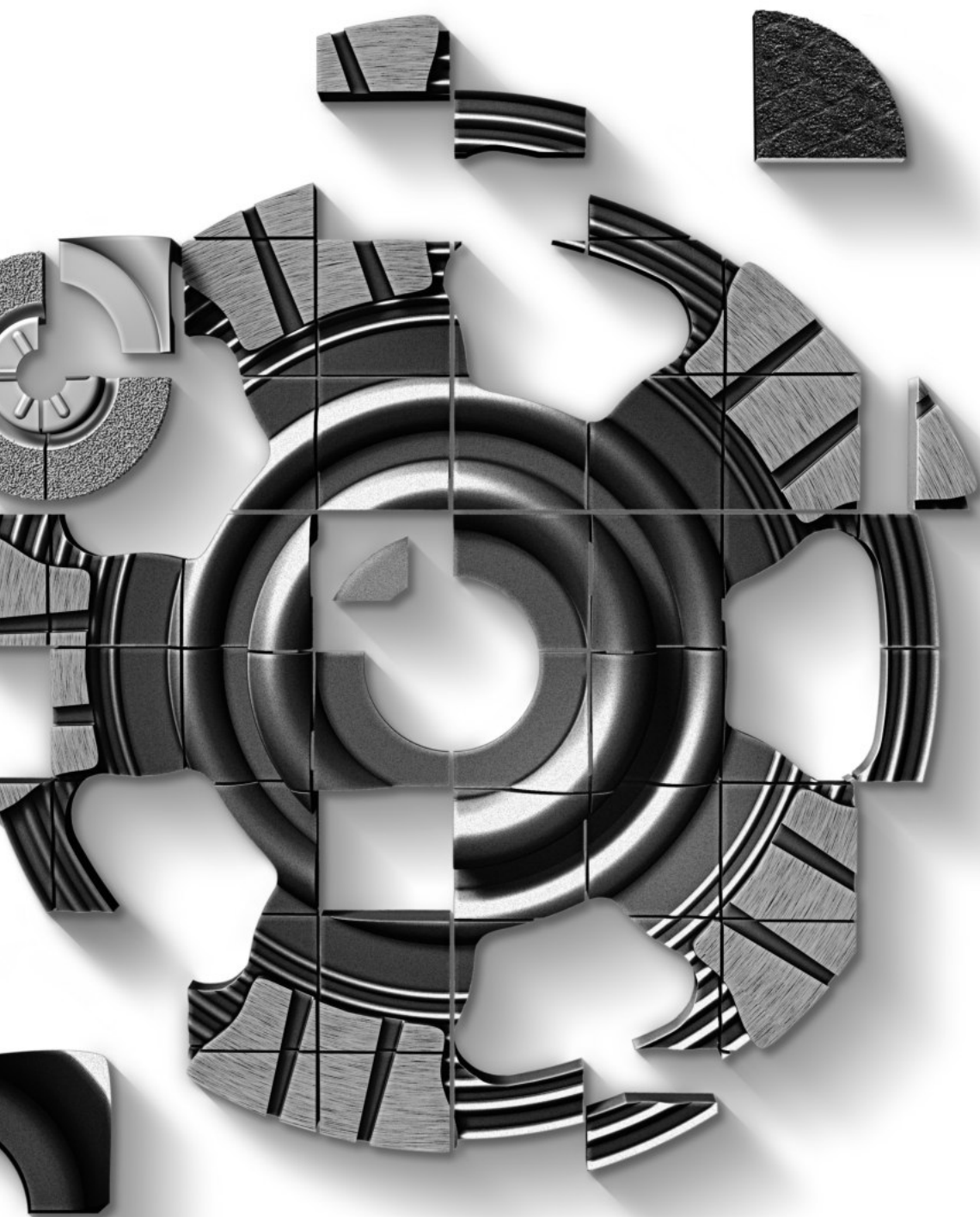


ROUGH GRINDING



6.1 Grinding discs

1–10

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS grinding discs

SHELF LIFE

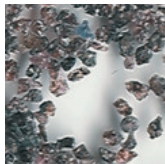
Resin-bonded grinding discs for handheld use may only be used up to three years after the manufacture date. The expiry date (month and year) is stamped on the metal ring, e.g. V07/2022.



LABELLING SYSTEM FOR RESIN-BONDED GRINDING DISCS

All of the important quality information about your LUKAS grinding disc is stated on the label: abrasive material, grit size, hardness and type of bond.

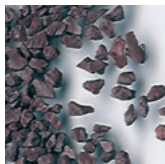
The following overview provides all the information concerning the abbreviations and markings.



