GV40P		
	2,070	2			05539527368 B	32AR46-HV40		
	2,070	2			05539527369	32AR46-IV40		
	2,070	2			05539562224	32AR46-JV40		
	2,070	2			05539562226	32AR60-HV40		
12 x 2 x 1-1/4	2,070	2			05539562227*	32AR46-KV40		
12 x 2 x 5	2,070	2			05539562316	32AR46-IV40	05539562166*	AA46-HV40
	2,070	2			New! 05539569544*	32AR46-JV40		
14 x 1 x 3	1,800	2	05539562339*	46-IVL	66253054713*	32AR46-HV40		
	1,800	2			66253054716*	32AR60-IV40		
14 x 1 x 5	1,800	2	05539527291*	46-GVLP	05539562230	32AR46-HV40	66253054785*	AA46-IV40
	1,800	2	05539562341*	46-HVLP	05539527370	32AR46-JV40	05539509806	AA46-JV40
	1,800	2	05539562342*	46-IVL	05539527371	32AR60-JV40	66253054786*	AA46-KV40
	1,800	2	05539527292	46-JVL	66253061056*	32AR60-KV40	66253054787*	AA60-IV40
	1,800	2	05539527293	60-JVL			05539562170*	AA80-KV40
	1,800	2	05539562345*	80-JVL			05539569202*	PA46-IV40 New!
	1,800	2					05539569204*	PA60-JV40 New!

See Carbo Cool Wheel listings on pages 85-87 for additional porous specifications.

Refer to pages 74, 101 and 104 for truing and dressing products.

BONDED ABRASIVES

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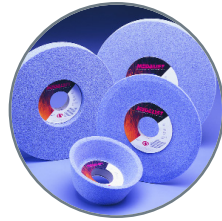


WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders								
14 x 1-1/2 x 5	1,800	1	05539527294	46-GVLP	05539562234*	32AR46-GV40P	05539524608*	AA46-HV40 New!
	1,800	1	05539527295 B	46-IVL	05539527372 B	32AR46-HV40	05539562172	AA46-IV40
	1,800	1	05539527296	46-JVL	05539527673	32AR46-IV40	05539509804 B	AA46-JV40
	1,800	1	05539562346 B	60-IVL	05539527700	32AR46-JV40	66253054791*	AA46-KV40
	1,800	1	05539527298	60-JVL	05539562236*	32AR46-KV40	66253054792*	AA60-HV40
	1,800	1	05539562347*	80-KVL	05539562237	32AR60-HV40	05539509803	AA60-JV40
	1,800	1			05539527674*	32AR60-IV40		
	1,800	1			05539527701*	32AR60-JV40		
14 x 2 x 5	1,800	1	05539562348	46-JVL	05539562240	32AR46-IV40	66253054797*	AA46-HV40
	1,800	1	05539562349	60-JVL	05539562241*	32AR46-KV40	66253054798*	AA46-JV40
	1,800	1			05539562242	32AR60-KV40	66253054799*	AA60-JV40
16 x 1-1/2 x 5	1,550	1					66253059029*	AA46-HV40
	1,550	1					66253059030*	AA46-JV40
	1,550	1					66253059031*	AA60-KV40
16 x 2 x 5	1,550	1					66253059032*	AA46-IV40
	1,550	1					66253059033*	AA46-JV40
	1,550	1					66253059038*	AA60-KV40
Type 02 – For Surface and Tool & Cutter Grinders								
6 x 1 x 4	3,600	5			66253052535*	32AR46-KV40		
Rim 1, Fits Both: Four 9/32 Holes on 3-1/4" Bolt Circle & Four 7/16 Holes on 3-1/4" Bolt Circle								
9 x 2 x 5 Rim 2-1/32,	2,546	2			05539562315	32AR70-JV40P	05539503517	AA70-JV40P
Six 9/32 Holes on 4" Bolt Circle								
Type 05 – For Internal Grinding								
1/2 x 1/2 x 1/8	14,935	40					66253062125*	PA60-KV40
Recess 1/8 1/4 x 5/32								
1 x 1 x 3/8	32,470	40					66253062136*	PA60-KV40
Recess 1/8 1/2 x 1/2								
1-1/2 x 1 x 3/8	21,645	40					66253062140*	PA60-KV40
Recess 1/8 5/8 x 1/2								
2 x 1 x 3/8	15,980	40					66253062141*	PA60-KV40
Recess 1/8 3/4 x 1/2								
Type 05 – For Surface Grinders								
7 x 3/4 x 1-1/4	3,600	5			05539527702*	32AR46-IV40		
Recess 1/8 2-3/4 x 1/4	3,600	5			05539568013*	32AR60-IV40 New!		
	3,600	5			05539562312*	32AR60-KV40		
	3,600	5					66253054745*	AA46-HV40
7 x 3/4 x 1-1/4	3,600	5					66253054746	AA46-IV40
Recess 1/8 3 x 1/4	3,600	5					66253054748	AA46-JV40
	3,600	5					66253054755*	AA60-HV40
	3,600	5					66253054756	AA60-JV40
	3,600	5						
7 x 1 x 1-1/4	3,600	5	05539527300	46-JVL	05539527703	32AR46-HV40		
Recess 1/8 2-3/4 x 1/2	3,600	5	05539527301	60-JVL	05539527675	32AR46-IV40		
	3,600	5			05539527704	32AR60-IV40		
	3,600	5					66253054764*	AA46-HV40
7 x 1 x 1-1/4	3,600	5	05539562369*	46-IVL	05539562284*	32AR46-HV40P	05539509798	AA46-IV40
Recess 1/8 3 x 1/2	3,600	5	05539562370	60-KVL	05539562285*	32AR46-KV40	05539509798	AA46-IV40
	3,600	5					66253054767	AA46-JV40
	3,600	5					66253054768	AA46-KV40
	3,600	5					05539509796*	AA60-IV40
	3,600	5					66253054769	AA60-JV40
	3,600	5					05539505805*	AA60-KV40 New!
	3,600	5						

* Non-stock. See your Carborundum Representative for current lead times.
Minimum quantity for all toolroom wheels equals box quantity.
B = Best seller

BONDED ABRASIVES

Toolroom Wheels

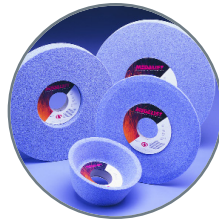


WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 05 – For Surface Grinders								
7 x 1-1/4 x 1-1/4	3,600	5			05539562286*	32AR60-IV40		
Recess 1/S 2-3/4 x 5/8								
7 x 1-1/2 x 1-1/4	3,600	5			05539562287*	32AR46-IV40		
Recess 1/S 2-3/4 x 3/4								
8 x 3/4 x 1-1/4	3,105	5					05539564321*	AA46-HV40 New!
Recess 1/S 3 x 1/4	3,105	5					66253052857*	AA46-HV40P
	3,105	5					05539569071*	AA46-IV40 New!
	3,600	5					66253052856*	AA46-JV40
	3,600	5					66253052859*	AA60-IV40
	3,600	5					66253052858*	AA60-JV40
	3,600	5					66253052860*	AA60-KV40
8 x 1 x 1-1/4	3,105	5					66253052861*	AA46-HV40P
Recess 1/S 3 x 1/2	3,600	5					66253052862*	AA60-HV40
	3,600	5					66253054864*	AA60-IV40
	3,600	5					66253052866*	AA60-JV40
	3,600	5					66253052868*	AA60-KV40
8 x 1 x 1-1/4	3,105	5			05539527677	32AR46-IV40		
Recess 1/S 3-1/4 x 1/2	3,600	5			05539527678	32AR46-JV40		
	3,600	5			05539527676*	32AR60-IV40		
12 x 1-1/2 x 3	2,070	2					66253053107*	AA46-HV40
Recess 1/S 7-1/2 x 1/2	2,070	2					66253053108*	AA46-IV40
	2,070	2					66253054575*	AA46-JV40
	2,070	2						
12 x 1-1/2 x 5	2,070	2	05539562366	46-GVLP	New! 05539569121*	32AR46-HV40	66253054583*	AA46-KV40
Recess 1/S 7-1/2 x 1/2	2,070	2			05539562277	32AR46-IV40	66253054578*	AA60-IV40
	2,070	2					66253054584*	AA60-JV40
14 x 1-1/2 x 5	1,800	1	05539562367	46-JVL	05539562279	32AR46-IV40	05539562195*	AA46-HV40
Recess 1/S 8 x 1/2	1,800	1	05539562368*	60-JVL	New! 05539562280*	32AR46-KV40	05539567482*	AA46-IV40 New!
	1,800	1			05539562281	32AR60-IV40	66253054794*	AA46-JV40
	1,800	1			66253061063*	32AR60-JV40	66253054796*	AA60-HV40
	1,800	1			New! 05539562282*	32AR60-KV40	05539569087*	AA60-IV40 New!
	1,800	1			New! 05539568664*	32AR46-KV40	66253054800*	AA46-HV40
14 x 2 x 5	1,800	1			05539562283	32AR60-KV40	66253054801*	AA46-IV40
Recess 1/S 8 x 1	1,800	1					66253054802*	AA46-JV40
	1,800	1					66253054803*	AA46-KV40
	1,800	1					66253054804*	AA60-IV40
	1,800	1					66253054805*	AA60-JV40
Type 06 – For Tool & Cutter Grinders								
4 x 2 x .787 (20mm)	5,730	5					05539509793	AA80-JV40
Rim 3/8, Back 3/8								
5 x 1-1/2 x 1-1/4	4,585	5			05539562288	32AR46-KV40		
Rim 3/8, Back 3/8	4,585	5			05539527705	32AR60-KV40		
6 x 1-1/2 x 1-1/4	3,820	5			66253052239*	32AR46-JV40		
Rim 3/8, Back 3/8	3,820	5			66253052240*	32AR60-JV40		
6 x 1-1/2 x 1-1/4	3,820	5					05539509792*	AA60-JV40
Rim 1-1/2, Back 1/2								
Type 07 – For Surface Grinders								
12 x 2 x 3	2,070	1					66253054700*	AA46-IV40
Recess 2/S 6-1/2 x 1/2	2,070	1					66253054703*	AA60-JV40
12 x 2 x 3	2,070	1			05539562291*	32AR46-JV40		
Recess 2/S 7-1/4 x 1/2								
12 x 2 x 5	2,070	1			05539562292	32AR46-HV40	66253054706*	AA46-IV40
Recess 2/S 7-1/2 x 1/2	2,070	1			05539562294	32AR46-KV40	66253054708*	AA46-JV40
	2,070	1					66253054709*	AA60-HV40
	2,070	1					66253054711*	AA60-JV40
	2,070	1					66253054712*	AA60-KV40

* Non-stock. See your Carborundum Representative for current lead times.
Minimum quantity for all toolroom wheels equals box quantity.

BONDED ABRASIVES

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WHEEL SIZE	MAX. RPM	WHEELS/ BOX	BEST – MEDALIST		BETTER – 32AR & AR		GOOD – AA & PA	
			PART NO.	GRADING	PART NO.	GRADING	PART NO.	GRADING
Type 07 – For Surface Grinders								
14 x 2 x 5	1,800	1					66253054806*	AA46-IV40
Recess 2/S 8 x 3/8	1,800	1					66253054808*	AA46-JV40
	1,800	1					66253054809*	AA46-KV40
Type 11 – For Tool & Cutter Grinders								
3-1/2 /2-3/4 x	7,640	5			66253051978*	32AR46-JV40		
1-1/2 x 1-1/4	7,640	5			66253051992*	32AR46-KV40		
Rim 3/4, Back 3/8	7,640	5			66253051993*	32AR60-JV40		
	7,640	5			66253041994*	32AR60-KV40		
4 / 3 x 1-1/2 x 1-1/4	5,730	5	05539562371*	46-IVLP	05539527679	32AR46-KV40	05539509790*	AA46-KV40
Rim 1/4, Back 1/2	5,730	5	05539527302	46-JVL	05539527680	32AR60-JV40	05539509788*	AA60-KV40
	5,730	5	05539569173*	60-HVLP New!	05539527681	32AR60-KV40		
	5,730	5	05539527303	60-JVL	66253051997*	32AR80-JV40		
	5,730	5	05539562373*	80-KVL	05539569167*	32AR120-KV40 New!		
5 / 3-3/4 x 1-3/4 x 1-1/4	4,585	5	05539527305	46-JVL	05539527682	32AR46-JV40	05539567353*	AA46-HV40 New!
Rim 1/4, Back 1/2	4,585	5	05539569177*	60-IVL New!	05539527684	32AR46-KV40	05539569412*	AA46-JV40 New!
	4,585	5	05539527306	60-KVL	05539527685	32AR60-JV40	05539569097*	AA46-KV40 New!
	4,585	5			05539527683	32AR60-KV40	05539509783	AA60-JV40
	4,585	5					05539509782	AA60-KV40
6 / 4-1/2 x 2 x 1-1/4	3,820	5			05539562301	32AR46-IV40	05539509781	AA46-KV40
Rim 3/8, Back 1/2	3,820	5			66253052001*	32AR46-JV40		
Type 12 – For Tool & Cutter Grinders								
4 x 1/2 x 3/4	6,210	5			66253051996*	32AR80-JV40		
U = 3/8, E = 5/16								
6 x 1/2 x 1-1/4	4,140	5	05539527308	46-JVL	05539527707	32AR60-JV40	05539509777	AA60-JV40
U = 3/8, E = 5/16	4,140	5	05539527309*	60-LVL	05539562306*	32AR60-KV40		
J = 3, K = 3								
6 x 3/4 x 1-1/4	4,140	5	05539527310*	60-KVL	66253051999*	32AR46-JV40	66253051998*	AA60-KV40
U = 3/8, E = 3/8, J = 3, K = 3		5			66253052000*	32AR60-JV40		
7 x 1/2 x 1-1/4	3,600	5			05539562275*	32AR60-KV40		
U = 7/16, E = 11/32, J = 2-3/4, K = 3-1/4								
7 x 3/4 x 1-1/4	3,600	5			05539562313 *	32AR60-KV40		
U = 1/2, E = 1/2, J = 2-3/4, K = 3-1/4								
8 x 1-9/16 x 1-1/4	3,105	4	05539562380	46-JVL				
U = 7/16, E = 25/32, J = 3, K = 3								
10 x 1 x 1-1/4	2,485	2			05539562303	32AR54-JV40		
U = 2, E = 11/16, J = 6-1/4, K = 3-5/8								
Refer to diagram on page 73 for dimension key.								
Type 37 – For Surface Grinders								
10 x 3-1/2 x 8	2,105	1	05539562383	54-IVL				
Rim 1, Eight 1/4-20 Bolts on 9" Bolt Circle								

* Non-stock. See your Carborundum Representative for current lead times.
Minimum quantity for all toolroom wheels equals box quantity.

See Carbo Cool Wheel listings on pages 85-87 for additional porous specifications.
Refer to pages 74, 101 and 104 for truing and dressing products.

