Bonded
Abrasives

Be Safe. Protect Yourself.

Start cut gently.

"Excessive heat can cause cut-off wheels to not cut straight or produce too much burring."

"A worn arbor shaft can cause the wheel to mount off center."

Safety Guide

General Safety Guide

- Grinding wheels improperly used are dangerous. Be safe. Protect yourself. Adhere to American National Standards Institute (A.N.S.I.) standards.
- A.N.S.I. and the Occupational Safety & Health Administration (OSHA) have published standards concerning the proper use, handling and storage of abrasive wheels.
- It is recommended that all personnel involved in the use, handling and purchasing of abrasive wheels become familiar with these standards.
- The following guidelines are based on material contained in A.N.S.I. B7-1 "Safety Requirements for the Use, Care and Protection of Abrasive Wheels."
- This information is not intended as a substitute for full knowledge of A.N.S.I. and OSHA Standards.

Warning

- Avoid inhalation of dust generated by grinding and cutting operations. Exposure to dust may cause respiratory ailments. Use approved NIOSH and OSHA respirators, safety glasses, face shields, gloves and protective clothing. Provide adequate ventilation to eliminate dust, or to maintain dust level below the threshold limit value for nuisance dust as classified by OSHA.

Portable Grinding

- All portable grinders should be inspected at regular intervals to ensure that mounting flanges are in good condition, of proper size and shape, that the speed governing device is functioning properly, and that no damage has occurred to the grinder or wheel as a result of abusive use or careless handling.

Cutting Off

- Must be rigid and maintain straight line cuts.
- Must provide "hold down" of work piece; avoids pressure.
- Must have adequately heavy arbor and arbor bearings.
- Must have proper drive flanges, min. 1/4" wheel diameter. Flanges must be clean, straight, have the same diameters, and have the proper arbor clearance.
- Must have adequate guard over wheel, at least 1/2" diameter.
- Must be maintained in first class condition.
- Do - always start cut gently.
- Do not - grind on the side of a cut off wheel or stand directly in front of a grinding wheel when a grinder is started.

Solving User Problems with Abrasives

When users complain of problems with resin bonded abrasives, they usually can be attributed to one of the following causes:

- The wrong application for the wheel being used.
- The operator is not using the product correctly.
- The wheel is being used on a tool other than for which it was designed.
- The wheel is being used on the proper tool, but one that is worn or defective.

Wrong Application:

- The most common problem with abrasives is the wrong product application. The use of cut-off and grinding wheels that are too hard is a frequent misuse. Operators want long life and tend to opt for harder wheels than they should be using. If the wheel is too hard for the material being cut or ground, it will generate excessive heat causing wheel distortion or chipping. Excessive heat can cause cut-off wheels to not cut straight or produce too much burring.

Operator Misuse:

Some of the most common misuses encountered in the field are:

- Using depressed center wheels too flat causes face wear instead of edge wear.
- Not having the material, being cut or ground, properly clamped.
- Excessive force or too little force with cut-off wheels.

Using Wheels on the Wrong Tool:

- All abrasive wheels are designed to be used on specific types of tools. The tool factors include: rotation speed, power, wheel flanges or attachment means, safety guarding, and whether it is for fixed or off-hand use. Using wheels on tools that provide appreciably different conditions can cause serious safety problems and performance.

Defective Tools:

A worn tool can make an abrasive wheel look like a poor or defective product. Some of the most frequently encountered problems are:

- Bad bearings can cause excessive vibration or chattering.
- Mounting flanges or uneven size can warp cut-off wheels, causing them to cut unevenly. Flanges that are not clean and free from blotters can result in off-center mounting.
- A worn arbor shaft can cause the wheel to mount off center.
- Loss of power due to motor or power transmission problems will cause the wheel to slow and not cut properly.

Depressed Center Grinding Wheels - T27, T28 and T29

Type 27

General Purpose - A24R

- For general purpose grinding.
- Longer life for fewer wheel changes.

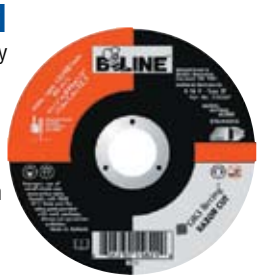
A24R	Size	Max RPM
27-41838	4" x 1/8" x 3/8"	15,000
41858	4" x 1/8" x 5/8"	15,000
27-41438	4" x 1/4" x 3/8"	15,000
41458	4" x 1/4" x 5/8"	15,000
4121878	4-1/2" x 1/8" x 7/8"	13,300
41231678	4-1/2" x 3/16" x 7/8"	13,300
41287T	4-1/2" x 1/8" x 5/8" - 11	13,300
4121478	4-1/2" x 1/4" x 7/8"	13,300
41247T	4-1/2" x 1/4" x 5/8" - 11	13,300
51878	5" x 1/8" x 7/8"	12,220
587T	5" x 1/8" x 5/8" - 11	12,220
51478	5" x 1/4" x 7/8"	12,220
547T	5" x 1/4" x 5/8" - 11	12,220
0787	7" x 1/8" x 7/8"	8,600
787T	7" x 1/8" x 5/8" - 11	8,600
0747	7" x 1/4" x 7/8"	8,600
747T	7" x 1/4" x 5/8" - 11	8,600
987T	9" x 1/8" x 5/8" - 11	6,640
947T	9" x 1/4" x 5/8" - 11	6,640

Type 28

Part No	Size	Grade	Max RPM
748T	7" x 1/4" x 5/8" - 11	A24R	8,600
948T	9" x 1/4" x 5/8" - 11	A24R	6,640

B-Flex Type 27 & 29 Reinforced

- **Grind and finish-** Can remove material as aggressively as a 24 grit depressed center wheel, and then blend in a "ready to paint" finish like a sanding disc.
- **Flexibility-** Flexes to follow contoured surfaces. A smooth finish with no gouging.
- **Versatility- no loading, no glazing-** One specification performs on a wide range of materials. No loading on soft material such as aluminum plus no glazing on hard material such as stainless steel.
- **Long life and economy-** Has an impressive ratio of material removal.
- **M-Medium Grade-** General purpose, metal grinding/finishing comparable to 24 through 60 grit sanding disc.
- **Iron-free-** For steel, stainless steel and aluminum.



Part No.	Size	Type	Max RPM	Spec
4A27M	4" x 1/8" x 5/8"	27	15,000	Medium
45A27M	4-1/2" x 1/8" x 7/8"	27	13,000	Medium
45A27MT	4-1/2" x 1/8" x 5/8" - 11	27	13,000	Medium
5A27M	5" x 1/8" x 7/8"	27	12,000	Medium
7A27M	7" x 1/8" x 5/8" - 11	27	8,600	Medium
7A29M	7" x 1/8" x 5/8" - 11	29	8,600	Medium

Thin Cut

- .045" ultra thin cutting wheel.
- Quick and easy cutting.
- Aluminum oxide wheels for steel and stainless steel.
- Iron-free eliminates contamination on stainless steel.

(AIO A46V)	Size	Max RPM
27RC57	5" x .045" x 7/8"	13,290

CP50 Adapter Kit

The CP50 Adapter Kit includes all parts necessary to properly mount a 7" or 9" Type 27 or 28 wheel on grinders with 5/8-11 NC spindles. One per package.

BB-3825 Adapter Mandrel

Permits the use of wheels with 3/8" arbor hole on die or pencil grinders with a 1/4" chuck. For wheels up to 4" diameter and 1/2" thickness. One per package.

Specifications For Die Grinders Only

A60T, A46T, A36R: General Purpose Metal

- Cutting - .035", 1/16", 1/8", and 3/16" thickness designed for fast, burr free cutting and slotting, Ideal for thin wall tube.

A36Q: Cutting & Peripheral Grinding

- Grinding - from 3/16" - 1/2" thick, these wheels perform on weld burr removal and surface conditioning of metal.

Type-1 Die Grinders- Reinforced

- For use on die grinders, small wheel grinders and some end grinders with straight or flexible shafts.
- Indispensable aids to production, construction and maintenance at refineries, power plants, foundries and fabrication shops.
- Wheel composition meets requirements of nuclear fabrication, pressure vessel and piping projects.
- Small diameter cut off wheels are available with 1/4" arbor.

Part No.	Size	Grade	Max RPM
203538	2" x .035" x 3/8"	A60T	31,513
211638	2" x 1/16" x 3/8"	A46T	31,513
21838	2" x 1/8" x 3/8"	A36R	31,513
303538	3" x .035" x 3/8"	A60T	25,461
311614	3" x 1/16" x 1/4"	A46T	20,400
311638	3" x 1/16" x 3/8"	A46T	25,461
31838	3" x 1/8" x 3/8"	A36R	25,461
31438	3" x 1/4" x 3/8"	A36Q	20,372
403538	4" x .035" x 3/8"	A60T	19,100
411614	4" x 1/16" x 1/4"	A46T	19,100
411638	4" x 1/16" x 3/8"	A46T	19,100
41838	4" x 1/8" x 3/8"	A36T	19,100
41438	4" x 1/4" x 3/8"	A36Q	19,100

Type-1 Dry Cutting on Stationary- Machines-Reinforced

- These wheels are designed for use on popular chop stroke machines, oscillating machines and other cut off machines where the work is fixed and the cutting plane of the wheel is controlled.

Part No.	Size	Grade	Max RPM
103258	10" x 3/32" x 5/8"	A30S	6,112
101858	10" x 1/8" x 5/8"	A30R	6,112
12181	12" x 1/8" x 1"	A30R	5,092
14181	14" x 1/8" x 1"	A30R	4,366
14321	14" x 3/32" x 1"	A30P	4,366
16181	16" x 1/8" x 1"	A30R	3,820
16321	16" x 3/32" x 1"	A30P	3,820
20181	20" x 3/16" x 1"	A30R	3,056

Type-1 Circular Saws-Reinforced

- Will transform any circular saw into a fast, effective economical tool to cut steel (in sheet, bar or profile) as well as concrete, brick and masonry products.
- These wheels feature a diamond arbor and are supplied with a 5/8" round bushing for use with both standard circular saw arbors.

Part No.	Size	Grade	Max RPM
ME718DIA	7" x 1/8" x 5/8"	A36TBF	8,600
ME818DIA	8" x 1/8" x 5/8"	A36TBF	7,500
MA718DIA	7" x 1/8" x 5/8"	C36R	8,600
MA818DIA	8" x 1/8" x 5/8"	C36R	7,500

A36TBF for metal, C36R for masonry.

Cup Wheels

Type 11 Flaring Cup Wheels

- **A16Q4B-** Aluminum oxide specification for general purpose work. Mild steels, stainless steels, alloys, cast steels. Most metals, most applications.
- **C16PB-** Silicon carbide specification for general purpose work on masonry.

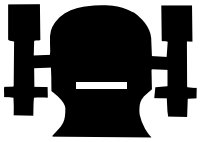
Part No.	Size	Grade	Max RPM
Without Safety Back - Aluminum Oxide			
0004	4/ 3" x 2" x 5/8" - 11"	A16Q4B	9,000
0005	5/ 4" x 2" x 5/8" - 11"	A16Q4B	7,200
0006	6/ 4-3/4" x 2" x 5/8" - 11"	A16Q4B	6,000
With Steel Safety Back - Aluminum Oxide			
004S	4/ 3" x 2" x 5/8" - 11"	A16Q4B	9,000
005S	5/ 4" x 2" x 5/8" - 11"	A16Q4B	7,200
006S	6/ 4-3/4" x 2" x 5/8" - 11"	A16Q4B	6,000
Without Safety Back - Silicone Carbide			
004C	4/ 3" x 2" x 5/8" - 11"	C16PB	9,000
006C	6/ 4-3/4" x 2" x 5/8" - 11	C16PB	6,000

Bench & Pedestal Grinding Wheels / Cones & Plugs

Straight Resinoid Wheels - Non-Reinforced

Wheels with 1" arbors have 1/2", 5/8", 3/4" bushings included.
Wheels with 1-1/4" arbors have 3/4", and 1" bushings included.

- Resin bonded wheels designed for general purpose shop grinding. More rugged than vitrified wheels.
- **Coarse:** 20 - 24 grit
- **Medium:** 30 - 36 grit
- **Fine:** 46 - 60 grit



Part No.	Size	Grit	Max RPM
6341C	6" x 3/4" x 1"	Coarse	6,048
6341M	6" x 3/4" x 1"	Medium	6,048
6341F	6" x 3/4" x 1"	Fine	6,048
611C	6" x 1" x 1"	Coarse	6,048
611M	6" x 1" x 1"	Medium	6,048
611F	6" x 1" x 1"	Fine	6,048
711C	7" x 1" x 1"	Coarse	5,183
711M	7" x 1" x 1"	Medium	5,183
711F	7" x 1" x 1"	Fine	5,183
811C	8" x 1" x 1"	Coarse	4,538
811M	8" x 1" x 1"	Medium	4,538
811F	8" x 1" x 1"	Fine	4,538
10114C	10" x 1" x 1-1/4"	Coarse	3,629
10114M	10" x 1" x 1-1/4"	Medium	3,629
10114F	10" x 1" x 1-1/4"	Fine	3,629
12214C	12" x 2" x 1-1/4"	Coarse	3,023
12214M	12" x 2" x 1-1/4"	Medium	3,023
12214F	12" x 2" x 1-1/4"	Fine	3,023
14214C	14" x 2" x 1-1/4"	Coarse	2,592
14214M	14" x 2" x 1-1/4"	Medium	2,592

Cones & Plugs

- **A20PB6-** Aluminum oxide general purpose. Use on mild steels, stainless steels, alloys - most metals and applications.
- For grinding pressure vessels and piping, boiler re-tubing and casting.
- All plugs and cones are dressed with mold skin removed ready to cut.

Type 16

Type 18

Type 18R

Size				Max RPM
1" x 3" x 3/8" - 24"	C1610303		C18R10303	36,300
1-1/2" x 2-1/2" x 3/8" - 24"	C1615253	P1815253	C18R15253	24,200
1-1/2" x 2-1/2" x 5/8" - 11"	C1615255	P1815255	C18R15255	24,200
1-1/2" x 3" x 3/8" - 24"	C1615303	P1815303	C18R15303	24,200
1-1/2" x 3" x 5/8" - 11"	C1615305		C18R15305	24,200
1-3/4" x 3" x 3/8" - 24"	C16134303			20,700
2" x 3" x 3/8" - 24"	C1620303	P1820303		18,100
2" x 3" x 5/8" - 11"	C1620305	P1820305	C18R20305	18,100
3" x 3" x 5/8" - 11"	C1630305		C18R30305	12,000
3" x 4" x 5/8" - 11"	C1630405			12,096

Vitrified Mounted Points

Mounted points are made with premium oxide grains and a strong vitrified bond. Used for grinding and deburring metals.

Shape	Type	Part No.	Size	Grade	Color	RPM
	A1	A1BG	3/4" x 2-1/2" x 1/4"	46-P	Blue-gray	19,800
	A3	A3BG	1" x 2-3/4" x 1/4"	46-P	Blue-gray	16,100
	A11	A11BG	7/8" x 2" x 1/4"	46-P	Blue-gray	19,860
	W220	W220-D2BG	1" x 1" x 1/4"	46-P	Blue-gray	25,500
	W222	W222-D2BG	1" x 2" x 1/4"	46-P	Blue-gray	15,900
	W225	W225-D2BG	1-1/4" x 1/4" x 1/4"	46-P	Blue-gray	30,560

3M™ Green Corps™
Depressed Center Wheel

These 1/4" thick bonded wheels contain proprietary 3M™ Cubitron™ abrasive grain and produce very high cut rates on a wide variety of metals.

Part No./UPC	Dia. x Thk x AH	Grade	Min./Case
051111-55960-4	4-1/2" x 1/4" x 5/8"-11 Max RPM: 13,300	24	10/60
051111-55961-1		36	
051111-55958-1	7" x 1/4" x 5/8"-11 Max RPM: 8,600	24	10/20
051111-55959-8		36	
051111-55956-7	9" x 1/4" x 5/8"-11 Max RPM: 6,600	24	10/20
051111-55957-4		36	

3M™ Green Corps™ Cut Off Wheels

General purpose cut-off wheel designed for cutting sheet metal, rusted bolts and more. Ideal for use on a wide variety of utility type cut-off tools. Do not use on tools without guards.

Part No./UPC	Dia. x W x AH	Min./Case
051144-83487-7	2" x 1/16" x 1/4" Max RPM: 42,000	50/50
051144-82238-6	3" x 1/32" x 1/4" Max RPM: 35,000	
051131-01989-8	3" x 1/32" x 3/8" Max RPM: 35,000	5/pack; 10/case 50/50
051131-01985-0		
051131-01990-4	3" x 1/16" x 3/8" Max RPM: 28,000	
051131-01986-7		
051144-83488-4	4" x 1/16" x 3/8" Max RPM: 21,000	50/50
051144-88755-2	4" x 1/32" x 1/4" Max RPM: 26,250	
051131-01994-2	4" x 1/32" x 3/8" Max RPM: 26,250	

PIPELINER® Wheels For Pipe Notching

- Tough Zirconium grain.
- Designed for light grinding and cutting.
- Specially developed for pipe notching applications
- For ferrous material such as steel, iron, and metal.
- For stainless steel.

Part No.	Type	Dimension	Specification
352338	27	7 x 1/8 x 5/8"-11	ZA24-BF
352340	27	9 x 1/8 x 5/8"-11	ZA24-BF

Cut-Off Wheels

Portable Cut-Off Wheels

- For all ferrous materials.
- Internal reinforced arbor.

Part No.	Size	Grit	Std Pkg.
7246033	14" x 1/8" x 1"	A36P	5
724603325	14" x 1/8" x 1"	A36P	25

Cut-Off Wheels - Type 1

- For cutting masonry/concrete, marble, slate etc. (C36 only).
- Tool must be properly guarded.
- For all ferrous materials (A46 only).

Part No.	Size	Grit	Max.RPM
724104110	4" x 3/32" x 5/8"	C36	15,000
724107510	4" x 5/64" x 5/8"	A46	14,000

Super Thin Cut-Off Wheels - Type 1

- Cuts up to 50% faster.
- Lasts up to 20% longer.
- Use with paper flange (included).

Part No.		Size	Grit	Max. RPM
Stainless	Metal			
724111A25	724114A25	4" x 3/64" x 5/8"	A46	15,280
724112A25	724115A25	4-1/2" x 3/64" x 7/8"	A46	13,285
724113A25	724116A25	5" x 3/64" x 7/8"	A46	12,200
724118A25	724117A25	6" x 1/16" x 7/8"	A46	10,185

Depressed Center Flex Wheels - Type 27

- Most versitile wheel for light metal grinding, sanding and cutting.

Part No.	Size	Grit	Max. RPM
7414040BP	4" x 1/8" x 5/8"	AC46	13,700
7414040CP	4" x 1/8" x 5/8"	AC60	13,700
7414387P*	4" x 1/8" x 5/8"	GC60	13,690
7414040DP	4" x 1/8" x 5/8"	AC80	13,700
7414040FP	4" x 1/8" x 5/8"	AC120	13,700

*Use with plastic back-up pad **Part No. 7430091**

Cut-Off Safety Guidelines

- Must be rigid and maintain straight line cuts.
- Must provide “hold down” of work piece; avoids pressure.
- Must have adequately heavy arbor and arbor bearings.
- Must have proper drive flanges, min. 1/4" wheel diameter. Flanges must be clean, straight, have the same diameters, and have the proper arbor clearance.
- Must have adequate guard over wheel, at least 1/2" diameter.
- Must be maintained in first class condition.
- **Do** always start cut gently.
- **Do not** grind on the side of a cut off wheel or stand directly in front of a grinding wheel when a grinder is started.

Inner Flanges

- Do not use N9514B with diamond blade and cut-off wheels.

Part No.	Grinder Size	Grinder Model No.
2243771	4"	9523NBH, 9553NB
2243763	4"	N9501BZ, N9514B
2243789	4-1/2", 5", 6"	9524NB, 9527NB/PB, 9528PB, 9005B, 9016B, 9015A, 9561CV, 9564/CV, 9565/CV, GA7011C
2243909	6"	9566CV
2241119	7"	GA7001L, GA7911
2243179	7", 9"	9067L, 9069, 9077SL

Part No.	Grinder Size	Grinder Model No.
2242783	4"	N9501BZ, N9514B, 9528PB
1935537	5"	9005B, 9016B, 9527NB
2243616	5"	9005BZ

Lock Nuts

For use with flex wheels.

Part No.	Grinder Size	Grinder Model No.
2245414	4"	N9501BZ, N9514B

For use with diamond blade, grinding, cut-off* & multi-disc wheels.

- Do not use N9514B with diamond and cut-off wheels.

Part No.	Grinder Size	Grinder Model No.
1934442	4"	N9501BZ*, N9514B, 9523NBH, 9560CV, 9563CV
2245731	4"	9553NB
1934654 (replaces 2245090)	4-1/2"*, 5", 7", 9"	9015A, 9005B*, 9067L, 9069, 9524NB*, 9527NB/PB*, 9528PB, 9557NB/PB, 9558NB/PB, 9564/CV, 9565/CV, GA7011C
2245749	6"	9566CV
2245121	7"	GA7001L, GA7911

* Use with corresponding cut-off wheel guard & lock nut.

For use with rubber pads.

Part No.	Grinder Size	Grinder Model No.
2245016	4"	N9501BZ, N9514B, 9523NBH
2245171	4-1/2", 5", 7", 9"	GA7001L, GA7911, GV7000C, 9005B, 9015A, 9067L, 9077SL, 9069, 9218SB, 9217SPC, 9227C, 9227CY, 9561CV, 9564CV, 9524NB, 9528PB, 9527NB/PB

metabo®

Metabo
Vendor Code: MET

Abrasive Wheels

Spec Information

A 24 N	Aluminum oxide general purpose wheel for grinding steel and other ferrous metals in normal working conditions. High stock removal. Good wheel life.
A 24 R	Aluminum oxide general purpose wheel for heavier working conditions for steel and other ferrous metals. Good stock removal. Longer wheel life.
A 24 T	Aluminum oxide general purpose wheel for steel and other ferrous metals. Extremely long life.
A 36 O	Aluminum oxide wheel specially formulated for harder metals such as stainless steel. Good stock removal. Good wheel life.
ZA 24 T	Zirconia alumina wheels for steel and stainless steel applications. Very aggressive stock removal. Extremely long wheel life.
C 24 N	Silicon carbide general purpose wheel for stone, concrete, cast iron, ductile iron, masonry materials, non-ferrous metals, brass, bronze, etc. High stock removal. Good wheel life.

Abrasive Wheels

For Small Grinders

Type 27
Depressed Center Wheel

Type 1
Cutting Wheel

Part No.	Size	Spec	Wheel Type	Application	RPM
Type 27					
624136000	4-1/2" x 7/8"	A24	Grinding	Steel	13,300
624137000	4-1/2" x 7/8"	A40	Grinding	Steel	13,300
624138000	4-1/2" x 7/8"	A60	Grinding	Steel	13,300
616726000	4-1/2" x 1/4" x 7/8"	A24N	Grinding	Steel	13,300
655726000	4-1/2" x 1/4" x 5/8"-11"	A24N	Grinding	Steel	13,300
616748000	4-1/2" x 1/4" x 7/8"	A36M	Grinding	Aluminum	13,300
616785000	4-1/2" x 1/4" x 7/8"	ZA24T	Grinding*	Stainless steel	13,300
616307000	4-1/2" x 1/4" x 7/8"	A24R	Grinding	Steel	13,300
616727000	4-1/2" x 3/32" x 7/8"	A30R	Cutting	Steel	13,300
655346000	4-1/2" x .045" x 7/8"	A60TZ	Cutting (Slicer™)	Steel/stainless steel	13,300
616281000	4-1/2" x 1/8" x 7/8"	A24T	(Pipeliner) Grinding & cutting	Steel/stainless steel	13,300
Type 29					
655181000	4-1/2" x 5/32" x 7/8"	A36	(Z-Plus) Grinding & blending	Steel, aluminum, and plastic	13,280
Type 1 Slicer™					
655317000	3" x .040" x 3/8"	A60TZ	Cutting	Steel/stainless steel	25,000
655318000	3" x 1/16" x 1/4"	A36TZ	Cutting	Steel/stainless steel	25,000
655320000	3" x 1/16" x 3/8"	A36TZ	Cutting	Steel/stainless steel	25,000
655321000	3" x 1/16" x 3/8"	A60TZ	Cutting	Steel/stainless steel	25,000
655323000	4" x .040" x 5/8"	A60TZ	Cutting	Steel/stainless steel	22,000
655324000	4" x .040" x 7/8"	A60TZ	Cutting	Steel/stainless steel	22,000
655328000	4" x 1/16" x 3/8"	A60TZ	Cutting	Steel/stainless steel	19,000
655329000	4" x 1/16" x 5/8"	A36TZ	Cutting	Steel/stainless steel	19,000
655331000	4-1/2" x .040" x 7/8"	A60TZ	Cutting	Steel/stainless steel	15,000
655332000	4-1/2" x 1/16" x 7/8"	A36TZ	Cutting	Steel/stainless steel	15,000
655997000	4-1/2" x .045" x 7/8"	A60TX	Cutting (Plus)	Steel/stainless steel*	15,000
655333000	4-1/2" x 1/16" x 7/8"	A60TZ	Cutting	Steel/stainless steel	15,000
655334000	5" x .040" x 7/8"	A60TZ	Cutting	Steel/stainless steel	12,225
655336000	5" x 1/16" x 7/8"	A60TZ	Cutting	Steel/stainless steel	12,225
655338000	6" x .040" x 5/8"	A60TZ	Cutting	Steel/stainless steel	10,200
655342000	6" x 1/16" x 5/8"	A36TZ	Cutting	Steel/stainless steel	10,200
655344000	6" x 1/16" x 7/8"	A36TZ	Cutting	Steel/stainless steel	10,200
655345000	6" x 1/16" 7/8"	A60TZ	Cutting	Steel/stainless steel	10,200

*Long life

Abrasive Wheels

For Medium Grinders

Part No. 655339000

Part No.	Size	Spec	Wheel Type	Application	RPM
Type 27					
655279000	4.5" x 1/4" x 5/8-11	A24T	Grinding	Steel	8,500
655281000	4.5" x 1/8" x 5/8-11	A24T	Grinding	Steel/stainless steel	13,300
616308000	5" x 1/4" x 7/8"	A24R	Grinding	Steel	12,300
616554000	6" x 1/4" x 7/8"	A24N	Grinding	Steel/stainless steel	10,200
616787000	6" x 1/4" x 7/8"	ZA24T	Grinding	Steel/stainless steel	10,200
Type 1 Slicer™					
655335000	5" x 1/16" x 7/8"	A36TZ	Cutting	Steel/stainless steel	12,225
655339000	6" x .040" x 7/8"	A60TZ	Cutting	Steel/stainless steel	10,200
655998000	6" x .045" x 7/8"	A60TX	Cutting* (Plus)	Steel/stainless steel	10,185
Type 27 Slicer™					
655347000	6" x .045" x 7/8"	A60TZ	Cutting	Steel/stainless steel	10,200

*Long life

Abrasive Wheels

For Large Grinders

Part No.	Description	Spec	Wheel Type	Application	RPM
Type 27					
655782000	7" x 1/4" x 5/8-11	A24R	Grinding	Steel	8,500
655788000	7" x 1/4" x 5/8"-11	ZA24T	Grinding	Steel/stainless steel	8,500
655282000	7" x 1/8" x 5/8"-11	A24T	(Pipeliner) grinding & cutting	Steel/stainless steel	8,500
616300000	7" x 1/8" x 7/8"	A30R	Cutting	Steel	8,500
655784000	9" x 1/4" x 5/8"-11	A24R	Grinding	Steel	6,600
655789000	9" x 1/4" x 5/8"-11	ZA24T	Grinding	Steel/stainless steel	6,600
655302000	9" x 1/8" x 5/8"-11	A30R	Cutting	Steel	6,600
Type 29					
655190000	7" x 5/32" x 5/8"-11	A36	Z-Plus grinding & blending	Steel, aluminum, plastic	8,600

High Speed Chop Saw

Part No.	Description	Spec	Wheel Type	Application	RPM
Type 1					
616137000	12" x 1/8" x 1"	A24N	Cut-off	Steel	6,400
616139000	14" x 1/8" x 1"	A24N	Cut-off	Steel/rail track	5,400
616338000	14" x 3/32" x 1"	A30R	Cut-off	Steel/stainless steel	4,300

Norton
Vendor Code: NRT

Depressed Center Wheels

General Information

NorZon Plus

- Premium, combination of Norton SG (ceramic alumina) and NorZon (zirconia alumina).
- 50 to 200% better overall performance than competitive Zirconia wheels.
- Up to 10 times the performance of aluminum oxide wheels.
- 50% or better cut rate than competitive wheels.
- Excellent performance on all grinding jobs from gray iron to exotic alloys and stainless steel.
- Advanced bond system.
- The fastest cutting zirconia wheel on the market.
- Easy on the operator and equipment.

Best

Charger Plus

- High percentage of premium NorZon (zirconia alumina) abrasive grain blended with premium aluminum oxide.
- 2-3 times the life of aluminum oxide wheels.
- Free cutting.
- Effectively grinds a variety of metals from alloys and stainless to gray iron.
- Economical performance to price ratio lowers total cost.

Better

Type 29 Flexible Wheels

- Type 29 shape used at a 15° angle.
- Aluminum oxide grain in a uniquely patterned face allows interrupted cut which reduces heat on work piece and prevents loading.
- Shallow grinding angle permits larger contact area with less gouging of work piece.
- **AVOS** patented technology - **A**llows **V**iew **O**f **S**urface.
- Innovative shape and patented design that provides complete vision of the griding zone.
- Operator can grind more accurately with less re-work.

Better

Gemini Aluminum Oxide

- Fast cut for quick stock removal on hard metals.
- Long life provides exceptional life and cut rate on carbon and stainless steels.
- Contains no wax or rubber fillers.
- Grinds aluminum and soft metals without loading.

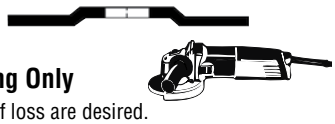
Gemini Stainless Steel

- 3/32" and 1/4" thick, contaminant free: no iron, sulfur or chlorine—Ideal for nuclear industry.
- Grinds all kinds of stainless steel and various hard alloys.