A
Semi-friable
aluminium oxide



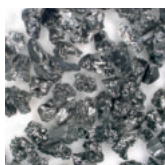
Z
Zirconia alumina



A
Ceramic-coated
annealed aluminium
oxide



CER
Ceramic grain



C
Silicon carbide

ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

| Abrasive | |
|----------|------------------|
| A | Aluminium oxide |
| C | Silicon carbide |
| Z | Zirconia alumina |
| CER | Ceramic grain |

GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

| coarse | medium | fine |
|----------|----------|-----------|
| 12 to 24 | 36 to 54 | 60 to 120 |

HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

| soft | medium | hard |
|------|--------|------|
| M | R | U |
| P | S | V |
| Q | T | Z |

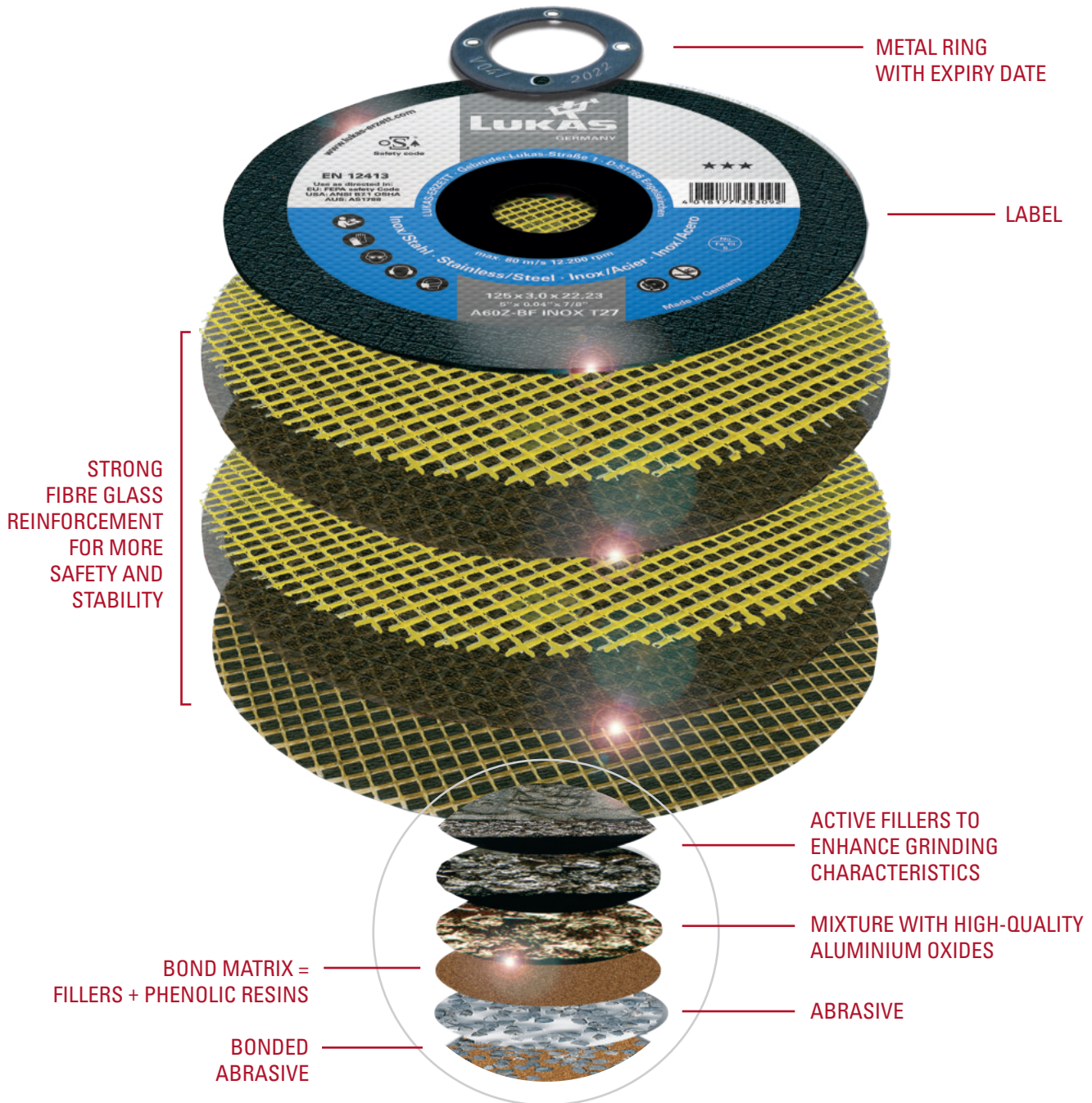
BOND

The bond holds the abrasive grain to the grinding disc. LUKAS grinding discs are available with the following bonds:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

