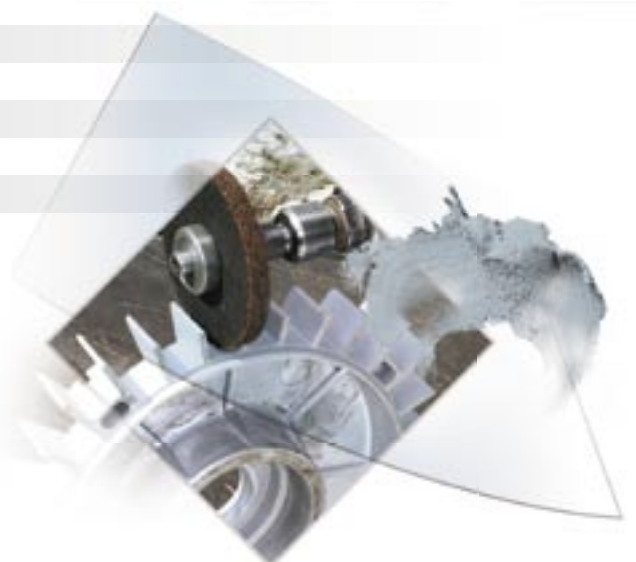
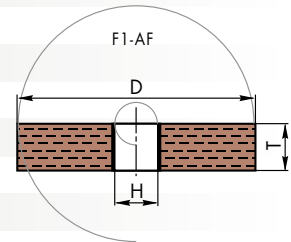


Grinding wheels F1-AF are intended for cleaning casts and forged pieces using flat, manual grinding machines. They are distinguished by optimal material removal rates and appropriate durability without workpiece overheating.

| QUALITY | HARDNESS | MATERIAL | QUALITY CLASS |
|------------|----------|-----------------|---------------|
| 10A24-30-B | R-S | Metals, steels | Standard |
| 15A30-B | P-R | Metals, steels | Standard |
| 47A30-B | Q-R | Stainless steel | Special |
| 47A24-30-B | R-S | Alloys | Special |

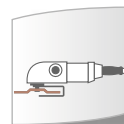
| Type | Dimensions D x T x H mm | Peripheral speed m/s | Rpm 1/min | Packaging units |
|-------|-------------------------------|----------------------------|--------------|--------------------|
| F1-AF | 50 x 4 x H | 80 | 30600 | 25 |
| F1-AF | 50 x 6 x H | | 30600 | |
| F1-AF | 50 x 10 x H | | 30600 | |
| F1-AF | 50 x 12 x H | | 30600 | |
| F1-AF | 60 x 4 x H | | 25500 | |
| F1-AF | 60 x 6 x H | | 25500 | |
| F1-AF | 60 x 10 x H | | 25500 | |
| F1-AF | 60 x 12 x H | | 25500 | |
| F1-AF | 65 x 6 x H1 | | 23500 | |
| F1-AF | 65 x 10 x H1 | | 23500 | |
| F1-AF | 65 x 12 x H1 | | 23500 | |
| F1-AF | 70 x 6 x H1 | | 21800 | |
| F1-AF | 70 x 10 x H1 | | 21800 | |
| F1-AF | 70 x 12 x H1 | | 21800 | |
| F1-AF | 76 x 6 x H1 | | 20100 | |
| F1-AF | 76 x 10 x H1 | | 20100 | |
| F1-AF | 76 x 12 x H1 | | 20100 | |
| F1-AF | 80 x 4 x H1 | | 19100 | |
| F1-AF | 80 x 6 x H1 | | 19100 | |
| F1-AF | 80 x 10 x H1 | | 19100 | |
| F1-AF | 80 x 12 x H1 | 19100 | | |
| F1-AF | 100 x 6 x H2 | 15300 | | |
| F1-AF | 100 x 10 x H2 | 15300 | | |
| F1-AF | 100 x 12 x H2 | 15300 | | |



| mm | | | | |
|----|---|----|----|----|
| H | 6 | 10 | | |
| H1 | 6 | 10 | 12 | |
| H2 | | 10 | 12 | 20 |



GRINDING WHEELS



The STANDARD grinding wheels are intended for grinding and cleaning of welds, casts and forged pieces.

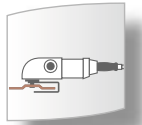
| QUALITY | MATERIAL | QUALITY CLASS |
|-----------|------------------------|---------------|
| A24-S-BF | Steel, metals | Standard |
| 20A24P-BF | Stainless steel, steel | Standard |
| 19A24S-BF | Grey cast, aluminium | Standard |
| C24S-BF | Stone, concrete | Standard |

