



CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING

The use of abrasives in secondary steel industries is vast; from ship building and production of domestic appliances, automotive and construction components, special profiles, pipes and electrical goods to maintenance and repair of equipment, tools and machines.

NORTON QUANTUM3 **INNOVATION** ULTRA THIN CUTTING DISCS



- Cutting performance taken to a new level in comfort, life and speed
- For precision, speed and the most accurate cut with reduced vibration levels, helping you to cut more comfortably for longer
- 1.3mm thickness is ideal for pipe cutting
- Ceramic grains give this wheel it's unique character. 1.0mm for ultimate speed and comfort. 1.6mm for absolute stability and longest life
- Delivers best in class performance on Steel and Stainless Steel



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.	
CUTTING DISCS							
	TYPE 41	115	1.0x22.23*	NQ 60 ZZ	25	66253371347	
				1.3x22.23*	NQ 60 ZZ	25	66253371348
				1.6x22.23*	NQ 46 ZZ	25	66253371349
		125	1.0x22.23*	NQ 60 ZZ	25	66253371350	
			1.3x22.23*	NQ 60 ZZ	25	66253371351	
			1.6x22.23*	NQ 46 ZZ	25	66253371352	
		180	1.6x22.23	NQ 46 ZZ	25	66253371354	
		230	1.9x22.23	NQ 46 ZZ	25	66253371355	
TYPE 42	115	0.8x22.23	NQ 60 ZZ	25	66252846642		
	125	0.8x22.23	NQ 60 ZZ	25	66252846643		



TUBS MADE FROM 100% RECYCLED PLASTIC.

* X-TEND included



AIRTIGHT PACKAGING
Stops atmosphere and weather elements eroding product performance

DESICCANT POUCH
Holds thousands of tiny pores that absorb and trap moisture in

X-TEND PERFORMANCE
is proven to be up to 40% better than standard packaging

NORTON QUANTUM3 CUTTING DISCS

INNOVATION



- Greater wheel thickness for a more robust cut
- Ceramic grain provides a fast, sharp cut time and time again
- Incomparable speed in rough cutting applications on black steel
- Ideal for large steel projects, shipyards, steel construction and general engineering



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
	TYPE 41 	125	2.0x22.23	NQ 36 Y	25	66252848856
		125	2.5x22.23	NQ 24 P	25	66252845954
		230	2.5x22.23	NQ 24 P	25	66252846173
	TYPE 42 	125	2.5x22.23	NQ 24 P	25	66252832258
		180	2.5x22.23	NQ 24 P	25	66252845041
		230	2.5x22.23	NQ 24 P	25	66252846174

SAINT-GOBAIN

MADE TO BITE

HOW WILL IT BENEFIT YOU?

**Norton
Zirconia Wheel**

**Norton Conventional
Ceramic Wheel**

**Norton Quantum3
Ceramic Wheel**

CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING



CUT THE CORD NOT THE POWER

At 3mm thickness, less energy is needed to power up and use the wheel. Get up to 50% longer battery life from cordless grinders.

NORTON QUANTUM3 LIGHT COMFORT GRINDING

INNOVATION



- Ideal for light grinding on thin walled workpieces
- Combines speed and precision in grinding, deburring and bevelling
- At 3mm thickness, less energy is needed to power up and use the wheel
- Self-sharpening ceramic grain technology for fast material removal resulting in less grinding time



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS	TYPE 27	115	3.0x22.23	NQ 30 S	10	66252846608
		125	3.0x22.23	NQ 30 S	10	66252846609



NORTON QUANTUM3 **INNOVATION**

GRINDING WHEELS



- Self-sharpening ceramic grain technology for high material removal and less grinding time
- More comfortable to use with reduced hand fatigue from less cutting vibration
- Longer wheel life means less downtime and waste, fewer wheels needed
- Offers true savings in grinding processes



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
 		115	7.0x22.23	NQ 24 P	10	66253371361
		125	7.0x22.23	NQ 24 P	10	66253371362
		125	7.0x22.23	NQ 24 N	10	66252839321



NORTON QUANTUM3 **INNOVATION**

HIGH FREQUENCY GRINDING WHEELS

- Optimised wheel for use on high frequency machines under high pressure, extra safe in all working conditions
- Self-sharpening ceramic grain technology for high material removal and less grinding time
- More comfortable to use with reduced hand fatigue from less cutting vibration
- Longer wheel life means less downtime and waste, fewer wheels needed



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
 		180	7.0x22.23	NQ 24 P	10	66253371364
		230	7.0x22.23	NQ 24 P	10	66253371365
		230	7.0x22.23	NQ 24 N	10	66252839322



HF
OPTIMISED FOR HIGH FREQUENCY ANGLE GRINDERS

High Frequency machines will not reduce in revolutions when grinding pressure is increased. When using high pressure on standard or non-reinforced wheels and machines, the risk of wheel breakage is high. Also, under low pressure, non-reinforced wheels can show cracks due to fatigue within the abrasive running at high revolutions. High Frequency reinforced grinding wheels ensure safe working conditions in all circumstances.

CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING

NORTON QUANTUM3



INNOVATION

COMBINATION WHEEL



- Fast grinding formula, gets the job done quickly
- Improved grinding control ensures precision and accuracy
- Easy access in hard to grind areas, corners and inside tight grooves
- Smoother feel, reduced fatigue and improved operator comfort
- Boost the amperage on cordless grinders due to light weight / fast cutting
- Ideal for pipe cutting





	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
COMBINATION WHEELS						
 		115	4.2x22.23	NQ 24 R	20	66253371356
		125	4.2x22.23	NQ 24 R	20	66253371357
		180	4.2x22.23	NQ 24 R	20	66253371359
		230	4.2x22.23	NQ 24 R	20	66253371360

X-TREME PRO HEAVY DUTY

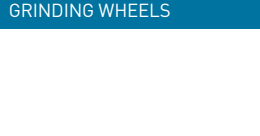

+++++

- Longest life reduces overall process cost, with more cuts per disc
- Fast, straight, clean and burr free cutting reduces the need for rework
- Choose Norton X-treme Pro for jobs that require that extra cutting performance



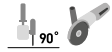
	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
CUTTING DISCS						
 		115	1.0x22.23	ZA60X	25	66252846978
		125	1.0x22.23	ZA60X	25	66252846979
			1.6x22.23	ZA46X	25	66252846980
			2.0x22.23	ZA36X	25	66252846981
		180	1.6x22.23	ZA46X	25	66252846983
		230	1.9x22.23	ZA46X	25	66252846984



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS						
 		125	4.2x22.23	A30V	20	66252846985
			7.0x22.23	A30V	10	66252846986
		180	4.2x22.23	A30V	20	66252846988
		230	7.0x22.23	A30V	10	66252846990

X-TREME **++++**

- High performance aluminium oxide grain for fast and high material removal
- Superior bond system holds the grain for long wheel life, resulting in less wheel erosion
- Ideal for heavy industrial use on all hard steel types and alloys



CORDLESS COMPATIBLE

METAL INOX

	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.	
CUTTING DISCS							
	TYPE 41	115	1.0x22.23	A 60 V	25	66252919427	
			1.6x22.23	A 46 V	25	66252920339	
			2.0x22.23	A 36 V	25	66252920340	
	125	TYPE 41	125	1.0x22.23	A 60 V	25	66252920341
				1.3x22.23	A 60 V	25	66252837992
				1.6x22.23	A 46 V	25	66252920342
				2.0x22.23	A 36 V	25	66252920343
				2.5x22.23	A 36 V	25	66252920350
	180	TYPE 41	180	1.6x22.23	A 46 V	25	66252920345
				2.0x22.23	A 36 V	25	66252920346
				2.5x22.23	A 36 V	25	66252920349
	230	TYPE 41	230	1.9x22.23	A 36 V	25	66252920348
				2.0x22.23	A 36 W	25	66252920360
				2.5x22.23	A 36 V	25	66252920349
	TYPE 42	115	115	2.5x22.23	A 36 V	25	66252921567
125				2.5x22.23	A 36 V	25	66252918816
				230	2.5x22.23	A 36 V	25



METAL INOX



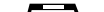
	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.	
GRINDING WHEELS							
	TYPE 27	115	7.0x22.23	A 24 R	10	66252918822	
			125	4.0x22.23	A 24 R	10	66252950672
				7.0x22.23	A 24 R	10	66252918823
			180	7.0x22.23	A 24 R	10	66252918824
			230	7.0x22.23	A 24 R	10	66252918825

CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING

VULCAN

- Great price versus performance ratio
- The general purpose range of cutting discs



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
CUTTING DISCS						
	TYPE 41 	115	1.0x22.23	A 60 S	25	66252925431
			1.6x22.23	A 46 S	25	66252925432
			2.0x22.23	A 30 S	25	66252925437
			2.5x22.23	A 30 S	25	66252925442
			3.0x22.23	A 30 S	25	66252925447
		125	1.0x22.23	A 60 S	25	66252925433
			1.6x22.23	A 46 S	25	66252925434
			2.0x22.23	A 30 S	25	66252925438
			2.5x22.23	A 30 S	25	66252925443
			3.0x22.23	A 30 S	25	66252925448
		180	1.6x22.23	A 46 S	25	66252925435
			2.0x22.23	A 30 S	25	66252925440
			2.5x22.23	A 30 S	25	66252925445
		230	1.9x22.23	A 46 S	25	66252925436
			2.0x22.23	A 30 S	25	66252925441
2.5x22.23			A 30 S	25	66252925446	
3.0x22.23			A 30 S	25	66252925450	
	100	3.2x22.23	A 30 S	25	66252835417*	
		115	2.5x22.23	A 30 S	25	66252925490
	TYPE 42 	125	3.2x22.23	A 30 S	25	66252925494
			2.5x22.23	A 30 S	25	66252925491
			3.2x22.23	A 30 S	25	66252925495
	180	2.5x22.23	A 30 S	25	66252925492	
		3.2x22.23	A 30 S	25	66252925497	
230	1.9x22.23	A 46 S	25	66252849388		
	2.5x22.23	A 30 S NEW	25	66252925493		
		3.2x22.23	A 30 S	25	66252925498	



* Made-to-order

VULCAN FAST CUT **++++**

- For use on low and medium power machines
- Hard steel types

METAL INOX 



GRINDING WHEELS		TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
	TYPE 27 		180	6.4x22.23	A 30 P	10	66252830805
			230	6.4x22.23	A 30 P	10	66252830807





CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING

NEW VULCAN COMFORT ADVANTAGE **++++**

- Improved comfort in use
- Reduced vibration
- Smoother wheel wear for reduced chipping
- Higher metal removal rates
- Suitable for low power machines
- Lower pressure needed, reduces operator fatigue
- Reduces workpiece burn





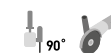
	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS						
	TYPE 27 	115	6.4x22.23	A 30 P	10	66252830803
		125	6.4x22.23	A 30 P	10	66252830804



VULCAN **++++**

- Great price versus performance ratio
- The general purpose range of grinding wheels





	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS						
	TYPE 27 	115	6.4x22.23	A 30 S	10	66252925522
		125	4.0x22.23	A 30 S	20	66252925519
			6.4x22.23	A 30 S	10	66252925523
		180	8.0x22.23	A 30 S	10	66252925524
			6.4x22.23	A 30 S	10	66252925526
		230	8.0x22.23	A 30 S	10	66252925527
			4.0x22.23	A 30 S	20	66252925521
				6.4x22.23	A 30 S	10



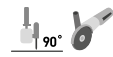
	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
CUTTING DISCS						
	TYPE 42 	115	3.2x22.23	C 30 R	25	66252925500
		125	3.2x22.23	C 30 R	25	66252925501
		230	3.2x22.23	C 30 R	25	66252925503



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS						
	TYPE 27 	115	6.4x22.23	C 30 R	10	66252925533
		125	6.4x22.23	C 30 R	10	66252925534
		180	6.4x22.23	C 30 R	10	66252925535
		230	6.4x22.23	C 30 R	10	66252925537

STARLINE

- Good material removal and cut rate
- For general trade and general usage



CUTTING DISCS - ANGLE GRINDER



TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
TYPE 41 	115	1.0x22.23	A 60 R	25	66252837243
		1.6x22.23	A 46 R	25	66252837244
		2.5x22.23	A 30 P	25	66252837249
	125	1.0x22.23	A 60 R	25	66252837245
		1.6x22.23	A 46 R	25	66252837246
		2.5x22.23	A 30 P	25	66252837250
	180	1.6x22.23	A 46 R	25	66252837247
		2.5x22.23	A 30 P	25	66252837251
	230	1.9x22.23	A 46 S	25	66252843278
2.0x22.23		A 36 R	25	66252837248	
2.5x22.23		A 30 P	25	66252837253	
TYPE 42 	115	3.2x22.23	A 30 P	25	66252837275
	125	3.2x22.23	A 30 P	25	66252837276
	180	3.0 x 22.23	A 30 S	25	66252837277
	230	3.2x22.23	A 30 P	25	66252837278



GRINDING WHEELS



TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
TYPE 27 	115	6.4x22.23	A 24 Q	10	66252837263
	125	6.4x22.23	A 24 Q	10	66252837264
	180	6.4x22.23	A 24 Q	10	66252837268
	230	6.4x22.23	A 24 Q	10	66252837269



ADAPTS TO ITS SURROUNDINGS

LCG
LIGHT COMFORT GRINDING

MULTI MATERIAL LIGHT COMFORT GRINDING

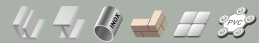


- Ceramic grain removes material quickly on a variety of different materials, one disc replaces many
- At 3mm thick, the lightweight wheel ensures precision and accuracy during grinding
- Easy access to hard to grind areas, corners and tight grooves
- Smoother feel, reduced fatigue and improved operator comfort

CORDLESS COMPATIBLE



ALU METAL INOX
STONE C.TILES PVC



TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.	
GRINDING WHEELS						
	TYPE 27	115	3.0x22.23	C 30 S	10	66252846610
		125	3.0x22.23	C 30 S	10	66252846611



CUT THE CORD NOT THE POWER

At 3mm thickness, less energy is needed to power up and use the wheel. Get up to 50% longer battery life from cordless grinders.