TECHNICAL INFORMATION

Construction and components of LUKAS grinding discs



OPERATING SPEED

LUKAS grinding discs are developed and tested for specified maximum operating speeds and grinding processes. Before fixing the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the grinding disc.

| Maximum operating speed | Grinding disc diameter (mm) | | | | | | | | | | |
|-------------------------|-----------------------------|--------|--------|--------|--------|--------|--------|-------|-------|-------|-------|
| | 50 | 76 | 100 | 115 | 125 | 150 | 180 | 230 | 300 | 350 | 400 |
| 80 m/s | 30,500 | 20,100 | 15,300 | 13,300 | 12,200 | 10,200 | 8,500 | 6,600 | 5,100 | 4,400 | 3,800 |
| 100 m/s | 38,200 | 25,100 | 19,100 | 16,650 | 16,600 | 12,700 | 10,600 | 8,300 | 6,400 | 5,400 | 4,700 |
| rpm | | | | | | | | | | | |

WORK SAFETY

Safely grinding with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

APPLIED STANDARDS

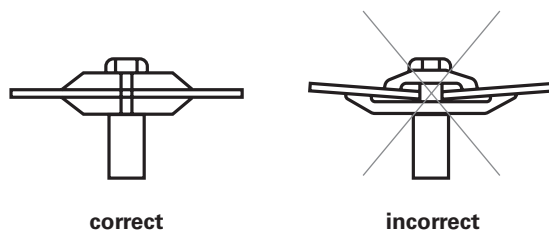
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced grinding discs on power tools.
- Store discs **in a dry place at room temperature.**
- Don't **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Only use discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Avoid bending the disc.
- Don't press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Don't cant and seize** the disc **when** grinding.
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Don't drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage. When grinding with a depressed centre grinding disc, maintain an angle of more than 20° to the workpiece.
- Use the machine only in a position where you have full control and are well balanced.




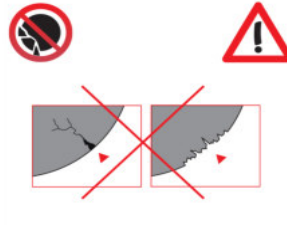
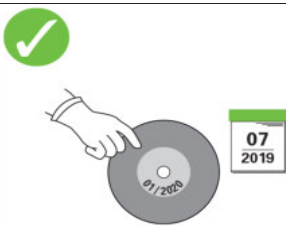

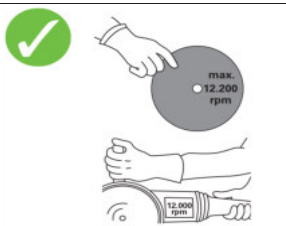



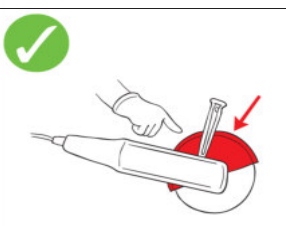
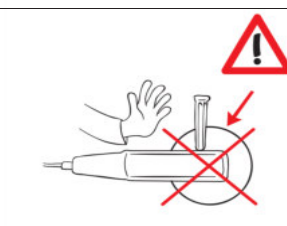
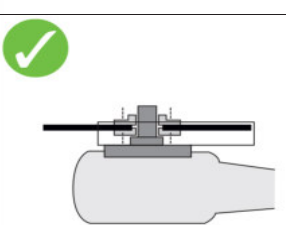
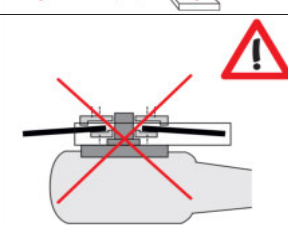
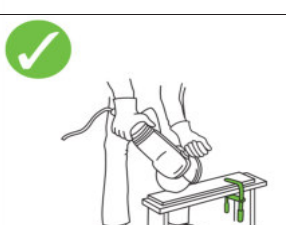


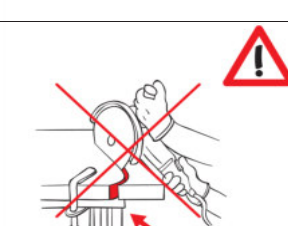
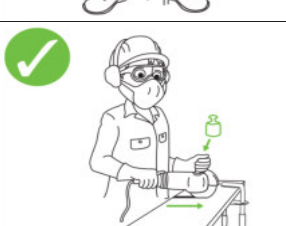