Skate Sharpening Wheels - Gold 32AR Aluminum Oxide Abrasive

Features

- Premium aluminum oxide abrasive - gray/purple
- Strong vitrified bond
- Plastic bushing

Benefits

- Fast, cool cutting action
- No burn
- Consistent form holding
- Long life
- Provides a tighter fit – reducing vibrations and arbor-wear on the skate grinder

Sharpening all types of skate blades.



Refer to pages 74, 101 and 104 for truing and dressing products.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 - For Skate Sharpening Machines				
05539528044*	8 x 5/16 x 1-1/4	32AR80-KV40	3,600	5
Type 01 Cross Grind - For Skate Sharpening Machines				
05539509972	6 x 1 x 1	60 - Medium	4,140	5

Saw Gumming Wheels - Premier Red Zirconia Alumina Abrasive - Resin Bond

Features

- Durable 2ZA zirconia alumina abrasive

Benefits

- Designed specifically for large, timber-harvesting, circular and band saw steel blades

Saw gumming wheels are used primarily to shape and resharpen various timber and woodworking saws.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 - For Saw Gumming				
66253062023*	10 x 5/8 x 1-1/4	2ZA36-NB67	3,630	5
66253062026*	12 x 5/8 x 1-1/4	2ZA36-NB67	3,025	5
66253062029*	12 x 3/4 x 1-1/4	2ZA36-NB67	3,025	5
66253062030*	12 x 7/8 x 1-1/4	2ZA36-NB67	3,025	5
66253062031*	12 x 1 x 1-1/4	2ZA36-NB67	3,025	5

* Non-stock. See your Carborundum Representative for current lead times.

Saw Gumming Wheels - Gold 32AR Aluminum Oxide Abrasive - Vitrified Bond

Features

- High-performance aluminum oxide abrasive and strong vitrified bond

Benefits

- Long wheel life on medium to heavy stock removal operations on lower-speed machines

Saw gumming wheels are used primarily to shape and resharpen various timber and woodworking saws.

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 - For Saw Gumming				
66253061632*	8 x 3/16 x 1-1/4	32AR46-MV40	4,535	5
66253062014*	10 x 3/8 x 1-1/4	32AR46-MV40	3,630	5
66253062013*	10 x 1/2 x 1-1/4	32AR46-MV40	3,630	5

* Non-stock. See your Carborundum Representative for current lead times.

Refer to pages 74, 101 and 104 for truing and dressing products.

Carbo Cool Medalist R Ceramic Alumina Abrasive

Features

- Ceramic Medalist R abrasive with VPP porous bond – purple
- Controlled porosity bond
- Durable bond post
- Maximum depth of cut

Benefits

- Maximum productivity; lowest total grinding costs
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life
- Consistent grinding action at high metal removal rates

High porosity for heavy stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Heavy Stock Removal				
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders				
05539564481*	7 x 1/2 x 1-1/4	46-HVPP	3,600	5
05539564497*	8 x 1/2 x 1-1/4	46-GVPP	3,600	5
05539564503		46-HVPP	3,600	5
05539564505*	12 x 1 x 3	46-HVPP	2,710	2

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Heavy Stock Removal				
Type 05 – For Surface Grinders				
05539564493*	7 x 1 x 1-1/4	46-GVPP	3,600	5
05539564495*	Recess 1/8 2-3/4 x 1/2	60-GVPP	3,600	5
05539564504*	8 x 1 x 1-1/4	46-HVPP	3,600	5
05539564516*	Recess 1/8 3-1/4 x 1/2	60-HVPP	3,600	5
05539564500*	12 x 1-1/2 x 5	46-GVPP	2,710	2
05539564518*	Recess 1/8 7-1/2 x 1/2	60-HVPP	2,710	2
05539564508*	14 x 1-1/2 x 5	46-HVPP	2,320	1
	Recess 1/8 8 x 1/2			

Carbo Cool AR Aluminum Oxide Abrasive

Features

- Durable aluminum oxide abrasive with VPP porous bond – ruby
- Controlled porosity bond
- Durable bond post

Benefits

- Extremely cool cutting
- Good form holding
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Engineered for medium to heavy stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Medium/Heavy Stock Removal				
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders				
66253051674*	6 x 1/2 x 1-1/4	AR60-HVPP	5,410	5
66253051678*	6 x 3/4 x 1-1/4	AR46-HVPP	5,410	5
66253051679*		AR60-GVPP	5,410	5
66253051680*		AR60-HVPP	5,410	5
05539564480*	7 x 1/2 x 1-1/4	AR46-GVPP	3,600	5
05539564484		AR46-HVPP	3,600	5
66253054724*		AR46-IVPP	3,600	5
05539564486*		AR60-HVPP	3,600	5
66253054725*		AR60-IVPP	3,600	5
66253054728*		AR80-HVPP	3,600	5
66253054734*	7 x 3/4 x 1-1/4	AR46-GVPP	3,600	5
66253054741*		AR60-GVPP	3,600	5

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Medium/Heavy Stock Removal (cont'd)				
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders				
66253052852*	8 x 1/2 x 1-1/4	AR46-GVPP	3,600	5
05539564530		AR46-HVPP	3,600	5
66253052855*		AR60-GVPP	3,600	5
66253053087*	10 x 3/4 x 3	AR46-GVPP	3,250	5
66253054530*	10 x 1 x 3	AR46-GVPP	3,250	5
66253054561*	12 x 1 x 3	AR46-HVPP	2,710	2
66253053102*	12 x 1 x 5	AR46-GVPP	2,710	2
66253053106*		AR46-HVPP	2,710	2
66253061069*	14 x 1 x 5	AR46-GVPP	2,320	2
66253061070*		AR46-HVPP	2,320	2
66253061074*	14 x 1-1/2 x 5	AR46-GVPP	2,320	2

BONDED ABRASIVES

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Carbo Cool Toolroom Wheels

Carbo Cool AR Aluminum Oxide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
High Porosity – For Medium/Heavy Stock Removal (cont'd)				
Type 05 – For Surface Grinders				
66253054759*	7 x 3/4 x 1-1/4	AR46-GVPP	3,600	5
66253054760*	Recess 1/S 3 x 1/4	AR46-HVPP	3,600	5
66253054761*		AR60-GVPP	3,600	5
05539564529*	7 x 1 x 1-1/4	AR46-HVPP	3,600	5
05539564545*	Recess 1/S 2-3/4 x 1/2	AR60-HVPP	3,600	5
66253054771*	7 x 1 x 1-1/4	AR46-GVPP	3,600	5
66253054772*	Recess 1/S 3 x 1/2	AR60-GVPP	3,600	5
05539564531*	8 x 1 x 1-1/4	AR46-HVPP	3,600	5
05539564538*	Recess 1/S 3-1/4 x 1/2	AR60-GVPP	3,600	5
05539564547*		AR60-HVPP	3,600	5
05539564535*	14 x 1-1/2 x 5 Recess 1/S 8 x 1/2	AR46-HVPP	2,320	1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
High Porosity – For Medium/Heavy Stock Removal (cont'd)				
Type 07 – For Surface Grinders				
05539564534*	12 x 2 x 5 Recess 2/S 7-1/2 x 1/2	AR46-HVPP	2,710	1

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.

Refer to pages 74, 101 and 104 for truing and dressing products.

Carbo Cool PA Aluminum Oxide Abrasive

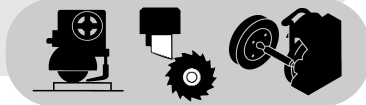
Features

- Friable, aluminum oxide abrasive with VPP porous bond – pink
- Controlled porosity bond
- Durable bond post

Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Increased chip clearance and maximum coolant flow
- Reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
High Porosity – For Light/Medium Stock Removal				
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders				
66253051941*	7 x 3/8 x 1-1/4	PA60-IVPP	3,600	5
05539564477	7 x 1/2 x 1-1/4	PA46-GVPP	3,600	5
05539564490		PA46-HVPP	3,600	5
05539564491*		PA60-GVPP	3,600	5
05539564492*		PA60-HVPP	3,600	5
05539564554*	8 x 1/2 x 1-1/4	PA46-GVPP	3,600	5
05539564562*		PA46-HVPP	3,600	5
05539564576*		PA60-HVPP	3,600	5
66253053088*	10 x 3/4 x 3	PA46-HVPP	3,250	5
66253054537*	10 x 1 x 3	PA46-IVPP	3,250	5
66253054538*		PA60-IVPP	3,250	5
66253054545*	12 x 3/4 x 3	PA46-HVPP	2,710	2
66253054551*		PA46-IVPP	2,710	2
66253054567*	12 x 1 x 3	PA46-IVPP	2,710	2
66253053104*	12 x 1 x 5	PA46-IVPP	2,710	2
66253054717*	14 x 1 x 3	PA46-IVPP	2,320	2
66253061075*	14 x 1-1/2 x 5	PA46-IVPP	2,320	2



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
High Porosity – For Light/Medium Stock Removal (cont'd)				
Type 05 – For Surface Grinders				
05539564565*	12 x 1-1/2 x 5	PA46-HVPP	2,710	2
05539564572*	Recess 1/S 7-1/2 x 1/2	PA60-GVPP	2,710	2
05539564560*	14 x 1-1/2 x 5	PA46-GVPP	2,320	1
05539564567*	Recess 1/S 8 x 1/2	PA46-HVPP	2,320	1
05539564574*		PA60-GVPP	2,320	1
05539564581*		PA60-HVPP	2,320	1
Type 07 – For Surface Grinders				
05539564566*	12 x 2 x 5 Recess 2/S 7-1/2 x 1/2	PA46-HVPP	2,710	1

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.

Carbo Cool AA Aluminum Oxide Abrasive

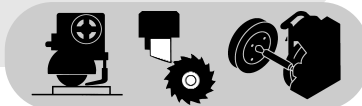
Features

- Most friable aluminum oxide abrasive with VPP porous bond – white
- Versatile
- Controlled porosity bond
- Durable bond post

Benefits

- Exceptionally cool cutting in light pressure grinding applications, or where burn is a concern
- Ideal for use across a broad variety of tool steels
- Increased chip clearance, maximum coolant flow, reduced loading
- Cool cutting – wet or dry – in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excellent for light stock removal, heat-sensitive applications.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Light Stock Removal				
Type 01 – For Surface, Cylindrical and Tool & Cutter Grinders				
05539564479	7 x 1/2 x 1-1/4	AA46-GVPP	3,600	5
05539564487*		AA46-HVPP	3,600	5
05539564488*		AA60-GVPP	3,600	5
05539564592*	8 x 1/2 x 1-1/4	AA46-GVPP	3,600	5
05539564599*		AA46-HVPP	3,600	5
05539564606*		AA60-GVPP	3,600	5
05539564601*	12 x 1 x 3	AA46-HVPP	2,710	2



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
High Porosity – For Light Stock Removal				
Type 05 – For Surface Grinders				
05539564602*	12 x 1-1/2 x 5	AA46-HVPP	2,710	2
05539564609*	Recess 1/S 7-1/2 x 1/2	AA60-GVPP	2,710	2
Type 07 – For Surface Grinders				
05539564603*	12 x 2 x 5	AA46-HVPP	2,710	1
	Recess 2/S 7-1/2 x 1/2			

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.

GC Silicon Carbide Abrasive

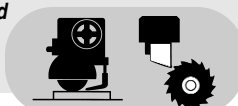
Features

- High performance, sharp, silicon carbide abrasive – green
- Performance vitrified bond

Benefits

- Fast stock removal
- Cool, free cut
- Long life

GC abrasive is used for grinding hard, cemented carbide tooling and non-ferrous materials.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Carbide				
Type 01 – For Surface and Tool & Cutter Grinders				
05539509586*	6 x 1/2 x 1-1/4	GC60-IVGC	4,140	5
05539509585 B		GC80-IVGC	4,140	5
05539509582		GC120-IVGC	4,140	5
05539509581	6 x 3/4 x 1-1/4	GC60-IVGC	4,140	5
05539509580		GC80-IVGC	4,140	5
05539509578		GC120-IVGC	4,140	5
66253060303*	7 x 1/4 x 1-1/4	GC60-IVGC	3,600	5
66253060304*		GC80-IVGC	3,600	5
66253060305*		GC100-IVGC	3,600	5
New! 05539569208*		GC120-HVGC	3,600	5
05539509576	7 x 1/2 x 1-1/4	GC60-IVGC	3,600	5
05539509575		GC80-IVGC	3,600	5
05539562390*		GC80-JVGC	3,600	5
05539509574*		GC100-IVGC	3,600	5
05539509573*		GC120-IVGC	3,600	5

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
For Carbide				
Type 01 – For Surface and Tool & Cutter Grinders (cont'd)				
05539562392*	7 x 3/4 x 1-1/4	GC80-JVGC	3,600	5
66253060314*	8 x 1/4 x 1-1/4	GC80-IVGC	3,600	5
05539509572	8 x 1/2 x 1-1/4	GC60-IVGC	3,600	5
66253060315*		GC80-IVGC	3,600	5
05539562395 B		GC100-IVGC	3,600	5

continued

BONDED ABRASIVES

Toolroom Wheels

GC Silicon Carbide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Carbide				
Type 01 - For Surface and Tool & Cutter Grinders (continued)				
05539509570	8 x 3/4 x 1-1/4	GC60-IVGC	3,600	5
05539562397	8 x 1 x 1-1/4	GC60-JVGC	3,600	5
05539562398		GC80-IVGC	3,600	5
66253061066*	10 x 1 x 3	GC60-JVGC	2,485	2
05539562386	14 x 1 x 5	GC60-IVGC	1,800	2
05539562388	14 x 2 x 5	GC60-JVGC	1,800	1
Type 02 - For Surface and Tool & Cutter Grinders				
05539509566	6 x 1 x 4	GC60-IVGC	3,600	2
05539509565*	Rim 1, Fits Both:	GC100-IVGC		2
05539509564	Four 9/32 Holes on 3-1/4" Bolt Circle Four 7/16 Holes on 3-1/4" Bolt Circle	GC120-IVGC		2
66253059203*	14 x 4 x 1-1/4 Rim 1-1/2", Plate Mounted, Tape Wound	GC60-IVGC	1,640	1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Carbide				
Type 05 - For Surface Grinding				
66253060309*	7 x 3/4 x 1-1/4	GC60-IVGC	3,600	5
66253060310*	Recess 1/S 3 x 1/4	GC80-IVGC	3,600	5
66253060311*		GC100-IVGC	3,600	5
66253060312*	7 x 1 x 1-1/4	GC60-IVGC	3,600	5
05539569224*	Recess 1/S 3 x 1/2	GC80-IVGC	3,600	5
66253060316*	8 x 1 x 1-1/4 Recess 1/S 3 x 1/2	GC60-IVGC	3,600	5

New!