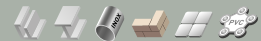
MULTI MATERIAL CUTTING

- One wheel for all materials
- The easy choice in general trade
- No lost time due to wheel changing
- Quick, comfortable and versatile

CORDLESS COMPATIBLE



ALU METAL INOX
STONE C.TILES PVC



TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.	
CUTTING DISCS						
	TYPE 41	115	1.0x22.23	C 60 T	25	66252833258
			1.6x22.23	C 46 T	25	66252828951
		125	1.0x22.23	C 60 T	25	66252918924
			1.6x22.23	C 46 T	25	66252828952
		180	1.6x22.23	C 46 T	25	66252926730
		230	1.9x22.23	C 46 T	25	66252918925





NORTON ALU

- Specially developed grain and bond system, designed to cut through aluminium and non-ferrous metals without clogging
- Counteracts loading and wheel glazing for fast, easy and free cutting action on all non-ferrous material



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
CUTTING DISCS						
	TYPE 41 	115 NEW	1.0x22.23	A 60 Q	25	66252828236**
			1.6x22.23	A 46 Q	25	66252828233
		125 NEW	1.0x22.23	A 60 Q	25	66252828237**
			1.6x22.23	A 46 N	25	66252839270
			1.6x22.23	A 46 Q	25	66252828234
			2.5x22.23	A 36 Q	25	66252828227
		180	2.5x22.23	A 36 Q	25	66252828229
		230	1.9x22.23	A 46 N	25	66252839271
			1.9x22.23	A 46 Q	25	66252828235
		TYPE 42 	230	3.0x22.23	A 36 Q	25



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
GRINDING WHEELS						
	TYPE 27 	115 NEW	7.0x22.23	A 36 Q	10	66252849497** **
		125 NEW	7.0x22.23	A 36 Q	10	66252828228**
		180	7.0x22.23	A 36 Q	10	66252828230
		230	7.0x22.23	A 36 Q	10	66252828232

* Made-to-order
** Up to +30% performance improvement

CUTTING DISCS & GRINDING WHEELS FOR METAL FABRICATION & WELDING

1-2-3

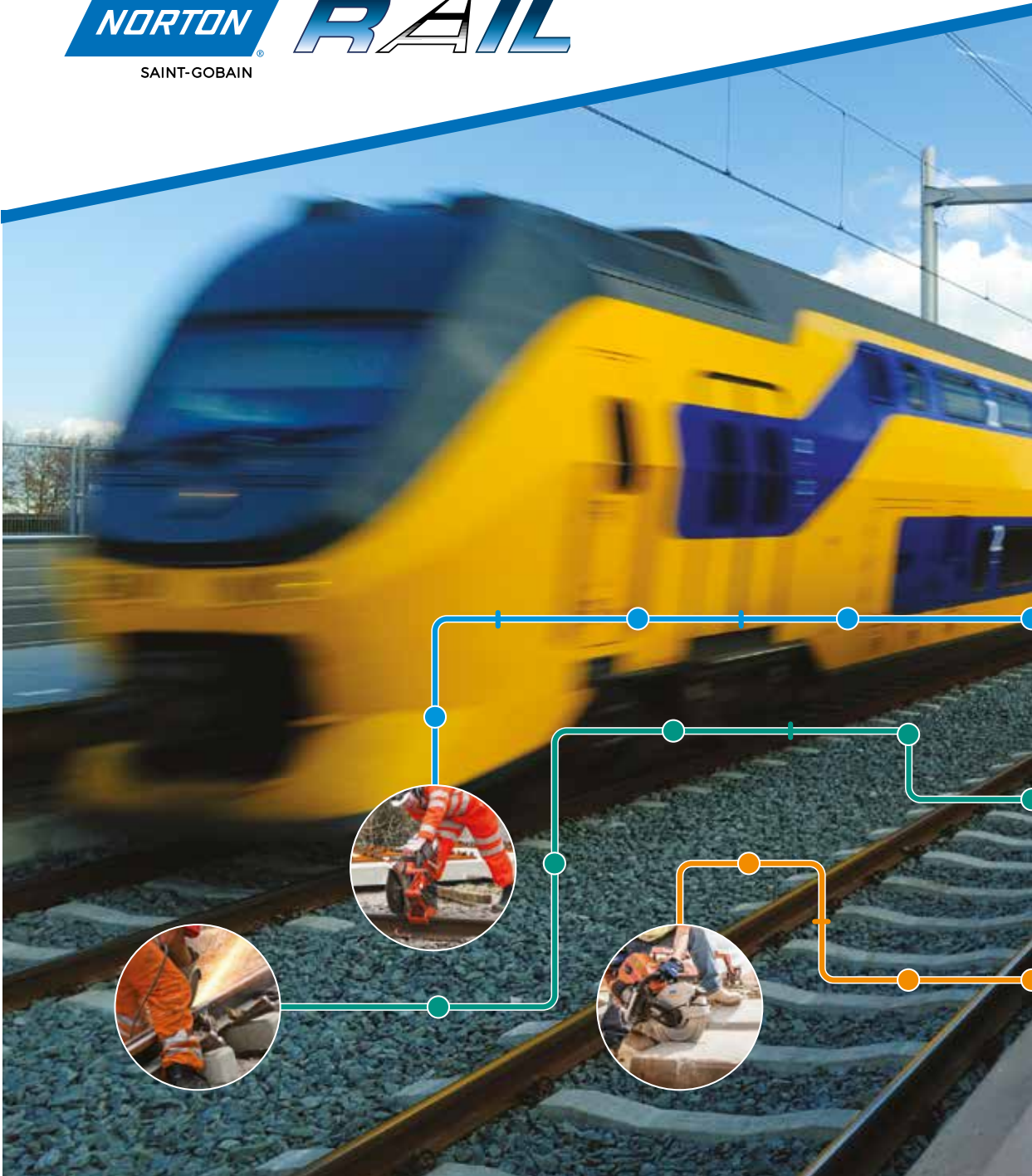
THE ALL IN ONE SOLUTION

- Cut, grind and finish with one wheel
- No lost time due to wheel changing
- Fine grit for a good, uniform finish when used at 15 degrees
- Three layers of reinforcement for maximum safety in use



TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
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COMBINATION WHEELS						
	TYPE 27	115	2.2x22.23	A 46 S	25	66252829704
		125	2.2x22.23	A 46 S	25	66252921592



CUTTING DISCS FOR RAIL

The Norton Rail range provides high performance wheels for demanding operations. Rail cutting requires precision, speed and power and Norton Rail is a complete program of cutting wheels suitable for any rail type (subway, tram, train) and any rail cutting machine with a clamping device (electrical and petrol).

AS RAIL TRACK TECHNOLOGY CONTINUES TO
MAKE MAJOR ADVANCES, NORTON IS GENERATING
POWERFUL, INNOVATIVE, USER-FRIENDLY SOLUTIONS
TO CUT, SHAPE AND GRIND HEAVY DUTY STEELS

CUTTING DISCS FOR RAIL

TECHNICAL INFORMATION

BF 41

FLAT CUTTING-OFF WHEELS

Rail cutting-off wheels are available in 300mm for clamped rail cutting machines that operate at 80m/s. For clamped rail cutting machines that operate on 100m/s wheels are available in 350mm and 400mm.

Bore dimensions of the cutting wheel can be adjusted using reduction rings that come with the original machine.

UNDERSTANDING THE PRODUCT

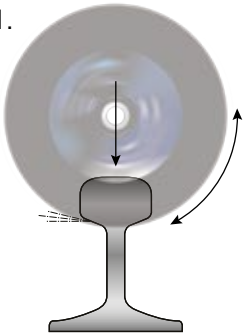
- 1 Product code
- 2 Application material
- 3 Diameter x Thickness x Hole
- 4 Product specification
- 5 Maximum peripheral speed
- 6 Machine cutting
- 7 Safety pictograms
- 8 OSA certification
- 9 EN standard



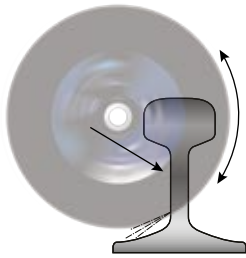
CUTTING-OFF

Arrange the workpiece so that a uniform section can be cut

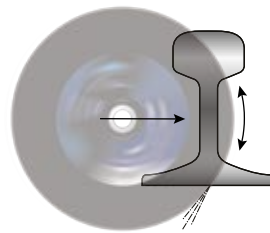
1.



2.



3.



KEY:

→
Direction of cut

↺
Oscillate the wheel, swing the machine for quickest and cleanest cut



NORTON QUANTUM3 RAIL

DESIGNED FOR COMFORT, BUILT TO LAST,
AND 'MADE TO BITE.'




NORTON QUANTUM3 RAIL **INNOVATION**



- Designed for comfort, built to last and 'made to bite'
- Long product life reduces the number of replacement discs, reducing total abrasive cost

- High speed cutting makes the overall rail repair process more efficient
- The wheel does the work and less vibrations are felt through the machine reducing the risk of white finger



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
	CUTTING DISCS					
	TYPE 41	356	4.0x22.23	NQ 24 Q	10	66252845405
			4.0x25.4	NQ 24 Q	10	66252845406
	406	4.0x25.4	NQ 24 Q	10	66252846183	

Don't just take our word for it, see what our customers have to say....

"The Norton Quantum3 really speeds up the cutting process - I can get through 3 cuts per wheel now, maybe even more, instead of struggling to get through one with the wheels I was using before. And it's not just that, it's much easier to use, kind of glides through the rail piece with ease. I'll definitely be switching over to Norton Quantum3"

**INNOVATION BOND
TECHNOLOGY**



**COMBINATION OF SHARP
PREMIUM ABRASIVE GRAINS**




**FAST CUTTING
LONGER LIFE**

CUTTING DISCS FOR RAIL

RAIL **++++**


- For a precise, straight and fast cut on rail, tram and subway track
- Low vibration, consistent performance throughout wheel life
- Hard, medium and soft wheels available
- High quality cut to help generate a perfect weld



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
	TYPE 41	356	4.0x25.4	ZA 24 Q Zirconia Medium	10	66252830924
		406	4.0x25.4	ZA 24 Q Zirconia Medium	10	66252833665

RAIL **++++**



	TYPE	DIA (mm)	TxB (mm)	SPEC	PK QTY	ART NO.
	TYPE 41	350	4.0x25.4	A 24 T Hard	10	66252829588
			4.0x25.4	A 24 P Soft	10	66252828620
			4.0x25.4	A 24 Q Medium	10	66252833554
		400	4.0x25.4	A 24 P Soft	10	66252919130





FIBRE DISCS FOR ANGLE GRINDERS

From rapid weld grinding to blending and finishing, Norton has a complete range of high performance fibre discs available in premium performance Norton SG ceramic aluminium oxide, zirconia alumina and aluminium oxide abrasives.

PRODUCT SELECTION GUIDE

Highly recommended ✓✓
Recommended ✓



MATERIALS	NEW NORTON RAZORSTAR®	NORTON QUANTUM F996	NEW BLAZE X F970X	NORZON F827	METAL F100
	<i>INNOVATION</i>	+++++	+++++	++++	+++
Stainless steel, inox	✓✓	✓✓	✓		
Titanium, inconel & super alloys	✓✓	✓✓	✓		
Carbon, construction & mild steel	✓✓	✓	✓✓	✓	✓
Cast iron	✓	✓	✓	✓	✓
Non-ferrous metal (brass/aluminium)	✓			✓	✓
Hardwood				✓	✓

NEW



UNBEATABLE GRINDING PERFORMANCE

NORTON RAZORSTAR® FIBRE DISCS
FEATURING ENGINEERED SHAPED
CERAMIC GRAIN



HIGHER CUT RATE



LONGER LIFE



COOLER CUT

SHARPER THAN EVER

NEW NORTON RAZORSTAR®

INNOVATION

- A breakthrough innovation of razor-sharp ceramic grain with a tough microstructure cuts faster and removes more material. This is combined with the highest percentage of grains applied to the backing in an upright position for razor-sharp cutting
- The sharp grain and top-size layer combine to significantly reduce heat generation, resulting in less thermal damage of the workpiece
- Unique, patented grain geometry means new, sharp cutting edges are exposed as the grain fractures during grinding providing consistent cut rate and unparalleled disc life



METAL



SIZE (mm)	GRIT	MAX. RPM	PK QTY	ART NO.
115x22	36+	13300	25	66254434179
125x22	36+	12000	25	66254434181
180x22	36+	8500	25	66254434506

NORTON RAZORSTAR® BACK-UP PADS

- The curved ribs keep the pad and abrasive cooler while retaining a level of flexibility across the pad
- For tougher grinding operations
- Conforms ISO 15636
- Compatible with grits 36+ and finer



SIZE (mm)	THREAD	DENSITY	MAX. RPM	PK QTY	ART NO.
115	M14	Rigid	13300	5	66254442905
125	M14	Rigid	12200	5	66254442902
180	M14	Rigid	8500	5	66254442907



NORTON QUANTUM F996 **+++++**

- Ideal for cool grinding on stainless steel and heat-resistant steels
- Exceptionally high material removal and long life
- Especially suitable for heavy duty applications
- Generates an excellent surface finish



	SIZE (mm)	GRIT	PK QTY	ART NO.
	115x22	36	25	66623327494
		50	25	66623327496
		60	25	66623327497
		80	25	66623327499
		120	25	66623327500
	125x22	36	25	66623327501
		50	25	66623327502
		60	25	66623327503
		80	25	66623327504
	120	25	66623327505	
	150x22	36	25	66623381328
<p>Grinding on stainless generates a considerable amount of heat; always use a Norton Quantum disc with 'supersize' layer, a grinding aid added to the disc to reduce heat generation and improve cut and finish quality. Typically, a coarse grit disc is used when grinding MIG welds and a finer grit disc is used when grinding TIG welds.</p>	180x22	36	25	66623327506
		50	25	66623327507
		60	25	66623327508
		80	25	66623327509
		120	25	66623327510



NORTON

SAINT-GOBAIN

BLAZE X

**BLAZING THE WAY
WITH THE NEXT
GENERATION OF
FIBRE DISCS**

BLAZE X STEEL F970X **+++++**
FOR CARBON STEEL

- Ceramic micro-fracturing grain constantly self-sharpens, exposing new sharp edges, for a better cut rate and longer disc life
- Stronger fibre backing provides better face-to-surface grinding, but also resists tearing in heavy-duty applications
- Specially designed for use on carbon steel, indicated on the back of every disc, for easy disc identification.