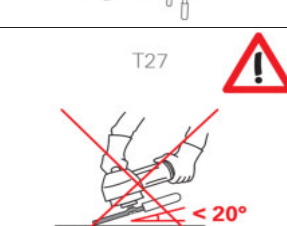
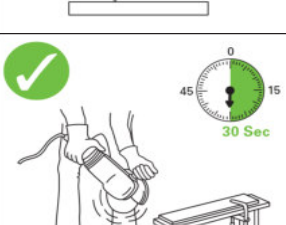
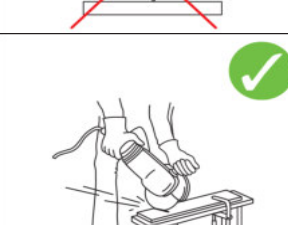






CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).



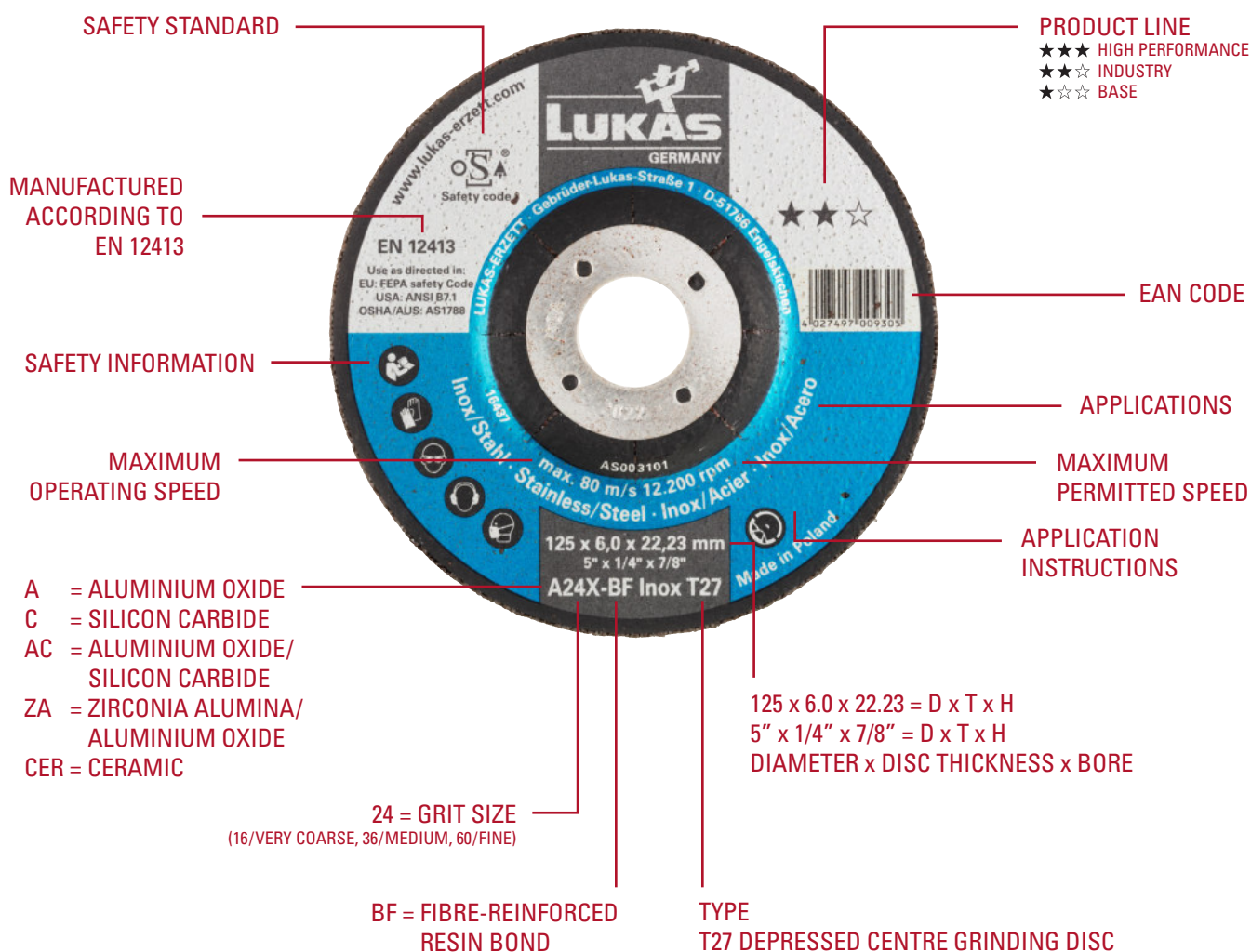
WORK SAFETY

Safe instructions

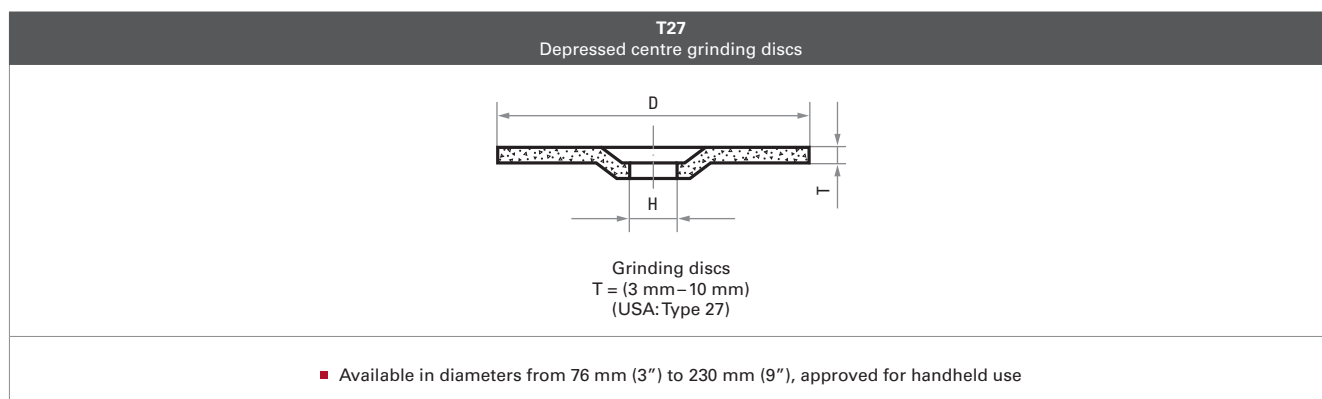
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LABELLING

All important markings on the label




TYPES OF RESIN-BONDED GRINDING DISCS



AREA OF USE

Overview of types of LUKAS grinding discs

■ best suitable ■ suitable

| Type | Page | Reference/ Qualities | Product line | Materials | | | | | | | |
|---|------|-------------------------|--------------|---|--------------------------|--------------------------------|----------------|---|-----------------------------------|-----------|----------------------------------|
| | | | | ● | ● | ● | ● | ● | ● | ● | ● |
| | | | | Inox/Stainless- Rust- acid- and heat-resistant steel | General purpose Steel | Alloyed/ tempered steels | Tool steels | Aluminium, magnesium and copper alloys | Stone/ Construc- tion material | Cast iron | Titanium and nickel alloys |