Good

Type 27 Wheels

Type 27 – .125", .045", 1/16" Metal/Steel/Stainless - Cutting Only



- Use where fast cutting and low kerf loss are desired.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252830742	4-1/2" x .045" x 7/8"	13,580	20	NorZon Plus
66252819549	4-1/2" x .045" x 5/8"-11	13,580	20	Gemini
66252830748	4-1/2" x .045" x 5/8"-11	13,580	20	NorZon Plus
66252819548	4-1/2" x .045" x 7/8"	13,580	20	Gemini
66252830744	5" x .045 x 7/8"	12,225	20	NorZon Plus
66252830586	5" x .045 x 5/8"-11	12,225	20	Gemini
66252819550	5" x .045 x 7/8"	12,225	20	Gemini
66252830745	6" x .045 x 7/8"	10,185	20	NorZon Plus
66252830587	6" x .045 x 5/8"-11	10,185	20	Gemini
66252819551	6" x .045 x 7/8"	10,185	20	Gemini
66252912626	7" x 1/16" x 7/8"	8,600	20	Gemini
66253019115	9" x 1/16" x 5/8"-11	6,600	10	Gemini

Type 27 – 3/16", 3/32" Cutting Only/Pipe

- Use where fast cutting and low kerf loss are desired.
- Ideal for pipe cutting.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252830446	4-1/2" x 3/16" x 7/8"	13,580	20	NorZon Plus
66252823102	4-1/2" x 3/32" x 5/8"-11	13,580	20	Gemini Stainless
66252823103	4-1/2" x 3/32" x 7/8"	13,580	20	Gemini Stainless
66252823106	5" x 3/32" x 7/8"	12,225	20	Gemini Stainless

Type 27 Wheels

Type 27 – 1/8" Metal/Steel - Cutting/Notching/Light Grinding

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243529885	4" x 1/8" x 5/8"	15,280	20	NorZon Plus
66243529851				Charger Plus
66243530619				Gemini
66252830445	4-1/2" x 1/8" x 5/8" -11	13,580	20	NorZon Plus
66252829853				Charger Plus
66252830435				Gemini
66252830444	4-1/2" x 1/8" x 7/8"	13,580	20	NorZon Plus
66252829854				Charger Plus
66252830609				Gemini
66252829857	5" x 1/8" x 5/8" -11	12,225	20	Charger Plus
66252830789	5" x 1/8" x 7/8"	12,225	20	NorZon Plus
66252829858				Charger Plus
66252830614				Gemini
66252809367	6" x 1/8" x 7/8"	10,185	20	Charger Plus
66252801864				Gemini
66252938855	7" x 1/8" x 5/8" -11	8,600	10	NorZon Plus
66252929862				Charger Plus
66252939259				Gemini
66252938854	7" x 1/8" x 7/8"	8,600	20	NorZon Plus
66252929863				Charger Plus
66252939207				Gemini
66253048897	9" x 1/8" x 5/8" -11	6,600	10	NorZon Plus
66253029866				Charger Plus
66253048983				Gemini
66253048896	9" x 1/8" x 7/8"	6,600	20	NorZon Plus
66253029867				Charger Plus
66253048994				Gemini

Type 27 – 1/4" Stainless Steel - Grinding

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252819568	4-1/2" x 1/4" x 5/8" -11	13,580	20	Gemini Stainless
66252819567	4-1/2" x 1/4" x 7/8"	13,580	20	Gemini Stainless
66252819570	5" x 1/4" x 7/8"	12,225	20	Gemini Stainless
66252912639	7" x 1/4" x 5/8"-11	8,600	10	Gemini Stainless
66252912638	7" x 1/4" x 7/8"	8,600	20	Gemini Stainless

Type 27 – 1/4" Metal/Steel - Grinding

- Fast Cut - Grinding with low horsepower and electric grinders or where low pressure is used.
- Long Life - Grinding with high horsepower machines (3 hp or higher) and heavy pressure; flame cut and other severe applications.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243529887	4" x 1/4" x 5/8"	15,280	20	NorZon Plus
66243529852				Charger Plus
66243519884				Gemini Fast Cut
66243530620				Gemini
66252828804	4-1/2" x 1/4" x 5/8"-11	13,580	20	NorZon Plus
66252829855				Charger Plus
66252817084				Gemini Fast Cut
66252830432				Gemini
66243578251				Charger Plus Fast Cut
66252828803	4-1/2" x 1/4" x 7/8"	13,580	20	NorZon Plus
66252829856				Charger Plus
66252830612				Gemini Fast Cut
66252830611				Gemini
66243578250				Charger Plus Fast Cut
66252828806	5" x 1/4" x 5/8"-11	12,225	5	NorZon Plus
66252829859				Charger Plus
66243578255				Charger Plus Fast Cut
66252828805	5" x 1/4" x 7/8"	12,225	20	NorZon Plus
66252829861				Charger
66252830617				Gemini Fast Cut
66252830615				Gemini
66243578254				Charger Plus Fast Cut
66252832391	6" x 1/4" x 5/8"-11	10,185	10	Charger Plus
66252832390				Gemini
66243578258				Charger Plus Fast Cut
66252809376	6" x 1/4" x 7/8"	10,185	20	NorZon Plus
66252809372				Charger Plus
66252801865				Gemini
66243578259				Charger Plus Fast Cut
66252917881	7" x 1/4" x 5/8"-11	8,600	10	NorZon Plus
66252929864				Charger Plus
66252940147				Gemini Fast Cut
66252940148				Gemini Long Life
66243578243				Charger Plus Fast Cut
66252917880	7" x 1/4" x 7/8"	8,600	20	NorZon Plus
66252929865				Charger
66252940099				Gemini Fast Cut
66252940098				Gemini Long Life
66243578242				Charger Plus Fast Cut
66253021634	9" x 1/4" x 5/8"-11	6,600	10	NorZon Plus
66253029868				Charger Plus
66253049105				Gemini Fast Cut
66253049104				Gemini Long Life
66253021633	9" x 1/4" x 7/8"	6,600	20	NorZon Plus
66253029869				Charger Plus
66253049077				Gemini Fast Cut
66253048991				Gemini Long Life

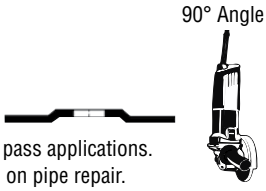
Depressed Center Wheels / Cut Off Wheels

Type 27 Wheels

Type 27 – 1/4" Aluminum - Grinding/Blending

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252830433	4-1/2" x 1/4" x 5/8"-11	13,580	20	Gemini A46
66252830627	4-1/2" x 1/4" x 7/8"	13,580	20	Gemini A46
66252940514	7" x 1/4" x 5/8"-11	8,600	10	Gemini A24
66252940515				Gemini A46
66252940516	7" x 1/4" x 7/8"	8,600	20	Gemini A24
66253049045	9" x 1/4" x 5/8"-11	6,600	10	Gemini A24

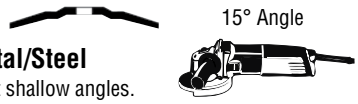
Type 27 – 1/8" Pipe Notching



- Triple reinforced.
- Cut on the face of the wheel for root pass applications.
- Clean weld joints or cutting out weld on pipe repair.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252939184	7" x 1/8" x 5/8" -11	8,600	10	NorZon Plus
66253049066	9" x 1/8" x 5/8" -11	6,600	10	NorZon Plus

Type 28 & 29 Wheels



Type 28 Saucer – 1/4" Metal/Steel

- Smooth, gouge-free grinding at shallow angles.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252905369	7" x 1/4" x 5/8"-11	8,600	10	NorZon Plus
66252905367				Charger Plus
66252940149				Gemini
66252905368	7" x 1/4" x 7/8"	8,600	20	NorZon Plus
66252940095				Gemini
66253006335	9" x 1/4" x 5/8"-11	6,600	10	NorZon Plus
66253006334				Charger Plus
66253049106				Gemini
66253006336	9" x 1/4" x 7/8"	6,600	20	NorZon Plus
66253049081				Gemini

Type 29 – 1/8" AVOS and Flexible - Grinding/Blending

- Polishing and blending.

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66252825236	4-1/2" x 1/8" x 5/8"-11	13,580	20	AVOS A36
66252830885				FLEX A36
66252833455				FLEX 36
66252833454	4-1/2" x 1/8" x 7/8"	13,580	20	FLEX A36
66252823473				AVOS A36
66252823474				AVOS A60
66252823475				AVOS A46 Alu
66252833456	5" x 1/8" x 7/8"	12,225	20	FLEX A36
66252823478				AVOS A36

Large Diameter Reinforced Flat Cutting-Off Wheels

Stationary Saws

Charger

- A blend of premium zirconia alumina and aluminum oxide - Outperforms standard aluminum oxide up to 3X in life.
- High performance bond system - Over 25% better cut rate than standard aluminum oxide.

Better

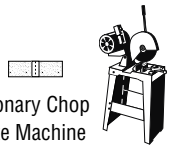
Gemini

- Quality aluminum oxide abrasive - Sets the aluminum oxide industry standard for cutting all material in metal fabrication applications.

Good

Type 1: 10" - 20"

Stationary Saws



Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66253106108	10" x 3/32" x 5/8"	6,110	10	Charger
66253106101				Gemini Free Cut
66253106102				Gemini Long Life
66253207550	12" x 1/8" x 1"	5,095	10	Charger
66253207547				Gemini Free Cut
66253207548				Gemini Long Life
66253306623	14" x 1/8" x 1"	4,365	10	Charger
66253306609				Gemini Free Cut
66253306611				Gemini Long Life
66252830885	16" x 1/8" x 20mm	3,820	10	Metal
66252830886	16" x 1/8" x 1"	3,820	10	Metal
66253410194	16" x 5/32" x 1"	3,820	10	Charger
66253410183				Gemini Free Cut
66253410184				Gemini Long Life
69078609045	20" x 5/32" x 1"	2,710	5	Charger Free Cut
69078609046				Charger Long Life
69078609031				Gemini Free Cut
69078609032				Gemini Long Life
69078609033	20" x 3/16" x 1"	2,710	5	Gemini Free Cut
69078609034				Gemini Long Life

Note: 3/32", 1/8" and 5/32" thick wheels are side reinforced. 3/16" thick wheels are centrally reinforced.

Small Diameter Reinforced Cut-Off Wheels

NorZon - The Absolute Force

Fastest Initial Cut Rate

- Patented Norton SG (ceramic alumina) and NorZon (zirconia alumina) grain combination.
- Fastest initial cut of any wheel; highest productivity.
- Highly advanced bond system - Free, cool cut.
- State-of-the-art manufacturing.
- Superior wheel balance.
- Free Cut has up to 3X life over aluminum oxide wheels on carbon steel and cast iron.
- Free Cut has 40% faster cut rate over standard aluminum oxide wheels.

Best

Charger

- Versatile: ideal for stainless steel.
- A unique blend of premium NorZon (zirconia alumina) and aluminum oxide.
- 2X the life of aluminum oxide wheels.
- Free cutting.
- Effectively cuts a variety of metals from alloys and stainless to gray iron.
- Long life and economical performance to price ratio lower total cost.
- Superior product at a value price.

Better

Gemini

- All purpose wheels, competitively priced.
- Advanced formulation.
- Maximizes the performance of conventional aluminum oxide abrasive.
- Gemini Free Cut wheels: Engineered to cut hard materials.

Good

Type 1: 3" - 4"

Horizontal/Straight Shaft Grinder

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243510668	3" x .035" x 1/4"	25,465	25	NorZon Plus
66243510627				Gemini Free Cut
66243510669	3" x .035" x 3/8"	25,465	25	NorZon Plus
66243527753				Charger
66243510628				Gemini Free Cut
66243510651	3" x 1/8" x 3/8"	25,465	25	Gemini
66243510652	3" x 1/8" x 1/4"	25,465	25	Gemini
66243510653	3" x 1/8" x 3/8"	25,465	25	Gemini LL
66243510670	3" x 1/16" x 1/4"	25,465	25	NorZon Plus Free Cut
66243510645				Gemini Free Cut
66243510671	3" x 1/16" x 3/8"	25,465	25	NorZon Plus Free Cut
66243527755				Charger
66243510647				Gemini Free Cut
07660747767	3" x 1/16" x 3/8"	25,465	25*	Metal Free Cut Contractor 5 pack*
66243510674	4" x .035" x 1/4"	19,100	25	NorZon Plus
66243510629				Gemini Free Cut
66243510675	4" x .035" x 3/8"	19,100	25	NorZon Plus
66243527340				Charger
66243510630				Gemini Free Cut
66243510657	4" x .045" x 1/4"	19,100	25	Gemini
66243510661	4" x 1/8" x 3/8"	19,100	25	Gemini
66243510676	4" x 1/16" x 1/4"	19,100	25	NorZon Plus Free Cut
66243510654				Gemini Free Cut
66243510677	4" x 1/16" x 3/8"	19,100	25	NorZon Plus Free Cut
66243527338				Charger
66243510655				Gemini Free Cut

*5 wheels per contractor pack, 5 contractor packs per standard package

Right Angle Grinder Reinforced Flat Cut-Off Wheels

- Unique reinforcement design - Provides safety, strength and straight cuts.
- Extra thin - Quick cutting action and low kerf loss.

NZ Plus

- Premium abrasive and bond.
- Unique reinforcement design.
- Maximum productivity.
- Provides safety, strength and straight cuts.
- Quick cutting action and low kerf loss.

Best

Charger Right Cut

- Durable zirconia alumina abrasive.
- 3X the life and 2X the cut rate of standard aluminum oxide wheels.
- Excels on a broad range of materials, from alloys and stainless to gray iron.
- Maximum productivity; lowest total grinding costs.

Better

Gemini Right Cut

- Quality aluminum oxide grain.
- Consistent performance at a competitive price.
- Ideal for small jobs on a variety of metal applications from carbon to stainless steels.

Good

Type 1: 3" - 6"

Right Angle Grinder Cutting

90˚ Angle

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243527956	4" x .045" x 5/8"	15,280	25	Gemini
66243527955	4" x 3/32" x 5/8"	15,280	25	Gemini
66252830730	4-1/2" x .045" x 7/8"	13,580	25	NZ Plus
66252823602	4-1/2" x .045" x 7/8"	13,580	25	Gemini
66252826569	4-1/2" x .045" x 7/8"	13,580	25	Charger
66252823599	4-1/2" x 3/32" x 7/8"	13,580	25	Gemini
66252830731	5" x .045" x 7/8"	12,225	25	NZ Plus
66252823603	5" x .045" x 7/8"	12,225	25	Gemini
66252826570	5" x .045" x 7/8"	12,225	25	Charger
66252823600	5" x 3/32" x 7/8"	12,225	25	Gemini
66252830734	6" x .045" x 7/8"	10,185	25	NZ Plus
66252823604	6" x .045" x 7/8"	10,185	25	Gemini
66252826571	6" x .045" x 7/8"	10,185	25	Charger
66252823601	6" x 3/32" x 7/8"	10,185	25	Gemini

High-Speed Reinforced Cut-Off Wheels

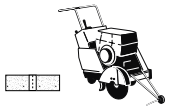
Gas, Electric-Powered and Walk-Behind Road Saws

- Metalworking - Versatile aluminum oxide.
- Ductile - Durable silicon carbide and aluminum oxide blend.
- Concrete - Sharp 24 grit silicon carbide.
- Asphalt - Coarse 16 grit silicon carbide.
- Asphalt/green concrete - Cold pressed silicon carbide blend.
- For higher performance on asphalt/green concrete - Hot pressed silicon carbide blend.

Good

Type 1: 12" - 18"

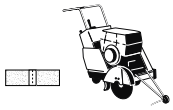
Gas & Electric Powered Saws



Part No.	Size (D x T x H)	RPM	Pkg.	Spec
70184680310	12" x 1/8" x 20mm	6,360	10	Metal
70184680314				Ductile
70184680312				Concrete
70184670243				Asphalt
70184680311	12" x 1/8" x 1"	6,360	10	Metal
70184680315				Ductile
70184680313				Concrete
70184670083				Asphalt
70184680317	14" x 1/8" x 20mm	5,400	10	Metal
70184680321				Ductile
70184680319				Concrete
70184680318	14" x 1/8" x 1"	5,400	10	Metal
70184680322				Ductile
70184680320				Concrete
70184625269	16" x 1/8" x 20mm	4,700	10	Concrete
70184623029	16" x 1/8" x 1"	4,700	10	Concrete

Type 1: 12" - 18"

Walk-Behind Saws



Part No.	Size (D x T x H)	RPM	Pkg.	Spec
70184671456	14" x 1/8" x 20mm Pin Hole	5,400	10	Asphalt
70184672877	14" x 1/8" x 1" Pin Hole	5,400	10	Asphalt
70184680323	14" x 3/16" x 1" Pin Hole	4,365	10	Concrete
70184680324				Asphalt
70184670100*				Asphalt/ Green Concrete
70184670533	14" x 1/4" x 1" Pin Hole	4,365	5	Concrete
70184670535				Asphalt
70184670099*				Asphalt/Green Concrete
70184670098	18" x 1/4" x 1" Pin Hole	4,250	5	Concrete
70184648998*	18" x 3/8" x 1"	4,250	5	Asphalt/Green Concrete

*Asphalt/Green Concrete wheels are hot-pressed for added strength.

Metal Seeking

Part No.	Size	Pkg.
66252832521	14" x 1/8" x 1"	10
66243578263	14" x 1/8" x 20mm	10

Rescue Blade

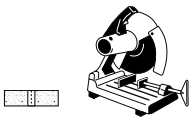
Part No.	Size	Pkg.
66243578262	14" x 1/8" x 1"	10
66243578260	14" x 1/8" x 20mm	10

Chop Saw Reinforced Flat Cutting-Off Wheels

- Free Cut - side reinforced - Engineered for larger cross-sections and/or hard-to-cut materials - Resist breakage and provide straight cuts
- Long Life - side reinforced - Ideal for small cross-section work pieces - Resist breakage and provide straight cuts
- Rapid Cut - centrally reinforced, rough sides - Free cutting, non-binding; burr - and burn-free cuts
- Aluminum - specially formulated bond for aluminum and other soft, non-ferrous metals; no wax or rubber fillers - Free cutting; resists loading - No surface contamination
- Steel Stud Cutter - thin, side-reinforced; aluminum oxide abrasive - Designed specifically for cutting steel studs

Type 1: 12" - 16"

Chop Saws



Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66253207552	12" x 7/64" x 1"	5,095	10	Charger
66253207554				Gemini Long Life
66253306624	14" x 7/64" x 1"	4,365	10	Charger Free Cut
66253306625				Charger Long Life
66253309614				Charger Rapid Cut
66253314816				Gemini Aluminum
66253306627				Gemini Free Cut
66253306626				Gemini Long Life
66253313588				Gemini Rapid Cut
07660789405				Stud Cutter
66253410196	16" x 7/64" x 1"	3,820	10	Charger Free Cut
66253410197				Charger Long Life
66253410198				Gemini Long Life

Bench and Pedestal Wheels

Premium White Aluminum Oxide

- White aluminum oxide in a premium vitrefied bond.
- Each wheel contains a nested bushing.
- Provides maximum cut rate and cool cutting action on hardened or high-speed tool steels.

Best

Part No.	Size (D x T x H)	RPM	Pkg.	Grit
07660788246	6" x 3/4" x 1"	4140	1	Med 60
07660788247				Fine 80
07660788248				Extra fine 150
04660788261	6" x 1" x 1"	4140	1	Med 60
07660788262				Fine 80
07660788263				Extra fine 150
07660788281	8" x 1" x 1"	3600	1	Med 60
07660788282				Fine 80
07660788283				Extra fine 150

Gemini Alundum

- Quality gray aluminum oxide for metal cutting.
- Each wheel contains a nested bushing.
- Economically priced for general purpose applications.

Better

Part No.	Size (D x T x H)	RPM	Pkg.	Grit
66252830649	5" x 1/2" x 1"	4965	1	Med 60/80
66252836132	6" x 1/2" x 1"	4140	1	Coarse 36/46
66252836131				Med 60/80
66252836133				Fine 80
66252836103	6" x 3/4" x 1"	4140	1	Coarse 36/46
66252836102				Med 60/80
66252836101				Fine 80
66252942292	7" x 1" x 1"	3600	1	Coarse 36/46
66252942294				Med 60/80
66252942295				Fine 80
66253044454	8" x 1" x 1"	3600	1	Very coarse 24
66253044449				Coarse 36/46
66253044448				Med 60/80
66253044447				Fine 80
66253160788	10" x 1" x 1-1/4"	2485	1	Very coarse 24
66253160787				Coarse 36/46
66253160789				Med 60/80
66253160350				Fine 100/120
66253161250	10" x 1-1/4" x 1-1/4"	2485	1	Med 60
66253161251				Fine 80
66253161393				Coarse 36/46
66253161395				Med 60/80
66253263052	10" x 1-1/2" x 1-1/4"	2070	1	Coarse 36/46
66253263053				Med 60/80
66253263054	12" x 2" x 1/4"	2070	1	Very coarse 24
66253263055				Coarse 36/46
66253263056				Med 60/80

Gemini Crystolon

- Sharp green silicon carbide for non-ferrous cutting.
- Each wheel contains a nested bushing.
- Economically priced for general purpose applications.

Good

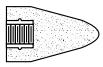
Part No.	Size (D x T x H)	RPM	Pkg.	Grit
66252836571	6" x 1/2" x 1"	4140	1	Med 60
66252836572				Fine 80
66252836573				Extra fine 120
66252837190	6" x 3/4" x 1"	4140	1	Med 60
66252837191				Fine 80
66252837192				Extra fine 120
66252837189	6" x 1" x 1"	4140	1	Med 60
66252837193				Fine 80
66252837194				Extra fine 120
66252942300	7" x 1" x 1"	3600	1	Med 60
66252942301				Fine 80
66252942302				Extra fine 120
66252942315	8" x 3/4" x 1"	3600	1	Coarse 36/46
66252942316				Med 60/80
66252942317				Fine 80
66253044087	8" x 1" x 1"	3600	1	Med 60
66253044534				Fine 80
66253044535				Extra fine 120
66253144536	10" x 1" x 1-1/4"	2485	1	Med 60
66253160366				Fine 80
66253263359	12" x 2" x 1/4"	2070	1	Med 60
66253263360				Fine 80

Cones and Plugs

Gemini 57A

- 57A aluminum oxide abrasive.
- Strong performance to price relationship.
- For all steel, steel alloys and irons.
- For hard-to-reach areas inside castings.
- Removing flaws and cracks.
- Removing metal in corners.

Type 16

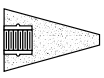


Type 16 Cones

Horizontal / Straight Shaft Grinder

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
61463622342	1" x 3" x 3/8"-24 (ME 107019)	36,290	10	Gemini 57A24-R
61463622349	1-1/2" x 2-1/2" x 3/8"-24 (ME 44436)	24,190	10	Gemini 57A24-R
61463622190	1-1/2" x 3" x 5/8"-11 (ME 70535)	24,190	10	Gemini 57A24-R
61463614503	1-3/4" x 3" x 3/8"-24 (ME49226)	20,735	10	Gemini 57A24-R
61463622195	1-3/4" x 3" x 5/8"-11 (ME 33432)	20,740	10	Gemini 57A24-R
61463622218	2" x 3" x 5/8"-11 (ME 28229)	18,145	10	Gemini 57A24-R
61463622387	2-3/4" x 3-1/2" x 5/8"-11 (ME 18265)	13,195	10	Gemini 57A24-R

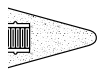
Type 17 Square tip



Type 17 Cones, Square Tip

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
61463622194	1-1/2 / 1/2" x 3" x 3/8"-24	24,190	10	Gemini 57A24-R

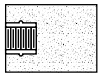
Type 17R Round tip



Type 17R Cones, Round Tip

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
61463615722	2 / 1/2" x 3" x 5/8"-11	18,145	10	Gemini 57A24-R

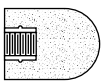
Type 18 Square tip



Type 18 Plugs, Square Tip

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
61463622217	1-1/2" x 2-1/2" x 3/8"-24	24,190	10	Gemini 57A24-R
61463622351	1-1/2" x 2-1/2" x 5/8"-11	24,190	10	Gemini 57A24-R
61463622191	1-1/2" x 3" x 5/8"-11	24,190	10	Gemini 57A24-R
61463622219	2" x 3" x 5/8"-11	18,145	10	Gemini 57A24-R
61463622366	2" x 4" x 5/8"-11	18,145	10	Gemini 57A24-R

Type 18R Round tip



Type 18R Plugs, Round Tip

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
61463622192	1-1/2" x 3" x 3/8"-24	24,190	10	Gemini 57A24-R
61463622220	2" x 3" x 5/8"-11	18,145	10	Gemini 57A24-R

Snagging Wheels

Gemini 57A, 57AC

- Versatile Aluminum Oxide Grain.
- Fully reinforced straight wheel for improved operator safety.
- 57A – aluminum oxide- For steel and steel alloys and irons.
- 57AC – aluminum oxide/silicon carbide blend - For dirty, scale-covered steel or iron parts.

Type 01, Straight

Horizontal/Straight Shaft Grinder

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243522381	2-1/2" x 1/2" x 3/8"	21,700	10	57A24-RBRA
66243528831	3" x 1/4" x 3/8"	20,370	10	57A24-TBRA
66243522415	3" x 3/8" x 3/8"	18,080	10	57A24-RBRA
66243522417	3" x 1/2" x 3/8"	18,080	10	57A24-PBRA
66243522221	4" x 1/4" x 3/8"	15,280	10	57A24-RBRA
66252809563	6" x 1" x 5/8" (S Webs)	8,000	10	Gemini 57A16-QS
66253006883	8" x 1" x 5/8"	6,000	10	Gemini 57A16-QS

15˚ Angle

Type 11, Flaring Cup

Portable Cup Grinder

Part No.	Size (D x T x H)	RPM	Pkg.	Spec
66243510512	4/3" x 2" x 5/8"-11 Rim 3/4" Back 3/4" (ME 48976)	9070	10	Gemini 57A16-Q
66252809598	5/3-3/4" x 2" x 5/8"-11 Rim 1" Back 3/4" (ME 49857)	7260	10	Gemini 57A16-Q
66252825201	6 / 4-3/4" x 2" x 5/8"-11 Rim 1" Back 3/4" (ME22100)	6000	5	Gemini 57A16-Q
66252809618	6 / 4-3/4" x 2" x 5/8"-11 Rim 1-1/2" Back 3/4" (ME 24180)	6000	5	Gemini 57A16-Q
66252809608				Gemini 57AC16-Q
66252809599	6/413/16" x 2" x 5/8"-11 Rim 11/2" Steel back 3/4"(ME 71438)	6000	5	Gemini 57A16-Q
66252809600				Gemini 57AC16-Q

Grinding Wheels

Applications
- Weld removal
- Cutting and parting
- Rough grinding
- Snagging

All Weiler wheels are resin bond formulated for fast, high quality grinding and cutting, and are reinforced with fiberglass webbing to provide stability.

Grain Selection Guide	
A24N	**Fast Cut** - ideal for use on hard welds and steel, stainless steel, and in low pressure, large contact grinding where the harder wheel grade (R) dulls or glazes.
A24R	**Long Life** - offers longer life than the softer wheel grade (N). Ideal for all general purpose grinding on structural steel, or in foundries or heavy fabrication applications.
Z24T	**High Performance Zirconium** - offers improved cut rate in high pressure applications. Ideal when grinding or cutting stainless steel, high carbon steel, cast iron and other metals.

Superior Construction Ensures Maximum Performance

Weiler's Type 27 Wheels contain no fillers and are made with 100% abrasive grain to maximize cut rate.

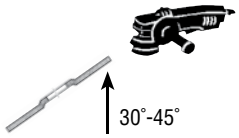
Weiler:
A side view of Weiler's Tiger Abrasives® Type 27 Grinding Wheel shows the even distribution of grain from the top to the bottom of the wheel. This provides a consistent rate of cut throughout the product life.

Competitor's:
A side view of competitor's Type 27 Grinding Wheel shows abrasive grain on the bottom portion of the wheel and filler grain on the top portion. The cut rate deteriorates dramatically when the filler portion of the wheel is reached.

Removing gates and risers from an iron casting.

Type 27 Cutting and Light Grinding Wheels

For root pass grinding, light grinding and cutting applications on various metals



Diameter x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
4" x 1/8" x 5/8"	15,200	A24T	56431
4-½" x 1/8" x 7/8"	13,300	A24T	56430
4-½" x 1/8" x 5/8"-11		A24T	56429
5" x 1/8" x 7/8"	12,200	A24T	56428
5" x 1/8" x 5/8"-11		A24T	56427
7" x 1/8" x 7/8"	8,500	A24T	56426
7" x 1/8" x 5/8"-11		A24T	56425
9" x 1/8" x 7/8"	6,600	A24T	56424
9" x 1/8" x 5/8"-11		A24T	56423

NOTE

Marking System

Grain Type	Grit Size	Grade (Hardness)
A	24	R

NOTE

For mounting wheels with 7/8" arbor holes on right angle grinders, use adapting nuts (Part No. 56494) as illustrated on page 406.

Cutting Wheels

Notching a piece of steel bar prior to welding.

Applications

- Cutting
- Parting
- Notching

Type 27 Thin Cutting Wheels

For fast, burr-free cutting of various metals

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/ Grade	Part No.	Grain/Grit/ Grade	Part No.
4-½" x .045" x 7/8"	13,300	A60V	56393	Z46T	56389
5" x .045" x 7/8"	12,200	A60V	56392	Z46T	56388
7" x .060" x 7/8"	8,500	A36V	56391	Z36T	56387

Type 27 Cutting Wheels

For a wide range of metal-cutting applications

Dia. x Thickness x Arbor Hole	Maximum RPM	Grain/Grit/Grade	Part No.
4" x 3/32" x 5/8"	15,200	A24T	56474
4-½" x 3/32" x 7/8" 4-½" x 3/32" x 5/8"-11	13,300	A24T A24T	56475 56385
5" x 3/32" x 7/8" 5" x 3/32" x 5/8"-11	12,200	A24T A24T	56476 56384
7" x 3/32" x 7/8" 7" x 3/32" x 5/8"-11	8,500	A24T A24T	56383 56477
9" x 3/32" x 7/8" 9" x 3/32" x 5/8"-11	6,600	A24T A24T	56382 56381

Adapting Nuts

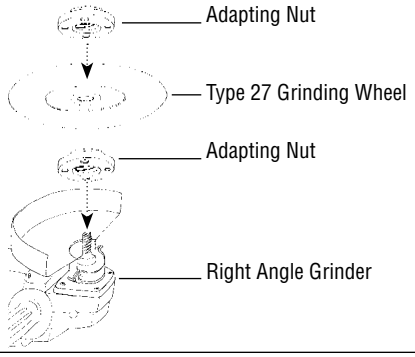
For mounting wheels with 7/8" arbor holes on right angle grinders.
For 4-½" & 5" Angle Grinders. Use with Part No. 56103 & 56118

Thread Size	Min. Wheel Thick.	Part No.
5/8" - 11	1/16"	56494

TIP

The following factors can cause wheel breakage:

- Excessive speed
- Excessive rate of wheel feed
- Improper mounting
- Improper machine conditions
- Work improperly clamped
- Misuse

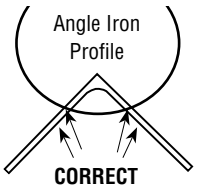


To mount wheels with 7/8" arbor holes on right angle grinders, use adapting nuts (Part No. 56494), as illustrated at left.

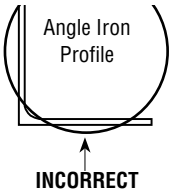
Cut-off Wheel Technical Information

General Operating Recommendations for Cut-Off Wheels

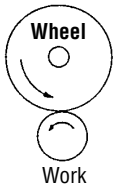
- Fixture work-piece to minimize wheel contact area for a faster, cooler cut.



CORRECT
(Two small contact points)

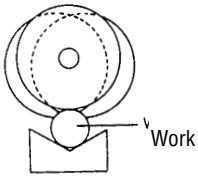


INCORRECT
(Wide contact point)

- 

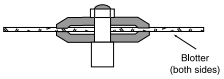
Counter rotation of the work-piece is recommended for cutting large cross sections (over 8") and when cutting tubular stock.

- Wheel

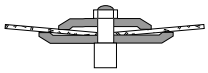


Use an oscillating head when cutting thicker cross sections (over 3"). This reduces arc of contact and permits larger sections to be cut with a given diameter wheel.

- Flanges should be of equal diameter, recessed and at least one-third the diameter of the wheel.



CORRECT



INCORRECT

Operation Guide for Cut-Off Wheels	
RPM	To maximize performance, run at or close to the Maximum Safe Free Speed or RPM. NEVER EXCEED the MSFS or RPM.
Feed Rate	Only the operator can determine if the feed rate is proper for an efficient operation. A good starting point for dry cutting most materials is 2-3 seconds per square inch.

Application Solutions Guide For Cut-off Wheels

There are many variables in using Cut-Off Wheels. If the product you are using does not accomplish the desired results, select a solution from the suggestions below for your specific application.

Problem	Cause	Recommended Solutions
Slow cut rate	Insufficient power being used	Increase feed rate; run machine at full power
	Contact area too large	Reduce contact area
	Side run out	Check for spindle run out
	Wheel binding	Provide relief under part
Workpiece burn	Insufficient feed rate	Increase feed rate
	Wheel speed too slow	Check for wheel slippage
	Wheel too coarse	Use finer grit or increase power
Non-square cuts	Work not properly fixtured	Support both sides and fixture properly
	Worn spindle bearings	Check spindle
Too much burr	Improper fixturing	Check part fixturing
	Grit too coarse	Use a finer grit

Safety

Abrasive users and others in area must wear goggles or face shields over safety glasses. Safety guards must be used. Do not exceed maximum RPM.

Cut-Off Wheels

Cutting a piece of hex bar stock.

Applications

- Cutting various shapes of metals and masonry
- Parting
- Snagging

NOTE

Marking System

Grain Type	Grit Size	Grade (Hardness)
A	24	T

TIP

For maximum wheel life, select the coarsest, hardest wheel that will perform the cut.

Small Type 1 Reinforced Wheels

For electric or air die grinders and angle grinders

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
1-½" x .035" x 1/8"	45,000	A60T	56003
2" x .035" x ¼"	30,000	A60T	56013
2" x 1/16" x ¼"		A36T	56015
2" x 1/16" x ¼"		A46T	56016
2" x 1/16" x ¼"		A60T	56017
3" x .035" x ¼"	25,000	A60T	56061
3" x .035" x 3/8"		A60T	56062
3" x 1/16" x ¼"		A36T	56065
3" x 1/16" x ¼"		A46T	56066
3" x 1/16" x ¼"		A60T	56067
3" x 1/16" x 3/8"		A36T	56068
3" x 1/16" x 3/8"		A46T	56069
3" x 1/16" x 3/8"		A60T	56070
3" x 1/8" x 3/8"		A36T	56076
4" x .035" x ¼"	19,000	A60T	56079
4" x .035" x 3/8"		A60T	56080
4" x 1/16" x ¼"		A36T	56083
4" x 1/16" x ¼"		A46T	56084
4" x 1/16" x ¼"		A60T	56085
4" x 1/16" x 3/8"		A36T	56086
4" x 1/16" x 3/8"		A46T	56087
4" x 1/16" x 3/8"		A60T	56088
4" x 1/8" x 3/8"		A36T	56099
4-½" x 1/16" x 7/8"	13,500	A60T	56103
5" x .035" x 3/8"	12,200	A60T	56106
5" x .035" x 5/8"		A60T	56108
5" x 1/16" x 5/8"		A36T	56115
5" x 1/16" x 5/8"		A60T	56117
5" x 1/16" x 7/8"		A36T	56118

Type 1 Portable Snagging Wheels

For electric or air die grinders

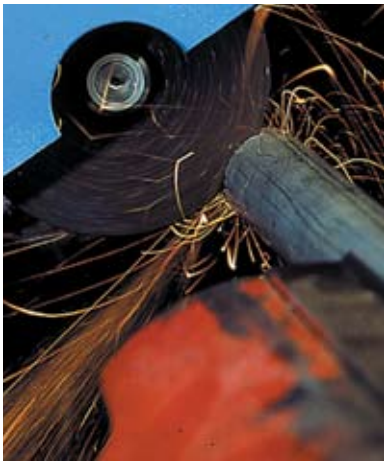
Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
2" x ¼" x 3/8"	30,000	A36T	56131
3" x ¼" x 3/8"	23,000	A36T	56147
4" x ¼" x 3/8"	19,000	A36T	56163

Mounting Mandrels - ¼" stem - Type 1 Wheels only

Arbor Size	Wheel Thickness	Part No.
¼"	.035" to ¼"	56489
3/8"	.035" to ¼"	56490
¼", 3/8"*	.035" to ¼"	56491

*Combination pack

Cut-off Wheel



Cutting a length of steel pipe.