	SIZE (mm)	GRIT	PK QTY	ART NO.
	115x22	36	25	78072718984
		50	25	78072718985
		60	25	78072718986
		80	25	78072718987
	125x22	36	25	78072718988
		50	25	78072718989
		60	25	78072718990
	180x22	80	25	78072718991
		36	25	78072718992
		50	25	78072718993
		60	25	78072718994
		80	25	78072718995



Using a supersized disc is not necessary on carbon steel due to less heat generated than that produced on stainless steel. BlazeX F970X is the best choice for carbon steel.

NORZON F827


- High stock removal rate for rough grinding and deburring of steel and stainless steel
- High and regular cut rate at medium pressures
- Norzon abrasive with self-sharpening effect
- Excellent price-performance ratio

SIZE (mm)	GRIT	PK QTY	ART NO.
115x22	24	25	69957360048
	36	25	63642539615
	50	25	69957360053
	60	25	63642539616
	80	25	63642539617
	120	25	63642533055
125x22	24	25	63642539619
	36	25	63642536483
	50	25	63642539620
	60	25	69957360057
	80	25	63642539622
	120	25	63642533056
180x22	24	25	63642533062
	36	25	63642533063
	50	25	63642533064
	60	25	63642533065
	80	25	63642533066
	120	25	63642533068

F100 METAL

- Versatile abrasive fibre discs for processing steel and metal alloys
- Increased stock removal rate for rough grinding and deburring
- Tough and versatile aluminium oxide abrasive
- Wide selection of grit sizes and diameters

SIZE (mm)	GRIT	PK QTY	ART NO.
115x22	16	25	66623385735
	24	25	66623385738
	36	25	66623385741
	40	25	66623385745
	50	25	66623385747
	60	25	66623385748
	80	25	66623385750
	100	25	66623385751
	120	25	66623385757
	125x22	16	25
24		25	66623385764
36		25	66623385768
40		25	66623385770
125x22	50	25	66623385773
	60	25	66623385775
	80	25	66623385776
	100	25	66623385778
	120	25	66623385779

FIBRE DISCS FOR ANGLE GRINDERS

SIZE (mm)	GRIT	PK QTY	ART NO.
180x22	16	25	66623385755
	24	25	66623385758
	36	25	66623385760
	40	25	66623385752
	50	25	66623385793
	60	25	66623385749
	80	25	66623385746
	100	25	66623385744
	120	25	66623385739

NYLON FIBREGLASS REINFORCED BACK-UP PADS

- The curved ribs keep the pad and abrasive cooler while retaining a level of flexibility across the pad
- For tougher grinding operations
- Conforms ISO 15636
- Grits 36+ and finer

SIZE (mm)	THREAD	DENSITY	MAX. RPM	PK QTY	ART NO.
115	M14	Rigid	13300	5	66623376727
125	M14	Rigid	12200	5	66623376821
180	M14	Rigid	8500	5	66623376822
	5/8	Rigid	8500	5	66623377069



NYLON BACK-UP PADS

- For universal use
- Grits 60+ and finer
- Conforms to ISO 15636

SIZE (mm)	THREAD	DENSITY	MAX. RPM	PK QTY	ART NO.
115	M14	Hard	13300	5	69957382828
	M14	Medium	13300	5	69957382825
125	M14	Hard	12200	5	69957382829
	M14	Medium	12200	5	69957382826
180	M14	Hard	8500	5	69957382830
	5/8	Medium	8500	5	63642588345
	M14	Medium	8500	5	69957382827



FIBRE DISC BACK-UP PAD DENSITY GUIDE



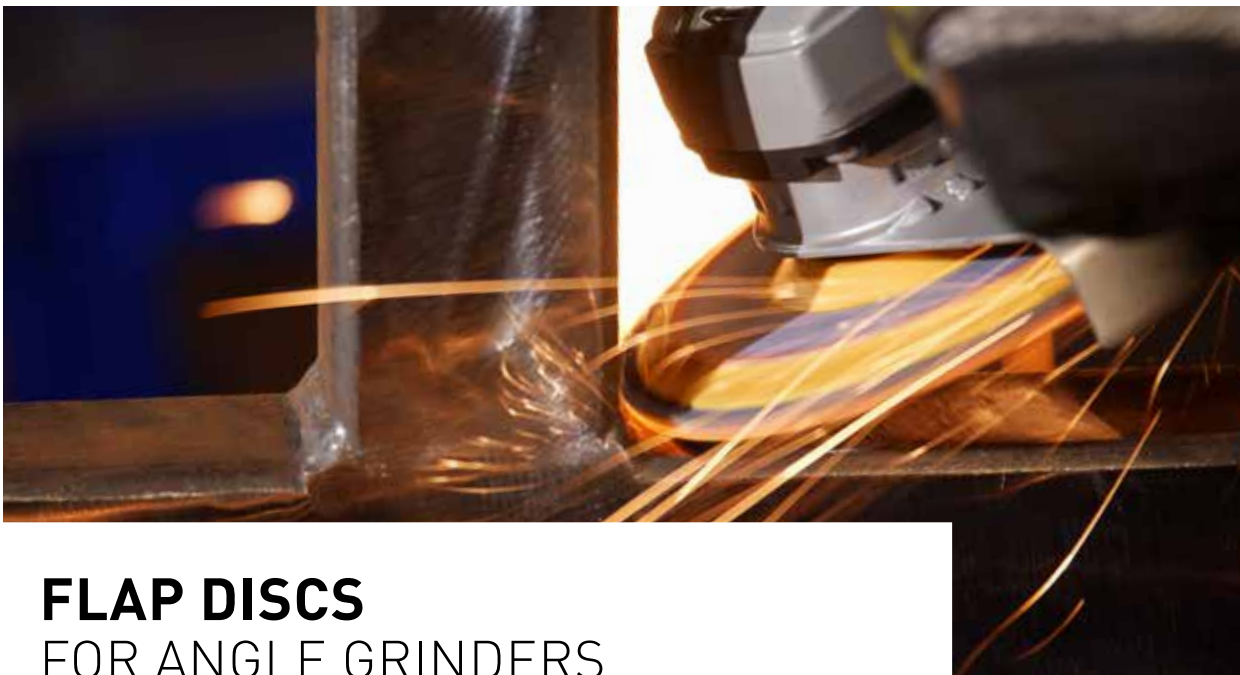
RIGID suitable for tough grinding operations and where very high stock removal is required such as chamfering.



HARD DENSITY suitable for coarse applications and higher stock removal such as chamfering, welded seam or deburring work.



MEDIUM DENSITY suitable for medium/fine applications such as edge rounding or surface grinding.



FLAP DISCS FOR ANGLE GRINDERS

Norton flap discs are engineered for light stock removal, edge chamfering, deburring, blending and finishing, reducing processing time and lowering total abrasive costs. Flap discs cut faster and provide a better finish than fibre discs while having the added benefit of longer life thanks to the flap construction.

PRODUCT SELECTION GUIDE

Highly recommended ✓✓
Recommended ✓



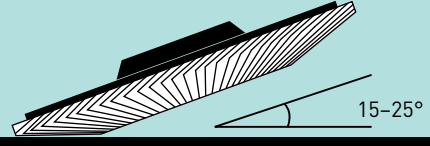
MATERIALS	NORTON QUANTUM R996	X-TREME PRO R928	X-TREME R860	VULCAN R842	STARLINE	NEW NORTON ALU
	+++++	+++++	+++++	++++	+++	
Stainless steel, inox & duplex	✓✓	✓✓	✓			
Inconel, titanium & super alloys	✓✓	✓✓	✓	✓		
Carbon, construction & mild steels	✓✓	✓✓	✓✓	✓✓	✓	
Cast Iron		✓	✓✓	✓✓	✓✓	
Non-ferrous metal (brass/aluminium)					✓✓	✓✓
Hard & softwood					✓✓	

DISC SHAPES

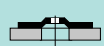
TYPE 29 CONICAL



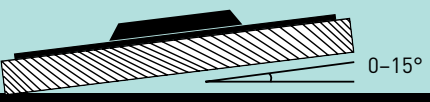
- For both contoured surfaces and edge work
- Angled flaps provide greater contact when removing stock on flat surfaces
- The best choice for fast stock removal



TYPE 27 FLAT



- For use on flat surfaces
- Best choice for blending and finishing





NORTON
SAINT-GOBAIN
ALU


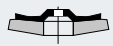

NEW Norton ALU flap discs feature a specially developed formulation to deliver the highest abrasive performance on aluminium and non-ferrous metals.

NEW ALU MESH FLAP DISC

- The mesh structure allows faster material removal without clogging and reduces heat generation during use for better part quality and minimal material loss
- Good stock removal on aluminium alloys
- Also removes old paint, corrosion and strips wood

CORDLESS COMPATIBLE 

 ALU 

FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.
	115x22 	40	10	78072764486*
		60	10	78072764488*
		80	10	78072764491*
	125x22 	120	10	78072764492*
		40	10	78072764493
		60	10	78072764494
		80	10	78072764495
		120	10	78072764496

* Made-to-order



X-TREME PRO R928 **+++++**

- X-Treme Pro R928 pink high-performance flap discs, with polycotton cloth backing and ceramic grain, provide an improved cut rate and product life compared to both premium zirconium discs and ceramic products in the market, thanks to its high density configuration.
- These discs also feature an additional supsize layer for cooler cutting, reducing heat generation during use for better part quality first and every time.
- X-Treme Pro R928 is ideal for fast grinding when used at medium pressure on stainless steel or harder metals.



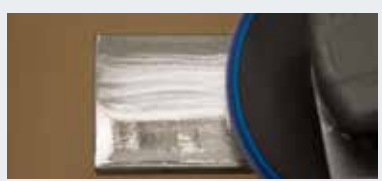
FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.
		40	10	78072723630
		60	10	78072723632
		80	10	78072723633
		120	10	78072723634
		40	10	78072723652
		60	10	78072723653
		80	10	78072723654
		120	10	78072723655
		40	10	78072723810
		80	10	78072723812



For heavy and fast material removal, has long life



Perfect for fast edge chamfering and de-burring




Supsize layer for a cooler cut and reduced heat generation during use, providing better part quality and no burn marks

FLAP DISCS FOR ANGLE GRINDERS

X-TREME R860 **+++++**

- 100% sharp Norzon grain for a faster cut from the very beginning
- Tough polyester backing for excellent product life and more material removal with one disc
- Ideal on medium to high pressure applications on carbon steel and hard metals




FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.	
 <p>SPEC CHECK</p> <p>Using a supersized disc is not necessary on carbon steel as less heat is generated than on stainless steel. X-Treme R860 is the best choice for carbon steel.</p>	115x22	40	10	78072726071	
			60	10	78072726074
			80	10	78072726075
	125x22	40	10	78072726076	
			60	10	78072726077
			80	10	78072726078
	180x22	40	10	78072726080	
			60	10	78072726081
	125x22	40	10	78072726053	
			60	10	78072726068

NORTON QUANTUM R996 **+++++**

- Ideal for cool grinding on stainless steel
- Extremely aggressive ceramic grain for noticeably faster cut rate
- Strong polyester backing for demanding work on edges
- Especially suitable for high pressure applications on high power angle grinders



FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.	
	115x22	40	10	66254461027	
			60	10	66254461029
			80	10	66254461031
	125x22	40	10	66254445878	
			60	10	66254445879
			80	10	66254461033



Flap discs with polyester backing will give the best performance when used with high power machines.