| Handheld cutting discs for angle grinders Diameter 100–230 mm  | 8 | A24X-BF Inox | ★★☆ | ■ | ■ | ■ | ■ | ■ | | | |
| | 9 | A24X-BF Steel | ★★★ | | ■ | | | | | ■ | |
| | 10 | A30T-BF Steel | ★★☆ | | ■ | ■ | ■ | | | | |
| | 10 | A30V-BF Steel | ★★☆ | | ■ | ■ | ■ | | ■ | | |
| | 10 | A24/30S-BF Steel | ★★☆ | | ■ | ■ | ■ | | | | |
| | 10 | A24V-BF Steel | ★★☆ | | ■ | ■ | ■ | | | | |
| | 10 | A24/30S-BF Steel | ★☆☆ | | ■ | ■ | ■ | | | | |

THE PERFECT ALTERNATIVE TO THE GRINDING
DISC: THE iQ-SERIES FLAP DISK FROM LUKAS!
GO TO **SECTION 4.1 PAGES 6–18** AND TEST THEM



LUKAS GRINDING DISCS IN 3-STAR QUALITY

EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE

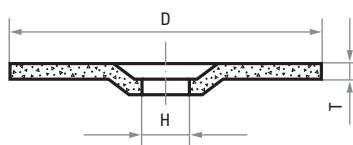
Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS grinding discs achieve the ultimate results. The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star grinding discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety. Eco-friendly production combined with first-class raw materials, optimised formulas and the state-of-the-art production processes provide for high quality and a maximum storage time.