TIP

- Convex wheel wear is a sign of proper wheel usage.
- Pointed wheel wear is a sign of improper usage. Wheel is too hard for application or feed rate is too slow for application.

Plastic Adapters

For Cut-Off Wheels with 1" arbor holes

Wheel Arbor Hole Size	Adapted Arbor Hole Size	Part No.
1"	20mm	04455

Type 1 Reinforced Wheels

For tool room & machine shop use

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
6" x .035" x ½" 6" x .035" x 5/8"	10,200	A60T A60T	56170 56171
7" x .035" x 5/8" 7" x .035" x 1-¼" 7" x 1/16" x 5/8" 7" x 1/16" x 5/8" 7" x 1/16" x 1-¼"	8,740	A60T A60T A36T A60T A60T	56183 56184 56188 56190 56193
8" x .035" x 1-¼"	7,640	A60T	56199

Type 1 Reinforced Wheels

For circular saws

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
7" x 1/8" x DIA.	8,500	A24T C24T	56208 56209
8" x 1/8" x DIA.	7,640	A24T C24T	56210 56211

Dia. = 5/8" arbor with diamond knockout adapter

Large Type 1 Reinforced Wheels

For stationary machines

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
10" x 1/16" x 5/8"	6,100	TA36R	56214
12" x 1/8" x 1"	5,100	TA24R	56226
14" x 1/8" x 1"	4,400	TA30R	56230

Large Type 1 Reinforced Wheels

For portable gas or electric saws

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
12" x 1/8" x 1"	6,300	A24T C24T CA30P	56241 56242 56243
14" x 1/8" x 1"	5,200	A24T C24T CA30P	56250 56251 56252

Large Type 1 Reinforced Wheels

For low horsepower chop saws

Dia. x Thickness x Arbor Hole	Max. RPM	Grain/Grit/Grade	Part No.
12" x 3/32" x 1"	5,100	A46T	56239
14" x 3/32" x 1"	4,400	A46T	56240

Flap Discs

Selection Guide For Backing and Grain Types

Application Requirement	Backing Type
Rigid support for maximum aggression; recyclable	Aluminum
Prevent backing from scratching the work-piece	Phenolic
Trimmable, non-marking backing; for hard-to-reach angles	Composite

Application Requirement	Grain Type
High rate of stock removal and long life	Zirconium
General purpose metalworking applications	Aluminum Oxide
Maximum material removal	Coarser Grits
Achieve desired finishes	Finer Grits

Flap Discs

Aluminum Oxide - Fiberglass Backing

Angled Style - T29

Part No.	Diameter	Arbor	Grit Size	Max RPM
40307	4-1/2"	7/8"	36	13,000
40308	4-1/2"	7/8"	40	13,000
40309	4-1/2"	7/8"	60	13,000
40310	4-1/2"	7/8"	80	13,000

Zirconium - Fiberglass Backing

Angled Style - T29

Part No.	Diameter	Arbor	Grit Size	Max RPM
40344	4-1/2"	7/8"	40	13,000
40345	4-1/2"	7/8"	60	13,000
40346	4-1/2"	7/8"	80	13,000
40349	4-1/2"	5/8" - 11 Nut	36	13,000
40350	4-1/2"	5/8" - 11 Nut	40	13,000
40351	4-1/2"	5/8" - 11 Nut	60	13,000
40352	4-1/2"	5/8" - 11 Nut	80	13,000
40362	7"	5/8" - 11	40	13,000
40363	7"	5/8" - 11	60	13,000

Zirconium - High Density

Fiberglass Backing - Flat Style - T27

Part No.	Diameter	Arbor	Grit Size	Max RPM
40373	4-1/2"	7/8"	40	12,000
40374	4-1/2"	7/8"	60	12,000
40375	4-1/2"	7/8"	80	12,000
40376	4-1/2"	7/8"	120	12,000
40377	4-1/2"	5/8" - 11 Nut	40	12,000
40378	4-1/2"	5/8" - 11 Nut	60	12,000
40379	4-1/2"	5/8" - 11 Nut	80	12,000
40381	7	5/8" - 11	60	12,000
40382	7	5/8" - 11	80	12,000

3M™ Flap Discs

747D

Premium ceramic mineral provides exceptional cut and life on the hardest metals.

Part No./UPC	Dia. x Ctr Hole	Grade	Min./Case
051111-49613-8	4-1/2" x 7/8" Max RPM: 13,300	36	10
051111-49614-5		50	
051111-49615-2		60	
051111-49616-9		80	
051111-49617-6		P120	
051111-49608-4	7" x 7/8" Max RPM: 8,600	36	5
051111-49609-1		50	
051111-49610-7		60	
051111-49611-4		80	
051111-49612-1		P120	

563D

Fast cutting disc with exceptionally long life. Alumina zirconia.

Part No./UPC	Dia. x Ctr Hole	Grade	Min./Case
051111-50467-3	4-1/2" x 7/8" Max RPM: 13,300	P36	10
051111-50468-0		P40	
051111-50469-7		P60	
051111-50470-3		P80	
051111-50471-0		P120	
051111-50769-8	4-1/2" x 5/8"-11 Max RPM: 13,300	P36	10
051111-50770-4		P40	
051111-50771-1		P60	
051111-50772-8		P80	
051111-50773-5		P120	
051111-50472-7	7" x 7/8" Max RPM: 8,600	P36	5
051111-50473-4		P40	
051111-50474-1		P60	
051111-50475-8		P80	
051111-50476-5		P120	
051111-50774-2	7" x 5/8"-11 Max RPM: 8,600	P36	5
051111-50775-9		P40	
051111-50776-6		P60	
051111-50777-3		P80	
051111-50778-0		P120	

Accessories

Flap Disc Adaptor Nut

Adaptor nut used for securing 4-1/2" diameter flap discs to right angle tool with a 5/8"- 11 threaded shaft.

Part No./UPC	Thread Size	Min./Case
051144-88765-1	5/8" –11	1 Pair/5 Pair

Flap Disc Holder

Backup plate for 7" diameter, type-27 flap discs.

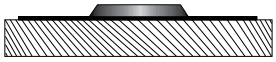
Part No./UPC	Thread Size	Min./ Case
051144-88769-9	4" x 5/8" –11	1

Flap Discs

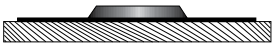
General Information

- Stock removal.
- Blending welds.
- Edge chamfering.
- Deburring.
- Rust removal.
- Cleaning and finishing.

Norton Type 29
Merit Type 27C (Conical)



Norton Type 27 Jumbo
Merit High Density



Type 27

Right Angle Grinder

15˚ Angle

Vertical Shaft Grinder

Twinfiber Type 29

For Maximum Stock Removal

- Premium ceramic and zirconia alumina abrasives blend.
- Excellent performance and efficiencies on stainless and carbon steel applications.
- Durable, fiberglass back - Less pressure for aggressive stock removal - Long life.
- Type 29 - angled face; conical shape - Maximum contact with work surface without loading.

Best

TwinStar Type 27

For Fine Finishes

- Premium ceramic and zirconia alumina abrasives blend.
- Excellent performance and efficiencies on stainless and carbon steel applications.
- Type 27 - flat face; plastic back - Plastic wears away with abrasive - for longer life - More forgiving than Type 29. For producing smooth finishes.

Best

Charger R822 Type 29

R822, Type 29, Type 27 and Type 27 Jumbo

- High performance zirconia alumina abrasive - Aggressive cut and up to 30% longer life than aluminum oxide products.
- Durable, fiberglass-construction back - Less pressure for aggressive stock removal and long life.

Better

Merit Type 27C, Type 27

Type 27C, Type 27, High Density and Mini's

- High performance zirconia alumina grain with a phenolic resin backing - Fast cutting; fine finishes.

Good

R822, T29, Type 27 and Type 27 Jumbo

Part No.	Size	Grit	RPM	Type	Pkg.	Spec
66261119265	4" x 5/8"	36	15,300	29	5	Charger R822
66261119264		40		29	5	Charger R822
66261119263		60		29	5	Charger R822
66261119262		80		29	5	Charger R822
66261119261		120		29	5	Charger R822
66261121291	4-1/2" x 5/8"-11	24	13,300	29	5	Charger R822
66261121290		36		29	5	Charger R822
66261121289		40		29	5	Charger R822
08834194803				27C	10	Merit Powerflex
66261121288		60		29	5	Charger R822
08834194804				27C	10	Merit Powerflex
66261121287		80		29	5	Charger R822
08834194805				27C	10	Merit Powerflex
66261121286		120		29	5	Charger R822
66261119271	4-1/2" x 7/8"	24	13,300	29	10	Charger R822
63642504329		36		29	10	TwinFiber
66261119270				29	5	Charger R822
08834194296				27C	10	Merit Powerflex
63642504330		40		29	10	TwinFiber
66261119269				29	5	Charger R822
08834194766				27C	10	Merit Powerflex
63642504331		60		29	10	TwinFiber
66261119268				29	5	Charger R822
08834194767				27C	10	Merit Powerflex
63642504332		80		29	10	TwinFiber
66261119267				29	5	Charger R822
08834194768				27C	10	Merit Powerflex
63642504333		120		29	5	TwinFiber
66261119266				29	5	Charger R822

Part No.	Size	Grit	RPM	Type	Pkg.	Spec.
66261119277	5" x 7/8"	24	12,250	29	5	Charger R822
66261119276		36		29	5	Charger R822
08834193649				27C	10	Merit Powerflex
66261119275		40		29	5	Charger R822
08834193650				27C	10	Merit Powerflex
66261119274		60		29	5	Charger R822
08834193651				27C	10	Merit Powerflex
66261119273		80		29	5	Charger R822
08834193652				27C	10	Merit Powerflex
66261119272		120		29	5	Charger R822
66261119289	7" x 5/8"-11	24	8,600	29	5	Charger R822
66261119288		36		29	5	Charger R822
66261119287		40		29	5	Charger R822
08834197210				27C	10	Merit Powerflex
66261119286		60		29	5	Charger R822
08834197212				27C	10	Merit Powerflex
66261119285		80		29	5	Charger R822
08834197213				27C	10	Merit Powerflex
66261119284		120		29	5	Charger R822
66261119283	7" x 7/8"	24	8,600	29	5	Charger R822
08834197194				27C	10	Merit Powerflex
63642504334		36		29	10	TwinFiber
66261119282				29	5	Charger R822
08834197195				27C	10	Merit Powerflex
63642504335		40		29	10	TwinFiber
66261119281				29	5	Charger R822
08834194777				27C	10	Merit Powerflex
63642504336		60		29	10	TwinFiber
66261119280				29	5	Charger R822
08834197199				27C	10	Merit Powerflex
63642504337		80		29	10	TwinFiber
66261119279				29	5	Charger R822
08834197204				27C	10	Merit Powerflex
63642504338		120		29	10	TwinFiber

Mini Powerflex Holder

Part No.	Description	Std. Pkg.
08834160172	Mini Powerflex Type III Holder	1
08834168539	T11 Merit holder for mini flap discs	1

Fits 2" and 3" Merit Flap Discs.

NORTON

Norton
Vendor Code: NRT

Flap Discs

Type 27

Part No.	Size	Grit	RPM	Pkg.	Spec
08834195020	2" Type II Turn-on	36	24,000	10	Merit Powerflex
08834195021		40			Merit Powerflex
08834195022		60			Merit Powerflex
08834195023		80			Merit Powerflex
08834195024		120			Merit Powerflex
08834195035	3" Type II Turn-on	36	20,000	10	Merit Powerflex
08834195036		40			Merit Powerflex
08834195037		60			Merit Powerflex
08834195038		80			Merit Powerflex
08834195039		120			Merit Powerflex
63642536153	4" x 5/8"	40	15,300	10	Twinstar
63642536154		60			Twinstar
63642536155		80			Twinstar
63642503510	4-1/2" x 5/8"-11	36	13,300	5	Charger R822
63642503511		40			Charger R822
63642503512		60			Charger R822
63642503513		80			Charger R822
63642536147		40			Twinstar
63642536148		60			Twinstar
63642536149		80			Twinstar
63642504876	4-1/2" x 7/8"	36	13,300	10	TwinStar
63642504877		40			TwinStar
66261134069				5	Charger R822
63642504878		60		10	TwinStar
66261134070				5	Charger R822
63642504879		80		10	TwinStar
66261134071				5	Charger R822
63642505279		120		10	TwinStar
63642505281	5" x 7/8"	36	12,250	10	TwinStar
63642503514				5	Charger R822
63642505282		40		10	TwinStar
63642503515				5	Charger R822
63642505283		60		10	TwinStar
63642503516				5	Charger R822
63642505284		80		10	TwinStar
63642505285		120		10	TwinStar
63642503518	7" x 5/8"-11	36	8,600	5	Charger R822
63642503519		40			Charger R822
63642503520		60			Charger R822
63642503521		80			Charger R822
63642536150		40	8,500		Twinstar
63642536151		60			Twinstar
63642536152		80			Twinstar
63642504880	7" x 7/8"	36	8,600	10	TwinStar
63642504881		40			TwinStar
66261134072				5	Charger R822
63642504882		60		10	TwinStar
66261134073				5	Charger R822
63642504883		80		10	TwinStar
66261134074				5	Charger R822
63642505280		120		10	TwinStar

Type 27 Jumbo / High Density

Part No.	Size	Grit	RPM	Pkg.	Spec
63642503527	4-1/2" x 5/8"-11	40	13,300	5	Charger Jumbo R822
63642503528		60			Charger Jumbo R822
63642503529		80			Charger Jumbo R822
63642503531	4-1/2" x 7/8"	40	13,000	5	Charger Jumbo R822
08834190172				10	Merit High Density Powerflex
63642503532		60		5	Charger Jumbo R822
08834190767				10	Merit High Density Powerflex
63642503533		80		5	Charger Jumbo R822
08834194360				10	Merit High Density Powerflex
63642503539	7" x 5/8"-11	40	8,600	5	Charger Jumbo R822
63642503540		60			Charger Jumbo R822
63642503535	7" x 7/8"	40	8,600	5	Charger Jumbo R822
08834190933				10	Merit High Density Powerflex
63642503536		60		5	Charger Jumbo R822
08834194514				10	Merit High Density Powerflex
63642503537		80		5	Charger Jumbo R822
08834194362				10	Merit High Density Powerflex

Type 29

Part No.	Size	Grit	RPM	Pkg.	Spec
63642536156	4-1/2" x 5/8"-11	40	13,300	5	Twinstar
63642536157		60			Twinstar
63642536158		80			Twinstar
63642541406	6" x 7/8"	40	10,200	10	TwinFibre
63642541407		60			TwinFibre
63642541408		80			TwinFibre
63642536159	7" x 5/8"-11	40	8,600	5	TwinFibre
63642536160		60			TwinFibre
63642536161		80			TwinFibre

TECH TIPS

- *Operate Type 29/27C flap discs at a 15° – 25° angle.*
- *Operate Type 27 (Regular and Jumbo/ High Density) flap discs at an angle less than 15°.*
- *More severe angles will weaken flap edges.*
- *Use one grit size coarser than fibre discs, except in 36 grit.*

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

Technical Information - Abrasive Flap Discs

Operational Advantages of Abrasive Flap Discs

Grind and Finish in One Step

Weiler's Abrasive Flap Discs save you time and money. Now, there's no need to switch from a Type 27 Wheel to a Resin Fiber Disc because flap discs grind and finish in one step. This results in fewer changeovers and increased productivity.

Construction Advantages of Abrasive Flap Discs

Abrasive Flap Disc:
Multi-layer flap construction
As the abrasive cloth flaps slowly wear down, new sharp abrasive grain is constantly exposed, producing a consistently high cut rate throughout disc life.

Resin Fiber Disc:
Solid one-layer construction
The cut rate of a resin fiber disc diminishes rapidly because, as the disc wears, no new abrasive grain is exposed.

Product Selection

Selection Guide For Abrasive Flap Discs

Application Requirement	Abrasive Flap Disc Type	Tool
High cut rate and consistent finish. Enables operator to trim non-marking backing, exposing more flaps, therefore extending life and increased flexibility..	***Trimable* Tiger® Flap Disc** Angled (Type 29)	
A high cut rate and a long life.	***Original* Tiger® Disc** Angled (Type 29)	
	***Original* Tiger® Disc** Flat (Type 27)	
A high cut rate at a value price (maintains similar cut rate as original Tiger Discs™).	**Vortec Pro™ Flap Disc** Angled (Type 29)	
Increased conformability on contoured parts; enhanced ergonomics; long life; minimized gouging on value-added components.	***High Density* Big Cat®** Flat (Type 27)	
Increased conformability at a value price.	***High Density* Vortec Pro™ Flap Disc** Flat (Type 27)	
Stainless steel and other high strength metal grinding applications.	***High Density* Tiger® Discs *For Stainless Steel*** Flat (Type 27)	
For use on air and electric right angle die grinders. Ideal for small, tight areas; non-marking backing.	**BobCat® Mini Disc** Angled (Type 29)	
	BobCat® Mini Disc Flat (Type 27)	

Selection Guide For Backing and Grain Types

Application Requirement	Backing Type
Rigid support for maximum aggression; recyclable	Aluminum
Prevent backing from scratching the work-piece during operation	Phenolic
Trimmable, non-marking backing; allows access to hard-to-reach angles.	Composite

Application Requirement	Grain Type
High rate of stock removal and long life in demanding applications	Zirconium
General purpose metalworking applications	Aluminum Oxide
Maximum material removal	Coarser Grits
Achieve desired finishes	Finer Grits

Tiger Disc™ Abrasive Flap Discs

Blending and finishing edges of a flame-cut steel part.

Applications

- Weld blending
- Grinding
- Deburring
- Deflashing
- Surface finishing and blending
- Edge chamfering
- Stock removal

Weiler's Original Tiger Discs™ are designed for the serious industrial user who values both a high cut rate and long life.

For Best Results:
Use 1 grit size coarser than resin fiber disc.

Exception:
36 grit, use same size.

Tiger Disc™ - Angled Style (Type 29)

Maximum aggression and long life.
Ideal for a working angle of 15°-25°

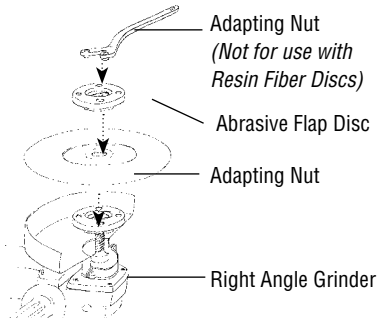
15°-25°

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No. Phenolic Backing Zirconium	Part No. Phenolic Backing Aluminum Oxide	Part No. Aluminum Backing Zirconium
4"	5/8"	36	15,000	50592	50552	50502
		40		50593	50553	50503
		60		50594	50554	50504
		80		50595	50555	50505
		120		50596	50556	50506
4-½"	7/8"	*24	13,000	50601	50561	50511
		36		50602	50562	50512
		40		50603	50563	50513
		60		50604	50564	50514
		80		50605	50565	50515
		120		50606	50566	50516
4-½"	5/8"-11 Nut	*24	13,000	–	–	50510
		36		–	–	50517
		40		50608	–	50518
		60		50609	–	50519
		80		50610	–	50520
		120		–	–	50509
5"	7/8"	*24	12,000	50611	50571	50521
		36		50612	50572	50522
		40		50613	50573	50523
		60		50614	50574	50524
		80		50615	50575	50525
		120		50616	50576	50526
7"	7/8"	*24	8,600	50621	50581	50531
		36		50622	50582	50532
		40		50623	50583	50533
		60		50624	50584	50534
		80		50625	50585	50535
		120		50626	50586	50536
7"	5/8"-11 Nut	*24	8,600	50641	50631	50541
		36		50642	50632	50542
		40		50643	50633	50543
		60		50644	50634	50544
		80		50645	50635	50545
		120		50646	50636	50546

*When grinding steel and other ferrous materials, a 36 grit Tiger Disc™ is more productive than a 24 grit. 24 grit Tiger Discs™ are most productive when used on aluminum and other soft materials.

Adapting Nuts and Spanner Wrench

Description	Thread Size	For Use With	Part No.
Adapting Nuts	3/8" - 24	4" Flap Disc with 5/8" arbor hole (Can be used with an adjustable or combination wrench.)	56484
Adapting Nuts	5/8"-11	4-½", 5" & 7" Flap Discs with 7/8" arbor hole	56494
Spanner Wrench	–	Part No. 56494 only	56495

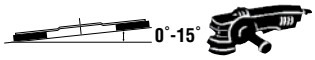


Tiger Disc™ Abrasive Flap Discs

Blending a corner weld on a stainless steel cabinet.

Tiger Disc™ - Flat Style (Type 27)

Smooth grinding action and long life.
Ideal for a working angle less than 15˚



Dia.	Arbor Hole	Grit Size	Max. RPM	Part No. Phenolic Backing Zirconium	Part No. Phenolic Backing Aluminum Oxide
4"	5/8"	40	15,000	50693	50653
		60		50694	50654
		80		50695	50655
		120		50696	50656
4½"	7/8"	40	13,000	50703	50663
		60		50704	50664
		80		50705	50665
		120		50706	50666
5"	7/8"	40	12,000	50713	50673
		60		50714	50674
		80		50715	50675
		120		50716	50676
7"	7/8"	40	8,600	50723	50683
		60		50724	50684
		80		50725	50685
		120		50726	50686
7"	5/8"-11 Nut	40	8,600	50743	50733
		60		50744	50734
		80		50745	50735
		120		50746	50736

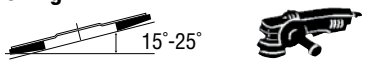
Trimmable Tiger Disc® Abrasive Flap Discs

Featuring a performance engineered, trimmable backing, this unique Tiger Disc™ design enables the operator to trim away the back of the disc, exposing more flap abrasive and dramatically extending the life of the disc.

Grinding corners just got easier!

Tiger Disc™ - Trimmable Backing

Zirconium Grain, Angled Style
(Type 29)



Dia.	Arbor Hole	Grit Size	Max RPM	Std. Pack	Part No.
4½"	7/8"	40	13,000	10	50002
		60			50003
		80			50004
		120			50005
4½"	5/8"-11	40	13,000	10	50006
		60			50007
		80			50008
		120			50009
5"	7/8"	40	12,000	10	50010
		60			50011
		80			50012
		120			50013
5"	5/8"-11	40	12,000	10	50014
		60			50015
		80			50016
		120			50017

The backing can be trimmed up to 3/8" from the original diameter, dramatically extending the life of the disc.

Vortec Pro™ Abrasive Flap Discs

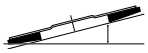
Weld blending after a repair on a steel rack.

***For Best Results:**
When grinding steel and other ferrous materials, a 36 grit Vortec™ flap disc is more productive than a 24 grit.

24 grit flap discs are most productive when used on aluminum and other soft materials.

Vortec Pro™ - Angled Style (Type 29)

High cut rate at a value price.



Dia.	Arbor Hole	Grit Size	Max. RPM	Part No.	
				Phenolic Back - Zirconium	Aluminum Back - Zirconium
4"	5/8"	24* 40 60 80 120	15,000	31337 31338 31339 31340 31341	31301 31302 31303 31304 31305
4-½"	7/8"	24* 36 40 60 80 120	13,000	31342 31343 31344 31345 31346 31347	31306 31307 31308 31309 31310 31311
4-½"	5/8"-11 Nut	24* 36 40 60 80 120	13,000	31348 31349 31350 31351 31352 31353	31312 31313 31314 31315 31316 31317
5"	7/8"	24* 36 40 60 80 120	12,000	31354 31355 31356 31357 31358 31359	31318 31319 31320 31321 31322 31323
7"	7/8"	24* 36 40 60 80 120	8,600	31360 31361 31362 31363 31364 31365	31324 31325 31326 31327 31328 31329
7"	5/8"-11 Nut	24* 36 40 60 80 120	8,600	31366 31367 31368 31369 31370 31371	31330 31331 31332 31333 31334 31335

Vortec Pro™ - Flat Style (Type 27)

Smooth grinding at a value price.

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No.
				Phenolic Back - Zirconium
4-½"	7/8"	36 40 60 80	13,000	31401 31402 31403 31404
4-½"	5/8"-11 Nut	36 40 60 80	13,000	31407 31408 31409 31410
7"	7/8"	36 40 60 80	8,600	31413 31414 31415 31416
7"	5/8"-11 Nut	36 40 60 80	8,600	31419 31420 31421 31422

Vortec Pro™ Abrasive Flap Discs

Grinding welds on a fabricated steel part.

Applications

- Weld blending
- Grinding
- Deburring
- Deflashing
- Surface finishing and blending
- Edge chamfering
- Stock removal

For Best Results:
Use 1 grit size coarser than resin fiber disc.

Exception:
36 grit, use same size.

Vortec Pro™ - High Density - Flat Style (Type 27)

Increased conformability at a value price. 0°-15°

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No. Phenolic Back - Zirconium
4-½"	7/8"	40 60 80	12,000	31387 31388 31389
4-½"	5/8"-11 Nut	40 60 80	12,000	31390 31391 31392

Vortec Pro™ - Display Packaged Angled Style - (Type 29)

Convenient hang-card makes increasing point-of-purchase sales easy! 15°-25°

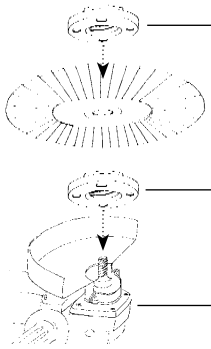
Dia.	Grit Size	Max. RPM	Phenolic Back - Zirconium		Aluminum Back - Zirconium	
			Arbor Hole	Part No.	Arbor Hole	Part No.
4"	36 60 80	15,000	5/8"	30822 30825 30826	5/8"-11	30821 30823 30824
4-½"	36 60 80	13,000	7/8"	30828 30831 30832	5/8"-11	30827 30829 30830
7"	36 60 80	8,600	7/8"	30834 30837 30838	5/8"-11	30833 30835 30836

Vortec Pro™ Assortments

Description	Part No.
Small Angle Grinder Assortment with backmat 3 each of 4" & 4-½" aluminum backed, 36, 60 & 80 grits	30840
Large Angle Grinder Assortment 2 each of 7" aluminum backed, 36, 60 & 80 grits	30841

Adapting Nuts & Spanner Wrench

Adapting Nut Assembly



Adapting Nuts and Spanner Wrench -

For use with Tiger®, Vortec Pro™ and High Density Flap Discs

Description	Thread Size	For Use With	Part No.
Adapting Nuts	3/8" - 24	4" Flap Disc with 5/8" arbor hole (Can be used with an adjustable or combination wrench.)	56484
Adapting Nuts	5/8"-11	4-½", 5" & 7" Flap Discs with 7/8" arbor hole	56494
Spanner Wrench	–	Part No. 56494 only	56495

Specialty Abrasive Flap Discs

Weld blending on an automotive part.

Big Cat® Applications
Provides increased conformability and long life when:

- Weld blending
- Grinding
- Deburring
- Deflashing
- Stock removal
- Surface finishing and blending
- Edge chamfering

Big Cat® - High Density - Flat Style (Type 27)

A thicker disc with larger flaps which conforms to curved and irregular surfaces while producing a consistent finish. 30-40% longer life than standard flap discs.

0°-15°

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No. Phenolic Backing	
				Zirconium	Aluminum Oxide
4-½"	7/8"	40 60 80 120	12,000	50803 50804 50805 50806	50763 50764 50765 50766
4-½"	5/8"-11 Nut	40 60 80	12,000	50808 50809 50810	– – –
7"	7/8"	40 60 80 120	8,600	50823 50824 50825 50826	50783 50784 50785 50786
7"	5/8"-11 Nut	40 60 80 120	8,600	50843 50844 50845 50846	50833 50834 50835 50836

Note: Weiler's Specialty Abrasive Flap Discs provide users with a flap disc designed for application-specific situations.

Tiger Discs™ for Stainless Steel:

- Made with specially formulated, fast-cutting abrasive cloth which prevents dulling and glazing of abrasive grains leading to consistently high cut rates.
- 50-65% more abrasive cloth than conventional flap discs - disc life is extended resulting in the lowest cost-per-piece finished.
- High density flat configuration adds flexibility which promotes smoother grinding action and reduces the possibility of damage to high-value stainless parts.
- Designed to work under lighter pressures which minimizes gouging, undercutting, heat discoloration and thermal distortion, and reduces operator fatigue.

For use in applications for stainless steel such as:

- Weld blending
- Grinding
- Heavy deburring
- Deflashing
- Stock removal and dressing
- Finishing and blending
- Edge chamfering

Tiger Discs™ for Stainless Steel High Density Flat Style (Type 27)

60 Grit: For maximum cut rate;
80 Grit: For superior finish

0°-15°

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No. Phenolic Backing
4-½"	7/8"	60 80	12,000	50864 50865
4-½"	5/8"-11 Nut	60 80	12,000	50869 50870
7"	7/8"	60 80	8,600	50884 50885
7"	5/8"-11 Nut	60 80	8,600	50894 50895

***For Best Results:**
When grinding welds that are less than a ¼" thick, use a 60 grit Tiger Disc™ for Stainless Steel as the first step, instead of a hard grinding wheel. This disc grinds faster while producing a smoother finish than a grinding wheel. This process cuts down the time and the number of abrasive products required to grind and finish the welds.

Specialty Abrasive Flap Discs

Blending excess brazing material on a machine component.

Applications

Used on right angle air die grinders for:

- Grinding, deburring and blending on steel, stainless steel and other metals
- Jobs requiring high aggression and rapid stock removal
- Metal fabrication requiring light weld blending or edge chamfering

BobCat™ - Angled Style (Type 29)

Used on right angle air die grinders for maximum aggression. Small size allows access to confined areas.

Dia.	Grit Size	Max. RPM	Part No. Zirconium
2"	36	30,000	50922
	40		50923
	60		50924
	80		50925
	120		50926
3"	36	20,000	50902
	40		50903
	60		50904
	80		50905
	120		50906

Patented

BobCat™ - Flat Style (Type 27)

Used on right angle air die grinders for smooth grinding and enhanced conformability. Small size allows access to confined areas.

Dia.	Grit Size	Max. RPM	Part No. Zirconium
2"	36	30,000	50932
	40		50933
	60		50934
	80		50935
	120		50936
3"	36	20,000	50912
	40		50913
	60		50914
	80		50915
	120		50916

Patented

BobCat™ Drive Mandrel

Description	Part No.
For mounting 2" & 3" BobCats on tools with ¼" collets.	07766

3" BobCats™ can also be mounted on Norton Speed-Lok® TS back-up pads and Weiler metal hub pad Part No. 60509. Speed-Lok® TS is a registered trademark of Norton Co.

Coated Abrasives

Safety Recomendations

- Do not exceed maximum RPM.
- Safety guards must be worn.
- Abrasive users must wear goggles or face shields over safety glasses.

Resin Fiber Discs

Aluminum Oxide

- Weld smoothing and cleaning.
- All purpose grinding-metals, plastic, wood and fiberglass.
- Rust removal.
- Paint removal (boats, walls, automobiles).
- Dimensional reduction.
- Removal of imperfections.

Aluminum Oxide Grain

- Grains wear during use.
- Fast, smooth cutting action.
- High resistance to heat, glazing and loading.

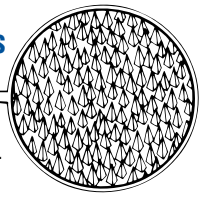
Zirconium

- High-performance metal grinding for stainless steel, tool steel and hard to grind materials.

Zirconium Grain

- Grains fracture during use, re-sharpening themselves as they grind. They have 2 - 3 times longer life than conventional grains.
- Superior cutting action.
- Ultra-high resistance to heat, glazing and loading.