VULCAN R842

- Versatile product for rough grinding and deburring on steel and stainless steel
- Self-sharpening zirconium abrasive grain
- High and regular cut rate at medium and low pressures



FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.
		40	10	63642502311
		60	10	63642502312
		80	10	63642502313
		120	10	63642502314
		40	10	63642502315
		60	10	63642502317
		80	10	63642502318
		120	10	63642502326
		40	10	63642502327
		60	10	63642502328
		80	10	63642502329
		40	10	63642502341
60		10	63642502343	
80		10	63642502345	
	40	10	63642502331	
	60	10	63642502332	
	40	10	63642502335	
	60	10	63642502336	

STARLINE

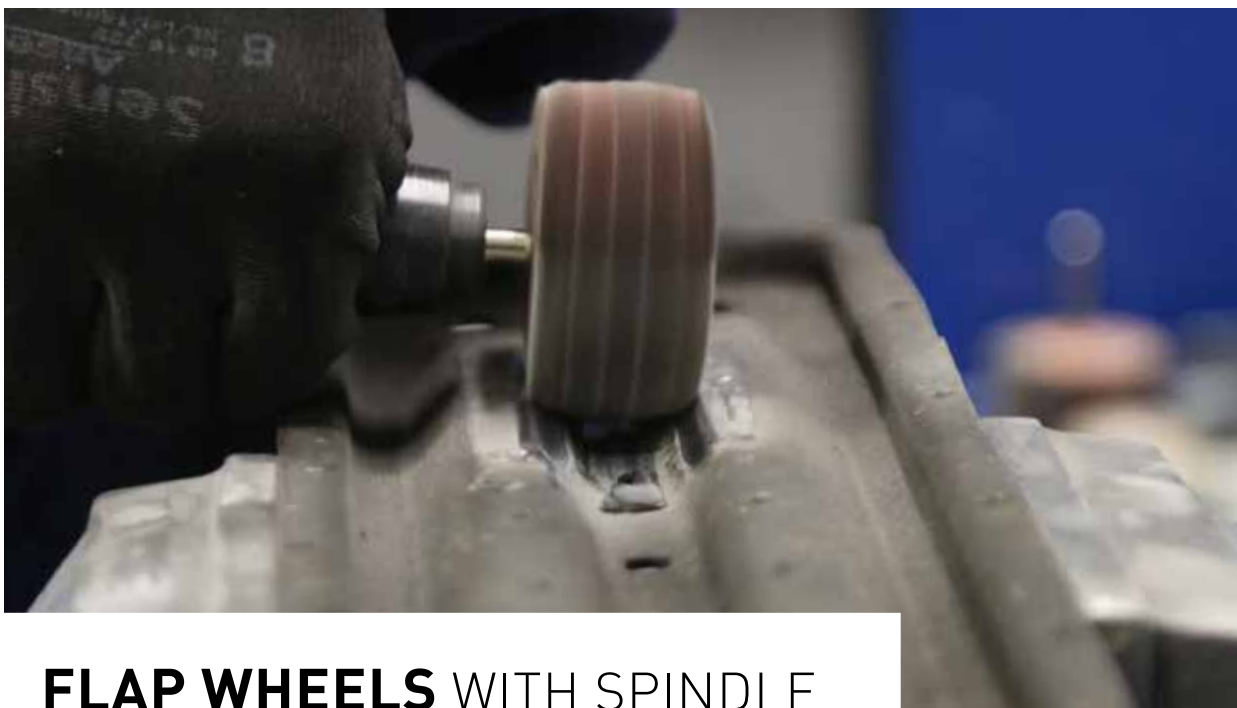
- Multipurpose flap discs for processing steel, metal alloys or soft materials like wood
- Good stock removal in rough grinding and deburring
- Hard and versatile Zirconia Alumina abrasive
- Best price-performance ratio



FIBRE GLASS BACKED	SIZE (mm)	GRIT	PK QTY	ART NO.
		40	10	66254492267
		60	10	66254492268
		80	10	66254492270
		120	10	66254492269
		40	10	66254492271
		60	10	66254492272
		80	10	66254492273
		120	10	66254492274



For an equivalent finish, always use a flap disc one grit size coarser than with a fibre disc



FLAP WHEELS WITH SPINDLE

Flap wheels conform to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, they wear away evenly and without residue, continually exposing fresh abrasives.

Wheels are designed with a 3 or 6mm steel shank which runs through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on air tools when using other abrasive products.

Flap wheels with shaft achieve their best performance at a recommended speed of 15-25m/s. Optimising stock removal, surface finish, thermal load of the workpiece and toll wear.

PRODUCT SELECTION GUIDE

Highly recommended ✓✓
Recommended ✓



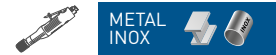
MATERIALS	NORTON QUANTUM	NORZON R822	METAL R207Plus
	+++++	++++	+++
Stainless steel, inox & duplex	✓✓	✓	
Inconel, titanium & super alloys	✓✓	✓	
Carbon steel, construction steel & mild steel	✓✓	✓✓	✓✓
Cast iron	✓	✓✓	✓✓
Non-ferrous metal (brass /aluminium)			✓✓
Hard & soft wood		✓✓	✓
Composite materials			✓
Stone, concrete			✓
Glass, plastic			✓

* Made-to-order

NORTON QUANTUM **++++**

HIGH PERFORMANCE

- The best choice for use on stainless steel, inconels, chromium cobalt, titanium and extremely hard materials
- Aggressive cut removes defects quickly and effectively
- Additional supersize layer minimises heat build-up on the workpiece for a cooler cut and longer life
- Ceramic aluminium oxide grain for greatest durability, longest life on tough applications and stainless steel



DIM DIAxWxS (mm)	GRIT	PK QTY	ART NO.	RECOMMENDED SPEED (RPM)
30x15x6	40	10	66261154243	9500 - 15900
	60	10	66261154300	
	80	10	66261154301	
40x20x6	40	10	66261154302	7100 - 12000
	60	10	66261154305	
	80	10	66261154306	
60x30x6	40	10	66261154315	4800 - 7900
	60	10	66261154316	
	80	10	66261154318	
	120	10	66261154320	
80x50x6	40	10	66261154340	3600 - 6000
	60	10	66261154341	



Grinding on stainless generates a considerable amount of heat; using a Norton Pink flap wheel improves cut, finish and reduces heat generation and workpiece burn.

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

FLAP WHEELS WITH SPINDLE

NORZON R822

- Self-sharpening zirconia alumina grain for use on stainless steel and resistant alloys
- Ideal for grinding, shaping, blending, edge breaking and weld removal
- Aggressive cutting action means a faster finish per part, maximising throughput
- Achieves a good linear finish thanks to load resistance for a regular cut rate




METAL INOX



HARD & SOFT WOOD



	DIM DIAxWxS (mm)	GRIT	PK QTY	ART NO.	RECOMMENDED SPEED (RPM)
	30x20x6	40	10	66261033325	9500 - 15900
		60	10	66261139984	
		80	10	66261139986	
	40x20x6	40	10	69957300004	7100 - 12000
		60	10	69957300006	
		80	10	69957300007	
	60x30x6	40	10	63642539952	4800 - 7900
		60	10	63642536547	
		80	10	63642539953	
	80x30x6	40	10	63642539954	3600 - 6000
		60	10	63642539955	
		80	10	63642536548	



Reducing the working pressure and the peripheral speeds of the abrasive wheels results in reduced heat generation on the workpiece and the tool, eliminating burn marks and improving finish.

Formerly X-Treme R822


METAL R207Plus

- Excellent cut rate even at low-pressure when used for finishing operations
- A universal product which achieves a good finish on steel and stainless steel
- New generation of premium aluminium oxide grain provides an aggressive cut yet long product life
- Conforms to the workpiece thanks to the flexible cotton backing



FERR. & NON FERR.



	DIM DIAxWxS (mm)	GRIT	PK QTY	ART NO.	RECOMMENDED SPEED (RPM)
	20x10x6	40	10	77696007699	14300 - 23900
		60	10	66261193703	
		80	10	66623329045	
		120	10	66261137904	
	25x20x6	40	10	66261100608	11500 - 19000
		60	10	66261106190	
		80	10	77696086608	
		120	10	66261137918	
	30x10x6	40	10	66261138103	9500 - 15900
		60	10	63642545207	
		80	10	63642537371	
		120	10	63642552728	

† +25% performance upgrade

6mm SHAFT



30x15x6	40	10	66261056890	9500 - 15900	
	60	10	63642513148		
	80	10	63642561466		
	120	10	63642551593		
30x30x6	40	10	66261138108	9500 - 15900	
	60	10	66254410858		
	80	10	66261063210		
40x15x6	40	10	63642539937	7100 - 12000	
	60	10	63642533099		
	80	10	63642533098		
	120	10	63642533094		
40x20x6	40	10	63642539938	7100 - 12000	
	60	10	63642546771		
	80	10	63642546768		
	120	10	63642546760		
50x20x6	40	10	63642546774	5700 - 9500	
	60	10	63642531870		
	80	10	63642533097		
	120	10	63642546759		
50x30x6	40	10	63642539943	5700 - 9500	
	60	10	63642534251		
	80	10	63642561879		
	120	10	63642531863		
60x15x6	40	10	63642546773	4800 - 7900	
	60	10	69957360901		
	80	10	63642546767		
	120	10	63642546758		
60x20x6	40	10	63642536738	4800 - 7900	
	60	10	63642531869		
	80	10	63642531866		
	120	10	63642531862		
60x30x6	40	10	63642536737	7100 - 12000	
	60	10	63642531868		
	80	10	63642531865		
	120	10	63642531861		
	240	10	63642546694		
	320	10	63642546727		
80x30x6	40	10	69957360911	5700 - 9500	
	60	10	63642531867		
	80	10	63642533096		
	120	10	63642534250		
80x50x6	40	10	69957360914	5700 - 9500	
	60	10	63642559718		
	80	10	69957360916		
	120	10	69957360917		



† +25% performance upgrade

FLAP WHEELS WITH SPINDLE



To prevent unnecessary tool wear, use a coarser grit size instead of increasing contact pressure. For a finer surface finish, increase the cutting speed. Using the same grit size, the finish will be rougher on softer materials.



MADE-TO-ORDER PRODUCT AVAILABILITY

PRODUCT / GRIT	36	40	60	80	120	150	180	240	320
NORTON QUANTUM R928		•	•	•	•				
NORZON R822	•	•	•	•	•	•			
R427	•	•	•	•	•	•	•	•	
METAL R207		•	•	•	•	•	•	•	•

MINIMUM ORDER QUANTITY

DIAMETER (mm)	MINIMUM ORDER QUANTITY
20	250 pieces
25	250 pieces
30	250 pieces
40	250 pieces
50	250 pieces
60	250 pieces
80	250 pieces



BEARTEX SPINDLE MOUNTED FLAP WHEELS

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

There are two types of non-woven flap wheels: those made with only non-woven flaps, where finishing is the primary application, and interleaved wheels, made with coated abrasive and non-woven flaps. The interleaved wheels are less conformable but more rigid for higher stock removal and must always be run in the direction indicated by the arrow on the product label.

FLAP WHEEL TYPES

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

BEARTEX NON-WOVEN FLAP WHEELS

- Non-woven only abrasive flaps
- Ideal for finishing large and awkward components
- Can be used for metals, wood, composite and plastics
- Less aggressive than conventional coated abrasive flap wheels

BEARTEX INTERLEAVED FLAP WHEELS

- BearTex non-woven abrasive interleaved with coated abrasive
- Soft yet aggressive, creating a "firmer" wheel that provides a higher rate of cut
- The ratio of coated abrasive to non-woven flaps can be altered to suit particular applications
- Ideal for deburring and grain finishing on stainless steel



DIM DIAxWxS (mm)	GRADE	INTERLEAVED GRIT	CAP CODE	PK QTY	ART NO.
60x30x6	Fine A Interleaved	60	F2401	10	63642549639
	Fine A Interleaved	100	F2401	10	63642549640
	Fine A Interleaved	150	F2401	10	63642549641
	Coarse	-	F2202	10	66261032167
	Medium A	-	F2300	10	66261032157
	Medium S	-	F4300	10	66261053048
	Fine A	-	F2401	10	63642549650
	Fine S	-	F4401	10	63642515902
	Very Fine A	-	F2501	10	63642515905
80x50x6	Fine A Interleaved	60	F2401	10	7660705179
	Fine A Interleaved	100	F2401	10	63642515544
	Fine A Interleaved	150	F2401	10	63642515545
	Coarse	-	F2202	10	63642586113
	Medium S	-	F4300	10	66261053053
	Fine A	-	F2401	10	63642515583
	Fine S	-	F4401	10	63642515614
	Very Fine A	-	F2501	10	63642515628
	100x50x6	Fine A Interleaved	60	F2401	10
Fine A Interleaved		100	F2401	10	63642515908
Fine A Interleaved		150	F2401	10	63642515909
Fine A		-	F2401	10	63642515903
Fine S		-	F4401	10	63642515904
Very Fine A		-	F2501	10	63642515906

Other specifications are available made-to-order. Please contact your local sales or customer service representative for more information.

BEARTEX FLAP WHEELS TR+ MOUNTED

- Where a quick change facility in a continuous operation is beneficial



DIM DIAxWxS (mm)	GRADE	CAP CODE	PK QTY	ART NO.
60x30xTR	Medium A	F2316	10	66261124072

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

Use with TR+ holder for quick change capability.
Also available in interleaved and TR+ in large and small diameter wheels.

BACK-UP PADS TR+ ATTACHMENT (TR+ - SL4)



TYPE	DENSITY	MAX RPM	PK QTY	ART NO.
Plastic back-up pad with 6mm spindle	Hard	15000	1	63642586196

For 100mm Speedlok TR+ discs



PNEUMATIC DIE GRINDER GRINDING TOOLS AND KITS

Our new Norton pneumatic die grinder quickly and comfortably accomplishes many portable applications without changing machines – including jobs for abrasive specialties (cartridge and spiral rolls...), small diameter flap wheels, mounted points, and carbide burrs. Equip your new die grinder with the complete line of Norton die-grinding abrasive products and it will run longer, at peak efficiency.

PNEUMATIC DIE GRINDER WITH 6MM COLLET, MAX RPM 25000 (0,9 HP)

- Extremely versatile and productivity-enhancing; includes a 6mm collet to accommodate numerous abrasive products: specialties (including cartridge and spiral rolls, spirabands, cones), mounted flap wheels, mounted points, and carbide burrs
- Achieve better tool handling, along with reduced fatigue, from the ergonomic and streamlined non-slip grip
- Their small size also enhances control and finishes while their light weight provides additional control, less vibration for operator comfort, and the ability to get into small parts
- Double-bearing spindle generates superb concentricity, reducing vibrations and allowing longer use, while producing finer finishes



COLLET DIAMETER (mm)	HORSEPOWER	TOOL WEIGHT	AIR CONSUMPTION (l/min)	RECOMMENDED OPERATING PRESSURE:	ART NO.
6	0.9	0.65 kg	85	6.2 bar	69957341008



SPEC CHECK

Air tools require regular lubrication throughout the life of the tool. The air motor and bearing use compressed air to power the tool. Because moisture in compressed air will rust the air motor, it must be lubricated daily. An inline oiling device is recommended. Before using the machine add 1-2 drops of oil in the machine air inlet.