* Non-stock. See your Carborundum Representative for current lead times.
Minimum quantity for all toolroom wheels equals box quantity.
B = Best seller

Bench and Pedestal Wheels

Aluminum Oxide Abrasive

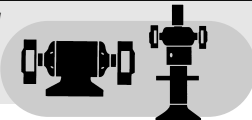
Features

- Aluminum oxide abrasive – gray
- Vitrified bond

Benefits

- Fast cut rate
- Free cutting action; long life

Ideal for removing burrs on steel parts, as well as sharpening high-speed steel cutting tools.
Note: Bushings included.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Type 01 - For Bench and Pedestal Grinders				
66253059518*	6 x 1/2 x 1	46-M	5,410	5
05539509978		60-M	5,410	5
66253059519*		80-M	5,410	5
05539509976*	6 x 3/4 x 1	36-M	5,410	5
66253059522*		46-M	5,410	5
05539509975		60-M	5,410	5
05539509974		100-K	5,410	5
05539509973	6 x 1 x 1	36-M	5,410	5
66253059524*		46-M	5,410	5
05539509972		60-M	5,410	5
05539509971		100-K	5,410	5
66253059529*	7 x 3/4 x 1	36-M	3,600	5
66253059533*		46-M	3,600	5
66253059534*		60-M	3,600	5
05539509966	7 x 1 x 1	36-M	3,600	5
66253059536*		46-M	3,600	5
05539509965		60-M	3,600	5
05539509964		100-K	3,600	5
05539509962	8 x 3/4 x 1	36-M	3,600	5
66253060232*		46-M	3,600	5
05539509961		60-M	3,600	5

continued



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Type 01 - For Bench and Pedestal Grinders (continued)				
05539509960	8 x 1 x 1	24-P	3,600	5
05539509959		36-M	3,600	5
66253060235*		46-M	3,600	5
05539509956		60-M	3,600	5
66253060236*		80-M	3,600	5
05539509955	10 x 1 x 1-1/4	24-P	2,485	2
05539509953		36-M	3,250	2
05539509952		60-M	3,250	2
05539509950	10 x 1-1/4 x 1-1/4	36-M	3,250	2

continued

Aluminum Oxide Abrasive

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Type 01 – For Bench and Pedestal Grinders (continued)				
05539509948	10 x 1-1/2 x 1-1/4	24-P	2,485	2
05539509947		36-M	3,250	2
66253060241*		46-M	3,250	2
66253060246*		60-M	3,250	2
66253060273*	12 x 1 x 1-1/4	24-P	2,070	1
66253060276*		46-M	2,705	1
05539509941	12 x 1-1/2 x 1-1/2	36-M	2,705	1
66253060250*		60-M	2,705	1
05539509939	12 x 2 x 1-1/2	24-P	2,070	1
05539509938		36-M	2,705	1
66253060252*		46-M	2,705	1
05539509937		60-M	2,705	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Steel/Metal				
Type 01 – For Bench and Pedestal Grinders (continued)				
05539509935	14 x 2 x 1-1/2	24-P	1,800	1
05539509934		36-M	1,800	1
66253060264*		60-M	1,800	1
66253060267*	14 x 3 x 1-1/2	36-O	1,800	1
66253060268*		46-M	1,800	1
66253060270*	16 x 2 x 1-1/2	36-O	1,800	1
66253060271*	18 x 3 x 1-1/2	24-O	1,800	1
66253060269*		36-O	1,800	1

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.

Silicon Carbide Abrasive

Features

- Sharp, silicon carbide abrasive – dark green
- Vitrified bond

Benefits

- Fast cut rate
- Free cutting action; long life

Ideal for sharpening carbide-tipped cutting tools. Note: Bushings included.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Carbide/Non-Ferrous Metals				
Type 01 – For Bench and Pedestal Grinders				
05539509929	6 x 3/4 x 1	60-l	5,410	5
05539509928		80-l	5,410	5
05539509927		120-l	5,410	5
05539509926	6 x 1 x 1	60-l	5,410	5
05539509925		80-l	5,410	5
05539509924		120-l	5,410	5
66253060286*	7 x 3/4 x 1	60-l	3,600	5
66253060287*		120-l	3,600	5

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
For Carbide/Non-Ferrous Metals				
Type 01 – For Bench and Pedestal Grinders (continued)				
66253060288*	7 x 1 x 1	60-l	3,600	5
05539509922		80-l	3,600	5
05539509920		120-l	3,600	5
05539509916	8 x 1 x 1	60-l	3,600	5
05539509915		80-l	3,600	5
05539509914		120-l	3,600	5
05539509913	10 x 1 x 1-1/4	60-l	3,250	2
05539509912		80-l	3,250	2
05539509911		120-l	3,250	2
66253062192*	12 x 1 x 1-1/4	60-l	2,705	1
66253062195*		80-l	2,705	1
66253060289*	12 x 2 x 1-1/2	60-l	2,705	1
66253060290*		80-l	2,705	1
66253060291*		120-l	2,705	1

* Non-stock. See your Carborundum Representative for current lead times. Minimum quantity for all toolroom wheels equals box quantity.

Reducing Bushings



Reducing bushings can be safely used to reduce the center hole in a grinding wheel. They are designed to fit freely on the spindle and maintain proper clearance. It is important that the bushing diameter does not come in contact with the flange bearing area and does not exceed the width of the wheel.

Reducing bushings are included with Bench and Pedestal Wheels as follows:

WHEEL DIAMETER	BUSHING
6", 7"	7/8, 3/4, 5/8, 1/2
8"	7/8, 3/4, 5/8
10"	1, 7/8, 3/4
12"	1-1/4, 1
14"	1-1/4, 1
16"	1-1/4
18"	1-1/4

Cylindrical Wheels

GA Aluminum Oxide Abrasive

Features

- Strong, blocky-shaped aluminum oxide abrasive – dark gray
- Strong vitrified bond system

Benefits

- Well suited for general purpose applications
- High "G" ratios (metal removed/wheel wear)
- Longer wheel life
- Excellent form holding

Ideal for general machine shop grinding of various steels and steel alloys.

Cylindrical grinding of cylindrical components between centers.

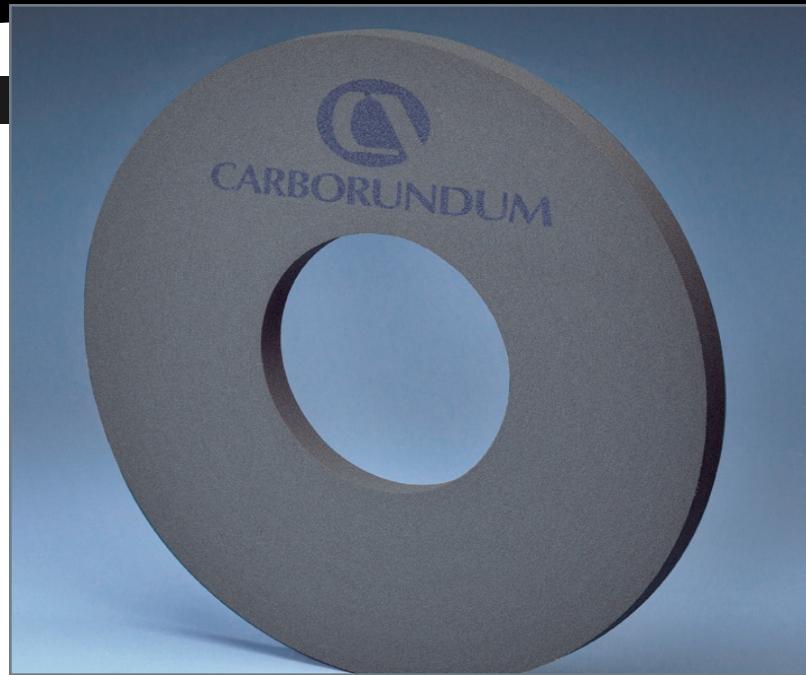


PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
Type 01 – For Cylindrical Grinders				
66253059251*	14 x 1 x 5	GA54-KV40	1,800	1
66253059252*		GA60-LV40	1,800	1
66253059253*		GA80-MV40	1,800	1

Type 05 – For Cylindrical Grinders

66253059254*	14 x 1-1/2 x 5	GA54-KV40	1,800	1
66253059256*	Recess 1/S 8 x 1/2	GA60-LV40	1,800	1
66253059257*		GA80-MV40	1,800	1
66253059258*	14 x 2 x 5	GA54-KV40	1,800	1
66253059259*	Recess 1/S 8 x 1	GA60-LV40	1,800	1
66253059261*		GA80-MV40	1,800	1

* Non-stock. See your Carborundum Representative for current lead times.



GRA Aluminum Oxide Abrasive

Features

- Blended aluminum oxide GRA abrasive - gray
- Premium performance vitrified bond

Benefits

- Cool cutting action
- Fast stock removal
- Long wheel life and excellent form holding

For general machine shop grinding of various steels and steel alloys.

Cylindrical grinding of cylindrical components between centers.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
Type 01 – For Cylindrical Grinders				
66253059262*	16 x 1 x 5	GRA60-LV14	2,030	1
66253059263*		GRA80-MV14	2,030	1
66253059264*	16 x 1 x 8	GRA54-KV14	2,030	1
66253059265*		GRA60-LV14	2,030	1
66253059266*		GRA80-MV14	2,030	1
66253059267*	16 x 1-1/2 x 5	GRA60-LV14	2,030	1
66253059268*		GRA80-MV14	2,030	1
66253059272*	16 x 1-1/2 x 8	GRA54-KV14	2,030	1
66253059273*		GRA60-LV14	2,030	1
66253059274*		GRA80-MV14	2,030	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
Type 01 – For Cylindrical Grinders				
66253059277*	16 x 2 x 5	GRA80-LV14	2,030	1
66253059278*	16 x 2 x 8	GRA54-KV14	2,030	1
66253059279*		GRA60-LV14	2,030	1
66253059280*		GRA80-LV14	2,030	1
66253059286*	20 x 1 x 12	GRA60-KV14	1,625	1
66253059287*		GRA60-LV14	1,625	1
66253059288*		GRA60-MV14	1,625	1
66253059291*	20 x 2 x 12	GRA60-KV14	1,625	1
66253059290		GRA60-LV14	1,625	1
66253059293*	20 x 3 x 12	GRA60-KV14	1,625	1
66253059476*	24 x 1-1/2 x 12	GRA60-KV14	1,350	1
66253059480	24 x 2 x 12	GRA60-LV14	1,350	1
66253059488*	24 x 3 x 12	GRA60-KV14	1,350	1
66253059509*	30 x 2 x 12	GRA54-JV14	1,355	1
66253059510*		GRA60-KV14	1,080	1
66253059511*	30 x 3 x 12	GRA54-JV14	1,080	1

* Non-stock. See your Carborundum Representative for current lead times.

DAC Aluminum Oxide/Silicon Carbide Abrasive Blend

Features

- Blended aluminum oxide/silicon carbide abrasives for versatility – gray
- Resinoid bond system

Benefits

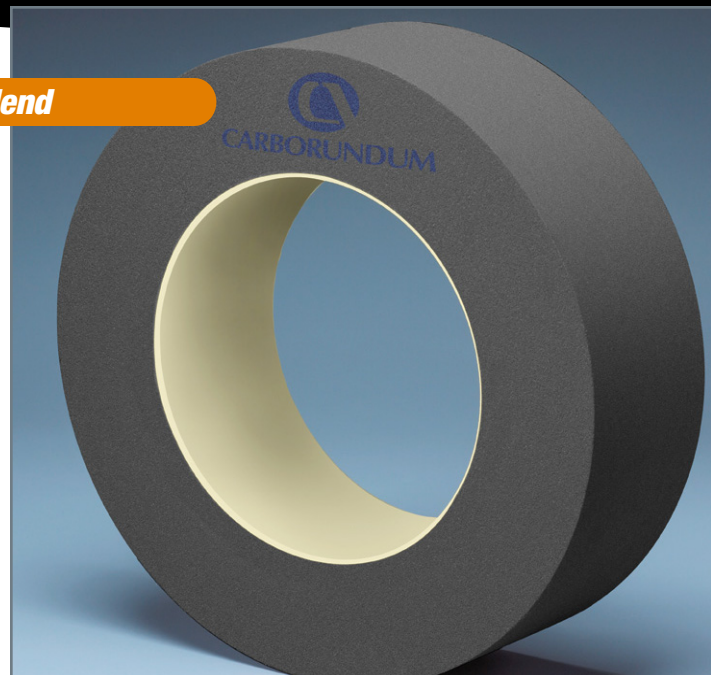
- Ideal when one wheel is used to grind several different materials from high to low tensile strength

Centerless grinding of cylindrical components in a thru-feed or plunge mode.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 – For Centerless Grinders				
66253062178*	20 x 6 x 305mm	DAC54-QB83	1,815	1
66253062180*	20 x 8 x 12	DAC54-QB83	1,815	1
66253062184*	24 x 6 x 12	DAC54-QB83	1,510	1
66253062188*	24 x 8 x 12	DAC54-QB83	1,510	1
66253062190*	24 x 10 x 12	DAC54-QB83	1,510	1

* Non-stock. See your Carborundum Representative for current lead times.



GRA Aluminum Oxide Abrasive

Features

- Blended aluminum oxide GRA abrasive - gray
- Premium performance vitrified bond

Benefits

- Cool cutting action
- Fast stock removal
- Long wheel life and excellent form holding

Ideal choice for general machine shop grinding of various steels and steel alloys.

Centerless Grinding cylindrical components in a thru-feed or plunge mode.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 – For Centerless Grinders				
66253059283*	16 x 4 x 10	GRA60-LV14	2,030	1
66253059285*		GRA80-LV14	2,030	1
66253059289*	20 x 2 x 12	GRA60-MV14	1,625	1
66253059292*		GRA80-MV14	1,625	1
66253059295*	20 x 3 x 12	GRA60-LV14	1,625	1
66253059296*	20 x 4 x 12	GRA60-KV14	1,625	1
66253059297*		GRA60-LV14	1,625	1
66253059298*		GRA60-MV14	1,625	1
66253059299*		GRA80-MV14	1,625	1
66253059302*	20 x 6 x 12	GRA60-KV14	1,625	1
66253059303*		GRA60-LV14	1,625	1
66253059305*		GRA60-MV14	1,625	1
66253059306*		GRA80-LV14	1,625	1
66253059309*		GRA80-MV14	1,625	1
66253059468*	20 x 8 x 12	GRA60-MV14	1,625	1
66253059470*		GRA80-LV14	1,625	1
66253059472*		GRA80-MV14	1,625	1
66253059473*	20 x 10 x 12	GRA60-LV14	1,625	1
66253059482*	24 x 2 x 12	GRA60-MV14	1,350	1
66253059485*		GRA80-MV14	1,350	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 – For Centerless Grinders (continued)				
66253059489*	24 x 4 x 12	GRA60-KV14	1,350	1
66253059490*		GRA60-MV14	1,350	1
66253059491*		GRA80-MV14	1,350	1
66253059492*	24 x 6 x 12	GRA60-KV14	1,350	1
66253059493*		GRA60-LV14	1,350	1
66253059494*		GRA60-MV14	1,350	1
66253059496*		GRA80-MV14	1,350	1
66253059498*	24 x 8 x 12	GRA60-KV14	1,350	1
66253059499*		GRA60-LV14	1,350	1
66253059500*		GRA60-MV14	1,350	1
66253059501*		GRA80-MV14	1,350	1
66253059507*	24 x 10 x 12	GRA60-KV14	1,350	1
66253059508*		GRA60-LV14	1,350	1
66253062309*	24 x 20 x 12	GRA60-KV14	1,350	1
66253062317*	Composed of Two 24 x 10 x 12 Butted Wheels	GRA60-LV14	1,350	1

* Non-stock. See your Carborundum Representative for current lead times.