Electrostatically Deposited Grains



- Ensures complete grain coverage including the outside edge of the disc.
- The grain is evenly dispersed and oriented with cutting edge facing up or outwards from the disc.

Part No. Aluminum Oxide	Part No. Zirconium	Grit	Size	Arbor Hole
4A24		24	4"	5/8"
4A36		36	4"	5/8"
4A50		50	4"	5/8"
4A60		60	4"	5/8"
4A80		80	4"	5/8"
4A100		100	4"	5/8"
4A120		120	4"	5/8"
45A16		16	4-1/2"	7/8"
45A24	45Z24	24	4-1/2"	7/8"
45A36	45Z36	36	4-1/2"	7/8"
45A50	45Z50	50	4-1/2"	7/8"
45A60	45Z60	60	4-1/2"	7/8"
45A80	45Z80	80	4-1/2"	7/8"
45A100		100	4-1/2"	7/8"
45A120		120	4-1/2"	7/8"
5A24	5Z24	24	5"	7/8"
5A36	5Z36	36	5"	7/8"
5A50	5Z50	50	5"	7/8"
5A60	5Z60	60	5"	7/8"
5A80	5Z80	80	5"	7/8"
5A100		100	5"	7/8"
5A120		120	5"	7/8"
7A16		16	7"	7/8"
7A24	7Z24	24	7"	7/8"
7A36	7Z36	36	7"	7/8"
7A50	7Z50	50	7"	7/8"
7A60	7Z60	60	7"	7/8"
7A80	7Z80	80	7"	7/8"
7A100		100	7"	7/8"
7A120		120	7"	7/8"
9A16		16	9"	7/8"
9A24		24	9"	7/8"
9A36		36	9"	7/8"
9A50		50	9"	7/8"
9A60		60	9"	7/8"
9A80		80	9"	7/8"
9A100		100	9"	7/8"
9A120		120	9"	7/8"

Pads For Resin Fiber Sanding Discs

High quality general purpose pads for use with any sanding disc with a 7/8" diameter arbor hole. Each pad includes retaining nut to fit tools with 5/8" - 11 shafts.

- **Ribbed Face-** Ribbed face pads are recommended with grits 36 and coarser. They are used for heavy stock removal applications. The ribs allow air to pass under the disc for cooler operation.
- **Smooth Face-** Smooth face pads are recommended with grits 36 and finer. They are more flexible than ribbed face pads.

Part No.	Diameter	Arbor	Flex
BP-400	4"	5/8" - 11	Medium
BP-450	4.5"	5/8" - 11	Medium
BP-500	5"	5/8" - 11	Medium
BP-700M	7"	5/8" - 11	Medium
BP-700F	7"	5/8" - 11	Soft
BP-900	9"	5/8" - 11	Medium
PP4250	4.5"	5/8" - 11	Firm
PP5000	5"	5/8" - 11	Firm
BP-700	7"	5/8" - 11	Firm

Back-up Pads For Surface Conditioning Discs

These pads have a special extended hook system to firmly hold surface conditioning discs. The pads feature a thin cushioning layer to provide the ideal flexibility for SCD discs

Part No.	Diameter	Arbor
SCP-2	2"	1/4" shank
SCP-3	3"	1/4" shank
SCP-4	4"	5/8" - 11
SCP-45	4-1/2"	5/8" - 11
SCP-5	5"	5/8" - 11
SCP-7	7"	5/8" - 11

Shop Rolls

- Abrasive shop rolls are manufactured of flexible material and are a must for any metal fabrication and machine shop.
- Ideal for light touch-up on finishing small parts.
- Aluminum oxide grain.

Part No. 1-1/2" x 50 yd.	Part No. 2" x 50 yd.	Grit
15-40	2-40	40
15-60	2-60	60
15-80	2-80	80
15-100	2-100	100
15-120	2-120	120
15-180	2-180	180
15-240	2-240	240
15-320	2-320	320

3M™ Fibre Discs

281C

Aluminum Oxide. General purpose disc for weld removal, grinding and bleeding.

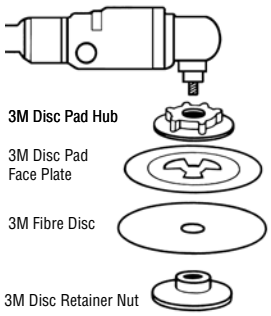
Part No./UPC	Dia. x Ctr Hole	Grade	Min./Case
051144-85959-7	4-1/2" x 7/8"	24	25
051144-85960-3		36	
051144-85961-0		50	
051144-85962-7		60	
051144-85963-4		80	
051144-85964-1		100	
051144-85966-5	5" x 7/8"	24	25
051144-85967-2		36	
051144-85968-9		50	
051144-85969-6		60	
051144-85970-2		80	
051144-85971-9		100	
051144-85972-6		120	
051144-85973-3	7" x 7/8"	24	25
051144-85974-0		36	
051144-85975-7		50	
051144-85976-4		60	
051144-85977-1		80	
051144-85978-8		100	
051144-85979-5		120	

501C

Alumina Zirconia, Premium mineral for fast, cool grinding on all metals.

Part No./UPC	Dia. x Ctr Hole	Grade	Min./Case
051111-50409-3	4-1/2" x 7/8"	24	25/100
051111-50413-0		36	
051111-50414-7		50	
051111-50415-4		60	
051111-50416-1		80	
051111-50417-8		100	
051111-50419-2		120	
051111-50410-9	5" x 7/8"	24	25/100
051111-50412-3		36	
051111-50420-8		50	
051111-50421-5		60	
051111-50422-2		80	
051111-50423-9		100	
051111-50424-6		120	
051111-50411-6	7" x 7/8"	24	25/100
051111-50426-0		36	
051111-50425-3		50	
051111-50427-7		60	
051111-50428-4		80	
051111-50429-1		100	
051111-50430-7		120	

Accessories



Disc Pad Hub

Plastic hubs with 5/8"–11 metal insert. Use with 3M™ disc pad face plates.

Part No./UPC	Diameter	Min./Case
051144-45205-7	2-1/2" (Use with all sizes)	1
051144-45190-6	4-1/2" (Use with 7" only)	

Disc Pad Face Plate

Backup plates for fibre discs. Color coded by density. Ribbed plates result in cooler running discs. Use harder face plates for heavier stock removal applications.

Part No./UPC	Diameter	Hardness	Color	Min./ Case
051144-13325-3	4-1/2" Smooth Max RPM 13,300	Medium	Gray	1
051144-14270-5		Hard	Black	
051144-81734-4	5" Ribbed Max RPM 12,000	Medium	Gray	1
051144-81733-7		Hard	Black	
051144-81732-0		Extra Hard	Red	
051144-80516-7	7" Ribbed Max RPM 8,600	Medium	Gray	1
051144-80515-0		Hard	Black	
051144-80514-3		Extra Hard	Red	

Disc Retainer Nut

Nuts have 5/8"–11 threaded arbor hole in three depths to accommodate grinder shaft lengths.

Part No./UPC	Depth	Min./Case
051144-05620-0	5/8"	1
051144-05621-7	1/2"	
051144-05622-4	3/8"	

Disc Pad Hub & Retainer Nut

Part No./UPC	Dia. x Thread Size	Min./Case
051144-05633-0	4-1/2" x 5/8"–11 (Use with 7" only)	1

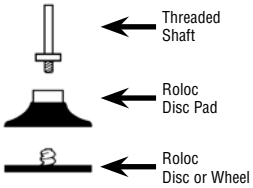
Disc Holder Adaptor 9

These adaptors will convert a grinder with M10–1.25, M10–1.5 or 3/8"–24 external threaded shaft to a 5/8"–11 external threaded shaft.

Part No./UPC	Thread Size	Min./Case
048011-22971-3	M10–1.25 INT	10
048011-22972-0	M10–1.50 INT	
048011-22970-6	3/8"–24 INT	

3M™ Roloc™ Discs

Provide a fast, efficient method for deburring, blending, finishing, removing tool marks and die polishing on all types of metal. Lock securely in place with just a half twist…a half twist and they're off. Each disc is color coded by grade.



Roloc System

361F

General purpose grinding, blending and deburring on all metals. Aluminum Oxide – YF wt. Cloth. Heavy duty cloth backing.

Part No./UPC	Diameter	Grade	Min./Case
051144-11412-2	1" Roloc™ TR Max RPM: 30,000	36	50/500
051144-11411-5		50	
051144-11417-7		60	
051144-11416-0		80	
051144-11415-3		P100	
051144-11414-6		P120	
051144-22396-1	1-1/2" Roloc™ TR Max RPM: 30,000	36	50/500
051144-11137-4		50	
051144-22397-8		60	
051144-22407-4		80	
051144-22408-1		P100	
051144-22409-8		P120	
051144-11000-1	2" Roloc™ TR Max RPM: 25,000	24	50/200
051144-22398-5		36	
051144-22399-2		50	
051144-22400-5		60	
051144-22401-2		80	
051144-22402-9		P100	
051144-22403-6		P120	
051144-14559-1		P150	
051144-13873-9		P180	
051144-11419-1		P240	
051144-22392-3	3" Roloc™ TR Max RPM: 20,000	24	50/200
051144-22393-0		36	
051144-22394-7		50	
051144-22395-4		60	
051144-22404-3		80	
051144-22405-0		P100	
051144-22406-7		P120	
051144-82244-7		P150	
051144-11418-4		P240	

461F

Ideal for grinding glass, titanium and non-ferrous metals. Silicon Carbide – YF wt. Cloth

Part No./UPC	Diameter	Grade	Min./Case
051144-12956-0	2" Roloc™ TR Max RPM: 25,000	P60	50/200
051144-12954-6		P80	
051144-12957-7	3" Roloc™ TR Max RPM: 20,000	P60	50/200
051144-12955-3		P80	

501C

Premium mineral for fast grinding on mild and stainless steel. Aluminum Zirconia - fibre.

Part No./UPC	Diameter	Grade	Min./Case
051111-50747-6	2" Roloc™ TR Max RPM: 25,000	36	50/200
051111-50748-3		50	
051111-50749-0		60	
051111-50750-6		80	
051111-50743-8	3" Roloc™ TR Max RPM: 20,000	36	50/200
051111-50744-5		50	
051111-50745-2		60	
051111-50746-9		80	
Roloc TSM			
051111-50755-1	2" Roloc™ TSM Max RPM: 25,000	36	50/200
051111-50756-8		50	
051111-50757-5		60	
051111-50758-2		80	
051111-50751-3	3" Roloc™ TSM Max RPM: 20,000	36	50/200
051111-50752-0		50	
051111-50753-7		60	
051111-50754-4		80	

Roloc™ Optimum Speeds Chart

Optimum tool speeds (RPM's) to maximize Roloc™ coated abrasive disc cut rates and life RPMs per material type.

Disc Size	Stainless	Aluminum	Steel	Titanium	Glass	Composites
1-1/2"	20,000	20,000	30,000	9,000	9,000	15,000
2"	15,000	15,000	20,000	7,000	7,000	10,000
3"	10,000	10,000	15,000	4,500	4,500	8,000

3M™ PSA Disc 248D

Aluminum Oxide – X wt. Cloth. Heavy duty cloth backed discs for more aggressive applications. Provides excellent adhesion while removing easily.

Part No./UPC	Diameter	Grade	Min./ Case
051144-20913-2	2"	P36	50/200
051144-20912-5		P40	
051144-20911-8		P50	
051144-20910-1		P60	
051144-20909-5		P80	
051144-20908-8		P100	
051144-20907-1		P120	
051144-01337-1	3"	P36	50/200
051144-01335-7		P40	
051144-01334-0		P50	
051144-01333-3		P60	
051144-01332-6		P80	
051144-01331-9		P100	
051144-01330-2		P120	
051144-20891-3	5"	P36	50/250
051144-20890-6		P40	
051144-20889-0		P50	
051144-20888-3		P60	
051144-20887-6		P80	
051144-20886-9		P100	
051144-20885-2		P120	
051144-88906-8	12"	P36	10
051144-88905-1		P40	
051144-88904-4		P50	
051144-88903-7		P60	
051144-88902-0		P80	
051144-88901-3		P100	
051144-88882-5	18"	P36	10
051144-88881-8		P40	
051144-88880-1		P60	
051144-88879-5		P80	
051144-88878-8	20"	P36	10
051144-88877-1		P40	
051144-88876-4		P50	
051144-88875-7		P60	
051144-88874-0		P80	
051144-20802-9	24"	P36	10
051144-20801-2		P40	
051144-20799-2		P60	
051144-20798-5		P80	

Accessories

3M™ PSA Disc Holder

Supports PSA disc and used with any air or electric grinding tool that accommodates a 1/4" shank.

Part No./UPC	Diameter	Min./ Case
051144-45070-1	2" Max RPM: 15,000	1
051144-05510-4	3" Max RPM: 10,000	1/10
051144-45068-8	5" Max RPM: 6,000	1

Roloc™ TR Disc Pads

Rubber back-up pads are available in different diameters and degrees of hardness for varying grinding applications. Pads are internally threaded to receive any standard 1/4"–20 thread shaft.

Part No./UPC	Diameter	Hardness	Min./ Box
051144-45101-2	1" Roloc™ TR Max RPM: 30,000	Medium	5
051144-45099-2	1-1/2" Roloc™ TR Max RPM: 30,000	Medium	5
051144-45100-5		Hard	
051144-45095-4	2" Roloc™ TR Max RPM: 25,000	Medium	5
051144-45096-1		Hard	
051144-45092-3	3" Roloc™ TR Med Max RPM: 18,000 Hard Max RPM: 20,000	Medium	5
051144-45091-6		Hard	

Roloc™ TSM Disc Pads

For use with Roloc TSM grinding discs and "screw on" abrasive discs.

Part No./UPC	Diameter	Hardness	Min./ Box
051144-77729-7	1-1/2" Roloc™ TSM Max RPM: 30,000	Medium	5
051144-77728-0		Hard	
051144-14211-8	2" Roloc™ TSM Max RPM: 25,000	Medium	5
051144-14212-5		Hard	
051144-14215-6	3" Roloc™ TSM Med Max RPM: 18,000 Hard Max RPM: 20,000	Medium	5
051144-14216-3		Hard	

3M™ Sheets & Rolls

341T

Utility rolls and sheets with durable cloth backing for general applications such as deburring, rust removal, strapping and all general maintenance work.

- Grades 60 and coarser.
- Aluminum Oxide – X wt. Cloth.

311T

Flexible utility rolls and sheets for general applications such as deburring, rust removal, strapping and all general maintenance work.

- Grades 80-280.
- Aluminum Oxide – J wt. Cloth.

Sheets

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-02463-6	341T	9" x 11"	40	50/250
051144-02462-9			50	
051144-02461-2			60	
051144-02460-5	311T	9" x 11"	80	50/250
051144-02459-9			100	
051144-02458-2			120	
051144-02457-5			150	
051144-02456-8			180	
051144-02455-1			220	
051144-02454-4			240	
051144-02453-7			280	

Crystal Bay™ Sheet

001K

- Crocus cloth (J wt.).
- For metal finishing.

011K

- Emery cloth (J wt.) – closed coat.
- General purpose use.

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-02435-3	001K	9" x 11"	-	50/250
051144-02433-9	011K	9" x 11"	Course	50/250
051144-02432-2			Medium	
051144-02431-5			Fine	

Utility Rolls

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-05112-0	341T	1" x 50 Yds	50	1/5
051144-05111-3			60	
051144-05110-6	311T	1" x 50 Yds	80	1/5
051144-05109-0			100	
051144-05108-3			120	
051144-05107-6			150	
051144-05106-9			180	
051144-05105-2			220	
051144-05104-5			240	
051144-05103-8			280	
051144-05127-4	341T	1-1/2" x 50 Yds	50	1/5
051144-05126-7			60	
051144-05125-0	311T	1-1/2" x 50 Yds	80	1/5
051144-05124-3			100	
051144-05123-6			120	
051144-05122-9			150	
051144-05121-2			180	
051144-05120-5			220	
051144-05119-9			240	
051144-05118-2			280	
051144-05143-4	341T	2" x 50 Yds	40	1/5
051144-05142-7			50	
051144-05141-0			60	
051144-05140-3	311T	2" x 50 Yds	80	1/5
051144-05139-7			100	
051144-05138-0			120	
051144-05137-3			150	
051144-05136-6			180	
051144-05135-9			220	
051144-05134-2			240	
051144-05133-5			280	

Accessories – Utility Rolls

Forked spindle for attaching utility cloth strips.

Part No./UPC	Dia. x L	Max RPM	Min./ Case
051144-45121-0	1/4" x 3"	24,000	1

3M™ Paper Sheets

Garnet

140N

- Open coat for non-loading; D wt. paper.
- Choice of cabinet makers and woodworkers.

110N

- Open coat for non-loading; A wt. paper.
- Traditional choice for woodworkers for producing fine finishes.

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-10035-4	140N	9" x 11"	50	50/500
051144-10034-7			60	
051144-10033-0			80	
051144-10006-4	110N	9" x 11"	100	100/1000
051144-10005-7			120	
051144-10004-0			150	
051144-10003-3			180	
051144-10002-6			220	

Silicon Carbide

415N/415U

Provides exceptional finishes and excellent conformability for contour sanding.

- A wt. paper – open coat.

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-02352-3	415N	9" x 11"	80	50/500
051144-02351-6			100	100/1000
051144-02350-9			120	
051144-02349-3			150	
051144-02348-6			180	
051144-02347-9			220	
051144-02346-2			240	
051144-02345-5	415U	9" x 11"	280	100/1000
051144-02344-8			320	
051144-02342-4			400	

Aluminum Oxide

346U

- Ideal for hand or machine sanding of many different materials, including woods, metals, paints, plastics and fiberglass.
- D wt. paper

336U

- Medium-weight sheets for general purpose sanding.
- Open coat resists loading on soft materials.
- C wt. paper

210U

- Provides exceptional conformability for contour sanding.
- Open coat resists loading.
- A wt. paper

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-02119-2	346U	9" x 11"	36	50/250
051144-02118-5			40	
051144-02117-8			50	50/500
051144-02116-1			60	
051144-02115-4			80	
051144-02114-7	336U	9" x 11"	100	100/1000
051144-02113-0			120	
051144-02112-3			150	
051144-02104-8	210N	9" x 11"	180	100/1000
051144-02103-1			220	

3M™ Flange Adapter 3

Two arbor hole (plug type) adaptors for 6" and 8" diameter flap wheels. 1" O.D. x various I.D.'s.

Part No./UPC	ID	Min./ Case
051144-45035-0	1/2"	1
051144-45034-3	5/8"	
051144-45033-6	3/4"	
051144-45032-9	7/8"	

3M™ Flange Adapter 5

For use with 6" wheels. Telescoping wheel adaptors 1" and 1/2" wide to reduce 1" wheel cores to fit 5/8". Must be used with side flanges.

Part No./UPC	OD x W x ID	Min./ Case
048011-16859-3	1" x 1/2" x 1/2"	1 Pair
048011-16860-9	1" x 1" x 1/2"	

3M™ Flange 356/365

For use with 8" wheels. Used to reduce wheel cores and internal diameters to fit smaller shaft sizes. Manufactured of spun aluminum, has a taper locking feature to automatically center the flange inside the core of the wheel. Use with wheels that are 1" or 2" wide.

Part No./UPC	Dia. x W	Min./ Case
No. 356: Use with wheels that are 1" or 2" wide		
048011-03896-4	3" x 1/2"	1
048011-03897-1	3" x 5/8"	
048011-03900-8	3" x 1-1/4"	
No. 365: Use with wheels that are 1/2" wide		
048011-18410-4	3" x 1/2"	1
048011-18411-1	3" x 5/8"	
048011-18415-9	3" x 1-1/4"	

Wetordry™ Sheets

431Q

- Construction reduces clogging, eliminates dust, extends abrasive life and improves finish.
- Heavyweight paper backing for increased durability.
- C wt. paper

413Q

- Excellent conformability.
- A wt. paper

Part No./UPC	Model	W x L	Grade	Min./ Case
051144-02018-8	431Q	9" x 11"	80	50/250
051144-02017-1			100	
051144-02016-4			120	
051144-02015-7			150	
051144-02014-0			180	
051144-02007-2	413Q	9" x 11"	220	50/250
051144-02004-1			320	
051144-02003-4			360	
051144-02002-7			400	

Sponges

3M™ Sanding Sponges

3M sanding sponges are ideal for corners, contours, sealer and flat surfaces on wood, metal, plastic and paint.

Part No./UPC	W x L x Thk	Grade	Min./Case
051115-00408-7	3-3/4" x 2-5/8" x 1" Full Size	Medium	1/48
051115-00409-4		Fine	
051131-02606-3	5-1/2" x 4-1/2" x 3/16" Soft Back	Medium	20/120
051131-02604-9		Fine	
051131-02602-5		Superfine	

3M™ Flap Wheel

244E/241E

Aluminum Oxide – XE wt. Cloth. General purpose flap wheel delivers consistent finish and uniform cut. Can be shaped to fit any desired contour.

Model 241E

Part No./UPC	Model	Dia. x W x AH	Grade	Min./ Case
051144-35114-5	241E/244E	6" x 1" x 1" Max RPM: 6,100	50	5
051144-35113-8			60	
051144-35112-1			80	
051144-35111-4			100	
051144-35109-1			120	
051144-35108-4			150	
051144-35105-3			220	
051144-35088-9	241E/244E	6" x 2" x 1" Max RPM: 5,200	60	5
051144-35086-5			80	
051144-35084-1			120	
051144-35083-4			150	
051144-35049-0	244E	8" x 2" x 1" Max RPM: 3,900	60	3
051144-35048-3			80	

General Information

- Material removal.
- Weld grinding and blending.
- Light deburring and finishing.

Right Angle Grinder

GreenLyte SG F968 and GreenLyte Plus SG F986

- Greatest productivity.
- Premium, dense, self-sharpening SG ceramic abrasive grain with a unique coating design - Faster initial cut rate, longer life and improved finishes versus competitive ceramic - Greatest productivity vs. any fibre disc and lowest total costs - Greater chip clearance; minimal loading.
- F986 has a self-lubricating, supersizing treatment - Superb on stainless steel and steel alloys - Provides better finishes and longer life.
- F968 versatility - The choice for grinding and finishing carbon steel, mild steel, cast iron and welds.
- 7" and 9-1/8" discs have doming - Design ideal for edges and corners - Better shape control; resists curling.

Best

Norzon Plus F826

- Ideal on stainless, alloy, and high pressure applications.
- Premium self-sharpening zirconia aluminum abrasive.
- Fast, aggressive cutting - Self-sharpens with use.
- Advanced resin bond technology with enhanced grain adhesion - More parts per hour to lower grinding costs.

Better

Merit Ceramic

- The economical choice for heavy stock removal.
- High performance ceramic alumina abrasive on a heavy fibre backing - Engineered for heavy stock removal.
- Economically priced - The choice when price is a main consideration.

Better

Merit Zirconia

- The economical choice for stainless steel applications.
- Durable zirconia alumina abrasive on a heavy fibre backing.
- Great performance on stainless steel at an economical price.

Better

Gemini Metalite F226

- Versatile performance for all MRO applications.
- Tough, versatile aluminum oxide abrasive - Fast initial cut.
- Ideal for general purpose application.

Good

Merit Aluminum Oxide

- Priced right for general purpose applications.
- Quality aluminum oxide grain on a heavy fibre backing.
- Economically priced, good for small job shops and general purpose application.

Good

Fibre Discs

Part No.	Size	Grit	Pkg.	Spec
66261133434	4" x 5/8"	24	25	Gemini Metalite F226
66261133433		36		Gemini Metalite F226
66261133432		50		Gemini Metalite F226
66261133431		60		Gemini Metalite F226
66261133430		80		Gemini Metalite F226
66261133429		100		Gemini Metalite F226
66261133428		120		Gemini Metalite F226
66261141306	4-1/2" x 7/8"	24	25	GreenLyte SG Plus F986
66261141313				GreenLyte SG F968
66261138457				NorZon Plus F826
66623355601				Merit Ceramic
66623353315				Merit Z/A
66261133519				Gemini Metalite F226
66623353309				Merit A/O
66261141305	4-1/2" x 7/8"	36	25	GreenLyte SG Plus F986
66261141312				GreenLyte SG F968
66261138456				NorZon Plus F826
66623355602				Merit Ceramic
66623353316				Merit Z/A
66261133517				Gemini Metalite F226
66623353306				Merit A/O
66261141304	4-1/2" x 7/8"	50	25	GreenLyte SG Plus F986
66261141311				GreenLyte SG F968
66261138454				NorZon Plus F826
66623355603				Merit Ceramic
66623353318				Merit Z/A
66261133515				Gemini Metalite F226
66623353310				Merit A/O
66261141303	4-1/2" x 7/8"	60	25	GreenLyte SG Plus F986
66261141310				GreenLyte SG F968
66261138453				NorZon Plus F826
66623355604				Merit Ceramic
66623353319				Merit Z/A
66261133513				Gemini Metalite F226
66623353311				Merit A/O
66261141302	4-1/2" x 7/8"	80	25	GreenLyte SG Plus F986
66261141309				GreenLyte SG F968
66261138452				NorZon Plus F826
66623353320				Merit Z/A
66261133511				Gemini Metalite F226
66623353312				Merit A/O
66261141308	4-1/2" x 7/8"	100	25	GreenLyte SG F968
66261133509				Gemini Metalite F226
66623353313				Merit A/O

Part No.	Size	Grit	Pkg.	Spec
66261141307	4-1/2" x 7/8"	120	25	GreenLyte SG F968
66261133507				Gemini Metalite F226
66623353314				Merit A/O
66261133617	5" x 7/8"	16	25	Gemini Metalite F226
66261141301	5" x 7/8"	24	25	GreenLyte SG Plus F986
66261141320				GreenLyte SG F968
66261138563				NorZon Plus F826
66623355597				Merit Ceramic
66623357290				Merit Z/D112A
66261133615				Gemini Metalite F226
66623357276				Merit A/O
66261141300	5" x 7/8"	36	25	GreenLyte SG Plus F986
66261141319				GreenLyte SG F968
66261138562				NorZon Plus F826
66623355598				Merit Ceramic
66623357291				Merit Z/A
66261133610				Gemini Metalite F226
66623357277				Merit A/O
66261141299	5" x 7/8"	50	25	GreenLyte SG Plus F986
66261141318				GreenLyte SG F968
66261138561				NorZon Plus F826
66623355599				Merit Ceramic
66623357292				Merit Z/A
66261133605				Gemini Metalite F226
66623357278				Merit A/O
66261141298	5" x 7/8"	60	25	GreenLyte SG Plus F986
66261141317				GreenLyte SG F968
66261138601				NorZon Plus F826
66623355600				Merit Ceramic
66623357293				Merit Z/A
66261133600				Gemini Metalite F226
66623357279				Merit A/O
66261141297	5" x 7/8"	80	25	GreenLyte SG Plus F986
66261141316				GreenLyte SG F968
66261138600				NorZon Plus F826
66623357294				Merit Z/A
66261133595				Gemini Metalite F226
66623357280				Merit A/O
66261141315	5" x 7/8"	100	25	GreenLyte SG F968
66261133590				Gemini Metalite F226
66623357281				Merit A/O
66261141314	5" x 7/8"	120	25	GreenLyte SG F968
66261133585				Gemini Metalite F226
66623357282				Merit A/O

AVOS Edger Speed-Lok Back-up Pads & Discs

- Discs feature Norton quick, tool-free, twist-on and off Speed-Lok fasteners. They lock to back-up pads but are easily removed, increasing your grinding time and productivity.
- Molded rubber back-up pads provide quick-change convenience. All pads have a 5/8"-11 threaded female hub. These pads can be adapted for use on conventional 7/8" center hole fiber discs by using a 66NS retainer nut to mount the disc to the Speed-Lok pad.

Part No.	Size	Grit	Pkg.	Spec
66261129718	4-1/2"	24	10/40	Norzon Plus F826 Discs
66261129719		36		
66261129720		50		
66261129721		60		
66261129722		80		
63642502985	4-1/2" x 5/8"-11	N/A	5	AVOS Edger Back-Up Pads

Part No.	Size	Grit	Pkg.	Spec
66261133760	7" x 7/8"	16	25	Gemini Metalite F226
66261141296*	7" x 7/8"	24	25	GreenLyte SG Plus F986
66261141327*				GreenLyte SG F968
66261138594				NorZon Plus F826
66623355578				Merit Ceramic
66623357295				Merit Z/A
66261133755				Gemini Metalite F226
66623357283				Merit A/O
66261141295*	7" x 7/8"	36	25	GreenLyte SG Plus F986
66261141326*				GreenLyte SG F968
66261138593				NorZon Plus F826
66623355594				Merit Ceramic
66623357296				Merit Z/A
66261133750				Gemini Metalite F226
66623357284				Merit A/O
66261141294*	7" x 7/8"	50	25	GreenLyte SG Plus F986
66261141325*				GreenLyte SG F968
66261138592				NorZon Plus F826
66623355595				Merit Ceramic
66623357297				Merit Z/D169A
66261133745				Gemini Metalite F226
66623357285				Merit A/O
66261141293*	7" x 7/8"	60	25	GreenLyte SG Plus F986
66261141324*				GreenLyte SG F968
66261138591				NorZon Plus F826
66623355596				Merit Ceramic
66623357298				Merit Z/A
66261133740				Gemini Metalite F226
66623357286				Merit A/O
66261141292*	7" x 7/8"	80	25	GreenLyte SG Plus F986
66261141323*				GreenLyte SG F968
66261138590				NorZon Plus F826
66623357299				Merit Z/A
66261133735				Gemini Metalite F226
66623357287				Merit A/O
66261141322*	7" x 7/8"	100	25	GreenLyte SG F968
66261133730				Gemini Metalite F226
66623357288				Merit A/O
66261141321*	7" x 7/8"	120	25	GreenLyte SG F968
66261133725				Gemini Metalite F226
66623357289				Merit A/O
66261133890	9-1/8" x 7/8"	16	25	Gemini Metalite F226

*All 7" x 7/8" and 9-1/8" x 7/8" GreenLyte F968 and GreenLyte Plus F986 discs feature our domed design.
**Not all sizes and grits listed. Please call customer service for additional options.

Part No.	Size	Grit	Pkg.	Spec
66261141290*	9-1/8" x 7/8"	24	25	GreenLyte SG Plus F986
66261141344*				GreenLyte SG F968
66261138584				NorZon Plus F826
66261133885				Gemini Metalite F226
66261141289*	9-1/8" x 7/8"	36	25	GreenLyte SG Plus F986
66261141343*				GreenLyte SG F968
66261138583				NorZon Plus F826
66261133880				Gemini Metalite F226
66261141288*	9-1/8" x 7/8"	50	25	GreenLyte SG Plus F986
66261141342*				GreenLyte SG F968
66261138582				NorZon Plus F826
66261133875				Gemini Metalite F226
66261141287*	9-1/8" x 7/8"	60	25	GreenLyte SG Plus F986
66261141341*				GreenLyte SG F968
66261133870				Gemini Metalite F226
66261141286*	9-1/8" x 7/8"	80	25	GreenLyte SG Plus F986
66261141340*				GreenLyte SG F968
66261133865				Gemini Metalite F226
66261141339*	9-1/8" x 7/8"	100	25	GreenLyte SG F968
66261133860				Gemini Metalite F226
66261133855	9-1/8" x 7/8"	120	25	Gemini Metalite F226

*All 7" x 7/8" and 9-1/8" x 7/8" GreenLyte F968 and GreenLyte Plus F986 discs feature our domed design.
**Not all sizes and grits listed. Please call customer service for additional options.

Air-Cooled Rubber Back-Up Pads

- Designed for medium to heavy grinding applications.
- Slotted aluminum hub design draws cool air behind the disc.
- Curved ribs on the rubber face force heat away from the disc and back-up pad.
- Cooler cutting action reduces disc loading and increases grinding life.
- All pads have a 5/8"-11 threaded female hub for mounting.
- Firm pads provide more aggressive cut; medium pads offer greater flexibility.
- Use with Norton and Merit fibre discs to maximize cut and life.

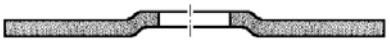
Part No.	Description	Max. RPM	Std. Pkg.
63642504918	4" Medium	12,000	5
63642502122	4-1/2" Medium	11,000	5
63642543421	5" Medium	10,000	5
63642543425	7" Firm	8,600	5
63642543422	7" Medium	8,600	5
63642543426	9" Firm	6,600	5
63642543423	9" Medium	6,600	5
63642543463	#103 Retainer Nut	-	10
63642543005	#834 Retainer nut spanner wrench	-	5
63642543461	66NS Short Retainer Nut	-	10

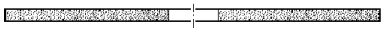
Backing Pads

Part No.	Diameter	Backing Nut	Use on	RPM
623279000	4-1/2"	M14	4-1/2" grinders & other grinders w/ M14 spindle	13,000
623281000	7"	5/8"-11	6" and 7" or 9" sander/grinders w/ 5/8"-11 spindle	8,500
623282000	9"	5/8"-11	9" sander/grinders w/ 5/8"-11 spindle	6,600
623283000	4-1/2"	5/8"-11	4-1/2" grinders & other grinders w/ 5/8"-11 spindle	13,000
623284000	5"	5/8"-11	5" grinders & other grinders w/ 5/8"-11 spindle	12,000

Coated Abrasive Shop Rolls

Cutting





Type 27 Products:

Type 27 Wheels are offered in .045", .060" and 3/32" wheel thicknesses. Diameters range from 4" to 9" and are available in aluminum oxide or zirconium grain, with a choice of a 5/8"-11 hub.