This is an **UNGUARDED** tool and should **NEVER** be used with cut-off discs. Never use any product that has a MAX RPM rating less than the RPM marked on the tool.

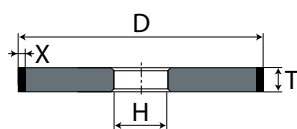


DIAMOND & CBN WHEELS FOR MACHINING ROUND TOOLS

The Norton B99 resin bonded wheel is ideal for flute grinding on CNC machines and is particularly suitable for applications on standard tools. D64R100B99 and B107 W B99 are the most commonly used products for flute grinding, however other specifications can be made available on request.



1A1 FLUTING



DxTxX (mm)	H (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND				
100x10x5	20	ASD64 R100 B99	1	7958732706
125x5x3	20	ASD126 R100 B99	1	7958732469
125x10x10	20	ASD64 R100 B99	1	7958732470
125x12x10	20	ASD64 R100 B99	1	7958732471
CBN				
100x11x5	20	CB107 W B99	1	7958732712
125x10x10	20	CB107 W B99	1	7958728828



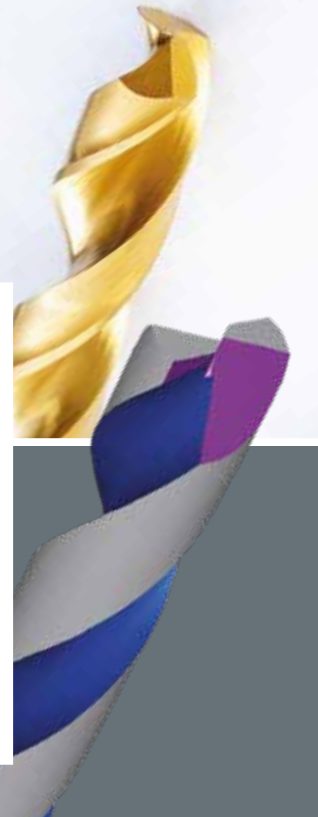
DIAMOND & CBN WHEELS FOR MACHINING ROUND TOOLS

The state-of-the-art Norton B99 resin bond is free cutting and has good corner stability, the most essential characteristic required for CNC gashing.

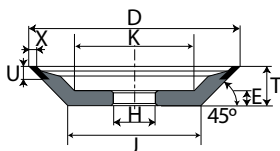
Two standard specifications are offered:

- For tungsten carbide tools: ASD64 R100 B99
- For HSS-tools: CB107 W B99.

Both are available in 12V9 as well as in 1V1 shape. Further combinations of dimensions, grit sizes and concentrations are available on request.



12V9 GASHING



DxXxU (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
100x2x10	20	20	52	11	60	ASD64 R100 B99	1	7958732837
100x3x10	20	20	52	11	60	ASD64 R100 B99	1	7958732832
125x2x10	20	25	60	12	74	ASD64 R100 B99	1	7958733019
150x3x10	20	25	81	15	99	ASD64 R100 B99	1	7958732919
CBN								
125x3x10	20	25	71	14	74	CB107 W B99	1	7958732814
150x3x10	20	25	81	15	99	CB107 W B99	1	7958732920

ADDITIONAL INFORMATION

Stiffened body



DIAMOND & CBN WHEELS FOR MACHINING ROUND TOOLS

Norton B99 resin bond tools are an ideal choice for grinding clearances and relief angles on CNC machines. With excellent cutting behaviour the bond produces a good surface finish. The listed grinding wheels are suitable for the production and re-sharpening of tungsten carbide and HSS round tools.

D64 R100 B99 and B107 W B99 are the most common specifications for clearance angle grinding applications; however, other specifications are available on request.



11V9 CLEARANCE ANGLE GRINDING

	DxXxU (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
	DIAMOND								
	100x2x10	20	35	59	15	74	ASD64 R100 B99	1	7958732876
	100x3x10	20	35	53	15	74	ASD64 R100 B99	1	7958732877
	CBN								
	100x3x10	20	35	53	15	74	CB107 W B99	1	7958732844

ADDITIONAL INFORMATION
Stiffened body

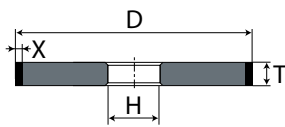


DIAMOND & CBN WHEELS FOR ROUND TOOL UNIVERSAL GRINDING

Norton offers a comprehensive selection of different bonds and concentrations for re-sharpening applications on universal machines. The B99 grinding wheels can be used wet or dry.

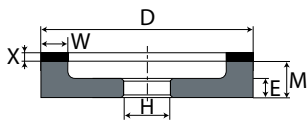
The lower the diamond or CBN concentration the more suited the product will be to grinding large contact areas. Aztec IV is a special free cutting resin bond which is designed for dry grinding operations and enables high material removal.

1A1 RE-SHARPENING



DxTxX (mm)	H (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND				
100x4x3	20	ASD91 R75 B99	1	7958732717
100x10x5	20	ASD91 R75 B99	1	7958732711
125x10x5	20	ASD126 R100 B99	1	7958732466
150x10x3	20	ASD126 R50 B99	1	7958732724
150x10x3	32	ASD126 R75 B99	1	7958732726
CBN				
100x10x5	20	CB126 T B99	1	7958732704
150x10x3	20	CB126 T B99	1	7958732725

6A2 RE-SHARPENING

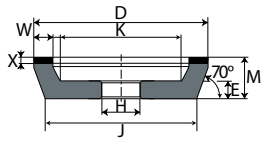


DxWxX (mm)	H (mm)	M (mm)	E (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND						
100x6x4	20	23	10	ASD151 R75 B99	1	7958732881
100x12x2	20	18	10	ASD107 R50 B99	1	7958732879
125x6x5	20	25	10	ASD64 R75 B99	1	7958732922
150x10x2	20	23	10	ASD91 R50 B99	1	7958732932
150x15x2	32	23	10	ASD107 R50 B99	1	7958732933
150x20x2	20	20	10	ASD126 R75 B99	1	7958732934
CBN						
150x6x4	20	23	10	CB151 T B99	1	7958732936
150x6x4	32	23	10	CB151 T B99	1	7958732935

DIAMOND & CBN WHEELS FOR ROUND TOOL UNIVERSAL GRINDING

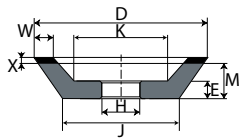
11A2-70° RE-SHARPENING

DxWxX (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
100x5x4	20	20	75	10	88	ASD151 R75 B99	1	60157682163
CBN								
100x5x4	20	20	75	10	88	CB126 T B99	1	60157682165



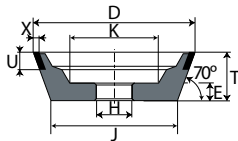
11V2 RE-SHARPENING

DxWxX (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
100x5x3	20	22	72	8	82	ASD91 R75 B99	1	7958733007
100x5x3	20	22	72	8	82	ASD126 R75 B99	1	7958733011



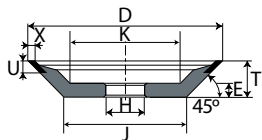
11V9 RE-SHARPENING

DxXxU (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
75x2x10	20	30	40	10	53	ASD126 R75 B99	1	7958732859
100x2x10	20	35	55	10	74	ASD126 R75 B99	1	7958732867
100x3x10	20	35	60	10	74	ASD126 R75 B99	1	7958732862
125x3x10	20	40	81	10	96	ASD126 R75 B99	1	7958732847
CBN								
75x1.5x10	20	30	40	10	53	BN181 Aztec IV	1	69014152323
75x2x10	20	30	40	10	53	CB126 T B99	1	7958732853
100x1.5x10	20	35	55	10	75	BN126 Aztec IV	1	69014152115
100x1.5x10	20	35	55	10	75	BN181 Aztec IV	1	69014152118
100x1.5x10	32	35	55	10	75	BN181 Aztec IV	1	69014152120
100x2x10	20	35	55	10	74	CB126 T B99	1	7958732869



12V9 RE-SHARPENING

DxXxU (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
75x2x10	20	25	34	10	39	ASD64 R75 B99	1	7958732816
100x3x10	20	20	65	10	59	ASD46 R75 B99	1	7958732885



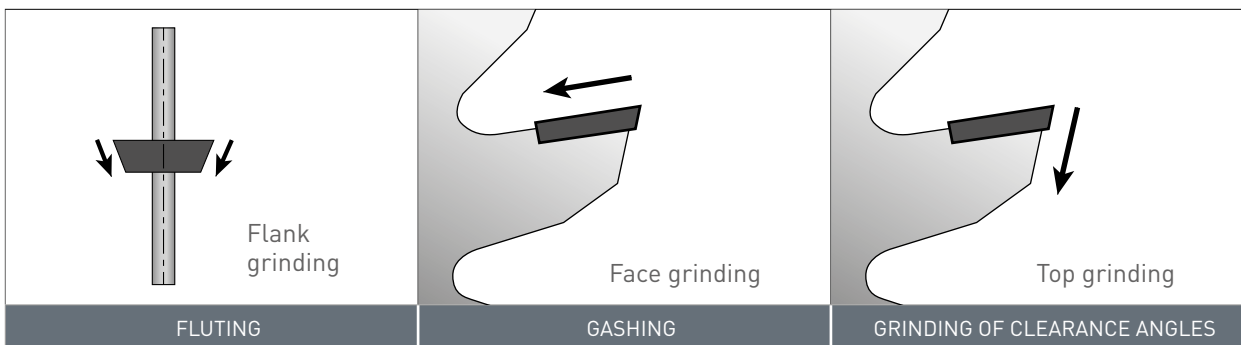


SAW BLADES

DIAMOND AND CBN GRINDING WHEELS FOR THE SAW BLADE INDUSTRY

With an emphasis on excellent price vs. performance ratios, the saw blade programme aims to provide the best solutions for grinding tungsten carbide tipped saw blades and one-piece HSS saws.

The tungsten carbide tipped circular saw blade grinding wheels have been specifically designed for face grinding and flank grinding. Norton offers grinding wheels for the most common machine types required for these applications.



1A1W grinding pins for hollow tooth grinding are also available.

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Face	↑	Face grinding of tungsten carbide tipped saw blades
ECO Flank		Flank grinding of tungsten carbide tipped saw blades
ECO Top-AW		Top-grinding of tungsten carbide tipped saw blades on AKEMAT and WOODTRONIC machines
ECO Top		Universal top-grinding of tungsten carbide tipped saw blades
ECO Top-R		Top-grinding of tungsten carbide tipped saw blades, especially re-sharpening
ECO Top-P		Top-grinding of tungsten carbide tipped saw blades, especially production
B99		Universal resin bond for wet and dry grinding

BOND OVERVIEW CBN

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Curve		Profiling and re-sharpening of HSS saw blades

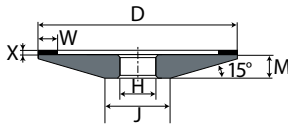


DIAMOND & CBN WHEELS FOR SHARPENING OF TUNGSTEN CARBIDE TIPPED SAW BLADES

The tooth face of circular saw blades is ground with sharp angled cup wheels. Depending on the tooth pitch, different angles and wheel thicknesses are required. The greater the number of teeth around the circumference, the narrower the space between them and the thinner the grinding wheel needs to be. Even the narrowest tooth gaps can be machined with our 12V9 *ECO* Face wheels.

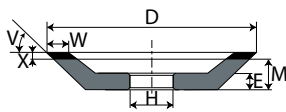
For reasons of stability, conventional tooth gaps are mainly ground using 4A2 or 12V2 grinding wheels.

4A2 FACE GRINDING



DxWxX (mm)	H (mm)	M (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND						
100x5x2	25*	7	51.5	ASD91 R75 B99	1	7958725784
ADDITIONAL INFORMATION For conventional tooth gaps						*4A2K (with Keyway)

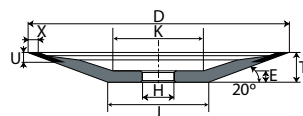
12V2 FACE GRINDING



DxWxX (mm)	H (mm)	M (mm)	V (°)	E (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND							
125x4x2	32	11	30°	9	ASD46 R125 B99	1	60157682189
125x4x2	32	11	30°	9	ASD76 R125 B99	1	60157682188
200x4x2	32	13	30°	11	ASD46 R125 B99	1	7958725781
200x4x2	32	13	30°	11	ASD76 R125 B99	1	7958725780

ADDITIONAL INFORMATION For conventional tooth gaps

12V9 FACE GRINDING



DxXxU (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
125x2.3x4	32	13	101	10	70	D46 <i>ECO</i> Face	1	69014148184
150x2.3x4	32	13	126	10	95	D46 <i>ECO</i> Face	1	7958719191
200x2.3x4	32	13	173	10	145	D46 <i>ECO</i> Face	1	69014148205

ADDITIONAL INFORMATION For conventional tooth gaps



DIAMOND & CBN WHEELS FOR SHARPENING OF TUNGSTEN CARBIDE TIPPED SAW BLADES

To ensure the circular nature of the saw and to define the wedge and clearance angles, the top of the saw blade needs to be ground.
Vollmer and Widma machines normally require 6VV5 cup wheels Akemat and Woodtronic machines require 14M1 state of the art peripheral wheels.

6VV5 TOP GRINDING

	DxWxX (mm)	v (°)	H (mm)	T (mm)	E (mm)	SPECIFICATION	ADDITIONAL INFORMATION	PK QTY	ART NO.
DIAMOND									
	125x5x10	8°	32	22	11	ASD126/46 R100/ R75 ECO TOP-P	For production, oil	1	7958725661
	125x5x10	8°	32	22	11	ASD126/46 R125/ R100 ECO TOP-R	For re-sharpening	1	7958725663

*6VV5K (with keyway)

14M1 TOP GRINDING

	DxUxX (mm)	v (°)	H (mm)	T (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
	200x5x8	8°	32	10	156	ASD126/46 R100/ R75 ECO TOP-AW	1	7958725786
ADDITIONAL INFORMATION D126/D46: U=2.5/2.5								



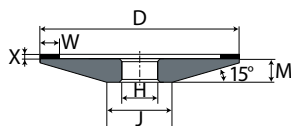
DIAMOND & CBN WHEELS FOR SHARPENING OF TUNGSTEN CARBIDE TIPPED SAW BLADES

During the flank grinding process the cutting width of the circular saw blade is defined. Therefore, typically two 4A9 grinding wheels are simultaneously fed from both sides.