TechTip

- Use resinoid bond wheels for stock removal, long irregular parts, and faster throughfeed grinding.
- Use vitrified bond wheels for form holding and plunge grinding.



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



Centerless and Feed Wheels

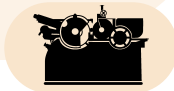
Rubber Bond Feed Wheels

Features

- The basic components of centerless grinding are the grinding wheels on the previous page, the rubber feed (regulating) wheels below, and the work rest blade
- The workpiece lies between the two wheels and is supported by the rest blade

Benefits

These rubber regulating/feed wheels are the drive mechanism for the workpiece.



PART NO.	WHEEL SIZE	GRADING	WHEELS/BOX
Type 01 – For Centerless Grinders			
66253060229*	8 x 2 x 3	GA80-RR	1
66253060233*	9 x 2 x 4	GA80-RR	1
66253060238*	11 x 6 x 6-1/2	GA80-RR	1
66253060239*	12 x 1 x 5	GA80-RR	1
66253060242*	12 x 1-1/2 x 5	GA80-RR	1
66253060243*	12 x 2 x 5	GA80-RR	1
66253060244*	12 x 2-1/2 x 5	GA80-RR	1
66253060245*	12 x 3 x 5	GA80-RR	1
66253060247*	12 x 4 x 5	GA80-RR	1
66253060251*	12 x 6 x 5	GA80-RR	1

Type 05 – For Centerless Grinders

66253060255*	12 x 8 x 5 Recess 1/S 7-1/2 x 1-1/2	GA80-RR	1
66253060262*	14 x 10 x 6 Recess 1/S 8-1/2 x 1-1/2	GA80-RR	1

* Non-stock. See your Carborundum Representative for current lead times.

PART NO.	WHEEL SIZE	GRADING	WHEELS/BOX
Type 07 – For Centerless Grinders			
66253060298*	8 x 4 x 3 Recess A/S 4-1/4 x 1-1/2 Recess B/S 4-1/4 x 1/2	GA80-RR	1
66253060295*	9 x 4 x 4 Recess 2/S 5-1/2 x 5/8	GA80-RR	1
66253060249*	12 x 4 x 5 Recess 2/S 7-1/2 x 1/2	GA80-RR	1
66253060253*	12 x 6 x 5 Recess A/S 7-1/2 x 1-1/2 Recess B/S 7-1/2 x 1/2	GA80-RR	1
66253060254*	12 x 6 x 5 Recess 2/S 7-1/2 x 1-1/2	GA80-RR	1
66253060256*	12 x 8 x 5 Recess A/S 7-1/2 x 2-1/2 Recess B/S 7-1/2 x 1-1/2	GA80-RR	1
66253060257*	12 x 8 x 5 Recess A/S 7-1/2 x 3-1/2 Recess B/S 7-1/2 x 1-1/2	GA80-RR	1
66253060258*	12 x 10 x 5 Recess A/S 8 x 2 Recess B/S 8 x 1-1/2	GA80-RR	1
66253060259*	14 x 8 x 5 Recess A/S 8 x 2 Recess B/S 8 x 1-1/2	GA80-RR	1
66253060261*	14 x 10 x 5 Recess 2/S 8 x 1-1/2	GA80-RR	1
66253060272*	14 x 20 x 6 Recess 2/S 8-1/2 x 1-1/2 Composed of Two 14 x 10 x 6 Butted Wheels	GA80-RR	1

Surface Grinding Wheels

AA Aluminum Oxide Abrasive

Features

- Aluminum oxide abrasive - white
- Excellent friability
- Durable, vitrified bond

Benefits

- Fast stock removal for light to medium stock removal operations
- Cool cutting action
- Long wheel life

AA abrasive is ideal for grinding heat sensitive steels, as well as easy- and medium-to-grind high-speed steels and cast, alloy steels.

Use V40 bond for general purpose applications or medium contact areas.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/BOX
Type 01 – For Large Surface Grinders				
66253059045*	20 x 1 x 8	AA46-HV40	1,240	1
66253059046*		AA60-JV40	1,240	1
66253059047*	20 x 1 x 10	AA36-HV40	1,240	1
66253059050*	20 x 1-1/2 x 10	AA36-JV40	1,240	1
66253059051*		AA46-HV40	1,240	1
66253059069*		AA60-JV40	1,240	1
66253059052*	20 x 2 x 10	AA36-JV40	1,240	1
66253059054*		AA46-HV40	1,240	1
66253059055*		AA60-JV40	1,240	1

continued

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AA Aluminum Oxide Abrasive (continued)

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 05 - For Large Surface Grinders				
66253059048*	20 x 1-1/2 x 8	AA46-HV40	1,240	1
66253059049*	Recess 1/S 11-1/2 x 1/2	AA60-JV40	1,240	1
Type 07 - For Large Surface Grinders				
66253059044*	18 x 2 x 8 Recess 2/S 11-1/2 x 1/2	AA60-HV40	1,380	1
66253059070*	20 x 2 x 8	AA46-HV40	1,240	1
66253059071*	Recess 2/S 11-1/2 x 1/2	AA60-JV40	1,240	1
66253059056*	20 x 3 x 8	AA46-HV40	1,240	1
66253059057*	Recess 2/S 11-1/2 x 1/2	AA46-IV40	1,240	1
66253059059*	20 x 3 x 10	AA46-HV40	1,240	1
66253059060*	Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	AA46-IV40	1,240	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 07 - For Large Surface Grinders (continued)				
66253059062*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	AA46-HV40	1,240	1
66253059065*	20 x 6 x 10 Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	AA46-HV40	1,240	1
66253059067*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	AA46-HV40	1,240	1

* Non-stock. See your Carborundum Representative for current lead times.

PA Aluminum Oxide Abrasive

Features

- Friable, aluminum oxide abrasive with porous bond - pink
- Controlled porosity bond
- Durable bond post

Benefits

- Designed to grind a broad variety of steels at light to moderate feed rates
- Increased chip clearance and maximum coolant flow
- Reduced loading
- Cool cutting - wet or dry - in heat-sensitive applications
- Maximum grain retention
- Less dressing; longer wheel life

Excels in light to medium stock removal applications. Use on wide contact areas where heat is an issue.



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 01 - For Large Surface Grinders				
66253059211*	20 x 2 x 10	PA46-G19V40P	1,625	1
Type 02 - For Large Surface Grinders				
66253059206*	18 x 5 - 1-1/2 Rim Tape Wound	PA30-G19V40P	1,060	1

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 05 - For Large Surface Grinders				
66253059202*	18 x 1-1/2 x 8 Recess 1/S 11-1/2 x 1/2	PA46-G19V40P	1,805	1
Type 07 - For Large Surface Grinders				
66253059209*	20 x 2 x 8 Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059213*	20 x 3 x 8	PA46-E19V40P	1,625	1
66253059215*	Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059217*	20 x 3 x 10	PA46-E19V40P	1,625	1
66253059219*	Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059222*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	PA46-G19V40P	1,625	1
66253059223*	20 x 6 x 10	PA46-E19V40P	1,625	1
66253059224*	Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	PA46-G19V40P	1,625	1
66253060320*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	PA46-G19V40P	1,625	1

* Non-stock. See your Carborundum Representative for current lead times.

DA Aluminum Oxide Abrasive Blend

Features

- A tough blend of AA and GA aluminum oxide abrasives

Benefits

- Fast, cool cutting action and good form holding

The choice for medium to heavy feed rates, less heat-sensitive, precision operations



PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 07 - For Large Surface Grinders				
66253059073*	20 x 2 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1
66253059058*	20 x 3 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1

continued

PART NO.	WHEEL SIZE	GRADING	MAX. RPM	WHEELS/ BOX
Type 07 - For Large Surface Grinders (continued)				
66253059061*	20 x 3 x 10 Recess A/S 12-1/2 x 1 Recess B/S 12-1/2 x 1/2	DA46-IV40	1,240	1
66253059063*	20 x 4 x 8 Recess 2/S 11-1/2 x 1/2	DA46-IV40	1,240	1
66253059066*	20 x 6 x 10 Recess A/S 12-1/2 x 2 Recess B/S 12-1/2 x 1	DA46-IV40	1,240	1
66253059068*	20 x 6 x 12 Recess 2/S 14-1/4 x 1	DA46-IV40	1,240	1
66253059226*	20 x 8 x 12 Recess 2/S 14-1/4 x 1	DA46-IV40	1,240	1

* Non-stock. See your Carborundum Representative for current lead times.

Surface Grinding Segments

Medalist Ceramic Alumina Abrasive

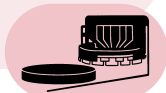
Features

- High-performance, ceramic alumina abrasive - blue
- Self-sharpening abrasive
- High-performance bond
- Induced porosity

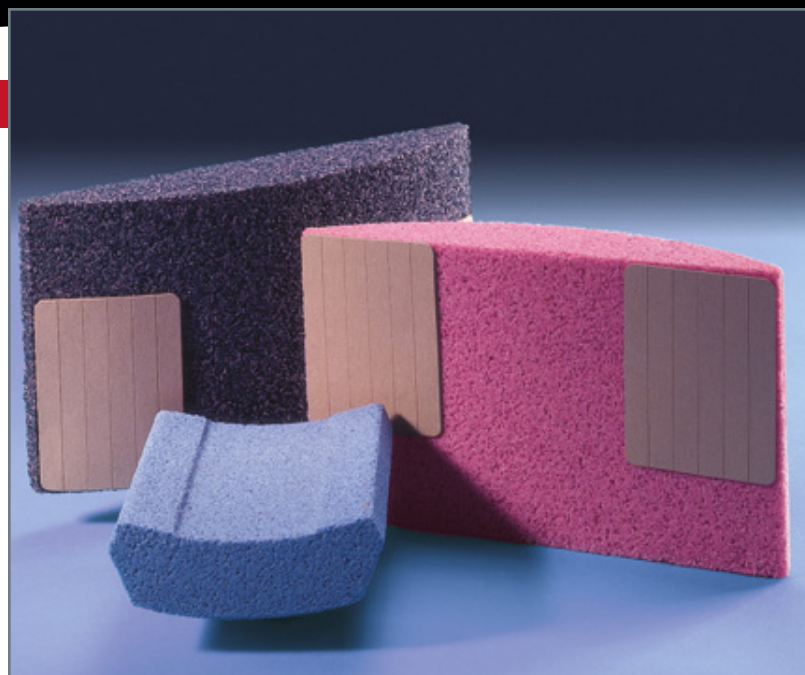
Benefits

- Fastest stock removal; maximum productivity
- Cool cutting
- Less burn on part
- Enhanced segment life
- Cool, free cut
- Excellent chip and coolant flow

Ideal for high stock removal on flat surfaces. Best for grinding hard materials.



PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539507043	5 x 1-1/2 x 6	30-EVLP	NO	8
05539562906		30-FVLP	NO	8
05539507044		30-GVLP	NO	8
05539507047	11-1/4 x 2-1/4 x 6	30-EVLP	CD	5
05539562907		30-FVLP	CD	5
05539507048		30-GVLP	CD	5
05539505202	11-1/4 x 2-1/4 x 8	30-GVLP	CD	5



Premier Red Aluminum Oxide Abrasive

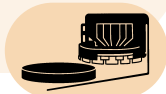
Features

- Performance, aluminum oxide abrasive - pink
- Premium vitrified bond
- Induced porosity

Benefits

- Fast, cool cutting action
- Long life
- Cool, free cut

Engineered for high stock removal on flat surfaces. Very versatile; work well on mild steels.



PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539562911	5 x 1-1/2 x 6	RA30-GV40P	NO	8
05539562912	11-1/4 x 2-1/4 x 6	RA24-EV40P	CD	5
05539562914		RA30-EV40P	CD	5
05539562915		RA30-GV40P	CD	5

Gold Aluminum Oxide Abrasive

Features

- Excellent value, aluminum oxide abrasive blend - gray/pink
- Advanced vitrified bond
- Induced porosity

Benefits

- Fast, cool cutting action
- Long life
- Cool, free cut

For high stock removal on flat surfaces. Excellent value for general purpose use.

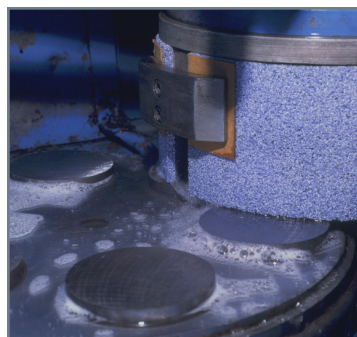


PART NO.	SEGMENT SIZE	GRADING	TYPE	SEGMENTS/BOX
05539563010	11-1/4 x 2-1/4 x 6	Gold 30-E	CD	5
05539562922		Gold 30-F	CD	5
05539562924	11-1/4 x 3 x 8	Gold 30-F	CD*	4

* Bonus Grind

BONDED ABRASIVES

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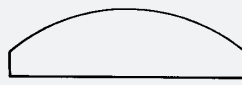
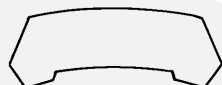
Size = width x thickness x height

SEGMENT NO. SEGMENTS PER SET
FOR NORTON-MATTISON CHUCKS (NO):

NO14	6
NO18	8
NO20	9
NO22	10

FOR CORTLAND CHUCKS (CD):

CD18L	4
CD22L	5
CD36	8



NorZon Zirconia Alumina Abrasive - Resin Bond

Features

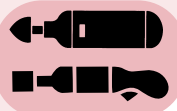
- Self-sharpening zirconia alumina abrasive
- Durable resin bond

Benefits

- Aggressive, free cut
- 4 times faster stock removal than competitive aluminum oxide products
- Long lasting

Premium quality mounted points for metal fabricating and foundry applications.

24 grit: snagging castings, smoothing contours, removing fins and parting lines.

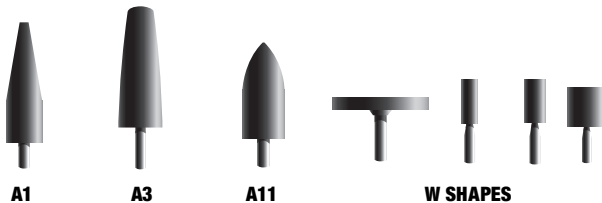


PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
"A" Shapes						
61463616457	A1	3/4 x 2-1/2	1/4	NZ24-UBXR1	20,960	5/25
61463616459	A3	1 x 2-3/4	1/4	NZ24-UBXR1	15,530	5/25
61463616463	A11	7/8 x 2	1/4	NZ24-UBXR1	25,420	5/25

"W" Shape

61463616465	W189	1/2 x 2	1/4	NZ24-UBXR1	26,830	5/25
61463616467	W197	5/8 x 2	1/4	NZ24-UBXR1	24,550	5/25
61463616471	W208	3/4 x 2	1/4	NZ24-UBXR1	22,830	5/25
61463617520	W220	1 x 1	1/4	NZ24-UBXR1	30,370	5/25
61463616473	W221	1 x 1-1/2	1/4	NZ24-UBXR1	24,490	5/25
61463616475	W222	1 x 2	1/4	NZ24-UBXR1	20,250	5/25

Shank length is 1-1/2". Maximum operating speed based on 1/2" overhang.