Type 1 Products:

This product category includes wheels ranging from 1-½ " to 14" diameters, in various grit sizes, and aluminum oxide and silicon carbide abrasive grains. Type 1 Wheels are for use on electric or air die grinders, tool room grinders, circular saws, stationary machines, portable gas or electric saws and chop saws.

Wheel Selection Guide	
Grain	
A	Aluminum Oxide: for general purpose use on all metals except titanium
C	Silicon Carbide: for cutting non-metallics and titanium (Type 1 only)
CA	Combination Silicon Carbide/Aluminum Oxide: for cutting ductile iron and non-ferrous metals (Type 1 only)
TA	Treated Aluminum Oxide: for extended wheel life and improved performance of large diameter wheels in coarser grits (Type 1 only)
Z	Zirconium: for higher cut rates in high pressure applications (Type 27 only)
Grit	
16	Extra Coarse: for extremely aggressive grinding
24	Coarse: for fast, aggressive cutting and maximum wheel life
30	Medium/Coarse: for fast cutting and long wheel life
36	Medium/Coarse: excellent for general purpose cutting
46	Fine/Medium: for a smoother finish and reduced burr
60	Fine: for a burr-free cut
Grade	
T-V	Hard: for maximum wheel life
R	Medium/Hard: for cutting large cross sections and improved rate of stock removal
P	Medium: for cutting very large cross sections and applications demanding very rapid stock removal
N	Soft/Medium: for maximum cut rate

Safety

Abrasive users and others in area must wear goggles or face shields over safety glasses.
Safety guards must be used. Do not exceed maximum RPM.

Solving User Problems

When users complain of problems with resin bonded abrasives, they usually can be attributed to one of the following causes:

- The wrong application for the wheel being used.
- The operator is not using the product correctly.
- The wheel is being used on a tool other than for which it was designed.
- The wheel is being used on the proper tool, but one that is worn or defective.

Resin Fiber Discs

Grinding welds on a fabricated steel part.

Applications

Zirconium:

- High performance grinding of stainless steel, tool steel and hard-to-grind materials

Aluminum Oxide:

- All purpose weld blending, grinding, surface preparation and finishing of metals, plastic, wood and fiberglass.

Resin Fiber Discs

Dia.	Arbor Hole	Grit Size	Part No.	
			Zirconium	Aluminum Oxide
4"	5/8"	24	–	59491
		36	–	59492
		50	–	59493
		60	–	59494
		80	–	59495
		120	–	59497
4-½"	7/8"	24	59731	59571
		36	59732	59573
		50	59733	59575
		60	–	59576
		80	59735	59577
		100	–	59578
		120	–	59579
5"	7/8"	16	–	59500
		24	59701	59501
		36	59702	59503
		50	59703	59505
		60	–	59506
		80	59705	59507
		100	–	59508
		120	–	59509
7"	7/8"	16	59710	59520
		24	59711	59521
		36	59712	59523
		50	59713	59525
		60	59714	59526
		80	59715	59527
		100	–	59528
		120	–	59529
9"	7/8"	16	–	59540
		24	–	59541
		36	59722	59543
		50	–	59545
		60	–	59546

Do not exceed maximum RPM of back-up pad.

Grain Selection Guide

Zirconium:

- Superior cutting action
- 2-3 times the life of conventional grains
- Ultra-high resistance to heat, glazing and loading

Aluminum Oxide:

- Fast, smooth cutting action
- High resistance to heat, glazing and loading

Resin Fiber Disc Accessories

Description	Thread Size	Max. RPM	Part No.
4" Back-up Pad	5/8"-11*	14,900	59605
4-½" Back-up Pad	5/8"-11*	13,200	59611
5" Back-up Pad	5/8"-11*	11,900	59600
7" Back-up Pad	5/8"-11	8,550	59601
9" Back-up Pad	5/8"-11	6,500	59602
Spanner Wrench	–	–	59603
Disc Nut	5/8"-11	–	59604

*Other thread sizes available on special orders. Please specify model number and machine make on which accessories are to be used.

AL-tra CUT™ Discs - For Grinding Aluminum

AL-tra CUT™ Discs

AL-tra CUT™ Discs are specially formulated for superior grinding performance - on aluminum. AL-tra CUT™s improve grinding on aluminum 400-800%! These revolutionary discs resist loading, ensure higher cut rates, prolong disc life and achieve a superior finish compared to conventional sanding/grinding discs in the market. AL-tra CUT™ Discs replace conventional resin fiber discs 5 to 1 or more.

Blending aluminum welds on a machine bracket.

Applications

For aluminum applications such as:

- Weld blending
- Grinding
- Deburring
- Finishing

2" & 3" AL-tra CUT™ Discs

Aluminum Oxide

Dia.	Grit Size	Part No. Plastic Button*	Part No. Metal Hub+
2"	36	59806	59869
	60	59807	59870
	80	59808	59871
	120	59809	59872
3"	36	59811	59874
	60	59812	59875
	80	59813	59876
	120	59814	59877

*Compatible with 3M Roloc™ back-up pads. (Roloc™ is a trademark of 3M.)
+Compatible with Norton Speed-Lok® TS back-up pads. (Speed-Lok® TS is a registered trademark of Norton Co.)

Do not exceed maximum RPM of back-up pad.
Do not store AL-tra CUT™ Discs above 120˚ F.

4½" & 7" AL-tra CUT™ Discs

Aluminum Oxide

Dia.	Arbor Hole	Grit Size	Part No.
4-½"	7/8"	36	59821
		60	59823
		80	59824
		120	59826
7"	7/8"	36	59862
		60	59864
		80	59865
		120	59867

Do not exceed maximum RPM of back-up pad.
Do not store AL-tra CUT™ Discs above 120˚ F.

Back-up Pads

for 2" & 3" Discs

Size	Max. RPM	Part No. Plastic Button	Part No. Metal Hub
2" x ¼" stem	25,000	51551	60508
3" x ¼" stem	20,000	51552	60509

Disc Accessories

for 4-½" & 7" Discs

Description	Thread Size	Max. RPM	Part No.
4-½" Back-up Pad	5/8"-11*	13,200	59611
7" Back-up Pad	5/8"-11	8,550	59601
Spanner Wrench	–	–	59603
Disc Nut	5/8"-11	–	59604

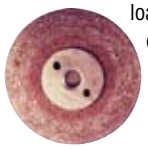
*Other thread sizes available on special orders. Please specify model number and machine make on which accessories are to be used.

NOTE

2" & 3" AL-tra CUT™ Discs vs. Blending Discs

AL-tra CUT™ Discs are made with a fiber backing, as opposed to cloth backed blending discs. This tougher fiber backing extends life, even in the most demanding applications. Combining this increased toughness with the special "load-resistant" formulation provides a long-life disc with superior, unparalleled grinding performance compared to conventional blending discs.

AL-tra CUT™ Performance



Weiler's exclusive AL-tra CUT™ Discs resist loading when grinding aluminum, ensuring constant grain contact

Conventional resin fiber discs load when grinding aluminum. This prevents the abrasive grain from contacting the work surface and dramatically decreases performance.

Coated Abrasive Flap Wheels

Weiler's Flap Wheels are designed with a solid hub construction which:

- Enables flap wheels to be rated at higher RPM's, providing more aggressive cutting action and increased productivity.
- Provides perfect balance leading to smooth, chatter-free finishing.

Applications

- Final finish on metal surfaces
- Deburring and mismatch removal on machined parts
- Edge blending
- Blending and finishing dies, molds, tools, tubing, channels
- Cleaning
- Smoothing metal plastic and wood
- Finish prior to painting or plating

Deburring perforated steel channel after saw-cut.

NOTE

Stems must be fully inserted into chuck or collet and tightened securely.

Vortec™ Mounted Flap Wheels

1/4" Stem - Aluminum Oxide
A price line designed to provide fast cutting action. Ideal for low to medium production environments.

Dia.	Width	Grit Size	Max. RPM	Part No.
1"	1"	60 80 120	30,000	30720 30721 30722
2"	1"	60 80 120	25,000	30723 30724 30725
3"	1"	60 80 120	23,000	30726 30727 30728

Metal Adapters

for Unmounted Flap Wheels
Used in pairs and priced per pair.

Wheel Arbor Hole Size	Adapted Arbor Hole Size	Part No.
1"	½"	03833
1"	5/8"	03834
1"	¾"	03835

Drive Arbor - for ¼"-20 Mounted Flap Wheels

Thread Size	Adapted Size	Part No.
¼"-20 UNC	¼"	07756

Tiger® Mounted Flap Wheels

¼" Stem - Aluminum Oxide - A premium line designed to provide long life. Ideal for medium to high production environments.

Dia.	Width	Grit Size	Max. RPM	Part No.
1"	1"	60 80 120	30,000	52003 52004 52005
1-½"	½"	60 80 120	25,000	52226 52227 52229
1-½"	1"	60 80 120	25,000	52009 52010 52011
2"	½"	60 80 120	25,000	52366 52367 52369
2"	1"	60 80 120	25,000	52015 52016 52017
2-½"	1"	60 80 120	23,000	52486 52487 52489
3"	½"	60 80 120	23,000	52024 52025 52026
3"	1"	60 80 120	23,000	52027 52028 52029

Tiger® Unmounted Flap Wheels

Aluminum Oxide - For use on bench and straight grinders.

Dia.	Width	Arbor Hole	Grit Size	Max. RPM	Part No.
4"	1"	5/8"	60 80 120	9,000	53166 53167 53169
6"	1"	1"	50 60 80 120	6,000	53285 53286 53287 53289
6"	1-½"	1"	50 60 80 120	6,000	53305 53306 53307 53309
6"	2"	1"	50 60 80 120	6,000	53325 53326 53327 53329

Tiger® Mounted Flap Wheels

¼"-20 Threaded Stem - Aluminum Oxide

Dia.	Width	Grit Size	Max. RPM	Part No.
1"	1"	60 80 120	30,000	52601 52603 52605
2"	1"	60 80 120	25,000	52611 52613 52615
3"	1"	60 80 120	20,000	52621 52623 52625

Blending Discs

Removing mill scale on a hot rolled steel part.

Applications

- Blending or finishing metal surfaces
- Light weld removal
- Removing handling marks, surface imperfections and mill marks

Grain Selection Guide

Aluminum Oxide: For general purpose applications on ferrous metals.
Aluminum Oxide Plus: For difficult to grind metals such as aircraft grade high nickel, chrome alloys and heat sensitive metals. Provides lower heat generation than regular aluminum oxide on ferrous metals.
Zirconium: For rapid stock removal and where medium to heavy pressure is applied. The grinding aid allows cool-cutting for extended stock removal on stainless steel.

Blending Discs - Metal Hub Style

Compatible with Norton Speed-Lok® TS back-up pads

Dia.	Grit Size	Part No. Zirconium	Part No. Aluminum Oxide
1-½"	36		60027
	60	60368	60030
	80	60369	60031
	120	60371	60033
2"	36	60378	60040
	60	60381	60043
	80	60382	60044
	120	60384	60046
3"	36	60391	60053
	60	60394	60056
	80	60395	60057
	120	60397	60059

Do not exceed the maximum RPM of the back-up pad.
(Speed-Lok® TS is a registered trademark of Norton Co.)

Metal Hub Style Back-up Pads

¼" Stem

Dia.	Max. RPM	Part No.
1-½"	30,000	60507
2"	25,000	60508
3"	20,000	60509

Blending Discs - Plastic Button Style

Compatible with 3M Roloc™ back-up pads

Dia.	Grit Size	Part No. Aluminum Oxide
2"	36	60118
	60	60121
	80	60122
	120	60124
3"	36	60131
	60	60134
	80	60135
	120	60137

Do not exceed the maximum RPM of the back-up pad. (Roloc™ is a trademark of 3M.)

Plastic Button Style Back-up Pads

¼" Stem

Dia.	Max. RPM	Part No.
2"	25,000	51551
3"	20,000	51552

Trim-Kut® Discs

Weiler's Trim-Kut® Discs are abrasive discs designed for light grinding and blending applications on a variety of materials. The abrasive grains are fused directly on to a wearable polymer backing, resulting in a disc that requires no back-up pad. The polymer backing trims during use to expose new grains to the work surface. 3" discs are designed for use on drills or right angle air die grinders, and 4-½" discs are for use on right angle grinders.

Chamfering the edge of a steel pipe.

Applications

- Edge blending
- Deburring
- Preparation for painting and surface finishing
- Light weld and stock removal

Trim-Kut® Discs - Aluminum Oxide

Dia.	Arbor Hole	Grit Size	Max. RPM	Part No.
3"	5/16"- 18	36 60 120	21,000	59300 59305 59315

Trim-Kut® Discs - Aluminum Oxide

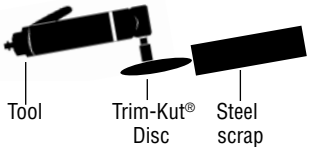
Dia.	Arbor Hole	Grit Size	Max. RPM	Part No.
4-½"	7/8"	36 60 120	13,000	59403 59404 59405

Do not use Trim-Kut® discs in temperatures lower than 48˚ fahrenheit. Store at 50% relative humidity.

Trim-Kut® Adapters

Description	For Use With	Part No.
¼" Mandrel	3" Trim-Kut® Discs	59327
3/8"-24 UNF Adapter	3" Trim-Kut® Discs	59326
Adapting Nuts	4-½" Trim-Kut® Discs	56485
Spanner Wrench	Part No. 56485 only	56496

TIP



Extend disc life 2-3 times. Renew Trim-Kut®'s sharp cutting edge by running the edge against a clamped piece of steel scrap.

If you are using a blending disc or Trim-Kut® Disc, ask our Application Engineering Department if Weiler's BobCat™ Abrasive Flap Discs can enhance your productivity. BobCats™ dramatically outperform blending and Trim-Kut® Discs by reducing changeovers and providing consistently high cut rates and extended life.

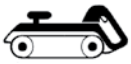
Coated Abrasive Belts

Blending a weld using a portable file belt.

Applications

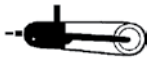
- Decorative finishing of metal surfaces
- Grinding, deburring and flash removal on saw-cut parts
- Edge blending
- Cleaning
- Smoothing metal, plastic and wood
- Removing tool mark and forging scale
- Finishing prior to painting or plating
- Grinding gates off castings

Portable Belts



Size (Width x Length)	Grit Size	Part No. Zirconium	Part No. Aluminum Oxide
3" x 18"	60	–	67488
	80	–	67489
	120	–	67491
3" x 21"	40	69005	67504
	50	69006	67505
	60	69007	67506
	80	69008	67507
	100	–	67508
	120	–	67509
3" x 24"	36	69040	67539
	40	69041	67540
	50	69042	67541
	60	69043	67542
	80	69044	67543
	100	–	67544
	120	–	67545
3-½"x15-½"	60	–	67614
	80	–	67615
	120	–	67617
4" x 21-¾"	60	–	67632
	80	–	67633
	100	–	67634
	120	–	67635
4" x 24"	36	69148	67647
	40	69149	67648
	50	69150	67649
	60	69151	67650
	80	69152	67651
	100	–	67652
	120	–	67653

Portable File Belts

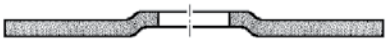


Size (Width x Length)	Grit Size	Part No. Zirconium	Part No. Aluminum Oxide
¼" x 18"	80	68524	67023
¼" x 24"	60	68541	67040
	80	68542	67041
	120	–	67043
¾" x 18"	40	68575	67074
	60	68577	67076
	80	68578	67077
	120	–	67079
½" x 24"	36	68592	67091
	40	68593	67092
	50	68594	67093
	60	68595	67094
	80	68596	67095
	100	–	67096
	120	–	67097
¾" x 20-½"	40	68629	67128
	50	68630	67129
	60	68631	67130
	80	68632	67131
	100	–	67132
	120	–	67133
1" x 12"	60	68649	67148
	80	68650	67149
	120	–	67151
1" x 30"	60	68667	67166
	80	68668	67167
	120	–	67169

Bonded Abrasive Technical Information

Bonded abrasive products are used for applications requiring heavy material removal such as rough grinding, weld removal, snagging, cutting and parting.

Grinding



Type 27 Products:
These products range from 4" to 9" diameters and are available in ¼" thick for grinding and 1/8" thick for light grinding or cutting. Type 27 Wheels are offered in aluminum oxide or zirconium grain with a choice of a 5/8"-11" hub. Type 27 Flexible Grinding and Blending Wheels are available in 4-½", 5" and 7" diameters in aluminum oxide grain.

Coated Abrasive Shop Rolls

Weiler's Shop Rolls are resin over resin bond - providing a stronger, heat and moisture resistant bond that better utilizes the abrasive grains. The egyptian cotton cloth provides a tougher, durable backing for longer life. J-flex cloth provides a higher degree of flexibility to conform to contoured parts.

Polishing the O.D. of a part turned in a lathe.

Applications

- Off-hand polishing of metal surfaces
- Cleaning stock which is being turned in a lathe
- General purpose machine shop use
- Off-hand deburring

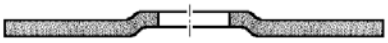
TIP

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

Shop Rolls - Aluminum Oxide - 50 yards

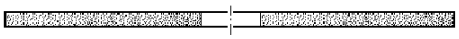
Roll Width	Grit	Part No.
1"	50	65204
	60	65205
	80	65206
	100	65207
	120	65208
	150	65209
	180	65210
	240	65212
	320	65213
1-½"	50	65217
	60	65218
	80	65219
	100	65220
	120	65221
	150	65222
	180	65223
	240	65225
	320	65226
2"	50	65230
	60	65231
	80	65232
	100	65233
	120	65234
	150	65235
	180	65236
	240	65238
	320	65239

Cutting



Type 27 Products:

Type 27 Wheels are offered in .045", .060" and 3/32" wheel thicknesses. Diameters range from 4" to 9" and are available in aluminum oxide or zirconium grain, with a choice of a 5/8"-11 hub.



Type 1 Products:

This product category includes wheels ranging from 1-½ " to 14" diameters, in various grit sizes, and aluminum oxide and silicon carbide abrasive grains. Type 1 Wheels are for use on electric or air die grinders, tool room grinders, circular saws, stationary machines, portable gas or electric saws and chop saws.

Wheel Selection Guide			
Grain		**Grit**	
A	Aluminum Oxide: for general purpose use on all metals except titanium	24	Coarse: for fast, aggressive cutting and maximum wheel life
C	Silicon Carbide: for cutting non-metallics and titanium (Type 1 only)	30	Medium/Coarse: for fast cutting and long wheel life
CA	Combination Silicon Carbide/Aluminum Oxide: for cutting ductile iron and non-ferrous metals (Type 1 only)	36	Medium/Coarse: excellent for general purpose cutting
TA	Treated Aluminum Oxide: for extended wheel life and improved performance of large diameter wheels in coarser grits (Type 1 only)	46	Fine/Medium: for a smoother finish and reduced burr
Z	Zirconium: for higher cut rates in high pressure applications (Type 27 only)	60	Fine: for a burr-free cut
		Grade	
		T-V	Hard: for maximum wheel life
		R	Medium/Hard: for cutting large cross sections and improved rate of stock removal
		P	Medium: for cutting very large cross sections and applications demanding very rapid stock removal
		N	Soft/Medium: for maximum cut rate

Safety

Abrasive users and others in area must wear goggles or face shields over safety glasses. Safety guards must be used. Do not exceed maximum RPM.

Non-Woven

Scotch-Brite™ Roloc™ Discs

Premium Scotch-Brite™ surface conditioning non-woven web provides a burr-free decorative finish. Removes grind marks, rust and coatings.

Part No./UPC	Diameter	Grade	Color	Min./Case
048011-08764-1	1-1/2" Roloc™ TR Max RPM: 30,000	ACRS	Brown	50/200
048011-08765-8		AMED	Maroon	
048011-08766-5		AVFN	Blue	
048011-05528-2	2" Roloc™ TR Max RPM: 25,000	ACRS	Brown	50/200
048011-05527-5		AMED	Maroon	
048011-05523-7		AVFN	Blue	
048011-05532-9	3" Roloc™ TR' Max RPM: 18,000	ACRS	Brown	25/100
048011-05531-2		AMED	Maroon	
048011-05530-5		AVFN	Blue	
Roloc TSM				
048011-25775-4	1-1/2" Roloc™ TSM Max RPM: 30,000	ACRS	Brown	50/200
048011-25774-7		AMED	Maroon	
048011-25773-0		AVFN	Blue	
048011-25765-5	2" Roloc™ TSM Max RPM: 25,000	ACRS	Brown	50/200
048011-25764-8		AMED	Maroon	
048011-25770-9		AVFN	Blue	
048011-25767-9	3" Roloc™ TSM Max RPM: 18,000	ACRS	Brown	25/100
048011-25766-2		AMED	Maroon	
048011-25780-8		AVFN	Blue	

Scotch-Brite™ Star

Perfect choice for polishing I.D. of pipe and tubing. Conformable Scotch-Brite™ construction assures complete cleaning and polishing of all surfaces. Variety of sizes to fit any application.

Part No./UPC	Diameter	Grade	Min./Case
048011-13800-8	1-1/2" Max RPM: 24,000	A VFN	5
048011-13370-6		A CRS	
048011-13803-9	2" Max RPM: 24,000	A VFN	5
048011-13371-3		A CRS	
048011-13802-2	3" Max RPM: 18,000	A VFN	5
048011-13372-0		A CRS	
048011-13804-6	4" Max RPM: 18,000	A VFN	5
048011-13373-7		A CRS	

Scotch-Brite™ Bristle Discs

Brush-like bristle disc removes coarse coatings from the large, open areas or a work piece. Works on right angle tools quickly and easily with little or no pressure.

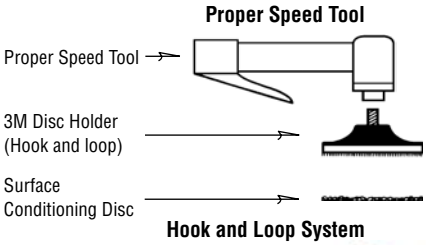
Part No./UPC	Diameter	Grade	Color	Min./Case
048011-18730-3	2" Roloc™ TR Max RPM: 25,000	50	Green	10/40
048011-18732-7		80	Yellow	
048011-18733-4		120	White	
048011-18734-1	3" Roloc™ TR Max RPM: 15,000	50	Green	10/40
048011-18736-5		80	Yellow	
048011-18737-2		120	White	

Scotch-Brite™ Radial Bristle Brushes

Durable radial brush replaces wire brush, doesn't throw wires, cleans better. Many MRO and production applications. Includes universal bench-motor adaptors. Works on heavy coatings leaving coarse scratch. Abrasive Material: aluminum oxide and Cibitron™ grains. Max. RPM: 6,000.

Part No./UPC	Dia. x Width	Grade	Color	Min./Case
048011-27603-8	6" x 1/2"	36	Dark Brown	5
048011-27605-2		50	Green	
048011-27606-9		80	Yellow	

Accessories



Hook and Loop System

Model: 905 | 917, 915, 9145 | 922, 923

3M™ Disc Pad Holders

For use with Scotch-Brite™ Surface Conditioning and Coating Removal discs.

Part No./UPC	Model	Diameter x Thread	Min./ Case
048011-07494-8	922	2" (Max RPM: 23,000)	10
048011-04132-2	923	3" (Max RPM: 20,000)	
048011-14111-4	9145	4-1/2" x 5/8"–11 INT (Max RPM: 13,000)	1
048011-05680-7	915	5" x 5/8"–11 INT (Max RPM: 10,000)	
048011-09448-9	905	5" x 5/16"–24 EXT (Max RPM: 10,000)	
048011-09450-2	917	7" x 5/8"–11 INT (Max RPM: 6,000)	

Accessories

3M™ Roloc™ + Holder 1

Plastic holder for use with Roloc™ Unitized Wheels.

Part No./UPC	L x Shaft Dia.	Min./ Case
048011-15408-4	1" x 1/4" Max RPM 25,000	5

3M™ Mandrels

Designed for use with Scotch-Brite™ Unitized Wheels.

Model: 936, 946 | 990

Part No./UPC	Model	L x Shaft Dia. x Washer Dia.	Min./Case
048011-04018-9	936	2-1/16" x 1/4" x 3/4" Plastic Max RPM 22,200	5
048011-05726-2	946	1-3/4" x 1/4" x 1/2" Steel Max RPM 35,200	5
048011-15012-3	990	1-3/4" x 1/4" Max RPM 18,200 with 3" wheel	5

Scotch-Brite™ Surface Conditioning Disc

Best for finishing, cleaning and light deburring on flat metal surfaces. Attach and remove easily to 3M™ Hook-and-Loop backup pads.

Part No./UPC	Diameter	Grade	Color	Min./Case
048011-07458-0	2" Max RPM: 23,000	ACRS	Brown	50/200
048011-07459-7		AMED	Maroon	
048011-04276-3		AVFN	Blue	
048011-04120-9	3" Max RPM: 20,000	ACRS	Brown	25/100
048011-04124-7		AMED	Maroon	
048011-04277-0		AVFN	Blue	
048011-27671-7	4-1/2" Max RPM: 13,000	ACRS	Brown	10
048011-14101-5				50
048011-27672-4		AMED	Maroon	10
048011-14100-8				50
048011-27673-1		AVFN	Blue	10
048011-14099-5				50
048011-27674-8	5" Max RPM: 10,000	ACRS	Brown	10
048011-00750-2				50
048011-27675-5		AMED	Maroon	10
048011-00643-7				50
048011-27676-2		AVFN	Blue	10
048011-04303-6				50
048011-27677-9	7" Max RPM: 6,000	ACRS	Brown	10
048011-00751-9				25
048011-27678-6		AMED	Maroon	10
048011-00645-1				25
048011-27679-3		AVFN	Blue	10
048011-04305-0				25

Scotch-Brite™ EXL Deburring Wheels

Use to clean, finish, blend, deburr or polish all types of metals, composites and glass. Convolutely wound on a core. Hard, durable 9 density. Abrasive mineral: Fine grade silicon carbide. Color: Gray.

Part No./UPC	Dia. x W x AH	Grade	Min./ Case
048011-13616-5	6" x 1/2" x 1" Max RPM: 6,000	8AMED	4
048011-09548-6		8SFIN	
048011-05790-3		9SFIN	
048011-13617-2	6" x 1" x 1" Max RPM: 6,000	8AMED	3
048011-09549-3		8SFIN	
048011-05132-1		9SFIN	
048011-17459-4	8" x 1/2" x 3" Max RPM: 4,500	8AMED	4
048011-14629-4		8SFIN	
048011-05791-0		9SFIN	
048011-13619-6	8" x 1" x 3" Max RPM: 4,500	8AMED	3
048011-09551-6		8SFIN	
048011-05135-2		9SFIN	
048011-13620-2	8" x 2" x 3" Max RPM: 4,500	8AMED	2
048011-09552-3		8SFIN	
048011-05136-9		9SFIN	

Scotch-Brite™ Cut & Polish Wheel

Heavy duty wheels for aggressive blending and finishing. Produce uniform results quickly and easily. Replace rubber bonded wheels, set-up wheels, and flap wheels.

Part No./UPC	Dia. x W x AH	Grade	Min./ Case
048011-03263-4	6" x 1" x 1" Max RPM: 6,000	7ACRS	3
048011-03262-7		7AMED	
048011-03270-2		7AFIN	

Scotch-Brite™ EXL Unitized Wheel

Excellent for deburring and polishing a wide range of metals, plastics and composites. Cool running allows more pressure to be applied. Cleaner than buffs and compounds. Eliminate danger of loose-flying wires.

Part No./UPC	Dia. x W x AH	Grade	Max RPM	Min./Case
048011-15527-2	1" x 1" x 3/16"	2AMED	25,100	50
048011-13713-1		2SFIN	30,100	
048011-14063-6		6AMED	35,100	
048011-15859-4		6SFIN		
048011-13753-7		8AMED		
048011-13752-0		8ACRS		
048011-16054-2	3" x 1/4" x 3/8"	2AMED	12,100	40
048011-14750-5		2SFIN		
048011-14751-2		4AFIN	18,100	
048011-15118-2		6AMED		
048011-14752-9		6SFIN		
048011-14753-6		8AMED		
048011-13766-7		8ACRS		

Scotch-Brite™ Roloc™ TR EXL Unitized Wheel

High performance and durability for deburring and finishing applications. Threaded attachment system secures the wheel to the holder. Soft, conformable, flexible 2 density. Abrasive mineral: Fine grade silicon carbide.

Part No./UPC	Diameter	Grade	Min./Case
048011-17190-6	2" Max RPM 22,100	6AMED	60
048011-17185-2		2AMED	
048011-17183-8		2SFIN	
048011-17191-3	3" Max RPM 15,100	6AMED	40
048011-17186-9		2AMED	
048011-17184-5		2SFIN	

Scotch-Brite™ Multi-Finishing Wheels

Produces uniform grain finishes on stainless steel and other metals. Highly conformable. Tough enough to finish edges and welds.

Part No./UPC	Dia. x W x AH	Grade	Min./ Case
048011-13170-2	6" x 1" x 1" Max RPM: 6,000	2SCRS	3
048011-13171-9		2SMED	
048011-13172-6		2SFIN	
048011-13176-4	6" x 2" x 1" Max RPM: 6,000	2SCRS	2
048011-13177-1		2SMED	
048011-13178-8		2SFIN	
048011-13182-5	8" x 1" x 3" Max RPM: 4,500	2SCRS	3
048011-13183-2		2SMED	
048011-13184-9		2SFIN	
048011-13185-6	8" x 2" x 3" Max RPM: 4,500	2SCRS	2
048011-13186-3		2SMED	

Scotch-Brite™ Belts / Accessories

Scotch-Brite™ Surface Conditioning Belt

Designed for cleaning, finishing and light deburring.
Maximum Operating Speed: 6,500 SFPM
(Surface Feet Per Minute).

Part No./UPC	Size (W x L)	Grade	Color	Min./Case
048011-08858-7	1/2" x 18"	ACRS	Brown	20
048011-08857-0		AMED	Maroon	
048011-08856-3		AVFN	Blue	
048011-05741-5	1/2" x 24"	ACRS	Brown	20
048011-03998-5		AMED	Maroon	
048011-04299-2		AVFN	Blue	
048011-13639-4	3/4" x 18"	ACRS	Brown	20
048011-15899-0		AMED	Maroon	
048011-14543-3		AVFN	Blue	
048011-04189-6	1" x 42"	AMED	Maroon	10
048011-04190-2		AVFN	Blue	
048011-08915-7	2" x 48"	AMED	Maroon	10
048011-04295-4		AVFN	Blue	
048011-00580-5	2" x 72"	AMED	Maroon	10
048011-00579-9		AVFN	Blue	
048011-03999-2	2" x 132"	AMED	Maroon	5
048011-04297-8		AVFN	Blue	
048011-05022-5	2-3/4" x 15-1/2"	ACRS	Brown	10
048011-05227-4		AMED	Maroon	
048011-05820-7	3" x 10-11/16"	ACRS	Brown	10
048011-05783-5		AMED	Maroon	
048011-09650-6		AVFN	Blue	
048011-14285-2	3" x 18"	AMED	Maroon	10
048011-14550-1		AVFN	Blue	
048011-08880-8	3" x 24"	ACRS	Brown	10
048011-00583-6		AMED	Maroon	
048011-04298-5		AVFN	Blue	
048011-05023-2	3" x 132"	ACRS	Brown	5
048011-00568-3		AMED	Maroon	
048011-04289-3		AVFN	Blue	
048011-05016-4	3-1/2" x 15-1/2"	ACRS	Brown	10
048011-05228-1		AMED	Maroon	
048011-05643-2		AVFN	Blue	
048011-05019-5	6" x 48"	ACRS	Brown	5
048011-00590-4		AMED	Maroon	
048011-04283-1		AVFN	Blue	

Recommended Operating Speeds

Application	Recommended SFPM
Decorative Finishing	500-3,000
Wood Sanding	1,200-2,700
Deburring	5,000-6,500
Cleaning and Conditioning	2,000-5,000
Oxide Removal	4,500-6,500

SFPM = Surface Feet Per Minute. Maximum Operating Speed: 6,500 SFPM.

Scotch-Brite™ Clean & Finish Rolls

Highly conformable Scotch-Brite web can be cut to desired length for hand sanding or oscillating sanders.