- maximum tool life and grinding performance with innovative bonding technology
- high maximum speed at a cool grinding temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in quality owing to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of Inox and steel materials

Grinding disc for machining stainless steel



★★☆



- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows ergonomic working with little use of force

| Product number | Description | Quality | D mm | T mm | H mm | n _{max} rpm | Pack contains |
|-----------------|--------------------------|-----------------|------|------|-------|----------------------|---------------|
| 5DA115702204024 | T27 115x6.0 A24X Inox | A24X-BF Inox | 115 | 6.0 | 22.23 | 13,300 | 10 |
| 5DA178652218251 | T27 178x6.5 A24/30S Inox | A24/30S-BF Inox | 178 | 6.5 | 22.23 | 8,500 | 10 |
| 5DA230702204024 | T27 230x6.0 A24X Inox | A24X-BF Inox | 230 | 6.0 | 22.23 | 6,600 | 10 |

Recommended for: ● Inox/Steel ● Steel ● Aluminium

TWO WORK STEPS WITH ONE TOOL

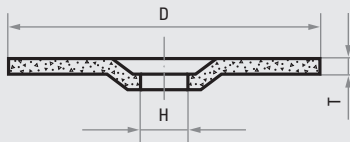
CUTTING AND GRINDING WITHOUT CHANGING TOOLS: THE COOL JOBBER FROM LUKAS



PRACTICAL, PRECISE AND SAFE! DISCOVER THE LUKAS COOL JOBBER **IN SECTION 5.1 ON PAGE 8**



- optimised for precise machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomic working with little use of force



Grinding disc for machining steel

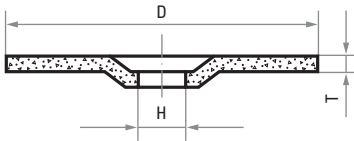


★★★

| Product number | Description | Quality | D mm | T mm | H mm | n _{max} rpm | Pack contains |
|-----------------|---------------------------|---------------|------|------|-------|----------------------|---------------|
| 5DA115702208024 | T27 115x7.0 A24X BF Steel | A24X-BF Steel | 115 | 7.0 | 22.23 | 13,300 | 10 |
| 5DA230702208024 | T27 230x7.0 A24X BF Steel | A24X-BF Steel | 230 | 7.0 | 22.23 | 6,600 | 10 |

Recommended for: ● Steel

Grinding disc for machining steel



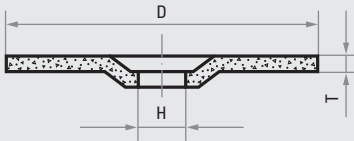
★★☆

- cut steel with ease
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

| Product number | Description | Quality | D mm | T mm | H mm | n _{max} rpm | Pack contains |
|-----------------|------------------------------|------------------|------|------|-------|----------------------|---------------|
| 5DA100601615051 | T27 100x6.0 A30T-BF Steel | A30T-BF Steel | 100 | 6.0 | 16.00 | 15,300 | 10 |
| 5DA115602215051 | T27 115x6.0 A30V-BF Steel | A30V-BF Steel | 115 | 6.0 | 22.23 | 13,300 | 10 |
| 5DA125602215051 | T27 125x6.0 A24/30S-BF Steel | A24/30S-BF Steel | 125 | 6.0 | 22.23 | 12,200 | 10 |
| 5DA230602218251 | T27 230x6.0 A24V-BF Steel | A24V-BF Steel | 230 | 6.0 | 22.23 | 6,600 | 10 |