TechTip

- Use "A" shapes for medium- to heavy-duty blending
- Use "W" shapes for offhand and precision grinding of medium to heavy stock



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

Charger Zirconia Alumina Abrasive - Resin Bond

Features

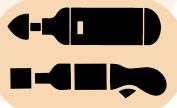
- Self-sharpening 30 grit zirconia alumina abrasive
- Specially formulated organic bond

Benefits

- 35% faster cut rate than standard aluminum oxide
- An aggressive, free cut
- More parts cleaned in less time to substantially increase productivity
- 5X greater life than ordinary aluminum oxide
- Reduces vibration and wheel chatter

Premium quality mounted points for metal fabricating and foundry applications.

30 grit: deburring, removing weld beads, smoothing and blending welded areas.



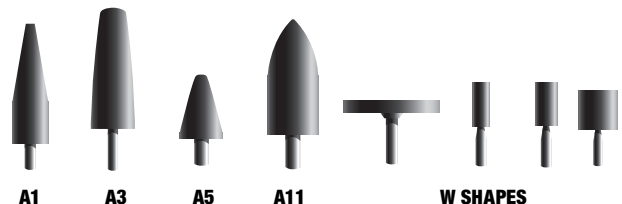
PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
"A" Shapes						
61463616458	A1	3/4 x 2-1/2	1/4	Charger	20,960	5/25
61463616460	A3	1 x 2-3/4	1/4	Charger	15,530	5/25
61463616462	A5	3/4 x 1-1/8	1/4	Charger	38,550	5/25
61463616464	A11	7/8 x 2	1/4	Charger	25,420	5/25

"W" Shape

61463616466	W189	1/2 x 2	1/4	Charger	26,830	5/25
61463616470	W207	3/4 x 1-1/2	1/4	Charger	27,070	5/25
61463616472	W208	3/4 x 2	1/4	Charger	22,830	5/25
61463617521	W220	1 x 1	1/4	Charger	30,370	5/25
61463616474	W221	1 x 1-1/2	1/4	Charger	24,490	5/25
61463616476	W222	1 x 2	1/4	Charger	20,250	5/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.



Mounted Points

Fiber-Reinforced Aluminum Oxide Abrasive – Resin Bond

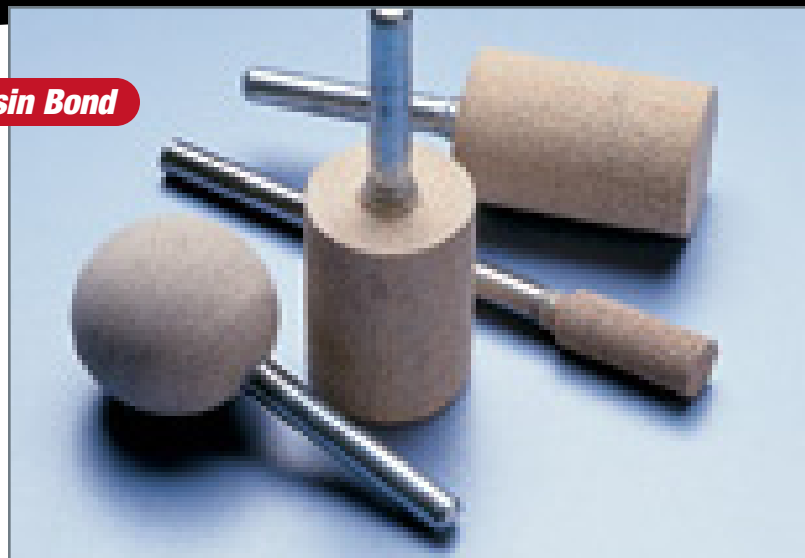
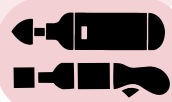
Features

- Cotton fiber reinforced aluminum oxide
- 80 grit
- 120 grit

Benefits

- Ideal for blending and finishing parts without changing geometry
- For most materials
- For polishing and stainless steel applications

Engineered for blending, polishing and finishing dies, cavities, etc.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
For Polishing						
61463622664	A11	7/8 x 2	1/4	A80-HBF3	25,420	25/25
61463620242	B52	3/8 x 3/4	1/8	A120-HBF3	64,810	25/25
61463622657	B121	1/2" Ball	1/8	A80-HBF3	62,420	25/25
61463622655	W163	1/4 x 1/2	1/8	A80-HBF3	59,990	25/25
61463622656				A120-HBF3		
61463622654	W176	3/8 x 1/2	1/8	A80-HBF3	50,460	25/25
61463622649	W185	1/2 x 1/2	1/8	A80-HBF3	42,750	25/25
61463622651	W187	1/2 x 1	1/8	A80-HBF3	22,630	25/25
61463622646	W220	1 x 1	1/4	A80-HBF3	30,370	25/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.



A11



B52



B121



W SHAPE

Center Lap – Aluminum Oxide Abrasive – Vitrified Bond

Features

- Specially formulated wheel treatment (#5 wood resin)
- Large diameter spindle
- Precise dimensional tolerances

Benefits

- Adds lubricity to the point, minimizing risk of metallurgical damage
- Minimum deflection, rigid support
- Ensure accurate location of centers

For use on Ex-Cello Center Lap and similar machines to produce accurate centers – precisely angled, truly conical, and free from ridges – for cylindrical grinding

PART NO.	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
For Center Lapping					
61463621421	1/2 x 2**	1/2	A80-VVM	65,000	5/25
61463622926	1 x 2**	1/2	A80-VVM	15,900	5/25

** Pointed 60°

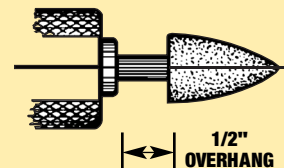
Shank length is 1-1/4". Maximum operating speed based on 1/2" overhang.



TechTip

Description of Overhang

- Overhang is the distance between the grinder chuck and the abrasive on the spindle. The larger the overhang, the lower the maximum safe operating speed.
- Maximum operating speed is based on 1/2" overhang.
- The standard shank length is 1-1/2".



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

Pacesetter Aluminum Oxide Abrasive – Vitrified Bond

Features

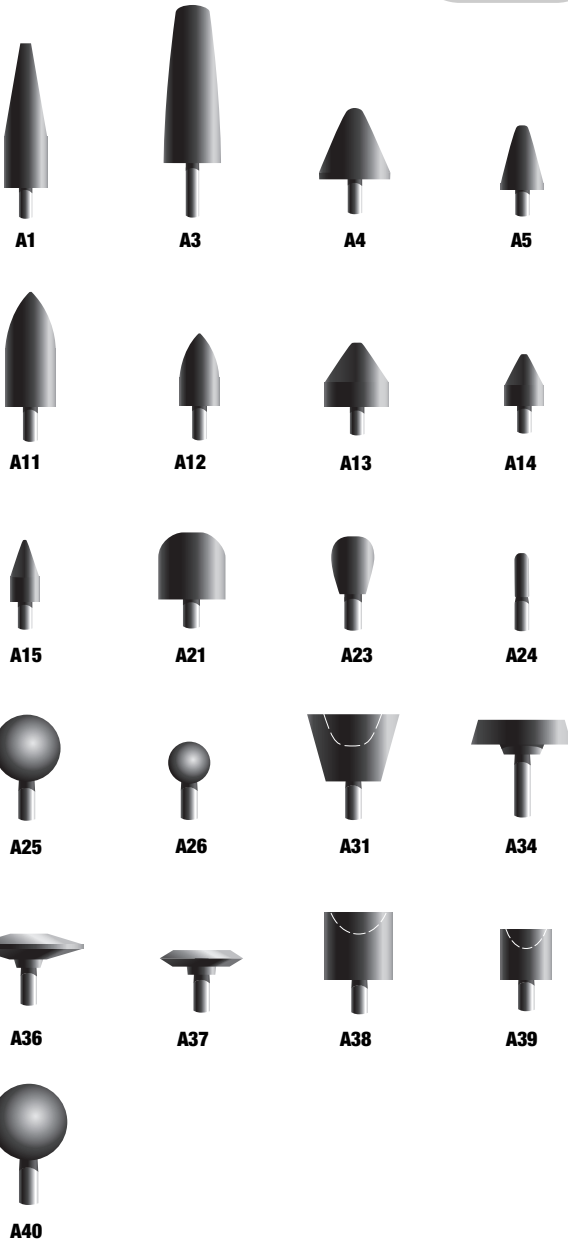
- Quality 38A aluminum oxide abrasive – brown
- Vitrified bond
- Diverse shapes and sizes

Benefits

- Cool cutting, less burn
- Long life
- Consistent form holding
- Ideal when initial price is the main purchasing consideration
- Great choice for small job shops

"A" Shape Applications

Ideal for general maintenance applications in metal fabrication plants.



PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
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"A" Shapes – For General Maintenance

61463624374	A1	3/4 x 2-1/2	1/4	38A36-T	20,960	5/25
61463624375	A1	3/4 x 2-1/2	1/4	38A60-P	20,960	5/25
61463624377	A3	1 x 2-3/4	1/4	38A36-T	15,530	5/25
61463624378	A3	1 x 2-3/4	1/4	38A60-P	15,530	5/25
61463624380	A4	1-1/4 x 1-1/4	1/4	38A60-P	28,550	5/25
61463624381	A5	3/4 x 1-1/8	1/4	38A36-T	38,550	5/25
61463624382	A5	3/4 x 1-1/8	1/4	38A60-P	38,550	5/25
61463624384	A11	7/8 x 2	1/4	38A36-T	25,420	5/25
61463624385	A11	7/8 x 2	1/4	38A60-P	25,420	5/25
61463624387	A12	11/16 x 1-1/4	1/4	38A36-T	38,050	5/25
61463624388	A12	11/16 x 1-1/4	1/4	38A60-P	38,050	5/25
61463624389	A13	1-1/8 x 1-1/8	1/4	38A60-P	31,850	5/25
61463624390	A14	11/16 x 7/8	1/4	38A60-P	43,440	5/25
61463624391	A15	1/4 x 1-1/16	1/4	38A60-P	50,510	5/25
61463624392	A21	1 x 1	1/4	38A60-P	35,510	5/25
61463624394	A23	3/4 x 1	1/4	38A60-P	40,300	5/25
61463624395	A24	1/4 x 3/4	1/4	38A60-P	56,000	5/25
61463624396	A25	1" Ball	1/4	38A60-P	35,510	5/25
61463624397	A26	5/8" Ball	1/4	38A60-P	48,980	5/25
61463624399	A31	1-3/8 x 1	1/4	38A60-P	27,780	5/25
61463624402	A34	1-1/2 x 3/8	1/4	38A60-P	25,460	5/25
61463624404	A36	1-5/8 x 3/8	1/4	38A60-P	23,510	5/25
61463624405	A37	1-1/4 x 1/4	1/4	38A60-P	30,560	5/25
61463624406	A38	1 x 1	1/4	38A60-P	35,510	5/25
61463624407	A39	3/4 x 3/4	1/4	38A60-P	44,030	5/25
61463624408	A40	3/4" Ball	1/4	38A60-P	44,030	5/25

Standard shank size is 1/4" x 1-1/2".

Maximum operating speed based on 1/2" overhang.

PART NO.	DESCRIPTION	GRADING	KITS/BOX
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Mounted Point Kits – Vitrified Bond

69083147789	Assorted 1/4" Spindle, 50 pieces	38A60-P	1
1/4" Spindle Mtd. Point Kit contains 5 each of A1, A5, A11, A21, A23, A26, A36, A39, W242 Pacesetter and 5 W220 A80-HBF3			
69083147669	Assorted 1/8" Spindle, 50 pieces	38A60-P	1
1/8" Spindle Mtd. Point Kit contains 5 each of B42, B52, B97, B122, B131, W154, W164, W185, W215 Pacesetter and W163 A80-HBF3			

TechTip

For best mounted point performance, always run the mounted point at the maximum allowable speed according to ANSI B7.1.

- Use 36 grit for rough grinding.
- Use 60 grit for imparting fine finishes or when grinding on narrow surfaces.

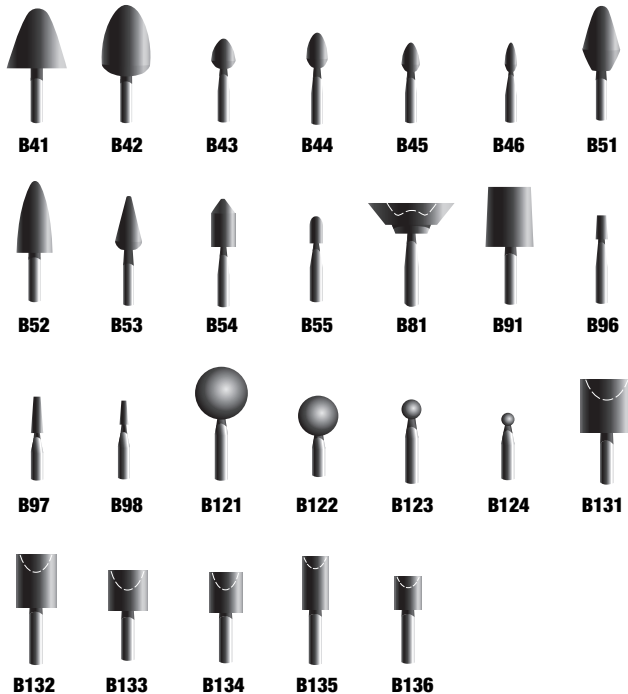


It is the user's responsibility to refer to and comply with ANSI B7.1

Pacesetter Aluminum Oxide Abrasive – Vitrified Bond (continued)

“B” Shape Applications

Ideal for light deburring of machined parts and for finishing/polishing molds and dies.