Part No./UPC	W x L	Grade	Min./Case
048011-00264-4	4" x 30 ft.	AMED	1/3
048011-00265-1		AFIN	
048011-00266-8		AVFN	
048011-00270-5		SVFN	
048011-00274-3	6" x 30 ft.	AMED	1/2
048011-00275-0		AFIN	
048011-00276-7		AVFN	

Scotch-Brite™ Multi-Flex Sheet Rolls

Highly conformable Scotch-Brite webs perforated on a roll. Excellent sharpness and conformability for cleaning and finishing surfaces by hand.

Part No./UPC	L x W	Grade	Min./Case
051131-07521-4	8" x 4" Sheets	AVFN/Maroon	1/4
051131-07522-1	60 Sheets/Roll	SULF/Lt. Gray	

Accessories

Mini Mandrel No. 935

Use with desired Scotch-Brite strips to clean and polish I.D.'s and other tight areas. Mandrel has a 1/4" shank to fit desired tool.

Part No./UPC	L x Dia.	Min./Case
048011-04020-2	2-7/8" x 1/4" Max RPM 14,000	5

6" x 9" Scotch-Brite™ Hand Pads

Excellent products for hand finishing and cleaning of woods, metals, and composites. Ideal for:

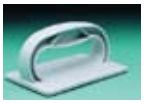
- Wood finishing
- Paint prep
- General cleaning

Part No./UPC	Model	Grade	Pads/Case
048011-04050-9	7440	AMED/Tan	40
048011-04051-6	7446	SMED/Gray	
048011-04028-8	7448	SULF/Lt. Gray	60
048011-04029-5	7447	AVFN/Maroon	

Accessories

Scotch-Brite Pad Holder No. 961

Use with Scotch-Brite hand pads or roll material cut to 4" by 6". Provides increased leverage and eliminates "finger" marks.



Part No./UPC	W x L	Min./Case
048011-09493-9	3-1/2" x 4-3/4"	10

Scotch-Brite™ Sponge Laminate

Unique product features Scotch-Brite laminated to a sponge backing. Excellent for wet cleaning and finishing.

Part No./UPC	W x L	Pads/Case
048011-20688-7	3-1/2" x 6-1/4"	20

Hand Pads

General Purpose

- 847: features a perforation to allow for a smooth, shred-free split to create two smaller, easy-to-use 4-1/2" x 6" pads.
- 747: no color bleeding when working with solvents.
- Grit size: very fine
- Maroon color.
- Aluminum oxide abrasive.
- 60 ct. 6" x 9" pads per package.

Best

Part No.	Product No.	Size	Color	Abrasive	Grit Size	Std. Pkg.
66261074700	747	6" x 9"	Maroon	Aluminum oxide	Very fine	60
66261084700	847	6" x 9"	Maroon	Aluminum oxide	Very fine	60

Bear-Tex

- Flexible pads conform to work surface.
- Gentle action easily removes flashing or burrs without affecting dimension of workplace.
- Non-loading to provide a constant supply of new cutting edges.
- Non-rusting.
- Solvent resistant and waterproof.
- Easily cut to desired size.
- Food Pro Pad (696) meets FDA/USDA and Canadian food industry standards.

Good

Part No.	Product No. / Description	Size	Color	Type	Abrasive	Grit Size	Std. Pkg.
66261045600	456	6" x 9"	White	Light-duty cleaning	N/A	N/A	60
66261063500	635	6" x 9"	Gray	Clean & finish	Silicon carbide	UF	60
66261069600	696	6" x 9"	Lt. green	Food Pro	Aluminum oxide	VF	2880
66261074000	740	6" x 9"	Tan	Heavy-duty	Aluminum oxide	Med	60
66261074600	746	6" x 9"	Gray	Metal blend	Silicon carbide	Med	60
66261074800	748	6" x 9"	Gray	Final shine	Silicon carbide	MF	60
66261077700	777	6" x 9"	Maroon	Long life	Aluminum oxide	VF	60
66261079600	796	6" x 9"	Green	Scouring	Aluminum oxide	VF	60
66261085100	851	6" x 9"	Gray	General purpose, perforated	Aluminum oxide	VF	60
66261047583	Hand pad holder	3-1/4" x 5-1/2"	-	-	-	-	10

Sponge Pads

Bear-Tex material is laminated to a top quality, long-lasting sponge for the convenience of 2 pads in one.

Good

Part No.	Product No.	Size	Color	Abrasive	Grit Size	Std. Pkg.
66261059402	875	3-1/4" x 6-14" x 3/4"	White/Yellow	N/A	N/A	60
66261059403	893	3-1/4" x 6-14" x 3/4"	Green/Yellow	Silicon carbide	VF	60

Roll Assortment

Bear-Tex rolls may be cut for use in jitterbug sanding or on-hand sanding applications. This convenient dispenser box contains three 2 inch wide x 15 foot long rolls.

- Contains 1 package. Package includes one of each type (3 rolls).

Part No. 66261008108

Better

Type	Abrasive	Grit
1	Aluminum oxide	Fine
2	Aluminum oxide	Very fine
3	Silicon carbide	Micro fine

Norton
Vendor Code: NRT

Bear-Tex Surface Finishing Products

STE and SCF Discs and Belts

Norton Bear-Tex surface blending material is now available in all three tiers. With four different stock product lines, and grit sizes of extra coarse to very fine, STE and SCF discs and belts perform well under a wide range of applications: from removing engine gaskets, and finishing nickel alloy turbine blades, to heavy deburring of aluminum and steel.

- Removing surface defects.
- Removing light edge burrs, parting lines or flashing.
- Removing rust oxides, corrosion, paints and scale.
- Cleaning molds.
- Blending mill marks, tool marks, uneven edges and coated abrasive finish.
- Color-coded grit sizes.
- Conformable.
- Uniform, thorough abrasive coating.
- Disc configurations: Hook and Loop; TR and TS Speed-Lok.
- Belt configurations: up to 37" width; Plyweld, butt joint; low stretch backing available in several product lines.

Good	Better	Good				
Part No.	Part No.	Part No.	Size	Abrasive	Grit size	Std. Pkg.
	66261017800	66261004431	2" Blank	A/O	Coarse	80
	66261017801	66261004441			Medium	
		66261004451			Very fine	
66261055015	66261017802	66261004432	3" Blank	A/O	Coarse	60
66261055016	66261017803	66261004442			Medium	
		66261004452			Very fine	
66261055018	66261017804	66261004433	4" Blank	A/O	Coarse	40
66261055019	66261017805	66261004443			Medium	
		66261004453			Very fine	
	66261017806	66261004434	4-1/2" Blank	A/O	Coarse	40
	66261017807	66261004444			Medium	
		66261004454			Very fine	
66261055021	66261017808	66261004435	5" Blank	A/O	Coarse	40
66261055022	66261017809	66261004445			Medium	
		66261004455			Very fine	
66261055024	66261017810	66121006910	6" Blank	A/O	Coarse	30
66261055025	66261017811	66121006911			Medium	
		66261006912			Very fine	
66261055027	66261017812	66261004436	7" Blank	A/O	Coarse	25
66261055028	66261017813	66261004446			Medium	
		66261004456			Very fine	
	66261017514	66261006913	8" Blank	A/O	Coarse	20
	66261017515	66261006914			Medium	
		66261006915			Very fine	

NEX Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing of metals or composites.

- Uniform construction.
- High quality virgin nylon fiber and unique resin formulation.
- Smear-resistant formula.
- Extra long life.
- Optimal combination of cut rate, life, finish and hardness/flexibility.
- Excellent, consistent, smear-free finish.

Best

Part No.	Size DxTxH	Spec	Max RPM	Max Pkg.
66261014891	1" x 1" x 3/16"	NEX-2AM	35,100	50
66261014883		NEX-2SF		
66261014900		NEX-6AF		
66261014904		NEX-6SF		
66261014908		NEX-6AM		
66261014915		NEX-8AC		
66261014924		NEX-8AM		
66261014923		NEX-8SF		
66261014897	2" Speed-Lok TR	NEX-2AM	18,000	60
66261014889		NEX-2SF		
66261015328		NEX-4AF	22,100	
66261014911		NEX-6AM		
66261014906		NEX-6SF		
66261014921		NEX-8AC		
66261014935		NEX-8AM		
66261014927	2" x 1/8" x 1/4"	NEX-8AM	22,100	60
66261014892	2" x 1/4" x 1/4"	NEX-2AM	18,000	60
66261014884		NEX-2SF		
66261014901		NEX-6AF	22,100	
66261014916		NEX-8AC		
66261014926		NEX-8AM		
66261014964		NEX-8SM		
66261014925	2" x 1/2" x 1/4"	NEX-8AM	22,100	30
66261014898	3" Speed-Lok TR	NEX-2AM	12,100	40
66261014890		NEX-2SF		
66261015419		NEX-4AF		
66261014912		NEX-6AM	18,100	
66261014907		NEX-6SF		
66261014922		NEX-8AC		
66261014936		NEX-8AM		

Part No.	Size DxTxH	Spec	Max RPM	Max Pkg.
66261014934	3" x 1/8" x 1/4"	NEX-8AM	18,100	40
66261014984	3" x 1/4" x 1/4"	NEX-2AM	12,100	40
66261014886		NEX-2SF		
66261015565		NEX-4AF	18,100	
66261014902		NEX-6AF		
66261014909		NEX-6AM		
66261014919		NEX-8AC		
66261014930		NEX-8AM		
66261014937		NEX-8SM		
66261014895	3" x 1/4" x 3/8"	NEX-2AM	12,100	40
66261014887		NEX-2SF		
66261014899		NEX-4AF	18,100	
66261014905		NEX-6SF		
66261014910		NEX-6AM		
66261014920		NEX-8AC		
66261014933		NEX-8AM		
66261014965		NEX-8SM		
66261014893	3" x 1/2" x 1/4"	NEX-2AM	12,100	20
66261014885		NEX-2SF		
66261014917		NEX-8AC	18,100	
66261014928		NEX-8SM		
66261014913	3" x 1/2" x 3/8"	NEX-7SXC	14,100	20
66261014918		NEX-8AC	18,100	
66261014929		NEX-8AM		
66261014914	3" x 1" x 3/8"	NEX-7SXC	14,100	10
66261014931	6" x 1/2" x 1"	NEX-8AM	7,500	4
66261014896	6" x 1" x 1"	NEX-2AM	5,000	2
66261014888		NEX-2SF		
66261015903		NEX-6AF	7,500	
66261014932		NEX-8AM		

Back-up Pads for Bear-Tex Discs

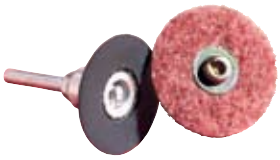
For Hook & Loop Discs

- Surface blending STE and SCF discs feature a hook & loop fastening system.

Part No.	Diameter	Spindle or Hole Size	Max RPM	3M Equivalent	Std. Pkg.
66261059350	1-1/2"	1/4" Steel shank	25,000	9215	5
66261059352	2"	1/4" Steel shank	23,000	922	
66261059354	3"	1/4" Steel shank	20,000	923	
66261059356	4"	1/4" Steel shank	18,000	924	
66261059303		1/2"-13"	13,000	914	
66261059304		5/8"-11"		914	
66261059305		M10 x 1.250			
66261059307		M14		914	
66261006948	4-1/2"	5/8"-11"	10,000	9145	
66261059360	5"	5/16"-24" male		905	
66261059308		3/8"-24" male		905	
66261059309		1/2"-13"		915	
66261059310		5/8"-11"		915	
66261059364	6"	5/8"-11" male*		906	
66261059312		5/8"-11"	8,000	916	
66261059368	7"	5/8"-11"	6,000	917	
66261059372	8"	5/8"-11"	4,500	918	

For Speed-Lok Discs

- Speed-Lok TS discs are compatible with the Norton Speed-Lok TS and standard abrasives quick change fastening systems.
- Speed-Lok TR discs are compatible with the Norton Speed-Lok TR and 3M ROLOC fastening systems.



TS Disc

TR Disc

Part No.	Description	Size	Max RPM	Std. Pkg.
63642543205	Hard Speed-Lok TS	2"	30,000	10
63642543210	Medium Speed-Lok TS		25,000	
66261055103	Medium Speed-Lok TR			
63642543220	Hard Speed-Lok TS	3"	20,000	
63642543225	Medium Speed-Lok TS			
63642804900	Hard Speed-Lok TR			
66261055105	Medium Speed-Lok TR			
66261043232	Medium Speed-Lok TS	4"	12,000	
66261047581	Medium Speed-Lok TR			
66261016581	Speed-Lok TR+		8,000	1

Rapid Strip Discs and Depressed Center Wheels

An open web of thick, strong synthetic fibers and extra coarse abrasive, bonded together by a smear-resistant adhesive allows cleaning and conditioning of a multitude of materials, quickly and easily with little loading.

- Thick, strong, synthetic fibers and extra coarse grit.
- Open web construction.
- Conformable.
- Used with portable tools.
- 2" and 3" discs with Speed-Loc TR fastener.
- New 4" TR+ discs.

Best

Part No.	Size D x H	Max. RPM	Abrasive	Grit	Std. Pkg.
Rapid Strip Discs					
66261013402	2" Speed-Loc TR	15,500	Silicon carbide	Extra coarse	10
66261059403	3" Speed-Loc TR	12,000	Silicon carbide	Extra coarse	10
66261016580	4" Speed-Loc TR	8,000	Silicon carbide	Extra coarse	10
66261008008	4" x 1/4"	8,000	Silicon carbide	Extra coarse	25
66261007916	4" x 1/2"	8,000	Silicon carbide	Extra coarse	25
66261008051	6" x 1/2"	5,500	Silicon carbide	Extra coarse	15
Rapid Strip Depressed Center Wheels					
66261020547	4-1/2" x 7/8" NEX-2AF	11,000	Silicon carbide	Extra coarse	10
66261020548	4-1/2" x 7/8" NEX-2AM	11,000	Silicon carbide	Extra coarse	10
66261020549	4-1/2" x 7/8" A/O M High Strength	11,000	Silicon carbide	Extra coarse	10
66261009649	4-1/2" x 7/8"	11,000	Silicon carbide	Extra coarse	10
66261009585	4-1/2" x 5/8"-11	11,000	Silicon carbide	Extra coarse	10
66261009586	7" x 7/8"	8,000	Silicon carbide	Extra coarse	10
66261009650	7" x 5/8"-11	8,000	Silicon carbide	Extra coarse	10

Abrasive Brushes

Tough, flexible nylon filaments embedded with abrasive grain form the bristles of these brushes. Use Bear-Tex abrasive brushes where maximum conformability is needed.

Part No. 63642543422 - 7" Medium Back-Up Pad
- 6,000 max RPM
- Std. Pkg. 5

Part No. 63642543463 - #103 Retainer Nut
- Std. Pkg. 10

Good

Part No.	Size	Abrasive	Grit	Std. Pkg.
66261058830	7" x 1" x 7/8"	Silicon carbide	80	5
66261058834	7" x 1" x 7/8"	Silicon carbide	120	5

AVOS Edger Speed-Lok Discs

Made of non-woven nylon web impregnated with abrasive grain and resin for use in a variety of applications. Choose one of three grit specifications to achieve the best results for your application.

- Light deburring.
- Cleaning and rust removal.
- Finishing, polishing and paint preparation.
- Patented scooped hole design.
- 15° angle back-up pad.
- Coarse removes 60-120 grit.
- Medium removes 120-180 grit guidelines.
- Very fine removes 180-320 grit guidelines.

Better

Part No.	Size	Grit	Std. Pkg.
66261010447	4-1/2" Edger Speed-Lok	A/O Coarse	40
66261010448		A/O Medium	
66261010449		A/O Very Fine	
66261009427	5" Edger Speed-Lok	A/O Coarse	40
66261009428		A/O Medium	
66261009429		A/O Very Fine	
66261009430	7" Edger Speed-Lok	A/O Coarse	40
66261009431		A/O Medium	
66261009432		A/O Very Fine	

Mandrel Assemblies and Threaded Mandrels for Unified Wheels and Discs on Edge

Mandrel Assemblies

Part No.	Fits Wheel Center Hole	Wheel Widths	Wheel Diameter	Shank Diameter	Overall Length	Washer Diameter	3M Equivalent	Std. Pkg
66261009849	1/8" - 3/16"	Up to 1/2"	Up to 2"	1/8"	1-3/4"	7/16"	931	1
66261009852	3/16"	1/8" - 1/2"	1" - 2"	1/4"	2"	7/16"	994	1
66261015146	1/4" - 5/16"	Up to 1/2"	Up to 2"	1/4"	2"	5/8"	932	1
66261059422	1/4" - 5/16"	Up to 1"	Up to 2"	1/4"	2-1/2"	5/8"	932	1
66261059421	1/4" - 5/16"	Up to 1"	2" - 3"	1/4"	2-1/2"	1"	933	1
66261009851	3/8"	Up to 1/2"	2" - 4"	1/4"	2-1/2"	1"	990	1
66261009850	1/2"	Up to 1"	3" - 6"	1/4"	3-1/8"	1-5/8"	934	1

Threaded Mandrels

Part No.	Shank Length	Shank Diameter	Center Hole	Use with Unified Wheel	3M+ Equivalent	Std. Pkg.
66261047584	1/4"	3/16"	3/16"	1" x 1" x 3/16"	948	5

Tiger® Non-Woven Hand Pads

Non-Woven Hand Pads

Weiler's Hand Pads are for cleaning and conditioning surfaces by hand. Unlike steel wool, the hand pads are non-metallic, and do not produce "after-rust" on worksurfaces. Hand pads can be used in wet applications.

Cleaning a sink in a restaurant with a commercial hand pad.

Applications

Hand Pads (Industrial):

- Producing satin finishes on aluminum and stainless steel
- Light deburring
- Surface preparation
- Blending light scratches
- Removing rust and oxidation

Hand Pads (Commercial):

- Cleaning and removing stains from stainless steel
- Removing rust and corrosion

Grain Types:
A - Aluminum Oxide S - Silicon Carbide

Hand Pads - Industrial Grade

Size	Grain	Part No.
Ultra Fine - Grey		
6" x 9"	S	51434
Economy General Purpose - Maroon		
6" x 9"	A	51460
General Purpose - Maroon		
6" x 9"	A	51444
Heavy-Duty - Tan		
6" x 9"	A	51454

Hand Pads - Commercial Grade

Size	Grain	Part No.
Economy - Green		
6" x 9"	A	51456
Standard-Duty - Green		
6" x 9"	A	51457
Heavy-Duty - Green (20% thicker than Standard-Duty)		
6" x 9"	A	51458

Hand Pad Holder

Description	Part No.
For 3" x 6" pad	59616

Surface Conditioning Discs

Weiler's Surface Conditioning Discs have an open construction, scrim reinforcement and a superior resin system. These features minimize loading, heat build-up, fraying of disc edges, grain shedding and extends disc life, providing superior performance.

Applications

- Scratch removal
- Removing flash, rust and oxidation
- Light deburring
- Blending ground out welds
- Gasket removal
- Cleaning, blending and conditioning metal surfaces
- Removing heat discoloration

Plastic Button Style Discs

Compatible with 3M Roloc™ back up pads

Dia.	Grade	Part No.	
		General Purpose	High Performance
1-½"	Very Fine (Blue)	51527	–
	Medium (Maroon)	51528	–
	Coarse (Brown)	51529	–
2"	Very Fine (Blue)	51530	57324
	Medium (Maroon)	51531	57323
	Coarse (Brown)	51532	57322
3"	Very Fine (Blue)	51533	57327
	Medium (Maroon)	51534	57326
	Coarse (Brown)	51535	57325
4"	Very Fine (Blue)	51536	–
	Medium (Maroon)	51537	–
	Coarse (Brown)	51538	–

Do not exceed the maximum RPM of the back-up pad.
(Roloc™ is a trademark of 3M.)

Surface Conditioning Discs

Surface blending on stainless steel

Hook & Loop Style Discs

Dia.	Grade	Part No.
2"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51503 51504 51505
3"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51506 51507 51508
4"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51509 51510 51511
4-½"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51512 51513 51514
5"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51515 51516 51517
6"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51518 51519 51520
7"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51521 51522 51523
8"	Very Fine (Blue) Medium (Maroon) Coarse (Brown)	51524 51525 51526

Hook & Loop Style Back-up Pads

1/4" Stem

Size	Max. RPM	Part No.
2" x ¼" Stem	16,000	51561
3" x ¼" Stem	16,000	51562
4" x ¼" Stem	16,000	51563
4-½" x 5/8"-11 Arbor Hole	13,000	51569
5" x 5/8"-11 Arbor Hole	10,000	51575
6" x 5/8"-11 Arbor Hole	8,000	51577
7" x 5/8"-11 Arbor Hole	6,000	51578
8" x 5/8"-11 Arbor Hole	4,500	51579

Do not exceed the maximum RPM of the back-up pad.

Plastic Button Style Back-up Pads

¼" Stem

Dia.	Max. RPM	Part No.
1-½"	30,000	51550
2"	25,000	51551
3"	20,000	51552
4"	12,000	51553

Industrial Brushes

Brushing Guide

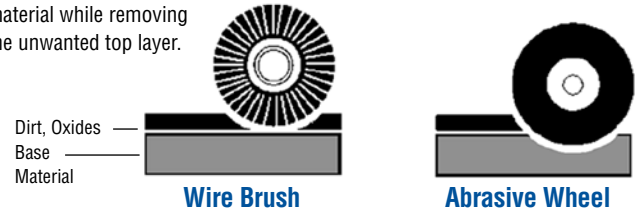
Proper Brushing Procedure

For maximum brushing results, use the lightest pressure necessary to accomplish the job. Let the wire tips do the work; excessive pressure can cause wire breakage.

Correct Incorrect

Wire Brushes vs. Abrasive Wheel

Power brushing removes dirt, contaminants and oxides from base material, not the base material itself. In some applications, hard abrasive wheels will remove the base material while removing the unwanted top layer.



Wire Brush Abrasive Wheel

Safety Guide

No. 1 Safety Goggles

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

No. 2 Protective Equipment

Appropriate protective clothing and equipment must be used where there is a possibility of injury that can be prevented by such clothing or equipment.

No. 3 Guards

Keep all machine guards in place.

No. 4 Speeds

Observe all speed restrictions indicated on brushes, containers, labels or printed pertinent literature. MSFS, "Maximum Safe Free Speed" should not be exceeded under any circumstances.

Bench and Straight Grinder Wire Wheels

Steel Wire Wheels

- Provide fine to medium brushing action.
- Excellent for uneven surfaces.

Diameter	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No.
6"	.014	5/8"-1/2"	1/2"	6,000	BW-605
			1"		BW-610

Knot Style for Small Angle Grinders

Standard Twist Wheels

- Cleaning grooves and bead welds.
- Easy to handle.

Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No. Steel	Part No. Stainless
4"	.014	5/8"-11 UNC	1/2"	20,000	BW-750 •	BW-9750 •
		1/2"-13 UNC			BW-751 •	BW-9751 •
		M-10 x 1.25			BW-752 •	BW-9752 •
		M-10 x 1.50			BW-753 •	BW-9753 •
		M-14 x 2.0			BW-754 •	BW-9754 •
		3/8"-24 UNF			BW-755 •	BW-9755 •

Stringer Bead Twist Wheels

- Cleaning of stringer bead welds.
- Great for fillet weld cleaning.

KEY
- • POP
- ¤ Box
- – Bulk

Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No. Steel	Part No. Stainless
4"	.020	5/8"-11 UNC	3/16"	20,000	BW-840 •	BW-9840 •
		1/2"-13 UNC			BW-841 •	BW-9841 •
		M-10 x 1.25			BW-842 •	BW-9842 •
		M-10 x 1.50			BW-843 •	BW-9843 •
		M-14 x 2.0			BW-844 •	BW-9844 •
		3/8"-24 UNF			BW-845 •	BW-9845 •

Crimped Wire Wheels for Small Angle Grinders

Crimped Steel Wire Wheels

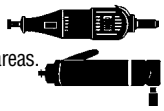
- Fast cleaning action.
- Surface preparation.

Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No.
4"	.014	5/8"-11 UNC	1/2"	14,000	BW-450 •
		1/2"-13 UNC			BW-451 •
		M-10 x 1.25			BW-452 •
		M-10 x 1.50			BW-453 •
		M-14 x 2.0			BW-454 •
		3/8"-24 UNF			BW-455 •

Small Diameter Crimped Wire Wheels

Small Wire Wheels

- Clean internal surfaces and hard-to-reach areas.
- For use on high speed grinders.



Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No. Steel	Part No. Stainless
	.0118				BW-701 –	
	.014				BW-702 –	
					BW-702C •	
3"	.0118	1/2"-3/8"	1/2"	20,000	BW-703 –	
	.014				BW-704 –	BW-9704 –
					BW-704C •	

Brush Drive Arbor

Brush drive arbors are display packed for P.O.P. merchandising.

Arbor Size: 1/2"
Shank Size: 1/4"
Overall Length: 1-3/4"
Part No. BW-594

Threaded Arbor Adapters

Small, high speed angle grinder adapters used to convert 5/8"-11 UNC.

Arbor Hole	Part No.
5/8"-11 to M-10 x 1.25	BW-590 –
5/8"-11 to M-10 x 1.50	BW-591 –
5/8"-11 to 3/8"-24	BW-592 –

Stem Mounted Wire Brushes

Crimped Wire End Brushes w/ 1/4" Stem

Dia.	Wire Size	Trim Length	Max. RPM	Part No. Steel	Part No. Stainless
3/4"	.006	7/8"	22,000		BW-9206 –
	.0104			BW-206 –	
	.014			BW-204 –	
	.020			BW-203 –	
	.020			BW-203C •	
1"	.006	7/8"	22,000	BW-210 –	BW-9210 –
	.014			BW-209 –	
	.020			BW-215C •	

Knot Style End Brushes w/1/4" Stem

Dia.	Wire Size	Trim Length	Max. RPM	Part No. Steel	Part No. Stainless
3/4"	.014	7/8"	22,000	BW-207 –	
	.020			BW-208 –	
				BW-208C •	
1-1/8"	.014	7/8"	22,000	BW-211 –	
	.020			BW-212 –	
				BW-212C •	BW-9212C •

Stem Mounted Wire Brushes

Crimped Wire Brushes w/1/4" Stem

Diameter	Wire Size	Trim Length	Max. RPM	Part No. Steel	Part No. Stainless
Light Duty Cup Brush					
2-1/2"	.014	1"	4,500	BW-213C •	
Wheels					
2"	.0118	1/2"	20,000	BW-217 –	
				BW-217C •	
3"	.008	1"	20,000	BW-218 –	
	.0118			BW-219 –	
	.014			BW-220 –	BW-9220 –
				BW-220C •	
Flared Wheels					
2-1/2"	.014	1"	20,000	BW-216 –	
				BW-216C •	
Encapsulated Wire Wheel					
3"	.0118	1"	20,000	BW-214C •	

KEY
- • POP
- ¤ Box
- – Bulk

Crimped Wire and Knot Style Cup Brushes

Crimped Wire Cup Brushes

- Fast cleaning action.
- Rust removal.
- Surface Preparation.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Part No. Steel	Part No. Stainless
4"	.014	5/8"-11	1-3/8"	9,000	BW-339 ¤	
	.020				BW-340 ¤	
5"	.020	5/8"-11	1-3/8"	9,000	BW-350 ¤	BW-9350 ¤
6"	.014	5/8"-11	1-1/4"	8,000	BW-359 ¤	
	.020				BW-360 ¤	

Heavy Duty Knot Brushes

- Fast cleaning action on large surfaces.
- Cleaning corners and hard-to-reach places.
- Long lasting.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Row Count	Part No. Steel	Part No. Stainless
4"	.014	5/8"-11	1-1/4"	9,000	1	BW-440 ¤	
	.020		1-3/8"		2	BW-2441¤	
	.023		1-1/4"		1	BW-441 ¤	BW-9441¤
6"	.014	5/8"-11	1-1/4"	7,000	1	BW-459 ¤	
	.023					BW-461 ¤	
	.035					BW-460 ¤	BW-9460¤
	.023		1-3/8"	6,600	2	BW-2461¤	BW-9461¤
	.035					BW-2460¤	

Cup Brushes for Small Angle Grinders

Crimped Wire Cup Brushes

- Greater brushing flexibility.
- Removes light rust & oxides.
- Fast brushing action.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Part No. Steel	Part No. Stainless
2-3/4"	.014	5/8"-11 UNC	7/8"	14,000	BW-320 •	
		1/2"-13 UNC			BW-321 •	
		M-10 x 1.25			BW-322 •	
		M-10 x 1.50			BW-323 •	
		M-14 x 2.0			BW-324 •	
		3/8"-24 UNF			BW-325 •	
3-1/2"	.014	5/8"-11 UNC	3/4"	12,000	BW-326 ¤	BW-9326 ¤

Cup Brushes for Small Angle Grinders

Knot Style Brushes

- Weld cleaning.
- Pipe bevel cleaning.
- Cleaning hard-to-reach areas.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Row Count	Part No.	
						Steel	Stainless
2-3/4"	.014	5/8"-11 UNC	7/8"	14,000	1	BW-420 •	BW-9420 •
		1/2"-13 UNC				BW-421 •	BW-9421 •
		M-10 x 1.25				BW-422 •	BW-9422 •
		M-10 x 1.50				BW-423 •	BW-9423 •
		M-14 x 2.0				BW-424 •	BW-9424 •
		3/8"-24 UNF				BW-425 •	BW-9425 •
3-1/2"	.020	5/8"-11 UNC	7/8"	13,000	1	BW-426 ¤	BW-9426 ¤

KEY
- • POP
- ¤ Box
- – Bulk

Knot Style Wire Wheel Brushes

Standard Twist Wheels

- Fast cleaning action.
- Weld cleaning.
- Surface preparation.

Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No.	
					Steel	Stainless
3"	.014	1/2"-3/8"	3/8"	25,000	BW-730C •	BW-720C •
4"	.014	1/2"-3/8"	1/2"	20,000	BW-740 –	
	.020				BW-756 –	
					BW-756C •	
6"	.016	5/8"-1/2"	1/2"	9,000	BW-763 –	BW-9765 –

Stringer Bead Twist Wheels

- Special construction to prevent unwinding of knots.
- Cleaning stringer bead welds.
- Quick mount threaded nut.

Dia.	Wire Size	Arbor Hole	Face Width	Max. RPM	Part No.	
					Steel	Stainless
5"	.020	5/8"-11 UNC	3/16"	12,500	BW-855 •	
		M-14 x 2.0			BW-856 •	
6"	.020	5/8"-11 UNC	3/16"	12,500	BW-861 •	BW-862 •
	.023		1/2"	9,000	BW-760 •	
6-7/8"	.020	5/8"-11 UNC	3/16""	9,000	BW-865 •	

Packaged Kits

Air Tool / Drill Accessory Kit

Contains 2 brushes and 2 wheels:
- 3/4" crimped wire end brush, .020 steel wire.
- 1-3/4" crimped wire cup brush, .0118 steel wire.
- 3" crimped wire wheel, .014 steel wire.
- 3" abrasive flap wheel, 80 grit/ aluminum oxide grain.

Part No. BW-GK

Mini Grinder Kit

Contains 1 brush and 2 wheels:
- 2-3/4" knot wire cup brush, .014 steel wire.
- 4" stringer bead knot wire wheel, .020 steel wire.
- 4-1/2" abrasive flap disc, 60 grit / zirconium grain.

Part No. BW-DK

Safety Information

Safety Goggles
Safety goggles or full face shields worn over safety glasses with side shields **MUST BE WORN BY ALL OPERATORS AND OTHERS IN THE AREA OF BRUSH AND ABRASIVE OPERATIONS.** Comply with the requirements of ANSI Z87.1 "Occupational Eye and Face Protection".

Guards
Keep all machine guards in place.

Speeds
Observe all speed restrictions indicated on brushes, abrasives, containers, labels, or printed in pertinent literature. MSFS means Maximum Safe Free Speed (RPM)–spinning free with no work applied. For reasons of safety, MSFS or Maximum RPM should not be exceeded under any circumstances.

Protective Equipment
Appropriate protective clothing and equipment must be used where there is a possibility of injury that can be prevented by such clothing or equipment.

Tool/Work Rest
On bench grinders and pedestal machines, tool/work rests should be used to support the work-piece during use. It should have a maximum opening of 1/8" to the product face. Only adjust the rest when the product is not in motion.

Safety Standards
Comply with the Safety Standards of the American National Standards Institute Standards ANSI B165.1 "Safety Requirements - Power Brushes" and ANSI B7.1 "Safety Requirements - For the Use, Care and Protection of Abrasive Wheels".

WARNING
Failure to observe safety precautions may result in injury.

Power Tool Icons

These icons illustrate the power tools used to drive Weiler brushed and abrasives.