When manufacturing saw blades there is a wide variety of tooth geometries and designs to choose from. Depending on the intended use of the saw, the tooth design can be flat, alternate, trapezoid or any combination of these. Hollow ground teeth are very common to achieve finer cuts with no burrs. The rounded shape of hollow ground teeth is produced with 1A1W grinding pins.

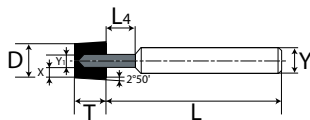


4A9 FACE GRINDING



DxXxW (mm)	H (mm)	T (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND						
100x4x5	32	10	55	ASD126 ECO Flank	1	7958725738
ADDITIONAL INFORMATION Universal use						*4A9K (with Keyway)

1A1W HOLLOW TOOTH GRINDING



DxTxX (mm)	Y (mm)	L (mm)	Y ₁ (mm)	L ₄ (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND							
6.5x3x1.75	6	42	4.1	10	ASD76 R125 B99	1	7958725782
ADDITIONAL INFORMATION For all common machines							

COLOUR CODES FOR MACHINE MANUFACTURERS

Vollmer-Biberach	Vollmer-Dornhan	Woodtronic	Akemat	Widma
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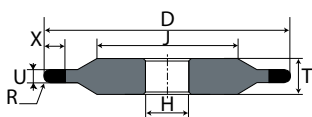
DIAMOND & CBN WHEELS FOR SHARPENING HSS SAW BLADES

HSS saw blades are one-piece saws that are ground from one solid piece of metal. For this process HSS saws require special grinding machines.

14F1 wheels grind the required profile under CNC control. Wheels are ideal for both initial profiling and re-sharpening thanks to the advanced resin bond systems which ensure the wheels are economic and extremely wear resistant.

14F1 INITIAL PROFILING AND RE-SHARPENING

	DxUxX (mm)	R (mm)	H (mm)	T (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
	CBN							
	200x1.3x6.5	0.65	32	8	169	CB107 ECO Curve	1	7958706686
	200x1.6x7	0.8	32	8	164	CB107 ECO Curve	1	7958714307
	200x2x8	1	32	8	164	CB107 ECO Curve	1	7958706684
	200x2.5x8	1.25	32	8	159	CB107 ECO Curve	1	7958716444
	200x3x10	1.5	32	8	160	CB107 ECO Curve	1	7958718179
ADDITIONAL INFORMATION For Loroach machines	200x4x12.5	2	32	8	157	CB107 ECO Curve	1	7958716216





GENERAL ENGINEERING

DIAMOND AND CBN GRINDING WHEELS FOR GENERAL ENGINEERING

Norton diamond and CBN wheels for general engineering are suitable for many grinding applications like OD-, ID-, and flat grinding, machining of knives, milling cutters and polishing.

Most of the bonds listed in this section are made with ASD (armoured synthetic diamonds) grit and are suitable for wet and dry grinding applications. Some wheels use AMD (armoured metal bond diamonds) which are more wear resistant but require a coolant.

More information about the application can be found in the relevant sub-chapters.

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
R100 B99	↑	For universal grinding (wet or dry)
R75 B99		For universal grinding (wet or dry)
R50 B99		For universal grinding (wet or dry)
R75 B49		For universal grinding (dry)
R50 B49		For universal grinding (dry)

BOND OVERVIEW CBN

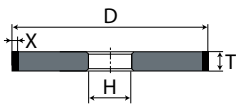
BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
W B99	↑	For universal grinding (wet or dry)
T B99		For universal grinding (wet or dry)
Q B99		For universal grinding (wet or dry)
R75 B49		For universal grinding (dry)
R50 B49		For universal grinding (dry)



DIAMOND & CBN WHEELS FOR GENERAL ENGINEERING

Norton offers a comprehensive stock programme for resin bonded 1A1 standard grinding wheels designed for OD- and flat grinding tungsten carbide and steel parts.
All specified grinding wheels can be used for OD- and flat grinding. However, wheels (R50) with lower concentration have been specifically designed for flat grinding operations.
Other specifications are available on request.

1A1 OD AND FLAT GRINDING



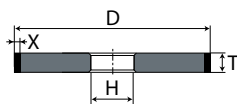
DxTxX (mm)	H (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND				
175x15x3	32	ASD126 R50 B99	1	7958732730
200x10x3	32	ASD126 R75 B99	1	7958732731
200x10x3	51	ASD126 R75 B99	1	7958732732
200x15x3	32	ASD126 R75 B99	1	7958732840
250x15x3	76.2	ASD126 R75 B99	1	7958732804
300x10x3	127	ASD126 R75 B99	1	7958732824
300x15x3	127	ASD126 R75 B99	1	7958732810
300x20x3	127	AMD126 R50 B99	1	7958732812
400x15x3	127	ASD126 R50 B99	1	7958788923*
CBN				
200x10x3	51	CB126 T B99	1	7958732803
200x15x3	32	CB126 Q B99	1	7958732838
300x15x3	127	CB126 T B99	1	7958732808
300x20x3	127	CB126 Q B99	1	7958732815
350x20x3	127	CB126 Q B99	1	7958788928*
350x30x3	127	CB126 Q B99	1	7958788929*
400x20x3	127	CB126 Q B99	1	7958788932*



DIAMOND & CBN WHEELS FOR GENERAL ENGINEERING

Resin bonded grinding pins and grinding wheels can be used for wet or dry applications, either manually or on automatic grinding machines. To avoid burning and to ensure stable grinding conditions the diameter must be carefully selected. It is highly recommended to choose a diameter no bigger than 70% of the bore. When using grinding pins, it is very important to follow the permitted speed instructions, which are engraved on the grinding tool. If the permitted speed is slower than the adjustable speed of the grinding spindle, a different technical solution is required.

1A1 ID GRINDING



DxTxX (mm)	H (mm)	SPECIFICATION	PK QTY	ART NO.
---------------	-----------	---------------	-----------	---------

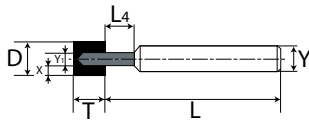
DIAMOND

15x12x2	6	ASD126 R100 B99	1	7958732728
20x10x2	6	ASD126 R100 B99	1	7958732950
30x10x3	10	ASD126 R75 B99	1	7958732956
40x15x3	10	ASD126 R75 B99	1	7958732971

CBN

12x10x2	6	CB126 W B99	1	7958732722
15x12x2	6	CB126 W B99	1	7958732729
20x10x2	6	CB126 W B99	1	7958732948
20x15x2	6	CB126 W B99	1	7958732957
30x15x3	10	CB126 W B99	1	7958732937
40x15x3	10	CB126 W B99	1	7958732961
50x15x3	20	CB126 W B99	1	7958732981

1A1W IDF GRINDING



DxTxX (mm)	Y (mm)	L (mm)	Y ₁ (mm)	L ₄ (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND							
3x6x0.65	3	60	1.7	8	ASD126 R100 B99	1	7958732949**
5x6x1.5	3	60	2.1	8	ASD64 R100 B99	1	7958732944
5x6x1.5	3	60	2.1	8	ASD126 R100 B99	1	7958732943
6x6x1.5	6	60	3.1	8	ASD64 R100 B99	1	7958732940
6x6x1.5	6	60	3.1	8	ASD126 R100 B99	1	7958732941
8x10x2	6	60	4.1	12	ASD64 R100 B99	1	7958732954
8x10x2	6	60	4.1	12	ASD126 R100 B99	1	7958732953
10x10x2	6	60	-	-	ASD64 R100 B99	1	7958732959
10x10x2	6	60	-	-	ASD126 R100 B99	1	7958732960
12x12x2	6	60	-	-	ASD64 R100 B99	1	7958732963
CBN							
3x6x0.65	3	60	1.7	8	CB126 W B99	1	7958732947
5x6x1.5	3	60	2.1	8	CB126 W B99	1	7958732946
6x6x1.5	6	60	3.1	8	CB126 W B99	1	7958732938
8x10x2	6	60	4.1	12	CB126 W B99	1	7958732955
10x10x2	6	60	-	-	CB126 W B99	1	7958732958
12x12x2	6	60	-	-	CB126 W B99	1	7958732962

** Available while stocks last

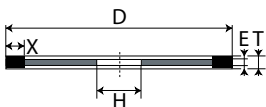


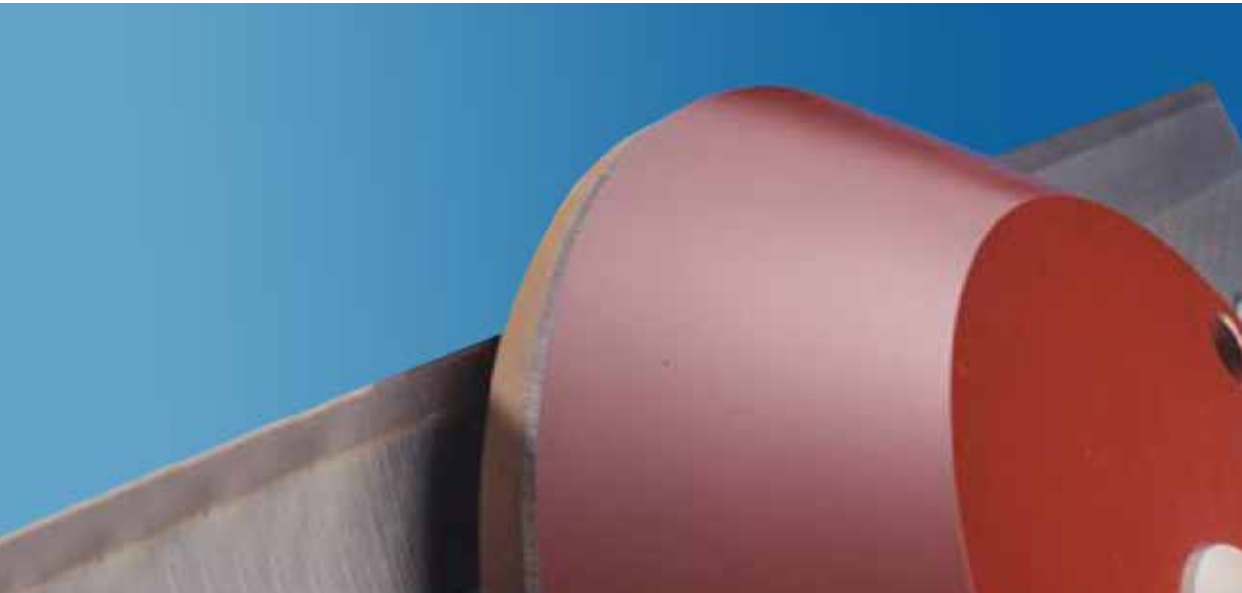
DIAMOND & CBN WHEELS FOR GENERAL ENGINEERING

Norton offers a small assortment of standard resin bonded cut-off grinding wheels. The specified diamond cut-off wheels cut hard, short-chipping and wear resistant materials such as glass, ceramics and carbide. The contained CBN cut-off wheels are ideal for machining high speed steel, hardened steel, 55 HRC and magnetic materials.

Further specifications for resin bond, sintered metal and electroplated metal bond are available on request.

1A1R CUT-OFF

	DxTxX (mm)	E (mm)	H (mm)	SPECIFICATION	PK QTY	ART NO.
	DIAMOND					
	100x0.9x5	0.7	20	ASD126 R75 B99	1	60157681683
	125x1x5	0.7	20	ASD126 R75 B99	1	60157681686
	150x1x5	0.8	20	ASD126 R75 B99	1	60157681688
	CBN					
	150x1x5	0.8	20	CB151 T B99	1	60157682103



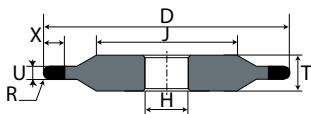
DIAMOND & CBN WHEELS FOR GENERAL ENGINEERING KNIFE GRINDING

Norton offers a range of resin bonded grinding wheels for machining flat, circular and profile knives.

The 6A2 grinding wheels are specifically designed for wet grinding of circular knives with tungsten carbide-steel combinations on Göckel and Reform machines.

The 14F1 grinding wheels are designed for use on Weinig machines for grinding profile knives for the wood industry.

14F1 PROFILE GRINDING



ADDITIONAL INFORMATION
For Weinig machines

DxUxX (mm)	R (mm)	H (mm)	T (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
CBN							
200x2x7	1	60	10	129	CB126 T B99	1	7958732990
200x4x7	2	60	10	134	CB151 W B99	1	7958732988

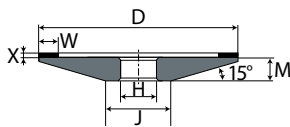


DIAMOND & CBN WHEELS FOR GENERAL ENGINEERING MILLING CUTTERS

Grinding tool faces and clearances are the main applications of the milling cutter.

Norton offers a diverse range of grinding wheels to enable excellent performance in both applications. A comprehensive range of grit sizes and concentrations provides the ideal solution for each application. The price vs. performance ratio of these tools is the underlying benefit of this product range.