Recommended for: ● Steel

Grinding disc for machining steel



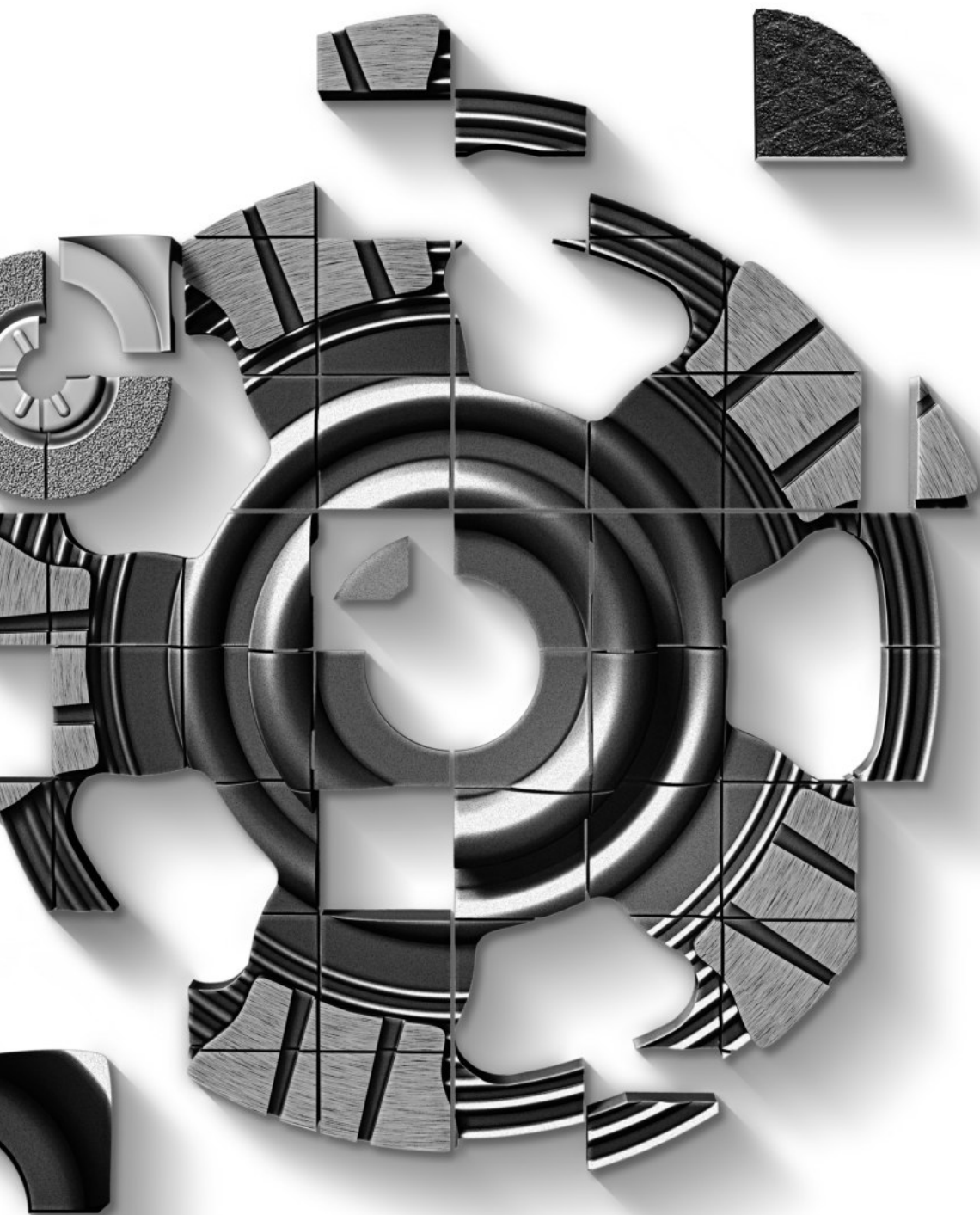
★★☆

- designed for easy machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

| Product number | Description | Quality | D mm | T mm | H mm | n _{max} rpm | Pack contains |
|-----------------|----------------------------|------------------|------|------|-------|----------------------|---------------|
| 5DA178652218251 | T27 178x7 A24/30S-BF Steel | A24/30S-BF Steel | 180 | 7.0 | 22.23 | 8,500 | 10 |

Recommended for: ● Steel

ROUGH GRINDING



6.1.1 Cupstones, snagging wheels, rubbing bricks 1–10

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS cupstone and snagging wheels

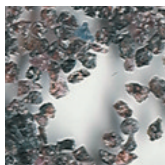
SHELF LIFE

Resin-bonded grinding discs for handheld use may only be used up to three years after the manufacture date. The expiry date (month and year) is stamped on the label blotter.

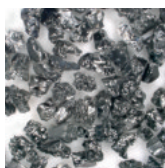
LABELLING SYSTEM FOR RESIN-BONDED GRINDING WHEELS

All of the important quality information about your LUKAS grinding wheel is stated on the label: abrasive material, grit size, hardness and type of bond.

The following overview provides all the information concerning the abbreviations and markings.



A
Semi-friable
aluminium oxide



C
Silicon carbide

ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

| Abrasive | |
|----------|-----------------|
| A | Aluminium oxide |
| C | Silicon carbide |

HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

| soft | medium | hard |
|------|--------|------|
| M | R | U |
| P | S | V |
| Q | T | Z |

GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

| coarse | medium | fine |
|----------|----------|-----------|
| 12 to 24 | 36 to 54 | 60 to 120 |







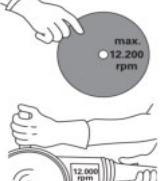





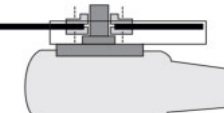







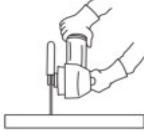







BOND

The bond holds the abrasive grain to the grinding disc. LUKAS grinding discs are available with the following bonds:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

WORK SAFETY

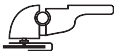


Safe instructions

| | | | |
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|  |  |  |  |
|  T41/T42 |  T41/T42 |  T27 |  T27 |
|  30 Sec |  |  |  |