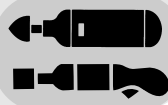
PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
61463624410	B41	5/8 x 5/8	1/8	38A60-P	59,560	5/25
61463624412	B42	1/2 x 3/4	1/8	38A60-P	61,320	5/25
61463624413	B43	1/4 x 5/16	1/8	38A60-P	76,160	5/25
61463624414	B44	7/32 x 3/8	1/8	38A60-P	75,840	5/25
61463624415	B45	3/16 x 5/16	1/8	38A60-P	79,600	5/25
61463624416	B46	1/8 x 5/16	1/8	38A60-P	83,530	5/25
61463624418	B51	7/16 x 3/4	1/8	38A60-P	62,820	5/25
61463624420	B52	3/8 x 3/4	1/8	38A60-P	64,810	5/25
61463624419	B52	3/8 x 3/4	1/4	38A60-P	78,340	5/25
61463624422	B52	3/8 x 3/4	1/8	38A90-Q	64,810	5/25
61463624423	B53	5/16 x 5/8	1/8	38A60-P	67,070	5/25
61463624424	B54	1/4 x 1/2	1/8	38A60-P	71,340	5/25
61463624425	B55	1/8 x 1/4	1/8	38A60-P	85,900	5/25
61463624437	B81	3/4 x 3/16	1/8	38A60-P	50,930	5/25
61463624443	B91	1/2 x 5/8	1/8	38A60-P	61,110	5/25
61463624448	B96	1/8 x 1/4	1/8	38A60-P	85,900	5/25
61463624449	B96	1/8 x 1/4	1/8	38A90-Q	85,900	5/25
61463624451	B97	1/8 x 3/8	1/8	38A60-P	81,550	5/25
61463624452	B98	3/32 x 1/4	1/8	38A60-P	88,040	5/25
61463624466	B121	1/2" Ball	1/8	38A60-P	62,420	5/25
61463624470	B122	3/8" Ball	1/8	38A60-P	68,740	5/25
61463624471	B122	3/8" Ball	1/8	38A90-Q	68,740	5/25
61463624472	B123	3/16" Ball	1/8	38A60-P	84,720	5/25
61463624474	B124	1/8" Ball	1/8	38A90-Q	91,770	5/25
61463624475	B131	1/2 x 1/2	1/8	38A60-P	62,420	5/25
61463624479	B132	3/8 x 1/2	1/8	38A60-P	65,910	5/25
61463624481	B133	3/8 x 3/8	1/8	38A60-P	68,740	5/25
61463624482	B134	5/16 x 3/8	1/8	38A60-P	71,220	5/25
61463624484	B135	1/4 x 1/2	1/8	38A60-P	71,340	5/25
61463624485	B136	1/4 x 5/16	1/8	38A60-P	76,160	5/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.

“W” Shape Applications

Ideal for precision grinding machine parts, molds and dies, involving medium to heavy stock removal.



W SHAPES

PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
61463624488	W144	1/8 x 1/4	1/8	38A60-P	92,460	5/25
61463624489	W145	1/8 x 3/8	1/8	38A60-P	84,190	5/25
61463624491	W146	1/8 x 1/2	1/8	38A60-P	76,820	5/25
61463624495	W152	3/16 x 1/4	1/8	38A60-P	82,070	5/25
61463624496	W153	3/16 x 3/8	1/8	38A60-P	73,880	5/25
61463624497	W154	3/16 x 1/2	1/8	38A60-P	66,580	5/25
61463624501	W160	1/4 x 1/4	1/8	38A60-P	75,330	5/25
61463624503	W162	1/4 x 3/8	1/8	38A60-P	67,210	5/25
61463624504	W163	1/4 x 1/2	1/8	38A60-P	59,990	5/25
61463624505	W164	1/4 x 3/4	1/8	38A60-P	47,880	5/25
61463624511	W170	5/16 x 1/2	1/8	38A60-P	54,860	5/25
61463624516	W175	3/8 x 3/8	1/8	38A60-P	57,530	5/25
61463624517	W176	3/8 x 1/2	1/8	38A60-P	50,460	5/25
61463624518	W177	3/8 x 3/4	1/8	38A60-P	38,640	5/25

PART NO.	SHAPE	SIZE D X L	SPINDLE	GRADING	MAX. RPM	MIN/STD PKG.
61463624525	W185	1/2 x 1/2	1/8	38A60-P	42,750	5/25
61463624526	W185	1/2 x 1/2	1/4	38A60-P	44,470	5/25
61463624528	W186	1/2 X 3/4	1/4	38A60-P	40,500	5/25
61463624530	W188	1/2 x 1-1/2	1/4	38A60-P	31,070	5/25
61463624531	W189	1/2 x 2	1/4	38A60-P	26,830	5/25
61463624539	W196	5/8 x 1	1/4	38A60-P	34,670	5/25
61463624543	W200	3/4 x 1/8	1/8	38A60-P	50,930	5/25
61463624544	W200	3/4 x 1/8	1/8	38A90-Q	50,930	5/25
61463624549	W204	3/4 x 3/4	1/4	38A60-P	36,510	5/25
61463624550	W205	3/4 x 1	1/4	38A60-P	32,950	5/25
61463624553	W208	3/4 x 2	1/4	38A60-P	22,830	5/25
61463624560	W215	1 x 1/8	1/8	38A60-P	38,200	5/25
61463624562	W216	1 x 1/4	1/4	38A60-P	38,200	5/25
61463624564	W218	1 x 1/2	1/4	38A60-P	37,890	5/25
61463624566	W220	1 x 1	1/4	38A60-P	30,370	5/25
61463624567	W221	1 x 1-1/2	1/4	38A60-P	24,490	5/25
61463624569	W222	1 x 2	1/4	38A60-P	20,250	5/25
61463624578	W230	1-1/4 x 1-1/4	1/4	38A60-P	25,200	5/25
61463624583	W235	1-1/2 x 1/4	1/4	38A60-P	25,460	5/25
61463624585	W236	1-1/2 x 1/2	1/4	38A60-P	25,460	5/25
61463624587	W237	1-1/2 x 1	1/4	38A60-P	25,460	5/25
61463624588	W238	1-1/2 x 1-1/2	1/4	38A60-P	20,720	5/25
61463624592	W242	2 x 1	1/4	38A60-P	19,100	5/25

Shank length is 1-1/2".

Maximum operating speed based on 1/2" overhang.

Abrasive Benchstones

Features

- Sharp, silicon carbide abrasive
- Aluminum oxide abrasive
- Arkansas natural ozark quartz
- Vitrified bond

Benefits

- Enhanced cutting action
- Fast stock removal
- Fast, cool cutting action
- Maintains high part tolerance
- High finishes
- Excellent conformability
- Long life and excellent form holding



SINGLE GRIT STONE



COMBINATION GRIT STONE

Single Grit Benchstones:

Aluminum oxide benchstones are used to provide sharp edges and quality finishes, clean and deburr.

Arkansas natural benchstones are made of natural novaculite, quarried in Arkansas. Natural stones provide the sharpest edges and near-mirror finishes. Use for fine honing after India stone.

Combination Grit Benchstones:

Silicon carbide combination benchstones have both coarse and fine grit silicon carbide surfaces. These fast-cutting stones are used to sharpen edges on tools to moderate tolerances quickly. Dark gray in color.

Aluminum oxide combination benchstones have both coarse and fine grit aluminum oxide abrasive surfaces to produce strong, keen, long-lasting edges on quality tools. Orange/brown in color.

Crystolon/India combination benchstones have fast-sharpening, medium grit silicon carbide (Crystolon) and fine aluminum oxide (India) abrasive surfaces for keen, long-lasting edges. Crystolon side is dark gray in color, India side is orange.

Oil Stone Instructional DVD:

Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life – to make all your sharpening, honing, etc. applications easier.

Sharpening Stone Oil:

Highly-refined lubricating oil specifically formulated for sharpening stone use, but equally ideal for all lubricating jobs. Meets U.S.A. Pharmacopoeia standards for mineral oil purity and may be used around food preparation operations.

PART NO.	SIZE	GRIT SIZE	PRODUCT NO.	QTY PKG/CASE
Single Grit Benchstones				
India (Aluminum Oxide)				
61463685580	4 x 1 x 1/4	Coarse	CB14	1/5
61463685575		Medium	MB14	
61463685570		Fine	FB14	
61463685595	4 x 1 x 1/2	Coarse	CB24	1/5
61463685590		Medium	MB24	
61463685585		Fine	FB24	
61463685605	5 x 2 x 5/8	Medium	MB35	1/5
61463685600		Fine	FB35	
61463685620	6 x 2 x 1	Coarse	CB6	1/5
61463685615		Medium	MB6	
61463685610		Fine	FB6	
61463685635	8 x 2 x 1	Coarse	CB8	1/5
61463685630		Medium	MB8	
61463685625		Fine	FB8	



PART NO.	SIZE	GRIT SIZE	PRODUCT NO.	QTY PKG/CASE
Single Grit Benchstones (continued)				
Hard Translucent Arkansas				
61463685655	4 x 2 x 3/4-1	Ultra Fine	HB4	1/5
61463685660	6 x 2 x 3/4-1	Ultra Fine	HB6	1/5
61463685665	8 x 2 x 3/4-1	Ultra Fine	HB8	1/5
Soft Arkansas				
61463687560	3 x 1 x 3/8	Extra Fine	SB13	5/10
61463685670	4 x 2 x 3/4-1	Extra Fine	SB4	1/5
61463685675	6 x 2 x 3/4-1	Extra Fine	SB6	1/5
61463685680	8 x 2 x 3/4-1	Extra Fine	SB8	1/5
Combination Grit Benchstones				
Crystolon (Silicon Carbide)				
61463685435	4 x 1 Round	Coarse/Fine	JB64	1/5
61463685440	4 x 1-3/4 x 5/8	Coarse/Fine	JB134	1/5
61463685445	5 x 2 x 3/4	Coarse/Fine	JB45	1/5
61463685450	6 x 2 x 1 with Anniversary Box	Coarse/Fine	JB6	1/5
61463685455	8 x 2 x 1 with Anniversary Box	Coarse/Fine	JB8	1/5
61463685840	11-1/2 x 2-1/2 x 1	Coarse/Fine	JUM3	1/2
61463685855	12 x 2-1/2 x 1-1/2	Coarse/Fine	JUM4	1/2
India (Aluminum Oxide)				
61463685545	4 x 1 Round	Coarse/Fine	IB64	1/5
61463685550	4 x 1-3/4 x 5/8	Coarse/Fine	IB134	1/5
61463685555	5 x 2 x 3/4	Coarse/Fine	IB45	1/5
61463685560	6 x 2 x 1 with Anniversary Box	Coarse/Fine	IB6	1/5
61463685565	8 x 2 x 1 with Anniversary Box	Coarse/Fine	IB8	1/5
61463685851	11-1/2 x 2-1/2 x 1	Coarse/Fine	IM2	1/2
Crystolon/India				
61463685643	6 x 2 x 1	Medium/Fine	IC6	1/5
61463687239	11-1/2 x 2 x 1	Medium/Fine	IC11	1/2
Oil Stone Instructional DVD				
07660787945	Oil Stone DVD			1/1
Sharpening Stone Oil				
61463687760	4-1/2 Ounces	Oil	XB1	1/20
61463687770	1 Pint	Oil	XB5	1/20
61463687775	1 Quart	Oil	XB2	1/5

Sticks and Stones

Waterstones

Features

Waterstones

- System of four synthetic "Japanese-type" stones designed to work together, with water
- Softer than traditional oilstones – providing lapping action

Prep Stone

- Synthetic stone raises the slurry

Flattening Stone

- Coarse grit silicon carbide stone
- Diagonal grooves
- Superbly flat with hard bond

Benefits

- Fast sharpening, fine finish

- Superb results with low pressure

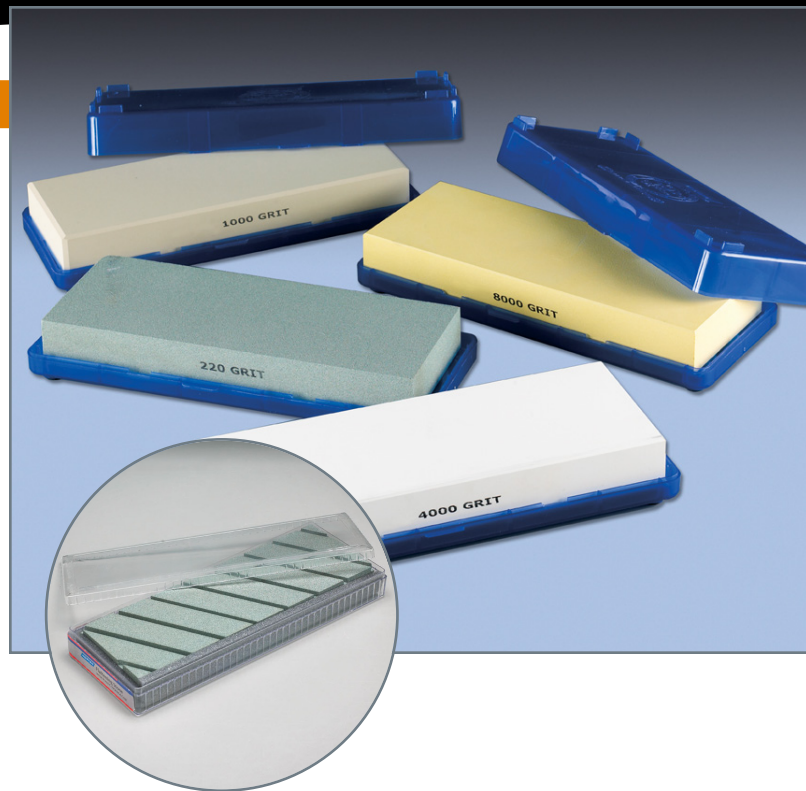
- Speeds up the slurry-making process needed to cut and polish with waterstones

- Promotes maximum cutting for all grit sizes of waterstones
- Provide swarf removal

- Produces extremely flat results on all waterstones

The waterstone system was designed in a carefully planned sequence to create sharpening efficiency.

PART NO.	SIZE	GRADING	QTY PKG/CASE
Waterstones			
Combination Grit (Bulk-packed)			
61463624335	8 x 3 x 1	220 / 1000	1/5
61463624450		1000 / 4000	
69936655039		1000 / 8000	
61463624336		4000 / 8000	
Prep Stone			
66243439361	20mm x 20mm x 3"	Aluminum Oxide	1/5
Flattening Stone			
69936687444	9 x 3 x 3/4	Silicon Carbide	1/5
Waterstone Instructional DVD			
07660787944		Waterstone DVD	1/1



TechTip

MAXIMIZE WATERSTONE PERFORMANCE

- Wet waterstone
- Rub evenly with the prep stone to create slurry
- Evening off the high spots will make for less-frequent flattening of the waterstones
- Waterstones wear concave with use; periodically flatten with flattening stone



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

Diamond Benchstones

Features

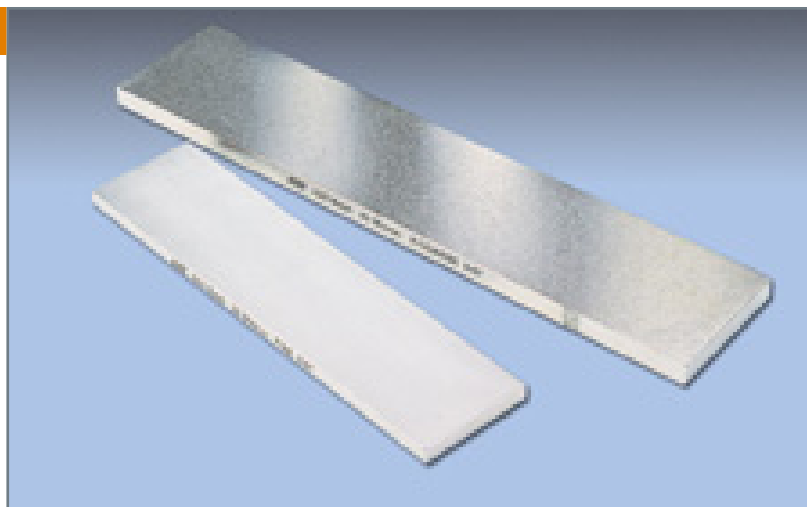
- Single, solid, monocrystalline diamonds
- Diamond abrasive with a nickel bond on a core of solid steel

Benefits

- Fastest cut
- Longest life
- Wear-resistant, unbreakable
- Will not groove, cup, or hollow
- Holds tolerance of $\pm .002$ "

Typical applications include initial sharpening procedures, rapid stock removal, sharpening any hard material including carbide, tool and knife repair, deburring, filing and abrading. Used with water, although oil may be used.