4A2 FACE GRINDING



DxWxX (mm)	H (mm)	M (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
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DIAMOND

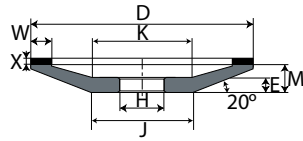
125x5x2	20	7	84	ASD126 R75 B99	1	7958732870
125x5x2	32	7	84	ASD91 R75 B99	1	7958732866
150x5x2	20	9	94	ASD126 R75 B99	1	7958732864
150x5x2	32	9	94	ASD91 R75 B99	1	7958732855

CBN

100x5x2	20	6	66	CB126 T B99	1	7958732884
150x5x4	20	9	94	CB107 T B99	1	7958732852

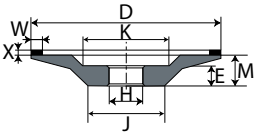
12A2-20° FACE GRINDING

DxWxX (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
125x6x4	32	14	54	8	54	ASD91 R75 B99	1	60157682172
150x5x2	20	16	68	9	68	ASD64 R50 B99	1	69014151397
150x5x2	32	16	68	9	68	ASD126 R75 B99	1	69014151963
CBN								
150x5x4	20	16	68	9	68	CB126 Q B99	1	69014151412



13A2 FACE GRINDING

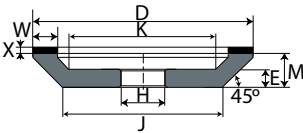
DxWxX (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
125x5x4	20	19	50	9	73	ASD126 R75 B99	1	7958732991**



** Available while stocks last

12A2-45° TOP GRINDING

DxWxX (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	SPECIFICATION	PK QTY	ART NO.
DIAMOND								
100x5x2	20	23	54	10	56	ASD107 R50 B99	1	7958732999
100x6x3	20	20	64	10	62	ASD76 R75 B99	1	7958732968
100x6x3	20	20	64	10	62	ASD126 R75 B99	1	7958732966
125x6x3	32	23	83	10	81	ASD126 R75 B99	1	7958732969
CBN								
125x6x2	20	23	83	10	81	CB126 T B99	1	7958732970





DIAMOND LAPPING COMPOUNDS FOR GENERAL ENGINEERING

Norton lapping compounds are supplied in a standard concentration of 5g dispenser syringes. Perfectly sized synthetic diamond powder is mixed with a paste. When used, this compound should be diluted with water or alcohol.

APPLICATIONS & MARKETS

- Used for lapping an extremely wide range of parts by hand
- Superfinishing of electronic components, semi-conductors, magnetic heads, rigid discs and optical discs
- Finishing for routine operations
- Preparatory lapping
- Fast removal of material, roughing

DIAMOND COMPOUND PASTE

- Optimised diamond grit distribution
- Easy and safe application

GRADE (MICRONS)	COLOUR	CONTENTS	PK QTY	ART NO.
1/4	GREY	5g	1	69014154990
1/2	LIGHT GREY	5g	1	69014154991
1	IVORY	5g	1	69014154992
3	YELLOW	5g	1	69014154993
6	ORANGE	5g	1	69014154994
9	GREEN	5g	1	69014154995
12	LIGHT BLUE	5g	1	69014154996
15	BLUE	5g	1	69014154997
20	BROWN	5g	1	69014154998
30	RED	5g	1	69014154999
45	CHESTNUT	5g	1	69014155000
60	VIOLET	5g	1	69014155001









DIAMOND FILES FOR GENERAL ENGINEERING

Norton offers a range of diamond files in various shapes for deburring, tool profiling, hardened steel and metal carbides, glass, ceramics and hard plastics.

FILES

- Free cutting and very high wear resistant, requiring only low contact pressure

SHAPE	BASE BODY CROSSSECTION	LENGTH OF DIAMOND LAYER	TOTAL LENGTH	SHAFT Ø	GRIT SIZE	PK QTY	ART NO.
	5x1	70	140	3	D91	1	66260134227
	5x1	70	140	3	D126	1	66260134228
	3.5	70	140	3	D126	1	66260134231
	5x2	70	140	3	D91	1	66260110230
	5x2	70	140	3	D126	1	66260134235
	Ø 3	70	140	3	D126	1	66260134237





DIAMOND DRESSERS FOR CONVENTIONAL GRINDING WHEELS

Norton-Winter stationary diamond dressing tools have a worldwide reputation for quality and technology. Ideal for profiling and straight dressing of all conventional grinding wheels.

PRODUCT SELECTION GUIDE

APPLICATIONS	STRAIGHT PLUNGE GRINDING	ANGULAR PLUNGE / PROFILE GRINDING	CENTRELESS / THROUGH-FEED GRINDING	INTERNAL GRINDING	DIAFORM	SINTERED GRAINS
PROFILE AVAILABILITY						
Blade tool with CVD		●				●
Blade tool with natural grains	●	◐	●			◐
Profile dresser					●	
Multi point	◐		◐			
Single point				●		
					● Highly recommended	◐ Recommended



WIRE BRUSHES FOR ANGLE GRINDERS

Wire brushes are excellent tools for deburring, removing rust, paint, corrosion and weld splatter from metal surfaces. They're almost spark free and with lower thermal impact, reduce the risk of workpiece burn. Norton offers a number of brush types and sizes for large flat areas to small, tight spaces. All provide a uniform finish and excellent price/performance ratio.

PRODUCT SELECTION GUIDE

FOR ANGLE GRINDERS

ANGLE GRINDER SIZE (mm)*	115	125	150	180	230
BRUSH TYPES	BRUSH DIAMETER (mm)*				
Wheel brush, knotted	100,115	75, 80, 100	115,125, 150	150, 178	178
Wheel brush, crimped	100,115	75, 80, 100, 125	115, 125, 150	115, 125, 150	178
Cup brush, knotted	65	75, 80, 100	80, 100	100, 125, 150	125, 150
Cup brush, crimped	60	75, 80, 100	80,100	100, 125, 150	125,150

* Please, check always MOS (Maximum operation Speed) marked on the wire brush and machine operation speed.

BY APPLICATION

Highly recommended ●

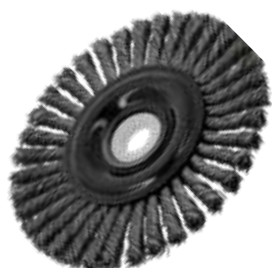
APPLICATIONS	WIRE DIAMETER (mm)				
	0.2	0.3	0.35	0.5	0.8
Roughening				●	●
Planing	●	●	●		
Deburring	●	●	●		
Edge honing	●	●	●		
Descaling/paint stripping	●	●	●	●	●
Weld seams	●	●	●	●	●

BY TYPE & MATERIAL

Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM
Normal steel	●	●			
Stainless steel			●	●	●

WIRE BRUSHES FOR ANGLE GRINDERS

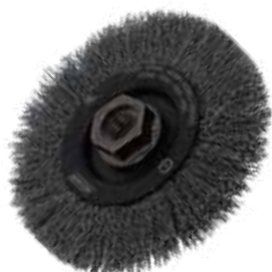


PIPELINE HIGH PERFORMANCE TWIST KNOTTED WHEEL BRUSHES **+++++**

- Long life, high material removal, for high-speed work
- Aggressive removal of welding scale and weld removal of tube joints in pipelines

DxBxA L (mm)	NO. KNOTS	RECOMMENDED RPM	PK QTY	STEEL	STAINLESS STEEL
0.50 mm					
115x6x22.2 T22	36	6300 - 12500	10	63642581151	63642581639
125x6x22.2 T23	42	5500 - 11000	1	63642581157	-
	42	5500 - 11000	15	-	63642581640
178x6x22 T35	76	4000 - 8000	15	63642581169*MTO	-

*MTO; Made-to-order



NEW! CRIMPED WHEEL BRUSHES **+++++**

- For cleaning light surface oxidation, paint and primers without removing the base material
- Wheel shape makes it easier to access hard-to-reach areas

DxBxA L (mm)	RECOMMENDED RPM	PK QTY	STEEL	STAINLESS STEEL
0.30 mm				
115x15xM14 T25	6300 - 12500	1	78072749618	-
115x15 x M14 T25	6300 - 12500	1	-	78072749622



TWIST KNOTTED WHEEL BRUSHES **+++++**

- Aggressive brush for de-burring, edge honing, removing rust, paint and weld spatter

DxBxA L (mm)	RECOMMENDED RPM	PK QTY	STEEL	STAINLESS STEEL
0.35 mm				
125x13x22.2 T28	5500 - 11000	1	66254406178	-
0.50 mm				
115x11x22.2 T23	6300 - 12500	15	-	78072704146
115x11x22.2 T23	6300 - 12500	1	66254406167	66254406153
115x11xM14 T23	6300 - 12500	1	66254406160	-
125x13x22.2 T28	5500 - 11000	1	66254406166	-
178x15x22.2 T35	4500 - 8500	1	66254406163	-

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length



TWIST KNOTTED CUP BRUSHES WITH GUARD **++++**

- Aggressive brush for removing rust, paint and weld spatter on large surfaces
- Includes a guard for added protection from dust and particles when in use

DxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.50 mm				
65xM14 T20	115 & 125	1	66261103046	66261103171



TWIST KNOTTED CUP BRUSHES **++++**

- Aggressive brush for removing rust, paint, weld spatter from large surfaces

DxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.35 mm				
65xM14 T20	115	1	66254406104	-
0.50 mm				
65xM14 T20	115	1	66254406095	66254406068
80xM14 T25	125	1	66254406094	-
100xM14 T25	150	1	66254406088	-



CRIMPED CUP BRUSHES WITH GUARD **++++**

- Multi-purpose brush for the most common cleaning jobs
- Includes a protection guard to shield the user from dust and particles when in use

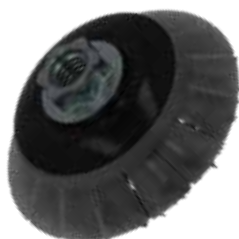
DxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.30 mm				
75xM14 T22	115 & 125	1	66261103049	66261103176



CRIMPED WIRE CUP BRUSHES **++++**

- For cleaning light oxidation, paint and primers of large areas

DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.30 mm				
60xM14 T16	115	1	66254406058	66254406037
75xM14 T20	125	1	66254406055	-
80xM14 T25	125	1	66254406054	66254404868
100xM14 T30	150	1	66254406053	-
125xM14 T35	230	1	66254406050	-
150xM14 T55	230	1	66254406049	-



TWIST KNOTTED BEVEL BRUSH WITH GUARD **++++**

- Aggressive brush for hard-to-reach areas
- Integrated guard offers protection against flying chips of material whilst maintaining surface visibility

DxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.50 mm				
100xM14 T22	115	1	66261103055	66261103179



TWIST KNOTTED BEVEL BRUSHES **++++**

- Twisted knotted wires for aggressive applications including preparing joints for welding and removing welds and heavy scale.

DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.50 mm				
100x13xM14 T20	115	1	66254406149	66254406146
115x15xM14 T27.5	125	1	66254406147	66254406144

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length



CRIMPED WIRE BEVEL BRUSH WITH GUARD **++++**

- For removal of light rust, corrosion, paint and primer
- Guard offers extra protection against chips

DxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL	STAINLESS STEEL
0.30 mm				
100xM14 T24	115	1	66261103056	66261103180



CRIMPED WIRE BEVEL BRUSHES **++++**

- Crimped wire is thinner and more flexible than knotted wire
- Bevel shape is designed for hard-to-reach areas including edges and corners

DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	STEEL
0.50 mm			
100x13xM14 T20	115	1	66254406142
115x15xM14 T27.5	125	1	66254406109





WIRE BRUSHES FOR HAND DRILLS

Norton wire brushes for hand drills are ideal for small and hard-to-reach areas like inner diameters of holes and tubes. Used with medium pressure, the brushes are almost spark free, reducing thermal damage on the workpiece. A number of brush types are available for different application needs.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	WIRE DIAMETER (mm)			
	0.2	0.3	0.35	0.5
Roughing			●	●
Planing	●	●	●	
Deburring	●	●	●	●
Edge honing	●	●	●	
Descaling/paint stripping		●	●	●
Weld seams	●	●	●	

BY TYPE & MATERIAL

Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFTWOOD	HARDWOOD
	Normal steel	●	●				●
Stainless steel			●	●	●		
Brass wire				●		●	



TWIST KNOTTED WIRE BRUSHES WITH SHANK ++++

- For aggressive removal of rust, corrosion, paint and primer

DxB L (mm)	SHANK (mm)	PK QTY	STEEL
0.35 mm			
70x15 T15	6	12	66254405406
0.50 mm			
70x15 T15	6	12	66254405407



TWIST KNOTTED END BRUSHES ++++

- Perfect for heavy-duty cleaning and deburring in hard-to-reach areas on pipes, tubes and internal diameters.