| Type | Dimensions D x T x H mm | Peripheral speed | | Packaging units |
|---------|-------------------------------|---------------------|--------------|--------------------|
| | | m/s | Rpm 1/min | |
| F27 | 100 x 4 x 16 | 80 | 15300 | 10 |
| F27 | 100 x 6 x 16 | | 15300 | |
| F27 | 100 x 7 x 16 | | 15300 | |
| F27 | 115 x 4 x 22.23 | | 13300 | |
| F27 | 115 x 6 x 22.23 | | 13300 | |
| F27 | 115 x 7 x 22.23 | | 13300 | |
| F27 | 115 x 8 x 22.23 | | 13300 | |
| F27 | 125 x 4 x 22.23 | | 12250 | |
| F27 | 125 x 6 x 22.23 | | 12250 | |
| F27 | 125 x 7 x 22.23 | | 12250 | |
| F27 | 125 x 8 x 22.23 | | 12250 | |
| F27 | 150 x 4 x 22.23 | | 10200 | |
| F27 | 150 x 6 x 22.23 | | 10200 | |
| F27 | 150 x 7 x 22.23 | | 10200 | |
| F27 | 150 x 8 x 22.23 | | 10200 | |
| F27 | 178 x 4 x 22.23 | | 8500 | |
| F27 | 178 x 6 x 22.23 | | 8500 | |
| F27 | 178 x 7 x 22.23 | | 8500 | |
| F27 F28 | 178 x 8 x 22.23 | | 8500 | |
| F27 | 178 x 10 x 22.23 | | 8500 | |
| F27 | 230 x 4 x 22.23 | 6650 | | |
| F27 | 230 x 6 x 22.23 | 6650 | | |
| F27 | 230 x 7 x 22.23 | 6650 | | |
| F27 F28 | 230 x 8 x 22.23 | 6650 | | |
| F27 | 230 x 10 x 22.23 | 6650 | | |



On customer request, grinding wheels can also be produced as type F27-GR.





The EXTRA grinding wheels are intended for professional use in industry whenever large material removal rates per time unit and a high grinding factor are required.

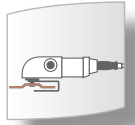
| QUALITY | MATERIAL | QUALITY CLASS |
|---------|----------|---------------|
|---------|----------|---------------|

| | | |
|------------|------------------------|-------|
| EA24R-BF | Steel, metals | Extra |
| E20A24R-BF | Stainless steel, steel | Extra |
| E54A30R-BF | Aluminium, alloys | Extra |

| Type | Dimensions D x T x H mm | Peripheral speed m/s | Rpm 1/min | Packaging units |
|------|-------------------------------|----------------------------|--------------|--------------------|
| F27 | 100 x 4 x 16 | 80 | 15300 | 10 |
| F27 | 100 x 7 x 16 | | 15300 | |
| F27 | 115 x 4 x 22.23 | | 13300 | |
| F27 | 115 x 7 x 22.23 | | 13300 | |
| F27 | 115 x 8 x 22.23 | | 13300 | |
| F27 | 125 x 4 x 22.23 | | 12250 | |
| F27 | 125 x 7 x 22.23 | | 12250 | |
| F27 | 125 x 8 x 22.23 | | 12250 | |
| F27 | 150 x 4 x 22.23 | | 10200 | |
| F27 | 150 x 7 x 22.23 | | 10200 | |
| F27 | 150 x 8 x 22.23 | | 10200 | |
| F27 | 178 x 4 x 22.23 | | 8500 | |
| F27 | 178 x 7 x 22.23 | | 8500 | |
| F27 | 178 x 8 x 22.23 | | 8500 | |
| F27 | 230 x 4 x 22.23 | | 6650 | |
| F27 | 230 x 7 x 22.23 | | 6650 | |
| F27 | 230 x 8 x 22.23 | | 6650 | |








SEMI-FLEXIBLE GRINDING WHEELS



Semi-flexible grinding wheels are intended for general cleaning of large surface areas. They are produced in grit sizes between 24 and 100, to be used for coarse, medium or fine grinding.

| QUALITY | MATERIAL | QUALITY CLASS |
|----------------|-------------------------|---------------|
| A24 - A100 | Steel | Standard |
| 20A24 - 20A100 | Stainless steel | Standard |
| 19A24 - 19A100 | Grey cast | Standard |
| C24 - C100 | Stone, concrete, marble | Standard |

| QUALITY | MATERIAL | QUALITY CLASS |
|----------------|-------------------------|---------------|
| A24 - A100 | Steel | Standard |
| 20A24 - 20A100 | Stainless steel | Standard |
| 19A24 - 19A100 | Grey cast | Standard |
| C24 - C100 | Stone, concrete, marble | Standard |

| Type | Dimensions D x T x H mm | Peripheral speed m/s | Rpm 1/min | Packaging units |
|---|-------------------------------|----------------------------|--------------|--------------------|
| F29  | 100 x 3.5 x 22.23 | 80 | 15300 | 25 |
| F29  | 115 x 3.5 x 22.23 | | 13300 | |
| F29  | 125 x 3.5 x 22.23 | | 12200 | |
| F29  | 150 x 3.5 x 22.23 | | 10200 | |
| F29  | 178 x 3.5 x 22.23 | | 8600 | |



Backing pads for semi-flexible grinding wheels are enclosed in each basic package.

Always use backing pads with diameter 100 mm for semi-flexible grinding wheels with diameters 100 mm, 115 mm and 125 mm, and with diameter 130 mm for wheels with diameters 150 mm and 178 mm.

NEVER use semi-flexible grinding wheel without a backing pad!