PART NO.	SIZE	GRID SIZE PKG/CASE	QTY
Diamond Benchstones			
61463690633	6 x 2 x 1/4	325	1/5
61463690634		600	
61463690636	8 x 2 x 1/4	220	1/5
61463690638		600	
61463690639		1200	



See the new Saint-Gobain Abrasives Professional Sharpening Products and Dressing Sticks catalog #200 to view the complete list and descriptions of our many sharpening products.

Dressing and Finishing Sticks

Features

- Aluminum oxide abrasive – white
- Silicon carbide abrasive – black
- Norbide and boron carbide – black
- Vitrified bond

Benefits

- Free dressing action
- Sharp, durable
- Hard, durable and wear-resistant
- Excellent conformability



SQUARE

Aluminum oxide dressing sticks work best on CBN grinding wheels, but can also be used on diamond grinding wheels.

Silicon carbide dressing sticks in coarse grit sizes and hard grades are used for dressing conventional

vitrified wheels. Silicon carbide dressing sticks in fine grit sizes and softer grades are used for dressing diamond wheels.

Norbide and boron carbide dressing sticks are used to dress medium grit/soft and medium grade conventional abrasive vitrified grinding wheels.



PART NO.	SIZE THICKNESS X WIDTH X LENGTH	GRADING	STICKS/BOX
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Dressing Sticks

High Performance Long Life

61463629472	1/4 x 1/2 x 3	Boron Carbide Stick	5
61463610148	1/4 x 1/2 x 3	Norbide Stick BEST	5

Aluminum Oxide

61463610555	1/2 x 1/2 x 4	38A220-HVBE	5
61463610303	1/2 x 1/2 x 6	38A150-IVBE	5
61463610103 B		38A220-HVBE	
61463610415	1/2 x 3/4 x 4	38A60-LVBE	5
61463610440	3/4 x 3/4 x 4	38A60-LVBE	5
61463610362		38A80-MVBE	
61463610291		38A150-HVBE	
61463610368		38A150-IVBE	
61463610290		38A220-HVBE	
61463610280	3/4 x 3/4 x 8	38A220-HVBE	5
61463610405	1 x 1 x 6	38A150-HVBE	5
61463610453		38A150-IVBE	
61463610406 B		38A220-HVBE	
61463610390	1 x 1 x 8	38A120-IVBE	5
61463610455		38A150-IVBE	

B = Best Seller

PART NO.	SIZE	GRADING	STICKS/BOX
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Dressing Sticks

Silicon Carbide

61463610201	1/2 x 1/2 x 6	37C100-LV	5
61463610205		37C150-KV	
61463610206		37C150-LV	
61463610207		37C150-MV	
61463610214		37C220-KV	
61463610375	3/4 x 3/4 x 6	37C150-LV	5
61463610459	1 x 1 x 6	37C20-SVK	5
61463610462		37C24-SVK	
61463610354		37C24-TVK	
61463610466		37C46-RVK	
61463610393		37C80-NV	
61463610438		37C150-KV	
61463610398		37C220-KV	
07660710466	1 x 1 x 6	S/C Medium Grit	5
Retail Carded			
61463610469	1 x 1 x 8	37C20-SVK	5
61463610471		37C24-SVK	
61463610482	1 x 2 x 8	37C16-TVK	5
61463610485		37C24-TVK	
61463610490	2 x 2 x 8	37C24-SVK	5

Spec Check

Selecting the appropriate dressing stick for each application depends on the wheel size, type, speed, specification, and grit size, as well as the workpiece material. Initial starting specifications are listed below. We recommend testing several sticks to find the best one for your application.

- For Resin Bond Diamond and CBN Wheels: Choose a dressing stick one or two grit sizes finer than the abrasive in the wheel – in a soft grade (H or I).

STARTING RECOMMENDATIONS FOR DRESSING WHEELS

SUPERABRASIVE WHEELS	VITRIFIED STICK SPECIFICATION
RESIN BOND	
- 100 AND 120 GRIT	38A150-HVBE
- 150 AND 220 GRIT	38A220-HVBE
CONVENTIONAL VITRIFIED BOND WHEELS	
- 46 GRIT AND FINER AND M GRADE AND SOFTER	37C24-SVK



Wheel Symbols and Markings

Carborundum abrasive wheels are marked according to the system which is standard throughout the industry. This standard marking system consists of six positions. The characters in each position denote a specific characteristic of the wheel.

Bonded Abrasive Terminology Key

Position 1 AA ABRASIVE	Position 2 46 GRIT SIZE			Position 3 K GRADE	Position 4 8 STRUCTURE	Position 5 V BOND TYPE	Position 6 40 BOND MODIFICATION
MEDALIST - BLUE CERAMIC ALUMINA	COARSE	MEDIUM	FINE	E - SOFT	1 - DENSE	V - VITRIFIED	40
MEDALIST R - PURPLE CERAMIC ALUMINA	14	46	220	F	2	B - RESINOID	P = Porous
MZ - CERAMIC ALUMINA/ZA BLEND	16	54	240	G	3	RR - RUBBER	
32AR - GREY/PURPLE ALUMINUM OXIDE	20	60	280	H	4		
38A - ALUMINUM OXIDE	24	70	320	I	5		
A - ALUMINUM OXIDE	30	80	400	J	6		
AA - WHITE ALUMINUM OXIDE	36	100	600	K	8		
AR - RUBY ALUMINUM OXIDE		120	800	L	9		
AZ - ZA/AO BLEND		150	900	M	10		
BA - ALUMINUM OXIDE				N	11		
DA - GREY ALUMINUM OXIDE BLEND				O	12		
GA - ALUMINUM OXIDE				P			
GRA - GA/RA BLEND				Q			
PA - PINK ALUMINUM OXIDE				R			
RA - PINK/PURPLE ALUMINUM OXIDE				S			
RGA - ALUMINUM OXIDE				T			
37C - BLACK SILICON CARBIDE				U			
C - BLACK SILICON CARBIDE				V			
CA - BLACK SILICON CARBIDE							
CGA - ALUMINUM OXIDE/SILICON CARBIDE BLEND							
DAC - ALUMINUM OXIDE/SILICON CARBIDE BLEND							
GC - GREEN SILICON CARBIDE							
Z - ZIRCONIA ALUMINA							
AZA - ZA/AO BLEND							
ZA - ZA/AO BLEND							
2ZA - ZA/GA BLEND							
2ZC - ZA/C BLEND							
3AZA - ZIRCONIA ALUMINA/ALUMINUM OXIDE BLEND							
3ZA - ZIRCONIA ALUMINA/ALUMINUM OXIDE BLEND							
NORZON - PREMIUM ZIRCONIA ALUMINA							
PR - ZIRCONIA ALUMINA							
CHARGER - ZIRCONIA ALUMINA							



Wheel Speeds - Conversion Table

Example: Find the machine RPMs. This should be written on the machine itself. For this example, assume that the machine RPM is 1,773 and that the wheel diameter is 14".

- Find the diameter of 14" in either the left-most or right-most column of the chart.
- Follow the row horizontally to RPM of 1,773 as this is the spindle speed of the machine.
- Follow column directly upwards to find SFPM of 6,500.

WHEEL	SURFACE SPEED IN FEET PER MINUTE (SFPM)																WHEEL
	4,000	4,500	5,000	5,500	6,000	6,500	7,000	7,500	8,000	8,500	9,000	9,500	10,000	12,000	12,500	14,200	
1"	15,279	17,189	19,098	21,008	22,918	24,828	26,737	30,558	32,467	34,377	36,287	38,196	45,836	47,745	54,240	61,116	1"
2"	7,639	8,594	9,549	10,504	11,459	12,414	13,368	15,278	16,238	17,188	18,143	19,098	22,918	23,875	27,120	30,558	2"
3"	5,093	5,729	6,366	7,003	7,639	8,276	8,913	10,186	10,822	11,459	12,096	12,732	15,278	15,915	18,080	20,372	3"
4"	3,820	4,297	4,775	5,252	5,729	6,207	6,685	7,162	7,640	8,116	8,595	9,072	9,549	11,459	11,940	13,560	4"
5"	3,056	3,438	3,820	4,202	4,584	4,966	5,348	5,720	6,112	6,494	6,876	7,258	7,640	9,168	9,550	10,850	5"
6"	2,546	2,865	3,183	3,501	3,820	4,138	4,456	4,775	5,092	5,411	5,729	6,048	6,366	7,639	7,960	9,040	6"
7"	2,183	2,455	2,728	3,001	3,274	3,547	3,820	4,092	4,366	4,638	4,911	5,183	5,456	6,548	6,820	7,750	7"
8"	1,910	2,148	2,387	2,626	2,865	3,103	3,342	3,580	3,820	4,058	4,297	4,535	4,775	5,729	5,970	6,780	8"
9"	1,698	1,910	2,122	2,334	2,546	2,758	2,970	3,182	3,396	3,606	3,820	4,032	4,244	5,092	5,305	6,030	9"
10"	1,528	1,719	1,910	2,101	2,292	2,483	2,674	2,865	3,056	3,247	3,438	3,629	3,820	4,584	4,775	5,425	10"
12"	1,273	1,432	1,591	1,751	1,910	2,069	2,228	2,386	2,546	2,705	2,864	3,023	3,183	3,820	3,980	4,520	12"
14"	1,091	1,228	1,364	1,500	1,637	1,773	1,910	2,046	2,182	2,319	2,455	2,592	2,728	3,274	3,410	3,875	14"
16"	955	1,074	1,194	1,313	1,432	1,552	1,672	1,791	1,910	2,029	2,149	2,268	2,387	2,865	2,985	3,390	16"
18"	849	955	1,061	1,167	1,273	1,379	1,485	1,591	1,698	1,803	1,910	2,016	2,120	2,546	2,655	3,015	18"
20"	764	859	955	1,050	1,146	1,241	1,337	1,432	1,528	1,623	1,719	1,814	1,910	2,292	2,390	2,715	20"
22"	694	781	868	955	1,042	1,128	1,215	1,303	1,388	1,476	1,562	1,649	1,736	2,084	2,170	2,465	22"
24"	637	716	796	875	955	1,034	1,115	1,194	1,274	1,353	1,433	1,512	1,591	1,910	1,990	2,260	24"
26"	588	661	734	808	881	955	1,028	1,101	1,176	1,248	1,322	1,395	1,468	1,762	1,840	2,090	26"
28"	546	614	682	750	818	887	955	1,023	1,092	1,159	1,228	1,296	1,364	1,637	1,705	1,940	28"
30"	509	573	637	700	764	828	891	955	1,018	1,082	1,146	1,210	1,274	1,528	1,595	1,810	30"

Note: The calculated RPM figures listed above are rounded off to the next higher 5 for wheel marking purposes. For intermediate diameters not listed, use the formula listed in Section 1,2,10 of ANSI B7.1 (SFPM = .262 x wheel diameter in inches x RPM) Note: SFPM ÷ 196.85 = m/s (meters per second)

Abrasive Grains

The abrasive grains (ceramic alumina, zirconia alumina, aluminum oxide and silicon carbide) perform the cutting action. An ideal grinding abrasive has the ability to fracture before serious dulling occurs and offers maximum resistance to point wear. Each abrasive has special crystal structure and fracture characteristics, making it suitable for grinding operations on specific materials.

Medalist - Ceramic Alumina

A superior performing grain for high temperature alloys such as Inconel, Waspalloy and Haspalloy, hardened tool steels, spray metal or Stellite and other hardened steels.

Zirconia Alumina

A tough, sharp abrasive designed for optimum performance in cut-off wheels, snagging wheels and depressed center wheels for grinding or cutting cast steel, alloy steel, and malleable and ductile iron.

Aluminum Oxide

A tough, sharp grain produced under controlled conditions and especially adapted to grinding or cutting materials of high tensile strength, such as alloy steel, high speed steel, annealed, malleable iron, and tough bronze.

Silicon Carbide

This is a very hard, sharp abrasive grain used in the grinding of tungsten carbide and low tensile strength materials such as cast iron, bronze, aluminum, copper, and non-metallic materials such as plastics, glass, marble, granite and stone.



Grade

The grade is the strength of bonding of a grinding wheel, and is frequently referred to as its hardness. The higher the letter designation, the stronger the bond.

Wheel Structures

Wheel structures (the spacing between grain particles) range from open to dense and vary with different grinding operations, depending upon the area of contact and type of material being ground, rate of stock removal and finish required. Carborundum offers standard structure wheels that will perform well on a wide range of materials.

Bonds

The purpose of the bonding material is to hold the abrasive grain particles together.

Vitrified Bonds

Vitrified wheels have a glass bond composition. Vitrified wheels hold form extremely well and produce a high ratio of stock removal to wheel use. Vitrified wheels are commonly used for precision grinding in the tool and die market.

Porosity

Vitrified wheels can be manufactured with induced porosity. All vitrified bonds that end in P (VLP, V40P, VPP) indicate induced porosity. This porosity allows excellent coolant flow and chip clearance. For materials that load or for wide surface area contact, this provides a cooler cutting action, less loading and less chance of burn on the workpiece.

Resinoid Bonds

Resinoid, or organic compound, bonds are more shock resistant than vitrified bonds and are generally operated at higher peripheral speeds. Most resinoid bond wheels are used for fast stock removal in the metal fabrication and foundry markets.

Procedures for Proper Handling and Storage of Bonded Abrasive Products

Handling

All grinding wheels are relatively fragile and must be handled with care. This applies to all types of bonds: vitrified, resinoid and rubber.

Do:

- Inspect all wheels upon receipt.
- Use pallets or trucks to transport.
- Support firmly at all times.
- Place wheels carefully in racks.

Do Not:

- Leave wheels packed in absorbent material.
- Roll wheels on floor.
- Lean wheel against equipment.
- Place tools or parts on top of wheels.