DxBxL (mm)	SHANK (mm)	PK QTY	STEEL	STAINLESS STEEL
0.20 mm				
25x69 T26	6	50	-	- 77696091115
0.35 mm				
19x68 T26	6	12	66254405421	- -
22x68 T26	6	12	66254405422	- -
0.50 mm				
28x68 T26	6	12	66254405423	- -



DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length



CRIMPED WIRE BRUSHES WITH SHANK

- For removal of light rust corrosion, paint and primer from hard-to-reach areas, edges and corners

DxB L (mm)	SHANK (mm)	PK QTY	STEEL +++	STAINLESS STEEL ++++	BRASS +++
0.20 mm					
20x4 T3	6	10	66254404872	-	- - -
30x6 T6.5	6	10	66254404875	-	- - -
30x9 T6.5	6	10	66254404876	66254404909*	-
40x9 T9	6	10	66254404879	66254404910*	-
50x10 T12.5	6	10	66254404880	-	- - -
50x15 T12.5	6	10	66254404881	66254405238*	66254405397
60x10 17.5	6	10	-	- 66254405269*	-
60x15 17.5	6	10	66254404885	66254405270*	-
70x10 T19	6	10	66254404886	66254405271*	-
80x20 T19	6	10	-	- -	66254405405
0.30 mm					
50x10 T12.5	6	10	66254404891	-	- - -
70x10 T19	6	10	66254404899	66254405395*	-
70x15 T19	6	10	-	- 66254405396*	-
80x20 T19	6	10	66254404907	66254405398*	-

* 12PK QTY

CRIMPED WIRE END BRUSHES WITH SHANK (ENB) ++++



- Small diameter and flexible wire is perfect for light cleaning of small and hard-to-reach areas including pipes and internal diameters

DxBxL (mm)	SHANK (mm)	PK QTY	STEEL	STAINLESS STEEL
0.20 mm				
12x60 T20	6	12	66254405408	-
17x65 T22	6	12	66254405409	-
0.30 mm				
12x60 T20	6	12	66254405410	66254405414
17x65 T26	6	12	66254405411	66254405415
24x68 T26	6	12	66254405412	66254405418
30x68 T26	6	12	66254405413	66254405419

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length



WIRE BRUSHES FOR BENCH GRINDERS

Wire wheel brushes for bench grinders are commonly used to remove rust, corrosion, hardened paint and adhesive residues, providing a good surface finish on large or small work pieces at a good price/performance ratio.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	WIRE DIAMETER (mm)		
	0.2	0.3	0.5
Roughing			●
Surface preparation	●	●	
De-burring	●	●	
Edge honing	●	●	
Descaling/paint stripping	●	●	●
Weld seams	●	●	●

BY TYPE & MATERIAL

Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFTWOOD	HARDWOOD
	Normal steel	●	●				●
Stainless steel			●	●	●		

WIRE BRUSHES FOR BENCH GRINDERS



CRIMPED WHEEL BRUSHES (WHB)

- Ideal for removing corrosion, rust, hardened paints and hard adhesive residues

DxBxAxR L (mm)	PK QTY	STEEL	STAINLESS STEEL	
0.20 mm				
200x26x32x80 T40	1	66254406401	-	-
0.30 mm				
125x24x20x30 T36	1	66254406282	-	-
200x36x32x80 T40	1	66254406243	-	-



CRIMPED WHEEL BRUSHES (WHB)

- Ideal for removing corrosion, rust, hardened paints and hard adhesive residues

DxBxAxR L (mm)	PK QTY	STEEL	STAINLESS STEEL	
0.30 mm				
100x11x12x20 T22	1	66254406455	-	-
150x18x32x50.8 T27	1	66254406265	66254406206	-
180x22x32x50.8 T42	1	66254406263	-	-
200x26x32x80 T40	1	66254406255	66254406187	-
250x32x50.8x100 T50	1	66254406241	-	-

FOR MORE INFORMATION VISIT
www.nortonabrasives.com





WIRE BRUSHES FOR MANUAL APPLICATIONS

Simple brushing operations can be carried out by hand using Norton manual brushes. A number of brush types are available for different applications including cleaning and removing rust, scale and paint.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	TYPE OF WIRE			
	BRASS	CRIMPED	STRAIGHT	NYLON/PVC
Descaling/paint stripping		●		
Weld seams		●		
Brushing/dust removal			●	●
Light cleaning	●			●

BY TYPE & MATERIAL

Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFTWOOD	HARDWOOD
	Normal steel	●	●				●
Stainless steel			●	●	●		
Brass wire				●		●	

BRUSHES WITH WOODEN HANDLE



- Easy manual cleaning of paint, rust, primers, hardened adhesives and silicones.



L1xL2xL (mm)	NUMBER OF ROWS	PK QTY	ART NO.
WOOD HANDLE NORMAL STEEL STRAIGHT WIRE 0.30 mm			
290x140x25	2R	12	66254405432
WOOD HANDLE STAINLESS STEEL CRIMPED WIRE 0.30 mm			
290x140x25	4R	12	66254405461
WOOD HANDLE BRASS CRIMPED WIRE 0.30 mm			
290x140x25	4R	12	66254405466



WOOD HANDLE NORMAL STEEL STRAIGHT WIRE 0.30 mm			
290x140x25	3R	30	66254405434
290x140x25	4R	24	66254405435
290x140x25	5R	20	66254405437
PLASTIC HAND STAINLESS STEEL STRAIGHT WIRE 0.30 mm			
290x140x25	3R	30	78072755571
290x140x25	4R	24	66254405447



BRUSHES WITH PLASTIC HANDLE

- Easy cleaning with an ergonomic plastic grip



L1xL2xL (mm)	NUMBER OF ROWS	PK QTY	ART NO.
PLASTIC HAND NORMAL STEEL STRAIGHT WIRE 0.30 mm			
265x140x25	1R	12	66254405470
PLASTIC HAND STAINLESS STEEL STRAIGHT WIRE 0.30 mm			
265x140x25	1R	12	66254405471
PLASTIC HAND BRASS CRIMPED WIRE 0.30 mm			
265x140x25	1R	12	66254405473



NON SPARK HAND BRUSH

- For use in potentially explosive environments, where 'traditional' wire brushes may create sparks.



L1xL2xL (mm)	WIRE	ROWS	PK QTY	ART NO.
SPB				
200x18x45	0.20	3x6R	12	66254405474

PIPE BRUSHES WITH THREAD **++++**



- For cleaning internal diameters of pipes

L1xL2xL (mm)	WIRE	THREAD	PK QTY	ART NO.
STEEL				
10x90x140	0.25	W ¼	20	78072753590
18x90x140	0.25	W ¼	20	78072753605
25x120x190	0.4	W ½	20	78072753616
30x120x190	0.4	W ½	20	78072753620
40x120x190	0.4	W ½	20	78072753626
50x120x190	0.4	W ½	20	78072753634
75x120x190	0.4	W ½	10	78072753635



OPERATING SPEED






Peripheral speed is a decisive factor in achieving optimum performance from a brush, the table opposite enables you to determine the relevant peripheral speed by simply reading down and across the appropriate diameter and drive shaft operating speed columns.

RPM	BRUSH DIAMETER (mm)												
	20	40	50	80	100	125	150	180	200	250	300	350	
min ⁻¹	-	-	-	-	-	-	-	-	-	-	-	-	-
800	-	-	-	3.35	4.19	5.23	6.28	7.53	8.37	10.47	12.56	14.75	-
900	-	-	2.35	3.77	4.71	5.88	7.06	8.48	9.41	11.77	14.12	16.47	-
1150	-	-	3.01	4.81	6.01	7.52	9.02	10.83	12.03	15.04	18.04	21.04	-
1200	1.26	2.51	3.14	5.02	6.28	7.85	9.41	11.3	12.55	15.69	18.83	21.97	-
1400	1.46	2.93	3.66	5.86	7.32	9.15	10.98	13.18	14.64	18.31	21.97	25.63	-
1500	1.57	3.14	3.92	6.28	7.85	9.81	11.77	14.13	15.69	19.61	23.54	27.46	-
1800	1.88	3.77	4.71	7.54	9.41	11.77	14.12	16.95	18.83	23.54	28.24	32.95	-
2000	2.09	4.19	5.23	8.37	10.26	13.08	15.69	18.84	20.92	26.15	31.38	36.61	-
2500	2.62	5.23	6.54	10.47	13.08	16.35	19.61	23.55	26.15	32.67	39.23	45.76	-
2800	2.93	5.86	7.32	11.72	14.64	18.31	21.97	26.37	29.29	36.61	43.93	51.25	-
3000	3.14	6.28	7.85	12.56	15.69	19.62	23.54	28.26	31.38	39.23	47.07	54.92	-
3200	3.35	6.7	8.37	13.4	16.74	20.92	25.1	30.14	33.47	41.84	50.21	58.58	-
3500	3.66	7.33	9.15	14.65	18.31	22.89	27.46	32.97	36.61	45.76	54.92	64.07	-
4000	4.19	8.37	10.46	16.75	20.92	26.16	31.38	37.68	41.84	52.33	62.76	73.22	-
4500	4.7	9.42	11.77	18.84	23.54	29.43	35.3	42.4	47.07	58.84	70.61	82.43	-
5000	5.23	10.47	13.08	20.93	26.15	32.7	39.23	47.1	52.33	65.38	78.5	-	-
5400	5.65	11.3	14.12	22.94	28.24	35.31	42.36	50.67	56.48	70.61	84.78	-	-
6000	6.28	12.56	15.69	25.12	31.38	39.24	47.07	56.52	62.76	78.5	-	-	-
7000	7.33	14.66	18.31	29.31	36.61	45.78	54.92	65.94	73.22	91.58	-	-	-
8000	8.37	16.75	20.92	33.94	41.48	52.32	62.76	75.36	83.73	-	-	-	-
9000	9.42	18.84	23.54	37.68	47.07	58.86	70.61	84.78	94.2	-	-	-	-
10000	10.47	20.93	26.17	41.86	52.33	65.4	78.5	94.2	-	-	-	-	-
12500	13.08	26.17	32.71	52.33	65.42	81.75	98.13	-	-	-	-	-	-
15000	15.7	31.4	39.25	62.8	-	-	-	-	-	-	-	-	-
17500	18.32	36.63	45.79	73.26	-	-	-	-	-	-	-	-	-
20000	20.93	41.87	52.33	83.73	-	-	-	-	-	-	-	-	-
22500	23.55	47.1	58.88	94.2	-	-	-	-	-	-	-	-	-
25000	26.17	52.33	65.42	104.66	-	-	-	-	-	-	-	-	-

HOW TO READ THIS TABLE

Select your brush diameter, then move down till you reach desirable peripheral speed in m/s, after check on the left side of the table the value for the RPM. Check on page 403 the maximum operating speed per type of brush.

MAXIMUM OPERATING SPEED

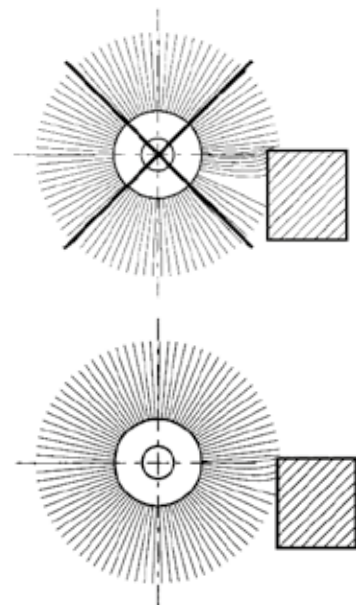
TYPE	DIAMETER (mm)	MAX RPM	TYPE	DIAMETER (mm)	MAX RPM
 WHEEL BRUSHES	80	10000	 BEVEL BRUSHES	100	11000
	100	8000		100/115	11000
	125	6000		115	10000
	150	6000	 TWIST KNOTTED WHEEL BRUSHES	100	11000
	180	6000		115	11000
	200	4500		125	10000
	250	3600		150/180	8500
	250 - 1 row	3500		200	6500
300	3000	20	20000		
 CUP BRUSHES	60/65/75	11000	 SHAFT MOUNTED WIRE BRUSHES	30	20000
	60/65/75	11000		40	18000
	60/65/75	10000		50	15000
	75	9300		60	15000
	80/100	8500		70	15000
	125/150	6500		80	12000

The maximum RPM ratings are safety ratings not recommended operating speeds. The optimum operating speed is determined by the application and in most cases lower operating speeds will prove more efficient and achieve the best result. As a general guide we recommend the following peripheral speeds when working on the materials listed with:

APPLICATION	CRIMPED WIRE	TWIST KNOTTED
STEEL	30m/s	35-40m/s
NON-FERROUS	18-20m/s	-
PLASTIC	15m/s	-

BRUSHING PRESSURE

- Let the tip of the wire brush do the work. Operate the brush with the lightest pressure so only the tips of the wire come in contact with the work
- If heavy pressure is used, wires will be over stressed, resulting in a wiping action, and if this is continued, the life of the brush will be shortened due to wire fatigue
- Apply the work to the face of the brush ensuring as much of the brush face as possible is in full contact. Applying the work to the side or edge of the brushing tool will result in wire breakage and shortened brush life
- Reversing the wheel brush rotation periodically will tend to increase the life of the brush. This results in the sharpening of the wire tips or ends, ensuring faster cutting action



SIZE OF WIRE

- Use the finest size of wire suitable for the application
- Finer wire size will perform better and last longer than heavier

TROUBLESHOOTING

Several factors can influence a brush application. If the selected brush does not achieve the expected result, the following table may provide solutions for the most common problems faced by a user. For further information, please contact our technical department.

PROBLEM	RECOMMENDED ACTIONS
Brush is too aggressive	Increase trim length
	Reduce wire diameter
	Reduce operating speed
Brush is not aggressive enough	Reduce trim length
	Increase wire diameter
	Increase operating speed
Action of brush does not totally remove scale	Reduce trim length
	Increase wire diameter
Finish is too coarse	Increase trim length
	Reduce wire diameter
	Increase operating speed
	Choose a nylon abrasive brush
Finish is too smooth	Reduce trim length
	Increase wire diameter
Action of brush is not uniform	Reduce brushing pressure
	Automate operations to avoid human inaccuracy
Wire breaks more than usual	Reduce brushing pressure
	Reduce wire diameter
	Reduce operating speed
Life of the brush is too short	Reduce wire diameter
	Increase brush diameter
	Reduce brushing pressure

SAFETY & STORAGE

Safety goggles or full face protection with side shields must be worn by all operators and others in the immediate area of power brush operations.

- Keep all machine guards in place
- Observe all speed restrictions indicated on brushes
- Appropriate protective clothing and equipment must be used
- Brushes should be carefully checked when removed from the original carton. Do not use if rusted or damaged
- Store brushes in the original carton. Wire brushes should not be exposed to heat, high humidity, acids, fumes or liquids that can result in deterioration of the wire filaments, and subsequently, premature failure of the wires. Also, check for distortion of brush fill that can cause imbalance and excessive vibration when the brush is running
- Check maximum spindle speed. Do not mount and operate the brush if spindle RPM exceeds the maximum safe free speed for which the brush is rated. Spindle length should be sufficient to permit a full nut mounting
- Before starting the machine, rotate the wire brush with a gloved hand to determine that the brush has been correctly mounted and turns freely