Right Angle Grinder

Straight Grinder

Bench/Pedestal Grinder

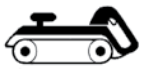
Die Grinder

Right Angle Air Die Grinder

Cut-Off Die Grinder

Stationary Belt Sander

Portable Chop Saw


Portable Belt Sander

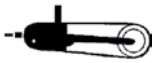
Chop Saw

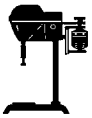
Circular Saw

High Speed Pencil Grinder

Low HP Chop Saw

Benchstand Belt Sander


Portable File Belt Sander


Drill Press

Flexible Shaft Tool

Stationary Cut-Off Machine

Availability of ANSI Standards

Based on the collective experience of the ABMA Industrial Division members (ANSI B165.1) and the United Abrasives Manufacturers Association's Bonded Division (ANSI B7.1), both ANSI Standards are referenced and provided solely as a public service for the guidance of the users of the members' products. All Brush and Abrasive recommendations are not necessarily complete with respect to any particular application and common sense safety considerations should be adhered to generally. Any applicable federal, state, local law or regulation must be strictly adhered to and is controlling over any recommendation contained herein. American National Standards are subject to periodic review and users are cautioned to obtain the latest editions. Contact The American National Standards Institute (ANSI), 1430 Broadway, New York, NY 10018.

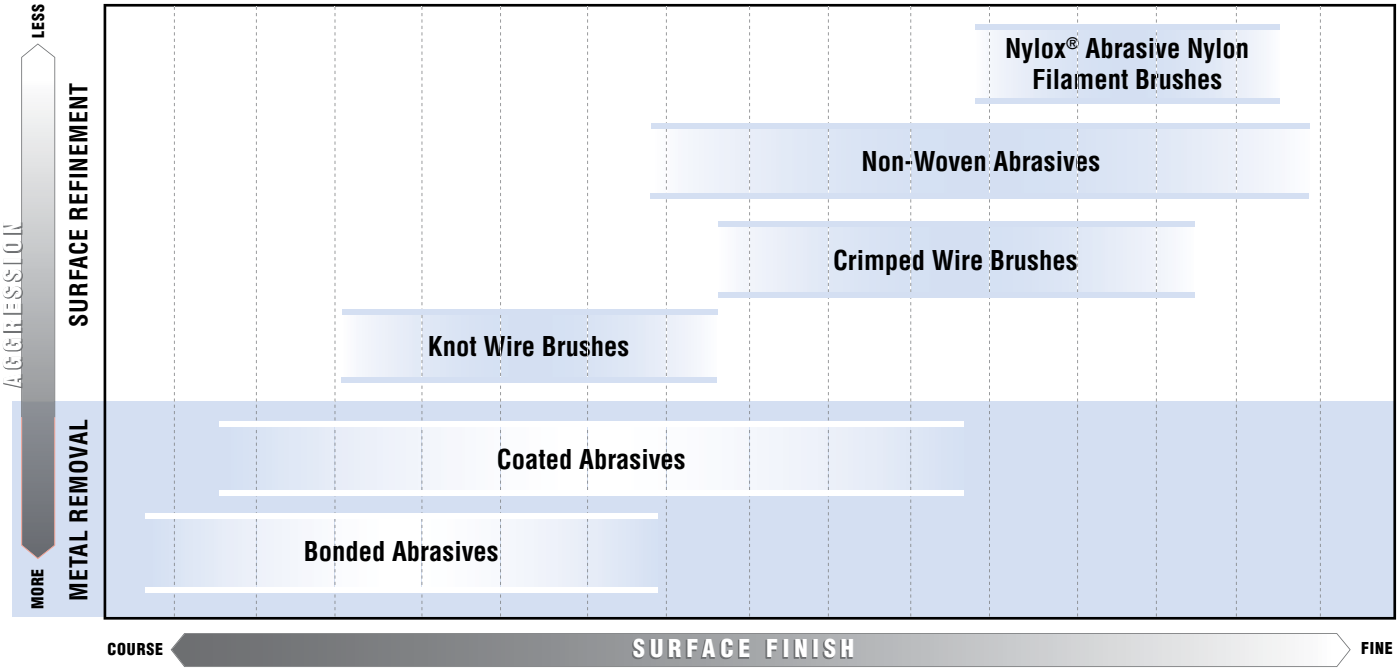
Weiler's Satisfaction Guarantee

Weiler Corporation hereby warrants that its Power Brush, Nylox®, Abrasive and Maintenance products shall be free from defects in material and workmanship under normal use and service, for a period of one year from the date of purchase. In the event the customer reasonably becomes dissatisfied with the performance of any of Weiler's products, Weiler will repair or replace the product at no cost to the customer. This repair or replacement is contingent upon prompt written notice and compliance by the customer with instructions given by Weiler regarding the return of the product for evaluation.

This warranty is expressly in lieu of all other warranties, expressed or implied, including the warranties of merchantability and fitness for a particular purpose. Correction in the manner provided hereinabove shall be the extent of Weiler's liability, and no other entity is authorized to extend that liability.

Product Selection Guide: By Surface Finish

See chart below for the most effective brush or abrasive product type based on surface finish and degree of aggression required for your application. As indicated, coated and bonded abrasives will remove base material. Wire Brushes, Nylox® Brushes and Non-Woven Abrasives will NOT typically remove base material and are used for jobs requiring surface refinement.

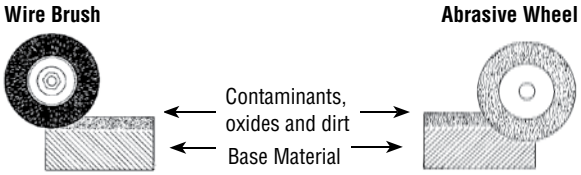


Power Brush Technical Information

Operational Advantages of Power Brushes

Power Brushes Will Not Remove Base Material

Wire brushes clean surfaces in the same manner as sand-blasting. Because of using superior quality hardened steel wire rotating at a high rate of speed, the brushes have the ability to separate surface contaminants from base material. Wire brushes will not remove base material or change part dimensions.



Brushes Are Non-Loading

Unlike non-woven, bonded and coated abrasives, wire brushes will not load when brushing soft materials or when used to remove paint and similar coatings.

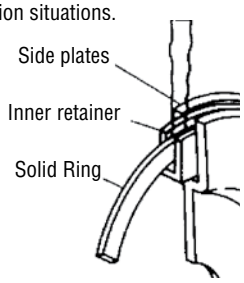
This resin fiber disc did not work very long before the grains became loaded with material.

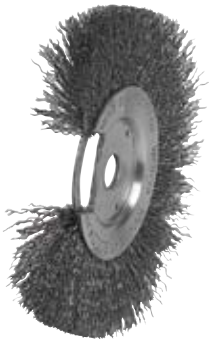
This power brush, however, can keep on working without ever becoming loaded with material.

Construction Advantages of Weiler Power Brushes

Weiler's Solid Ring Construction

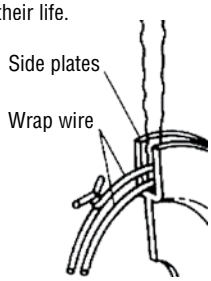
Our construction ensures that the brush will run smoother and last longer, even in the toughest application situations.





Competitor's Wrap-Wire Construction

Brushes made using the old wire wrapping method lack balance and permit wires to move around at the base, shortening their life.



Construction Advantages of Weiler Power Brushes

Weiler's Individual Knot Hole Construction

Weiler's knot wheels are constructed with an internal steel plate that has equally spaced individual holes around the perimeter. Wire is inserted through each hole and twisted into a knot. Each hole has precisely the same wire count, thereby assuring perfect balance. This eliminates vibration, reduces operator fatigue and increases brush life.

Weiler's Roughneck® Weld Cleaning Brushes Patented Construction

Each knot is twisted through its own hole and locked into an individual sprocket tooth. This prevents the knots from moving and allows them to have stronger striking action on the work surface.

Competitor's Knot Construction

Competitor knot wheel construction is commonly characterized by the placement of multiple knots into a single slot in the knot plate. The primary disadvantage of this type of construction is the lack of precise control of the knot location. As the brush wears, the knots have a tendency to move. In addition to creating vibration, this movement is detrimental to brush life and brushing aggression.

Fill Materials

Steel Wire:
Heat-treated, high-tensile steel wire, drawn to exacting Weiler specification, is used in all Weiler brushes with a wire diameter of .008 and above. This wire provides superior fatigue resistance and excellent brushing action.

Hard Drawn Wire:
Generally used in .003, .005 and .006 wire diameters for fine surface work.

Stainless (Type 302) Wire:
Highly corrosion resistant. Recommended where contamination or "after rust" is a problem, such as brushing stainless steel or non-ferrous metals. All Weiler stainless steel brushes are made with Type 302 stainless steel wire.

Non-Ferrous:
Brass, Bronze and Aluminum are some of the non-ferrous wires available in Weiler power brushes for special applications.

Animal:
Horsehair - A very durable material. The tail hair is stiff and the mane hair is soft. It can be blended with other materials such as synthetics. Used in a variety of brushes for scratch-free cleaning.

Goat hair - This soft material is mainly used in our miniature brushes for polishing.

Natural:
Tampico - Produced from the stem of the Mexican agave plant. Its texture is soft to medium with good durability. Used for scrubbing and washing applications. It is heat, alkali and acid resistant. The natural color is off-white but it may be dyed or bleached.

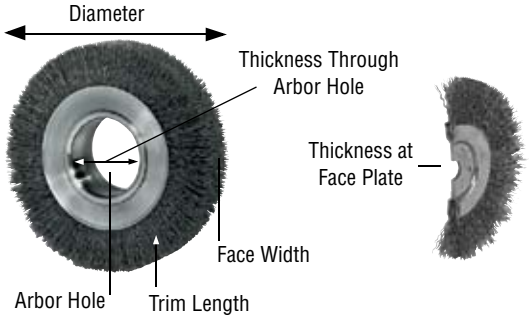
Synthetic:
Nylon - Resistant to most acids and alkalis. Long wearing nylon has the greatest use in cleaning applications. It is available straight or crimped.

Polypropylene - Available in strip brushes.

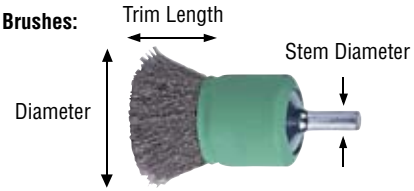
Product Attributes

Brush Terminology

Wheel Brushes:

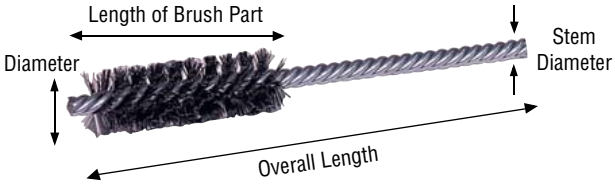


Stem-Mounted End Brushes:



Cup Brushes:

Tube Brushes:



Stainless Steel Wire Brushes:

There is an increasing need for stainless steel wire brushes in a variety of industries, such as the nuclear, aircraft, electronics, chemical, shipbuilding and missile industries.

Weiler's complete line of stainless steel brushes are made using Type 302 stainless steel wire. This wire was developed to provide long brush life and corrosion resistance. Using a stainless steel brush when brushing aluminum, stainless steel and other high strength alloys eliminates the danger of "after rust". When these alloys are brushed with carbon steel wire, a deposit of carbon material remains which can cause rust. Type 302 brush wire is austenitic.

Once a stainless steel brush has been used on carbon steel, it should never be used on stainless steel since rusting can occur. To avoid contamination, all stainless brushes should be stored away from areas (such as steel work benches) where carbon steel particles might come in contact with the brush.

It is recommended that a stainless steel surface be passivated with a solution of 10-20% nitric acid, after brushing, to ensure its resistance to corrosion.

Most stainless steel types look alike. How can you determine whether or not you really have Type 302 stainless steel wire in your brush? Stainless steel wire has magnetic properties as a result of the wire drawing process. Type 302 stainless wire will lose its magnetic properties if a wire strand is heated red with a match. If the wire strand retains its magnetic properties after heating, it is not Type 302.

Care of Stainless Steel Wire Brushes:
For critical operations, stainless steel wire brushes should be degreased before beginning the operation. Brushes that are stored after use should also be degreased and stored in plastic wrapping. If stored unprotected for any length of time, the brush could collect foreign matter due to its magnetic properties, and leave "after rust" when reused.

Power Brush Operating Information

Brushing Speeds

- Power brushes, like cutting tools, operate most effectively when the speed and pressure of the operation are properly matched to the demands of the application. In most operations, the highest speed and lightest pressure will ensure the fastest brushing action and longest brush life.
- Increasing brush speed increases the face hardness and brushing action; therefore, a fine wire brush rotating at a higher speed will often produce the same results as a coarser wire brush rotating at a slower speed. Finer wire operating at a higher speed is generally preferred and will provide a longer brush life.
- MSFS - Maximum Safe Free Speed (RPM) is the maximum speed at which the brushes may be used safely and is not necessarily the optimum speed for a given application. Operating speed should be determined by the application, but should not exceed the MSFS (RPM) for which the brush is rated.
- Make sure spindle size and motor of machine are large enough to accommodate the diameter of brush to be used.

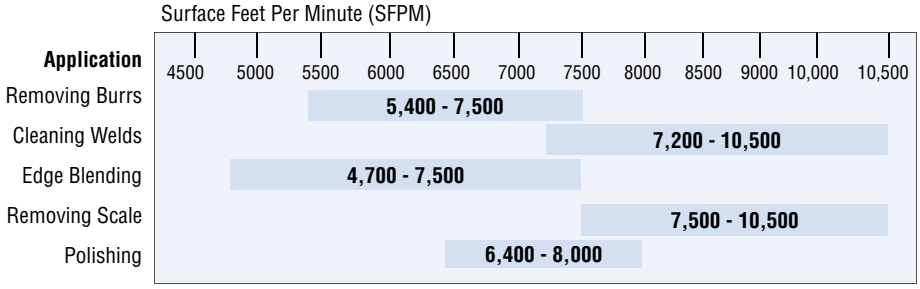
Brushing Pressure

Avoid excessive pressure when using a wire brush.
Excessive pressure causes over-bending of the filaments and heat build-up resulting in filament breakage, rapid dulling and reduced brush life.

Instead of greater pressure, try the following:
- **A brush with more aggressive action** (increase filament diameter, decrease trim length, different brush type, i.e.: knot type instead of crimped type)
- **Higher surface speed** (increase RPM or brush diameter)

Important Note: Never exceed the recommended Maximum Safe Free Speed or RPM rating of the brush.

Recommended Surface Speeds For Brushing Applications



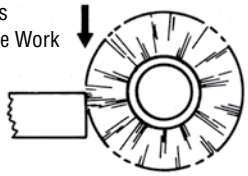
$$SFPM = \pi \frac{\text{Dia. (Inches)} \times \text{RPM}}{12}$$

Table of Surface Speeds (Peripheral Speed in Ft./Min.)

	Diameter (Inches)							
RPM	**2**	**3**	**4**	**6**	**8**	**10**	**12**	**15**
1000	525	785	1050	1575	2100	2625	3150	3925
1500	785	1175	1575	2350	3150	3925	4725	5900
1750	915	1375	1850	2750	3650	4550	5500	6800
2500	1300	1950	2625	3925	5250	6550	7850	9825
3000	1575	2350	3125	4725	6275	7850	9425	11,775
3450	1800	2700	3600	5400	7200	9000	11,000	13,500
4000	2100	3150	4175	6275	8375	10,475	–	–
6000	3125	4700	6275	9425	–	–	–	–
10,000	5250	7850	10,500	–	–	–	–	–
15,000	7850	11,775	15,750	–	–	–	–	–
20,000	10,450	15,700	20,950	–	–	–	–	–

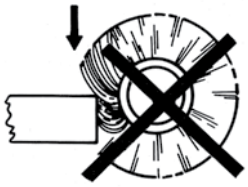
Correct

Wire Tips
Doing the Work



Incorrect

Excessive Pressure
Causes Wire Breakage



Important: When running a wire brush, a rule of thumb is to run it a "mile a minute" or a minimum of 5,000 Surface Feet Per Minute (SFPM). Normally, higher surface speeds result in faster cycle times and longer brush life. However, never exceed the Maximum Safe Free Speed (MSFS) or RPM of the brush.

Example: A 6" diameter wheel running at 3,450 RPM has a surface speed of 5,400 SFPM.

Power Brush Operating Information

Minimum Spindle (Shaft) Diameter for Brushes of Various Sizes

(From ANSI Standard B165.1)

Outside Diameter of Wheel Brush	Maximum Face Width of Wheel Brush	Minimum Outside Diameter of Spindle (Shaft)
2"	¼"	¼"
3"	¾"	¼"
3" (heavy-duty)	1"	3/8"
4"	1"	3/8"
6"	1-¼"	½"
8"	1-¼"	5/8"
10"	2"	¾"
12"	3"	1"
14"	3"	1-¼"
15"	3"	1-¼"
16"	3"	2"

Note:
These diameters are based upon the wheel brush being mounted next to the supported end of the shaft, rather than the unsupported end, in order to minimize overhang.

Recommended Motor Sizes

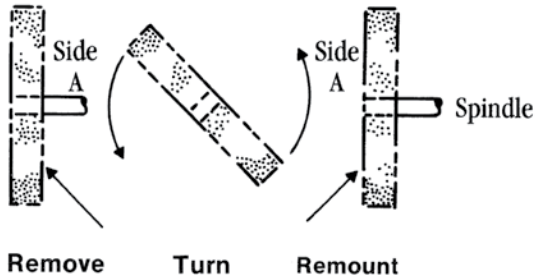
Brush Diameter	Motor Size	RPM
4"	¼ HP	3,450
6"	½ HP	3,450
8"	¾ HP	3,450
10"	1 HP	1,750
12"	1 HP	1,750
15"	1-½ HP	1,750

Note: This chart is based on 1" brush face.

- Select a brush which is compatible with the horse power of the machine (see chart above).
- Select the largest diameter brush which will fit on the machine with all guards in place.

Self-Sharpening Tip for Wire Wheel Brushes

When using wire wheel brushes without nuts, periodically reverse the direction of rotation to take advantage of the self-sharpening action that will result. Remove the brush from the spindle, flip the wire brush 180˚ and remount the brush securely.



Conversion Charts

(Inches to Millimeters; 1"=25.4mm, 1mm=.03937")

Brush Diameter	
Inches	Millimeters
2-¾"	70mm
3"	76mm
3-½"	89mm
4"	102mm
5"	127mm
6"	152mm
7"	178mm
8"	203mm
10"	254mm
12"	305mm
14"	356mm
15"	381mm
16"	406mm

Arbor Hole Size	
Inches	Millimeters
¼"	6.4mm
3/8"	9.5mm
½"	12.7mm
5/8"	15.9mm
¾"	19.0mm
7/8"	22.2mm
1"	25.4mm
1-1/8"	28.6mm
1-¼"	31.8mm
1-½"	38.1mm
1-¾"	44.5mm
2"	50.8mm

Brush Face Width	
Inches	Millimeters
1/8"	3.0mm
¼"	6.4mm
3/8"	9.5mm
½"	12.7mm
5/8"	15.9mm
¾"	19.0mm
7/8"	22.2mm
1"	25.4mm
1-1/8"	28.6mm
1-¼"	31.8mm
1-½"	38.1mm
2"	50.8mm

Product Selection

Crimped vs. Knot Wire Brushes

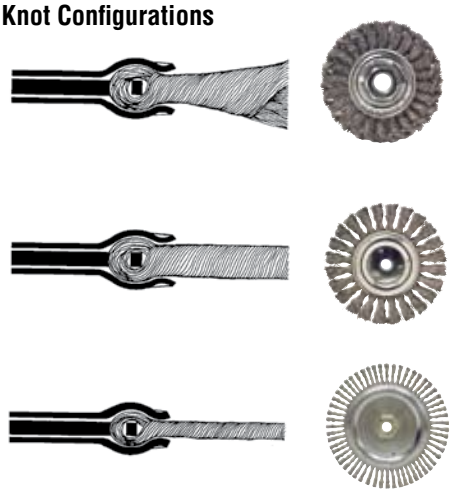
Crimped Wire Brushes:

- Made of heat-treated wire which is crimped to allow individual filaments to support each other.
- Provide flexibility for light to medium duty brushing action.
- Use on parts that could be damaged by the impact of a knot brush.
- Use for a broad range of applications.

Knot Wire Brushes:

- Made of heat-treated straight wire filaments twisted as a single unit like a piece of cable or wire rope.
- Provide less flexibility and more aggressive brushing action in heavy-duty applications.
- Use on parts requiring high-impact action.
- Use to remove large burrs and heavy contamination, such as multiple layers of rust, scale, paint or oxides.

Knot Configurations



Standard Twist:
A slight tuft at the end of the wire knot provides some flexibility for use on irregular surfaces.

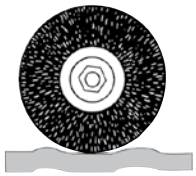
Cable Twist:
The wire is tightly twisted to the end of the knot, providing very aggressive brushing action.

Stringer Bead Twist:
The wire is very tightly twisted to the end of the knot, creating a narrow face with high-impact action, primarily used for weld cleaning.

Product Selection

Trim Length

Long Trim Brushes are more conformable and are able to follow contoured surfaces.



Short Trim Brushes are faster acting and suited for more severe brushing action.

Fill Density

High Density Brushes produce faster brushing action, longer brush life and finer surface finishes.

Low Density Brushes offer greater flexibility for surface cleaning operations on irregular surfaces.

Wire Size

It is recommended to use:

Very Fine to Fine Wire for light-duty applications

Medium to Coarse Wire for heavy-duty applications

To maximize brush life, always use the finest wire which will accomplish the job.

Wire	Coarse		Medium to Coarse		Medium		Fine		Very Fine	
Gauge #	20	24	25	30	33	34	35	38	43	47
Dia. in Inches	.035	.023	.020	.014	.0118	.0104	.0095	.008	.006	.005
Dia. in mm	0.89	0.58	0.51	0.36	0.30	0.26	0.24	0.20	0.15	0.13

Wire sizes in decimals of an inch are shown in all tables.

American Steel Wire Equivalent Gauge (Formerly Washburn & Moen)

Polyflex® Encapsulated Brushes

Polyflex® Encapsulated Brushes are ideal for extremely demanding applications. They are especially well-suited for users with the following type of requirements:

- **Extreme Brushing Pressure** - Encapsulation protects wires from over-flexing and extends brush life relative to conventional knot and crimped wire brushes.
- **Severe Cleaning Operations** - Encapsulation holds the wire tips rigidly in place and creates the most aggressive brushing action which can be achieved with a wire brush.

In order to optimize the performance of encapsulated brushes, selection of the correct elastomer is critical. The following is a description of the three types of elastomers and their performance attributes.

Burgundy (Standard)
General purpose elastomer; suitable for most manufacturing applications.

Orange (Heavy-Duty)
A more heavy-duty elastomer than burgundy; used for more demanding applications found in steel fabrication.

Black (Extra Heavy-Duty)
A heat stabilized elastomer that does not wear easily; used primarily for cleaning pipeline welds. Minimizes smearing on hot parts.

Power Brush Selection Chart	Cleaning Surface Prep Roughening Weld Cleaning Remove Oxides & Rust	Surface Finishing (Functional, Aesthetic, Decorative, Satin)	Heavy Deburring	Light Deburring & Edge Blending	Deflashing
Crimped Wheels	SG, RAG, BPG	SG, BPG		RAG, SG, BPG	
Knot Wheels	SG, RAG, BPG		SG, BPG		RAG, BPG
Crimped Cups	BPG	RAG		BPG	
Knot Cups	BPG		RAG		
Crimped Stem-Mounted	RAD, SDG			RAD, SDG	
Knot Stem-Mounted	RAD, SDG		RAD, SDG		RAD, SDG
Encapsulated	RAG, SG, RAG, SDG, BPG		RAG, SG, RAG, SDG		RAG,SG,RAG,SDG,RAD
Power & Hand Tube	HDP	HDP		HDP	
Miniature	SDG	SDG		SDG	

Product & Application Key
RAG Right Angle Grinder
SG Straight Grinder
BPG Bench/Pedestal Grinder
RAD Right Angle Die Grinder
SDG Straight Die Grinder
HDP Hand Drill/Drill Press

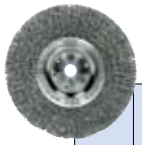
Application Solutions Guide

There are many variables in power brush applications. If the power brush you are using does not accomplish the desired results, select a solution from the suggestions below for your specific application.

Problem	Recommended Solutions
Brush works too fast	• Select a brush with longer filaments • Select a brush with a smaller diameter wire • Select a brush with a narrower face • Select a brush with a smaller outside diameter • Operate the brush at a slower RPM
Brush works too slowly	• Select a brush with shorter filaments • Select a brush with a larger diameter wire • Select a brush with a wider face • Select a brush with a larger outside diameter • Operate the brush at a faster RPM
Brushing action rolls or peens the burr over instead of removing burr	• Select a brush with a wider face • Select a brush with a larger diameter wire • Select a brush with shorter filaments • Operate the brush at a faster RPM
Finer final finish required	• Select a brush with longer filaments • Select a brush with a smaller diameter wire • Operate the brush at a higher RPM • Select a brush with a wider face • Replace the wire brush with an abrasive nylon brush (Nylox®)
Coarser final finish required	• Select a brush with shorter filaments • Select a brush with a narrower face • Operate the brush at a slower RPM • Select a brush with a larger diameter wire
Non-uniform brushing action	• Select a brush with longer filaments • Select a brush with a narrower face • Automate the operation to reduce human variables
Filaments break off	• Reduce pressure • Select a brush with a smaller diameter wire
Short brush life	• Select a brush with a smaller diameter wire • Reduce pressure • Select a brush with a wider face

Trulock™ Crimped Wire Wheels

Removing paint prior to welding.



Crimped Wire Wheels - Narrow Face

Flexible brushing action. Can be mounted in multiples.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Max. AH Avail.	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.006	½"-3/8"	½"	7/8"	¾"	7/16"	12,500	TLN-4	00104	00154
	.0118								00134	00184
	.014								00144	-
6"	.006	5/8"-½"	¾"	1-7/16"	1-¼"	7/16"	6,000	TLN-6	01035	01675
	.008								01045	-
	.0118								01065	01705
	.014								01075*	-
8"	.006	5/8"	¾"	2-1/16"	1-¼"	½"	6,000	TLN-8	01135	01775
	.0104								01155	-
	.0118								01165	01805
	.014								01175*	-

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Applications

- Cleaning rust, scale and dirt
- Light deburring
- Edge blending
- Roughening for adhesion
- Finishing for appearance
- Finish preparation prior to plating or painting
- Ideal for high production applications

Crimped Wire Wheels - Medium Face

Greater fill density and more aggressive brushing action.
Can be mounted in multiples.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
6"	.0118	2"	1"	1-1/8"	15/16"	6,000	TLM-6	06070	-
	.014							06080	-
8"	.0118	2"	1"	1-3/8"	1"	4,500	TLM-8	06110	06490
	.014							06120	-
10"	.0118	2"* with keyway	1-1/8"	2"	1"	3,600	TLM-10	06150	06530
	.014							06160	-
	.020							06170	-

*1/2" x 1/4" Double Keyway

Crimped Wire Wheels - Wide Face

Maximum wire density and aggression, covers more surface area in a single pass.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
6"	.0118	2"	1-¼"	1-1/8"	1"	6,000	TL-6	03060	03510
	.014							03070	03520
7"	.0118	2"	1-¼"	1-5/8"	1"	6,000	TL-7	03090	-
	.014							03100	-
8"	.0118	2"	1-½"	1-3/8"	1-3/8"	4,500	TL-8	03140	03590
	.014							03150	-
	.020							03160	-
10"	.0118	2"	2"	1-7/8"	1-5/8"	4,000	TL-10	03190	-
	.014							03200	-
	.020							03210	-
12"	.014	2"	2"	2-7/8"	1-9/16"	3,000	TL-12	03230	03680
	.020				1-11/16"			03240	-

Trulock™ Crimped Wire Wheels

Remove carbon build-up from an automotive valve.

Metal Adapters
For Medium & Wide Face Brushes.
Used in pairs & priced per pair.

For Brush Arbor Hole Size	Adapted Arbor Hole Size	Part No.
2"	½"	03809
	5/8"	03810
	¾"	03811
	7/8"	03824
	1"	03812
	1-¼"	03813
	1-½"	03814

Bench Grinder Wheels - Medium & Wide Face
A lower price, commercial grade brush for general purpose applications.

ORBITOR

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
6"	.014	5/8"-½"	5/8"	1-1/16"	½"	6,000	OM-6	02325*
7"	.014	5/8"	¾"	1-9/16"	½"	6,000	OM-7	02335*
6"	.014	5/8"-½"	7/8"	1-1/8"	7/8"	6,000	OW-6	06645*
7"	.014	5/8"	7/8"	1-5/8"	7/8"	6,000	OW-7	06655

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Copper Center™ - Small Diameter Wire Wheels

Removing carbon build-up from an engine.

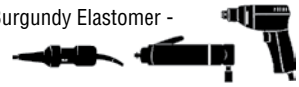
Applications

- Deburring
- Rust, scale and carbon removal
- Cleaning internal surfaces and hard to reach areas
- Cleaning threads and boiler tubes
- Edge blending
- Cleaning and polishing I.D. & O.D. surfaces
- Finishing for appearance
- Roughening for adhesion
- Wide usage in aircraft, aerospace, naval and nuclear work

Small Diameter Wheels - Wire Fill
General purpose applications. Can be mounted in multiples.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
2"	.0118	½"-3/8"	3/8"	½"	20,000	C-2	15463	16863
	.014	½"-3/8"					15473	16873
3"	.0118	½"-3/8"	5/8"	1"	20,000	C-3	15563	16963
	.014	½"-3/8"		1"			15573	16973
	.014	5/8"		15/16"			15677	

Small Diameter Wheels - Polyflex® Encapsulated Burgundy Elastomer - Standard. Elastomer gradually wears exposing consistent short trim for maximum aggression and long life.



Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel
2"	.006	½"	¼"	½"	20,000	PC-2	35335
	.0104						35240
	.014						35070

Drive Arbors

Arbor Dia.	Stem Dia.	Stem Length	Length of Shaft	For Brushes with Max. Dia. of:	Max. RPM	Ref. Code	Part No.
Unthreaded							
¼"	¼"	1-1/8"	3/16"	2"	20,000	AU-3	07723
3/8"	¼"	1-1/8"	3/16"	4"	20,000	AU-2	07722
Threaded							
½"	¼"	¾"	¾"	3"	25,000	SA-1	07724
3/8"	¼"	¾"	¾"	3"	25,000	SA-2	07727
½"	¼"	7/8"	¾"	3"	20,000	AU-1	07721
¼"	¼"	1-1/16"	1-1/8"	2"	20,000	FA-1	07725
3/8"	¼"	1"	1-1/8"	3"	20,000	FA-2	07726

Duralife® Knot Wire Wheels

Standard Twist Wheels

Rugged knot-type construction provides aggressive, high-impact action for severe applications.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Max. AH Avail.	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
3"	.0118 .014 .020	½"-3/8"	20	3/8"	5/8"	½"	7/16"	25,000	ST-3	08004 08014* 08024	08254 08264 08274
4"	.0118 .014 .020	½"-3/8"	24	½"	7/8"	½"	7/16"	20,000	ST-4	08034 08044* 08064	08284 08294 08314
6"	.0118 .014 .016 .023	5/8"-½"	24	½"	1-3/8"	1-¼"	9/16"	9,000	ST-6	08075 08085* 08095 08105	08325 – 08345 –
6"	.016	5/8"-½"	30	5/8"	1-¼"	1-¼"	5/8"	9,000	STH-6	08975	–
7"	.014	5/8"	24	5/8"	1-7/8"	1-¼"	9/16"	9,000	ST-7	08835	–
8"	.0118 .014 .016 .023	5/8"	38	5/8"	1-5/8"	2"	½"	6,000	ST-8	08125 08135 08145 08155	08375 – 08395 –

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Removing rubber coating from a hydraulic hose.

Applications

- Removing rust, scale, weld spatter and oxidation
- Roughening surfaces
- Removing rubber or plastic flash
- Heavy burr removal
- Heavy-duty cleaning operations
- Weld cleaning
- Surface conditioning
- Coating removal

Standard Twist Wheels - Wide Face - Two Sections

Covers more surface area in a single pass.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
3"	.0118	½"-3/8"	40	¾"	5/8"	¾"	22,000	WST-3	09104
4"	.0118	½"-3/8"	48	¾"	7/8"	¾"	20,000	WST-4	09134
6"	.0118	2"	60	7/8"	1-3/8"	7/8"	8,000	WST-6	09160
	.016								09180
8"	.0118	2"	76	1"	1-5/8"	1"	6,000	WST-8	09410
	.016								09430
10"	.016	2"	104	1-¼"	1-¾"	1-¼"	4,500	WST-10	09480
	.023								09490
12"	.0118	2"	104	1-¼"	2-¾"	1-¼"	3,600	WST-12	09510
	.016								09530
	.023								09540

Cable Twist Wheels

Maximum impact for extremely severe applications.