Storage

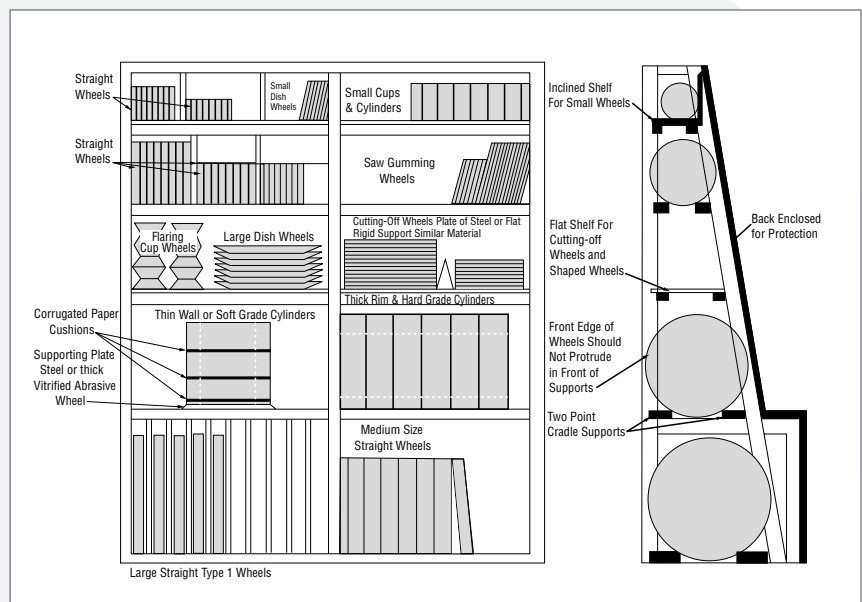
Suitable racks, cradles and drawers should be provided to store the various types of wheels used.

Do:

- Store wheels correctly supported.
- Stack thin wheels flat.
- Ensure storage in dry conditions.

Do Not:

- Store in damp or humid conditions.
- Subject wheels to dramatic change in temperature.
- Subject wheels to temperatures at or approaching freezing.



THIS DRAWING ILLUSTRATES A RACK DESIGN WHICH IS SUITABLE FOR SAFELY STORING A WIDE VARIETY OF ABRASIVE WHEELS.



The knowledgeable, Amplex Customer Service Teams are always available to help you with any product and application questions, quotes, etc.

USA: Worcester, MA | Phone: 1-800-635-1992 | Fax: 1-800-242-1468

Canada: Hamilton, ON | Phone: 1-800-263-6565 | Fax: 1-800-561-0490

■ Stock, altered-from-stock and made-to-order diamond and CBN products for all your superabrasive needs are available from Amplex. Call your local Carborundum/Amplex Distributor for an Amplex catalog (form #A100) or visit www.amplexabrasives.com.

Electroplated Diamond and CBN Products



- Contour Tools
- Drills
- Files
- Honers
- Mounted Points
- Routers
- Saw Blades
- Wheels

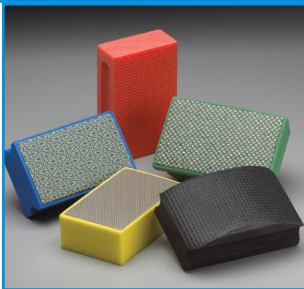
Diamond Compounds



Excellent for polishing and other applications that require mirror finishes and close tolerance performance.

- Oil-Soluble Diamond Compounds
- Water-Soluble Diamond Compounds

Flexible Hand Pads



For shaping, rapid stock removal, touch-up and repair, and polishing.

Flexible Discs



Designed specifically for grinding glass, ceramics, composites, reinforced plastics, fiberglass, carbide and other tough metals and coatings.

- PSA Discs
- Flex-Loc TR Discs

Resinoid Bond Diamond and CBN Wheels



The choice for tool and die applications.

- Three performance/price tiers of Diamond and CBN resinoid bond wheels

Metal Bond Diamond Wheels



Ideal for use on hard, brittle materials such as glass, ceramics and other non-metallics.

Diamond Dressing Tools and Truing Devices



To maximize the performance of all your grinding wheels.

- Single Point Dressing Tools
- Multi-Point Dressing Tools
- Specialty Dressing Tools
- Brake-Controlled Truing Devices

Part Number-to-Page Number Cross Reference

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05539500694	68	05539504701	48	05539509145	71	05539509581	87	05539509927	89	05539510540	13	05539510719	23
05539501900	80	05539504702	48	05539509149	71	05539509582	87	05539509928	89	05539510542	13	05539510720	23
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Saint-Gobain Abrasives Trademarks

Abrasotex®	Dri-Lube®	Flex-Loc™	Merit®	Stick-On™
Amplex®	Edger™	Gold™	PowerLock®	Surface Finish™
Carbo Cool®	EZ Touch™	GoldCut™	Premier™	Surface Strip™
Carbo-Cut™	E-ZView™	Gold MaXX™	Premier Red™	and others
Carbo Gold™	Fat Boy™	Grip-On®	Premier RedCut™	
Carborundum logo®	Fibratex®	Medalist®	ShurStik™	

Product Warranty

WARRANTY – Carborundum warrants the products in this catalog to be free from defects in material or workmanship for a period of one year from the date of purchase. Carborundum's sole obligation under this warranty shall be to repair or replace, at Carborundum's option, any product which is non-conforming provided any such product failure was not caused by a subsequent modification of the product, misuse or a failure to follow any applicable instructions for the product.

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Product Quality Complaints

All product quality complaints should be submitted to your local Carborundum Distributor.

Liability Limitation

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Safety – It's the Smart Thing to Do

Safe operating practices must be part of every grinding wheel user's operation.

- 1 Be sure to read any safety material/guidelines provided with the abrasive product.
- 2 Always check the wheel for cracks or damage before use.
- 3 Before mounting the wheel, use a tachometer to measure the spindle speed. Wheel speeds should never exceed the maximum speed shown on the wheel or package.
- 4 Ensure the mounting flanges, backplate or adapter supplied by the machine manufacturer are properly used and kept in good condition. ANSI Safety Requirement B7.1 provides wheel mounting requirements. Check mounting flanges for equal and correct diameter and use blotters when supplied.
- 5 Always mount, true and dress the wheel in compliance with the guidelines published in the ANSI Safety Requirements B7.1.
- 6 Ensure the correct wheel guard is in place before starting the wheel. Allow the wheel to come up to full operating speed for a minimum of 1 minute before starting to grind. Stand out of the plane of rotation.
- 7 NEVER use a high speed air sander as a portable grinder.
- 8 Never use a grinding wheel with a rated speed less than the grinder.
- 9 NEVER exceed the maximum operating speed marked on the wheel being used. The following formula may be used to convert wheel speed from RPM to SFPM.

SFPM = Spindle Speed in RPM x Wheel Dia. in inches x .262
(or refer to the Wheel Speeds Conversion Table, where applicable, in Bonded Abrasives Basics, page 102.)

- 10 When not using the wheel, store the wheel in its original packing materials and avoid dropping or bumping the wheel. This protects the wheel from chips and cracking, as well as provides easy identification of the wheel.

To obtain the maximum performance of the wheel, your operating procedures must include the care of the wheel both before and after its actual use. The greatest efficiency and lowest overall abrasive cost can be realized only if proven care and use techniques become standard practice.



WARNING

This warning icon appears on our products and packaging. It is intended to draw your attention to the specific safety warning practices outlined after it.

For more information on product safety, ask your Carborundum Abrasives distributor for these publications:

- "Play it Safe at the Wheel" pamphlet CA8900, and "Safety, It's the Smart Thing to Do" DVD
- ANSI Standard B7.1 Safety Requirements for the Use, Care and Protection of Abrasives Wheels
- ANSI Standard B7.7 Safety Requirements for Abrading Materials with Coated Abrasive Systems

For additional safety information, visit our website at www.carborundumabrasives.com



Face Protection

Always wear government-approved face and eye protection when using abrasive products.



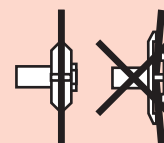
Safety Gloves

Grinding applications are conducted in harsh environments. The use of proper fitting gloves is recommended.



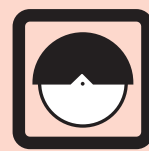
Hearing Protection

Use of abrasive products may create elevated sound levels. Hearing protection must be worn where required.



Flanges

When mounting most grinding wheels, use flanges of equal diameter and bearing surface. For exceptions, see ANSI B7.1.



Wheel Guard

Always use the wheel guard as supplied by the machine manufacturer, in the proper position.



Speeds

Check machine spindle speed and speed listed on machine against safe maximum operating speed marked on the grinding wheel. Do not overspeed the wheel.



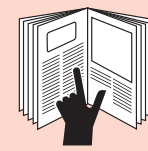
Dust Protection

Exposure to dust generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury.

Use dust capture or local exhaust as stated in the MSDS. Wear government-approved respiratory protection and eye and skin protection.

Failure to follow this warning can result in serious lung damage and/or physical injury.

This is a general dust warning and does not cover specific situations. For more information, refer to the MSDS dust warning provided with your products, and workpiece.



Safety Guides, MSDS & Wheel Warning Messages

Before using any abrasive materials, READ:

- The Safety Guides
 - Wheel Warning Messages and
 - Material Safety Data Sheets (MSDS)
- Carborundum provides information pertaining to the safe use of all products. Please take the time to read it carefully. Contact suppliers of the workpiece and abrasive materials for copies of the MSDS if one is not readily available. Carborundum abrasives MSDS can be obtained on www.carborundumabrasives.com

SafetyTIPS

Depressed Center, Cut-off and Snagging Wheels

Do's

- Check all wheels for cracks or damage before use
- Check machine speed against established safe operating speed marked on the wheel
- Always use the guard furnished with machine
- Run wheel in a protected area for one minute at operating speed before grinding

Don'ts

- Don't use wheels that have been dropped or otherwise damaged
- Don't use heavy side pressure on any thin Type 01 cut-off wheel or Type 27 thin depressed center wheel
- Never use a grinding wheel with a rated speed less than that of the grinder

Proper Grinding Wheel Operating Speeds and Safety!

As abrasive wheel producers have known for many years, most grinding wheel breakages and injuries are caused by one major oversight. That oversight is operating a grinding wheel in an over-speed condition. A grinding wheel should never be operated at speeds greater than the wheel's rated speed.

- Never mount grinding wheels on sanders (Pistol Grip Air Sanders)
- Never mount grinding wheels directly on electric motors
- Never mount grinding wheels on the wrong size machine for the grinding wheel
- Always properly maintain your machine: especially governors on pneumatic machines and linkage on floorstand machines
- Never use the incorrect air, hydraulic or electric power supply
- Never use the improper speed setting on a machine

Toolroom Wheels

Do's

- Check all wheels for cracks or damage before use
- Always use a safety guard and ensure work rest is properly adjusted on a bench grinder
- Always handle and store wheels in a careful manner
- Check mounting flanges for equal and correct diameter and use blotters when supplied
- Check machine speed against established safe operating speed marked on wheel

Don'ts

- Don't use a cracked wheel or one that has been dropped or damaged
- Don't exceed recommended operating speeds
- Don't tighten the mounting nut excessively
- Don't jam work into the wheel
- Do not sand wood, plastic or any other non-metallic material on benchstand pedestal grinders

A Deadly Equation

Pistol Grip Air Sander + Grinding Wheel = Certain Injury!

- Never use a high-speed air sander as a portable grinder
- Use only sanding discs specifically designed for sanders
- Because the speed of these sanders far exceeds the maximum rated speeds for grinding wheels, a potentially lethal wheel breakage might occur



Pistol Grip Air Sander



It is the user's responsibility to refer to and comply with ANSI B7.1 and B7.7

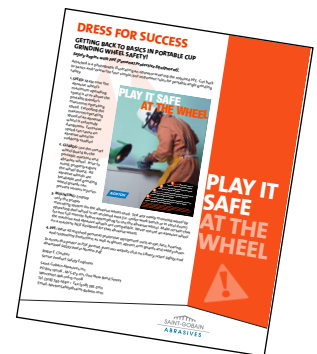


Call your local Distributor for our safety DVD:

"Safety, It's The Smart Thing To Do!"

Safety on the Web

As part of Saint-Gobain Abrasives' ongoing commitment to safety, each month a new safety article is published on the Carborundum website. Topics include proper abrasive storage, equipment maintenance, proper wheel mounting, using blotters, ring testing a grinding wheel, wheel dressing and much more. Visit the Carborundum website at www.carborundumabrasives.com and check the "News" section for the newest article. Or click on "Safety" to review our archived safety articles.





CARBORUNDUM



Judge for Yourself

We are confident of the superior performance of Carborundum abrasive products. In-plant tests against other brands of abrasive products and other performance tiers of our products are invited. In-plant tests make it easy for you to make your own judgement of the time, labor, and money saving advantages of Carborundum abrasive products. You have nothing to lose and everything to gain by conducting an in-plant test...

The Carborundum No-Risk Test Policy

- 1 The test will be conducted in your own plant, on your machines and workpieces.
- 2 You may purchase a minimum quantity of product, and receive the quantity discount that would apply to your own normal order quantity.
- 3 If the product tested proves completely unsatisfactory, you will receive a full refund.
- 4 If the product tested performs at a lower level than the product presently used, you will receive an adjustment to make up the performance difference.
- 5 You are the final judge.

SAINT-GOBAIN IS COMMITTED TO BEING A COMMUNICATIONS AND ENVIRONMENTAL LEADER

24/7 Online Information

Along with an updated, easy-to-navigate look, the Norton web site continues to evolve in order to provide fuller content with enhanced product information and application solutions. Our goal is to tie our printed materials more closely with our electronic tools so that finding what you need is simple and productive. Our product search catalog will become more interactive with links to safety tips, MSDS sheets, photography, case histories, etc.

www.carborundumabrasives.com



Just like our product innovation, we are also dedicated to being a leader in green practices. As we transition to more electronic communications, our aim is to enhance the speed of information to you, allow you to print on demand just what you need, and give you more online tools to find the products and solutions for the application at hand.

More Innovation Higher Productivity



Grind and Finish with One Wheel

Premier Red Fat Boy Flap Discs

- XC 1176 Zirconia Aluminum
- More flaps stacked for thicker surface area providing 40% longer life than standard flap discs



Polish and Finish in One Step

Fibratex Surface Finish

- Non-woven depressed center wheels
- Polish while imparting final finishes on a variety of materials



Looking for a Proven Toolroom Wheel?

Look for the "B"

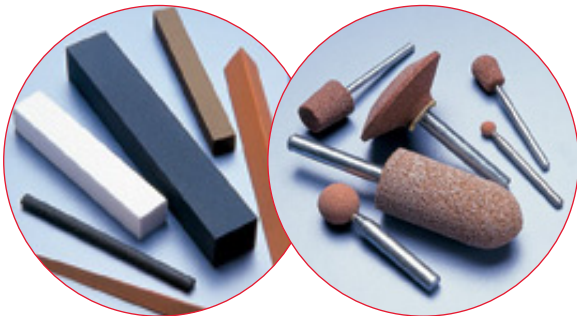
- Best Seller "B" indicator helps you make the perfect selection



Access to the Full Line of Merit Abrasive Products

The Industry's Specialty Leader

- Quick-Change PowerLock Discs
- ShurStick PSA cloth discs
- Abrasotex non-woven products
- Grind-O-Flex flap wheels, and more
- See Merit Abrasive Products Catalog M100, visit www.meritabrasives.com or ask your Carborundum/Merit distributor for more details



Access to Saint-Gobain Abrasives Sharpening Stones Catalog #200, and Stock Mounted Points

- Oil, water and diamond benchstones, dressing sticks and more
- Heavy-duty resin bond and vitrified precision mounted points

For more product information or to place an order, contact your local Carborundum distributor. Visit our web site: www.ind.carborundumabrasives.com



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