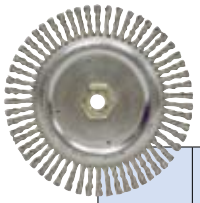
Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Max AH Avail.	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.020	½"-3/8"	24	¼"	7/8"	½"	7/16"	20,000	CT-4	08534	–
6"	.023	5/8"-½"	24	3/8"	1-3/8"	1-¼"	9/16"	9,000	CT-6	08565	08695
8"	.023	5/8"	38	½"	1-5/8"	2"	½"	6,000	CT-8	08615	–

Duralife® Knot Wire Wheels

Removing weld slag before the next weld pass.

Cable Twist Wheel - Wide Face
Ideal for external pipe cleaning.
For automatic and semi-automatic equipment.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Max. AH Avail.	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
10"	.023	2"	208	1-¾"	1-¾"	2"	1-7/8"	4,500	WCT-10-4	94008



ROUGHNECK

Stringer Bead Twist Wheels - Very Narrow Face
For hard-to-reach areas; primarily for weld cleaning

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
5"	.020	5/8"-11 UNC	38	3/16"	7/8"	3/8"	12,500	STB-538	08756	08806
5"	.023	5/8"-11 UNC	24	½"	7/8"	3/8"	12,500	STB-524	09856	09866 •
6"	.020	5/8"-11 UNC	38	3/16"	1-3/8"	3/8"	12,500	STB-620	08766+	08786+
6"	.020	5/8"-11 UNC	56	3/16"	1-1/8"	7/16"	12,500	STB-6	09400*	09500
6"	.023	5/8"-½"	24	½"	1-3/8"	9/16"	12,500	STB-623	08775	–
		5/8"-11 UNC							08776*	08796 •
6"	.023	5/8"-11 UNC	30	½"	1-¼"	5/8"	12,500	STB-630	08916*	08926 •
6"	.023	5/8"-11 UNC	30	5/16"	1-3/8"	½"	12,500	STC-6	09386	09396
6-7/8"	.020	5/8"-11 UNC	56	3/16"	1-1/8"	7/16"	9,000	STB-756	09000*T	09200T
6-7/8"	.020	5/8"-11 UNC	72	3/16"	1-1/8"	7/16"	9,000	STB-772	09100	–

+Light Duty T Patented • Note: This product has ½" face width.
*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Stringer Bead Twist Wheels - Polyflex® Encapsulated
Black Elastomer (Extra Heavy-Duty). Elastomer gradually wears exposing consistent short trim for maximum aggression and long life. For hot pass through cap pass weld cleaning.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
4"	.020	5/8"-11 UNC	32	3/16"	7/8"	7/16"	20,000	PSTBA-432	35800
6"	.014	5/8"-11 UNC	–	3/16"	1-7/16"	3/8"	9,000	PSTB-6-HD	35206*
6-7/8"	.020	5/8"-11 UNC	56	3/16"	1-1/8"	7/16"	9,000	PSTB-756-BG	35600+
7"	.014	5/8"-11 UNC	–	3/16"	1-15/16"	3/8"	9,000	PSTB-7-HD	35216*

*Crimped wire +Patented

Knot Wire Cup Brushes

Removing paint from a metal surface with a crimped wire cup brush.

Applications

- Heavy-duty cleaning of large metal surfaces
- Cleaning prior to welding
- Weld scale and corrosion removal
- Rust and paint removal
- Roughening
- Deburring

Crimped Wire Cup Brushes

For light to medium duty, general purpose applications.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.0118	5/8"-11 UNC	1-3/8"	9,000	CR-4	14016	–
	.014					14026	–
	.020					14036*	14126
5"	.014	5/8"-11 UNC	1-¼"	8,000	CR-5	14206	–
	.020					14216	14256
6"	.014 .020	5/8"-11 UNC	1-¼"	6,600	RCR-6	14066+ 14076*+	– 14166+

*Available in Display Packaging. Add "P" to end of Part No. when placing order.
+With internal nut.

Crimped Wire Cup Brush - Non-Sparking

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Bronze	Part No. Brass
3"	.020	5/8"-11 UNC	7/8"	14,000	CRA-2	13231	–
4"	.020	5/8"-11 UNC	1-3/8"	9,000	CR-4	14616	–
5"	.014	5/8"-11 UNC	1-¼"	8,000	CR-5	–	14606
6"	.020	5/8"-11 UNC	1-¼"	6,600	RCR-6	14316*	–

*With internal nut

Cup Brushes - Polyflex® Encapsulated

Burgundy Elastomer - Standard. Elastomer gradually wears exposing consistent short trim for maximum aggression and long life.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel
4"	.020	5/8"-11 UNC	1-1/8"	9,000	PCR-4	35186
6"	.020	5/8"-11 UNC	1-¼"	6,000	PRCR-6	35006
Orange Elastomer - Heavy-Duty						
6"	.020	5/8"-11 UNC	1-¼"	6,000	PRCR-6-HD	35530
Black Elastomer - Extra Heavy-Duty						
6"	.020	5/8"-11 UNC	1-¼"	6,000	PRCR-6-BG	35760

Knot Wire Cup Brushes - Single Row - General Duty

For fast cleaning of large surfaces.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
3-½"	.014 .020	5/8"-11 UNC	1-¼"	9,000	SR-3	12736 12746	– –
4"	.014 .023 .035	5/8"-11 UNC	1-¼"	9,000	SR-4	12306 12316 † 12326	12406 12416 –
4"	.023	5/8"-11 UNC	1-¼"	9,000	SRC-4	12206◊	–
4"	.023	5/8"-11 UNC	1-¼"	9,000	RSR-4	12826*	–
5"	.014 .023	5/8"-11 UNC	1-3/8"	7,000	RSR-5	12256* 12276 †*	– –
6"	.014 .023 .035	5/8"-11 UNC	1-3/8"	6,600	SR-6	12356+ 12376 †+ 12396+	12456+ 12476+ –
6"	.023	5/8"-11 UNC	1-3/8"	6,600	RSR-6	12816 †*	–
6"	.014 .023 .035	5/8"-11 UNC	1-5/8"	6,000	SRF-6	12846+ 12856+ 12866+	– 12886+ –

* With internal nut
\+ Patented
◊ Cable Twist
† Available in Display Packaging. Add "P" to end of Item No. when placing order.

Knot Wire Cup Brushes

Removing rust and a label from a 55 gallon drum lid.

Knot Wire Cup Brushes - 1-½" Rows - For line traveling machines.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel
4"	.023	5/8"-11 UNC	1-¼"	7,000	RDR-4-LT	94012*
6"	.030	5/8"-11 UNC	1-3/8"	4,000	RDR-6-LT	94092*

* With internal nut

Knot Wire Cup Brushes - Double Row - Heavy-Duty
For aggressive action in severe applications.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.014 .020	5/8"-11 UNC	1-¼"	9,000	DR-4	12756 12766	– 12726
6"	.014 .023 .035	5/8"-11 UNC	1-3/8"	6,600	DR-6	12536* 12556* 12576*	– 12636* –
6"	.014 .023 .035	5/8"-11 UNC	1-½"	6,000	DRF-6	12906* 12916* 12926*	– – –

* Patented

Knot Wire Cup Brushes - Double Row - Banded - Extra Heavy-Duty
Banded brushes provide shorter trim for maximum aggression.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel
4"	.020	5/8"-11 UNC	7/8"	9,000	DR-4-HD	12796
6"	.023 .035	5/8"-11 UNC	7/8"	6,600	DR-6-HD	12676 12686

Knot Wire Cup Brushes - Banded - Extra Heavy-Duty

Dia.	Wire Size	Arbor Hole	Trim* Length	Max. RPM	Ref. Code	Std. Pkg.	Part No. Steel	Part No. Stainless
2-¾"	.014 .020	5/8"-11 UNC	5/8"	12,500	SRA-2-HD	1	13300 13301	– 13302
4"	.023	5/8"-11 UNC	7/8"	9,000	SR-4-HD	1	12301	–

* Trim length from band

Mighty-Mite® - Brushes For Small Angle Grinders

Knot Wire Wheels - Standard Twist
Rugged knot-type construction provides aggressive, high-impact action for severe applications.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
3"	.014	3/8"-24 UNF	20	3/8"	5/8"	7/16"	25,000	STA-3	13201	13208
4"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	24	½"	7/8"	7/16"	20,000	STA-4	13100 13101 13102 13103 13105 13106*	13107 13108 13109 13110 13112 13113*
4"	.020	M10 x 1.25 M14 x 2.0 ½"-13 UNC 5/8"-11 UNC	24	½"	7/8"	7/16"	20,000	STA-4	13114 13116 13119 13120	– – – –

Weiler's Mighty Mite® Brushes are specifically designed for smooth, yet aggressive brushing action on small angle grinders.

* Available in Display Packaging. Add "P" to end of Item No. when placing order.

Small Angle Grinder Reference Chart

Weiler's Mighty-Mite® brushes can be used on the following small angle grinders.

Manufacturer	Model No.	Male Thread Size	Grinder Size	RPM
AEG	WS601	5/8"-11 UNC	4-½"	10,000
Black & Decker	6246	M10 x 1.50	4"	10,000
	2750/2750G	5/8"-11 UNC	4-½"	10,000
	4252	5/8"-11 UNC	5"	10,000
	7750	5/8"-11 UNC	4-½"	10,000
	G750/G850	5/8"-11 UNC	4-½"	10,000
	FS6500AG	5/8"-11 UNC	4-½"	10,000
	G950	5/8"-11 UNC	4-½"	10,000
Bosch	1347A	5/8"-11 UNC	4-½"	11,000
	1375/1375A	5/8"-11 UNC	4-½"	11,000
	1700/1710D	5/8"-11 UNC	4-½"	11,000
	1800/1810PS	5/8"-11 UNC	4-½"	11,000
	1701/1711D	5/8"-11 UNC	5"	11,000
	1703EVS	5/8"-11 UNC	5"	11,000
	1711/1801	5/8"-11 UNC	5"	11,000
	1811PS	5/8"-11 UNC	5"	11,000
	1803EVS	5/8"-11 UNC	5"	11,000
	1347	M14 x 2.0	4-½"	11,000
	1348/1348E	M14 x 2.0	5"	11,000
	1347A/1348AE	5/8"-11 UNC	5"	11,000
	7352-111 Air	M14 x 2.0	5"	12,000
DeWalt	DW831	5/8"-11 UNC	5"	10,000
	DW802G	5/8"-11 UNC	4-½"	10,000
	D28110	5/8"-11 UNC	4-½"	11,000
	D28402/D28112	5/8"-11 UNC	4-½"	11,000
	D28114	5/8"-11 UNC	4-½" / 5"	11,000
	D28131	5/8"-11 UNC	4-½" / 5"	11,000
	DW402/DW400	5/8"-11 UNC	4-½"	10,000
Hilti	AG 125-SE	M14	5"	11,000
	AG 125-S	M14	5"	11,000
	DEG 500-D	5/8"-11 UNC	5"	11,000
	HG 500-D	5/8"-11 UNC	5"	11,000
	DC 500-S	5/8"-11 UNC	5"	11,000
	DAG 450-S	5/8"-11 UNC	4-½"	11,000
	DAG 451-S	5/8"-11 UNC	4-½"	11,000
	HG450	5/8"-11 UNC	4-½"	11,000
	HG500/DC500	5/8"-11 UNC	5"	11,000
Hitachi	G10SR2	M10 x 1.50	4"	11,000
	G12SA3/G12SE2	5/8"-11 UNC	4-½"	10,000
	G12SR2	M10 x 1.50	4"	11,000
	G135C2	5/8"-11 UNC	4-½"	10,000
	G10SD1	M10 x 1.50	4"	11,000
	G12SA	5/8"-11 UNC	4-½"	10,000
	G12S1	5/8"-11 UNC	4-½"	11,000
	G13SC	5/8"-11 UNC	5"	11,000
Ingersoll-Rand	AG230P64	3/8"- 24 UNC	4"	12,000
	AG230P1045	5/8"-11 UNC	4-½"	12,000
	AG230P105	5/8"-11 UNC	5"	12,000
	3445	5/8"-11 UNC	4-½"	12,000
	TA120RP64	3/8"- 24 UNC	4"	12,000
	HA120RP64	3/8"- 24 UNC	4"	12,000
	HA120RP1045	5/8"-11 UNC	4-½"	12,000
	IR344	3/8"- 24 UNC	4"	13,500
Jepson	4601	M10 x 1.50	4"	11,000
	4205	5/8"-11 UNC	5"	10,000
	4105N	M14	5"	10,000
	4045	5/8"-11 UNC	4-½"	11,000
	4050	M14	5"	11,000
Jet	JSM-619	3/8"- 24 UNC	4"	
	JSM-6195B	5/8"-11 UNC	5"	11,500
	JEG-400HD	3/8"-16 UNC	4"	11,500
	JEG-450	5/8"-11 UNC	4-½"	9,800
	JEG-500	5/8"-11 UNC	5"	

Manufacturer	Model No.	Male Thread Size	Grinder Size	RPM
Makita	9553NB	M10 x 1.25	4"	11,000
	9564	5/8"-11 UNC	4-½"	10,500
	9527PB/9557PB	5/8"-11 UNC	4-½"	10,000
	9557NB	5/8"-11 UNC	4-½"	11,000
	9554NB	5/8"-11 UNC	4-½"	10,000
	9558NB	5/8"-11 UNC	5"	11,000
	9565	5/8"-11 UNC	5"	10,500
	9015A/9558PB	5/8"-11 UNC	5"	10,000
	9005B	5/8"-11 UNC	5"	10,000
	9514B	M10 x 1.25	4"	11,000
	9501BZ	M10 x 1.25	4"	10,000
	9501BKW	M10 x 1.25	4"	10,000
	9526PB	M10 x 1.50	4"	10,000
	9503BHZ	5/8"-11 UNC	4-½"	10,000
	9527PB	5/8"-11 UNC	4-½"	10,000
	9505BHZ/9528PB	5/8"-11 UNC	5"	10,000
Metabo	W 7-115	5/8"-11 UNC	4-½"	10,000
	W 7-125	5/8"-11 UNC	5"	9,000
	WE 9-125	5/8"-11 UNC	5"	10,000
	W 10-125	5/8"-11 UNC	5"	10,000
	WE 14-125	5/8"-11 UNC	5"	10,500
	W14-125	5/8"-11 UNC	5"	10,000
	7010	M14 x 2.0	4-½"	10,000
	6014/7015	5/8"-11 UNC	4-½"	10,000
	EWE9125S	5/8"-11 UNC	4-½"	1,750-8,000
	11025	5/8"-11 UNC	4-½"/5"	10,000
	7026/10125	5/8"-11 UNC	5"	8,500
	9023	5/8"-11 UNC	5"	10,000
	9025	5/8"-11 UNC	5"	10,000
	11050	5/8"-11 UNC	6"	8,500
	7016	5/8"-11 UNC	4-½"	1,750-8,000
Milwaukee Electric Tool	6140	5/8"-11 UNC	4-½"	10,000
	6145	½"-13 UNC	4-½"	10,000
	6148-6	5/8"-11 UNC	4-½"	10,000
	6141	5/8"-11 UNC	5"	10,000
	6149-20	5/8"-11 UNC	5"	10,000
	6151	5/8"-11 UNC	4-½"	10,000
	6153-20	5/8"-11 UNC	4-½"	11,000
	6154-20	5/8"-11 UNC	4-½"	11,000
	6155-20	5/8"-11 UNC	5"	11,000
	6156-20	5/8"-11 UNC	5"	11,000
	6140/6142	5/8"-11 UNC	4-½"	10,000
	6145	½"-13 UNC	4-½"	10,000
	6146	½"-13 UNC	5"	10,000
Porter Cable	749/8749	M14 x 2.0	4-½"	12,000
	7406	5/8"-11 UNC	4-½"	10,000
	7405	5/8"-11 UNC	5"	10,000
Ryobi	AG401	5/8"-11 UNC	4"	11,000
	AG450	5/8"-11 UNC	4-½"	11,000
	SG-1000K	3/8"-16 UNC	4"	11,000
	G -1155-C	5/8"-11 UNC	4-½"	11,000
	G -1125-C	5/8"-11 UNC	5"	10,000
Sioux	1240	M10 x 1.50	4-½"	11,000
	1240A	M10 x 1.25	4-½"	11,000
	1245	5/8"-11 UNC	5"	10,000
Skil	9290-01	5/8"-11 UNC	4-½"	11,500
	9330-01	5/8"-11 UNC	4-½"	11,000
	9325-01	3/8"-16 UNC	4-½"	11,000
	9410/(9410:02)	M10 x 1.50	4-½"	12,000
	9310/9415	5/8"-11 UNC	4-½"	11,000
	9611/(9611:02)	5/8"-11 UNC	4-½"	12,000
	HD9611	5/8"-11 UNC	4-½"	12,000

Mighty-Mite® - Brushes For Small Angle Grinders

Removing rubber coating from a roller.

Applications

- Roughening
- Deburring
- Cleaning prior to welding
- Rust and paint removal
- Weld scale, weld spatter and corrosion removal
- Surface conditioning
- Surface prep prior to painting

Knot Wire Wheels - Cable Twist

Maximum impact for extremely severe applications.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.020	M10 x 1.25 M10 x 1.50 M14 x 2.0 5/8"-11 UNC	24	1/4"	7/8"	7/16"	20,000	CTA-4	13261 13262 13263 13266*	– – – 13276

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Knot Wire Wheels - Stringer Bead Twist

For hard-to-reach areas; primarily for weld cleaning.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
4"	.020	1/2"-3/8"	32	3/16"	7/8"	7/16"	20,000	STB-432	13124	08954
4"	.020	M10 x 1.25	32	3/16"	7/8"	7/16"	20,000	STBA-432	13125*	13132
		M10 x 1.50							13126*	13133
		M14 x 2.0							13127	13134
		3/8"-24 UNF							13128	13135
		1/2"-13 UNC							13130*	13137
		5/8"-11 UNC							13131*	13138*

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Knot Wire Wheel - Stringer Bead Twist - Polyflex® Encapsulated

Black Elastomer (Extra Heavy-Duty). Elastomer gradually wears exposing consistent short trim for maximum aggression and long life.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
4"	.020	5/8"-11 UNC	32	3/16"	7/8"	7/16"	20,000	PSTBA-432	35800

Crimped Wire Wheels - Narrow Face Flexible brushing action.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Thickness at Face Plates	Max. RPM	Ref. Code	Part No. Steel
4"	.014	M10 x 1.25 5/8"-11 UNC	1/2"	7/8"	7/16"	14,000	TLNA-4	13075 13081

Mighty-Mite® Adapters

For Cup or Wheel Brushes

Fixed Thread Size	Adapted Thread Size	Item No.
5/8" - 11 UNC	M10 x 1.25	07771*
5/8" - 11 UNC	M10 x 1.50	07772*
5/8" - 11 UNC	3/8" - 16 UNC	07769
5/8" - 11 UNC	3/8" - 24 UNF	07746

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Crimped Wire Wheel - Polyflex® Encapsulated - Narrow Face

Burgundy Elastomer (Standard). Elastomer gradually wears exposing consistent short trim for maximum aggression and long life.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Thickness at Face Plate	Max. RPM	Ref. Code	Part No. Steel
4"	.014	5/8"-11 UNC	1/2"	7/8"	7/16"	14,000	PTLNA-4	35416

Mighty-Mite® - Brushes For Small Angle Grinders

Cleaning a weld with a Mighty-Mite® knot wheel brush.

Knot Wire Bevel Brushes

Maximum aggression for cleaning in corners.

Dia.	Wire Size	Arbor Hole	No. of Knots	Face Width	Trim Length	Max. RPM	Part No.	
							Steel	Stainless
4"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 5/8"-11 UNC	20	3/8"	¾"	12,500	13401 13402 13403 13406	13411 13412 13413 13416
4"	.020	M10 x 1.25 M10 x 1.50 M14 x 2.0 5/8"-11 UNC	20	3/8"	¾"	12,500	13421 13422 13423 13426	13431 13432 13433 13436
4-½"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 5/8"-11 UNC	20	3/8"	1"	12,500	13451 13452 13453 13456	13461 13462 13463 13466
4-½"	.020	M10 x 1.25 M10 x 1.50 M14 x 2.0 5/8"-11 UNC	20	3/8"	1"	12,500	13471 13472 13473 13476	13481 13482 13483 13486

Knot Wire Cup Brushes - Single Row

For fast cleaning of large surfaces.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No.	
						Steel	Stainless
2-¾"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	1"	14,000	SRA-2	13015 13016 13020 13021 13023 13025*	– – – – – –
2-¾"	.020	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	1"	14,000	SRA-2	13281* 13282 13283 13284 13285 13286*	13253 13254 13255 13256 13257 13258
3-½"	.023	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	7/8"	13,000	SRA-3	13150 13151 13152 13153 13155 13156*	13157 13158 13159 13160 13162 13163

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

Mighty-Mite® - Brushes For Small Angle Grinders

Removing slag from the edge of a flame-cut steel plate.

Crimped Wire Cup Brushes

For light to medium duty, general purpose applications.

Dia.	Wire Size	Arbor Hole	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
3"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	1"	14,000	CRA-2	13240* 13241 13242 13243 13244 13245*	– – – – – –
3-½"	.014	M10 x 1.25 M10 x 1.50 M14 x 2.0 3/8"-24 UNF ½"-13 UNC 5/8"-11 UNC	7/8"	12,000	CRA-3	13175 13176 13177 13178 13180 13181*	13182 13183 13184 13185 13187 13188

*Available in Display Packaging. Add "P" to end of Item No. when placing order.

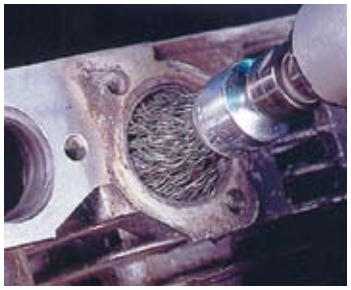
Crimped Wire Bevel Brushes

Aggressive cleaning action in corners.

Dia.	Wire Size	Arbor Hole	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel
3-3/8"	.0118	M10 x 1.25 ½" - 13 UNC 5/8"-11 UNC	½"	½"	12,500	BV-3	13091 13094 13095

Stem-Mounted Brushes - ¼" Stems

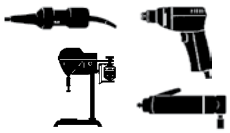
Weiler's Stem-Mounted Brushes are permanently mounted on ¼" steel stems, providing quick installation on chuck or collet. High RPM ratings provide faster finishing for the lowest cost-per-piece brushed.



Cleaning the exhaust port on a gasoline engine.

Applications

- Cleaning and finishing recessed areas or I.D.s
- Die, mold and tool cleaning and polishing
- Rubber and plastic flash removal
- Rust and paint removal
- Scale and slag removal
- I.D. pipe cleaning
- Carbon cleaning
- Weld cleaning
- Deburring
- Spot facing



Crimped Wire End Brushes - Solid End

For light duty, general purpose applications.

Dia.	Wire Size	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
½"	.006 .0104 .014 .020	7/8"	25,000	EBA-20	10001 10002 10003 10004	10013 10014 10015 10016
¾"	.006 .0104 .014 .020	7/8"	22,000	EBA-21	10005 10006 10007 10008*	10017 10018 10019 10020
1"	.006 .0104 .014 .020	1" 1-1/8"	22,000	EBA-22	10009 10010 10011 10012*	10021 10022 10023 10024

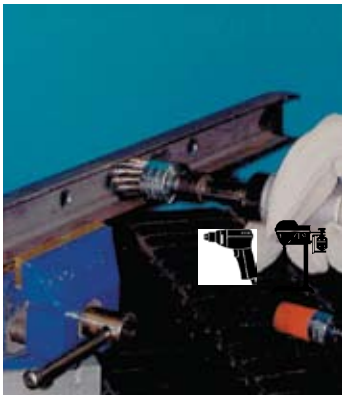
*Available in Display Packaging. Add "P" to end of Part No. when placing order.

Safety Tip For Mounting End Brushes

Mount the brush on the straight portion of the stem, not the curved portion.

End Brush Chucked Incorrectly

Stem-Mounted Brushes - ¼" Stems



Deburring edges of holes drilled in a C-channel.

Knot Wire End Brushes - Hollow End

Rugged knot-type construction provides aggressive, high-impact action for severe applications.

Dia.	Wire Size	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
¾"	.014	7/8"	22,000	EBB-40	10025*	10029
	.020				10026*	10030
1-1/8"	.014	7/8"	22,000	EBB-41	10027*	10031
	.020				10028*	10032

* Available in Display Packaging. Add "P" to end of Item No. when placing order.

Conflex Brushes - Narrow Face Crimped Wire Wheels

For light-duty brushing action.

Dia.	Wire Size	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
2"	.006	3/8"	½"	20,000	CFX-2	17609	–
	.0118					17610	17611
3"	.008	½"	1"	20,000	CFX-3	17615	–
	.0118					17616	–
	.014					17617	17618

Conflex Brushes - Wide Face Crimped Wire Wheels.

Covers a broader surface area.

Dia.	Wire Size	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel	Part No. Stainless
1-½"	.008 .0118	½"	½"	20,000	CFX-1-1/2	17603 17604	– –
2"	.0118	¾"	7/16"	20,000	CFX-2	17619	–
3"	.008 .0118 .014	1"	15/16"	20,000	CFX-3	17621 17622 17623	17637 – –

Knot Wire Wheels - Standard Twist

Rugged knot-type construction provides aggressive, high-impact action for severe applications.

Dia.	Wire Size	Face Width	Trim Length	Max. RPM	Ref. Code	Part No. Steel
3-¼"	.0118 .014 .020	3/8"	5/8"	25,000	STM-3	17680 17681 17682
4"	.0118 .014 .020	½"	7/8"	20,000	STM-4	17686 17687 17689

Crimped Wire Cup Brushes

For general purpose applications.

Dia.	Wire Size	Trim Length	Max. RPM	Ref. Code	Part No. Steel
1-¾"	.0118	¾"	13,000	UC-14	14301
2-¾"	.0118	7/8"	6,000	UC-22	14302

Power and Hand Tube Brushes

Crosshole deburring an aluminum manifold.

Applications

- Deburring and cleaning drilled holes and internal threads
- Cleaning and finishing internal diameters of pipes and tubes
- Deburring and cleaning internal keyways and grooves
- Carbon removal
- Crosshole deburring

Double Stem, Double Spiral

Use with power tools for heavy-duty cleaning and deburring.

Dia.	Wire Size	Brush Part	Stem Dia.	Overall Length	Ref. Code	Part No.	
						Steel	Stainless
5/8"	.008	2"	7/32"	5"	DS-5/8	21109	21119
¾"	.006 .008 .0104	2-½"	¼"	5-½"	DS-¾	21110 21247 21111	– – 21121
1"	.0104	2-½"	¼"	5-½"	DS-1	21115	–

Nylon Tube Brushes

Loop Handle, Straight Black Nylon Fill

Dia.	Fill Dia.	Brush Part	Stem Dia.	Overall Length	Ref. Code	Part No.
¼"	.005	2"	3/32"	6-¼"	NN-28	44110
3/8"	.005	2"	3/32"	6-¼"	NN-38	44213
½"	.010	3"	1/8"	8-½"	NN-48	44111
¾"	.012	3"	1/8"	8-½"	NN-68	44112
1"	.014	4"	5/32"	12-¼"	NN-88	44113
1-¼"	.014	4"	5/32"	13"	NN-128	44114
2"	.014	5"	3/16"	16-¾"	NN-168	44115

Power and Hand Tube Brush Selection Tips

- A flat burrite style tube brush is most effectively used with a holder on blind, threaded holes.
- A round tube brush is most effectively used fully chucked on smooth or threaded blind holes.
- A single stem, single spiral tube brush is most effectively used for manual or hand cleaning applications.
- A double stem, double spiral tube brush is most effectively used with power tools for heavy-duty cleaning and deburring.
- A Polyflex® Encapsulated double stem, double spiral tube brush is most effectively used on power tools for very aggressive cleaning and deburring applications.

Tube Brush Operating Recommendations

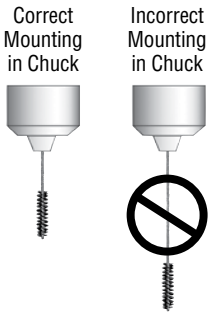
The stems in power tube brushes are not as strong as the stems in most other brushes. Therefore, it is very important to avoid any load conditions and brush speeds that can cause excessive stem deflections and destructive bending.

A suggested guideline to avoid this unsafe condition is minimizing the overhang of the stem to under an inch, and running the brush at speeds below 2,000 RPM.

Increasing overhang could decrease the safe speed at which the brush can operate. To reach into deeper holes, use drill extension rods instead of increasing stem overhang.

Before Starting the Brush:

- Secure brush in chuck
- Ensure clockwise brush rotation (running the brush counter-clockwise could cause the brush to fall apart.)
- Clamp work securely.
- Position all guards in place.
- Align brush with the work so the brush rotates on its true centerline to prevent any stem deflections.
- Guide the brush into the hole before starting the brush rotation.
- Always wear eye protection.



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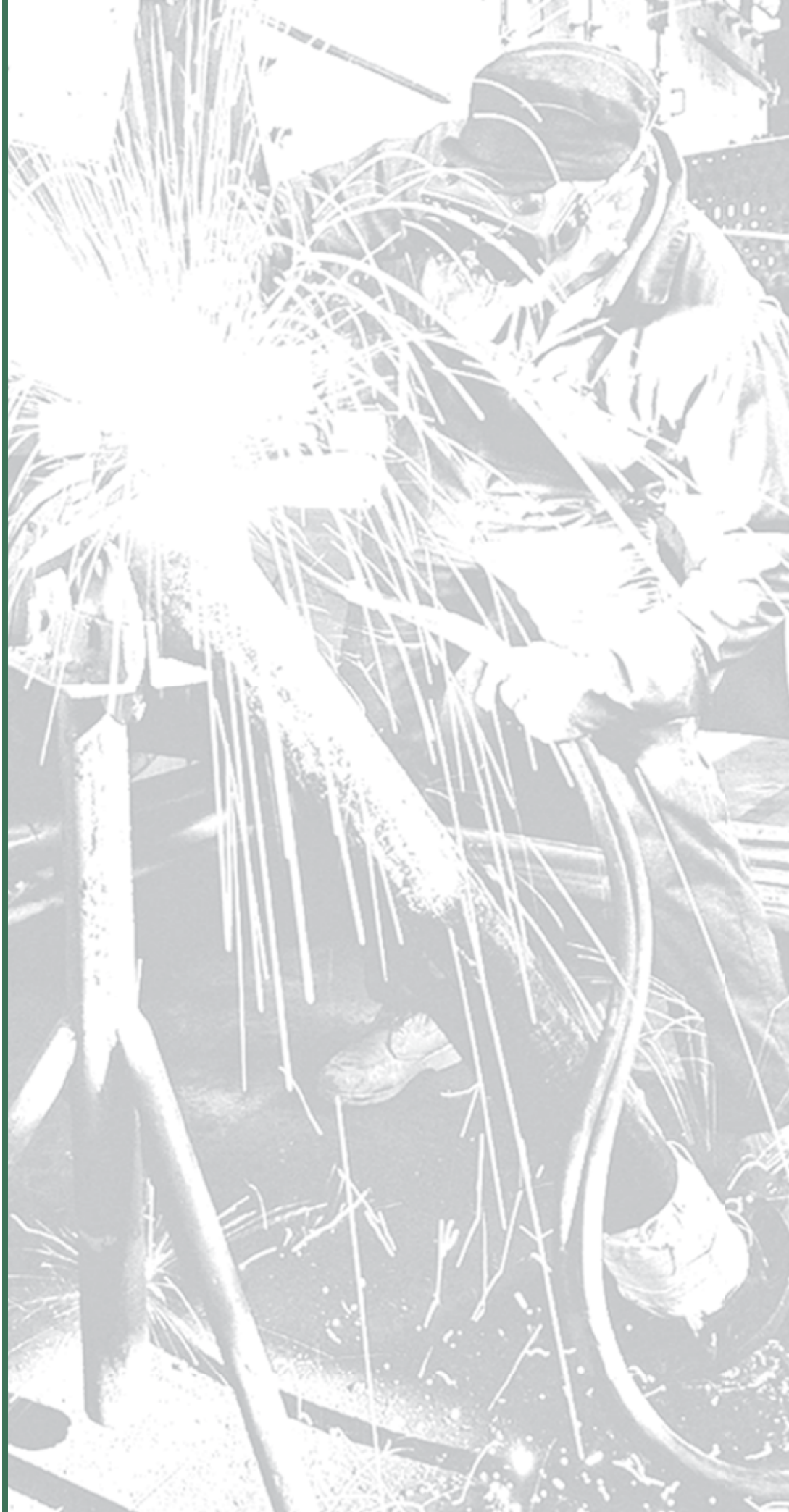
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