AREA OF USE

Overview of types of LUKAS cupstones and snagging wheels

■ best suitable ■ suitable

| Type | Page | Reference/ Qualities | Product line | Materials | | | | | | | |
|--|------|---------------------------|--------------|--|--------------------------|--------------------------------|----------------|---|-----------------------------------|-----------|----------------------------------|
| | | | | Inox/Stainless- Rust-, acid- and heat-resistant steel | General purpose Steel | Alloyed/ tempered steels | Tool steels | Aluminium, magnesium and copper alloys | Stone/ Construc- tion material | Cast iron | Titanium and nickel alloys |
|  | 5 | 18A16T5BD steel cupstone | ★★☆ | | ■ | ■ | ■ | | | ■ | ■ |
| | 6 | 18C16V5 masonry cupstone | ★★★ | | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | 6 | 18C46V5 masonry cupstone | ★★☆ | | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | 6 | 18C60V5 masonry cupstone | ★★☆ | | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | 6 | 18C36R2B masonry cupstone | ★★☆ | | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
|  | 6 | A24Q snagging wheel | ★★☆ | | ■ | ■ | ■ | | | ■ | ■ |
|  | 7 | rubbing bricks | ★★☆ | | | | | | ■ | | |

OPERATING SPEED

LUKAS grinding wheels are developed and tested for specified maximum operating speeds and grinding processes. Before fixing the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the grinding wheel.

LUKAS CUP STONE SNAGGING WHEELS FOR HEAVY-DUTY GRINDING

EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE

The major advantage of cup stone grinding wheels is the high material removal rates. Great for heavy duty applications where large amounts of material needs to be removed quickly

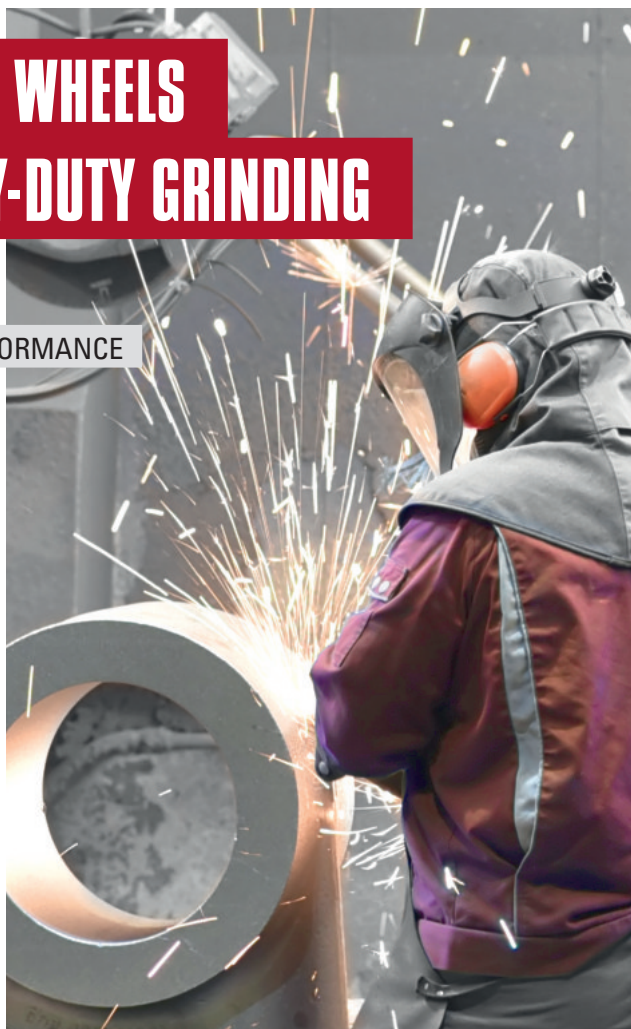
DIFFERENT GRAIN QUALITIES

Aluminum Oxide grains for tough grinding applications are excellent for cleaning castings, mold marks, and removing waste material and welds from ferrous metals

Silicon carbide grain for tough grinding applications are excellent for cleaning castings, mold marks, and removing waste material and welds from non ferrous metals, cast iron as well as concrete and masonry applications

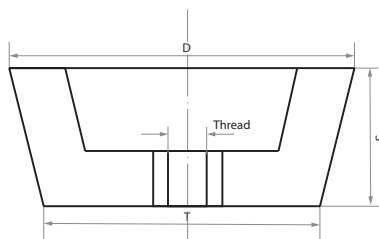
CAN BE USED ON STANDARD ELECTRIC MACHINES

This tool can be used on standard angle grinders and is available in different sizes. However these products are best suited for powerful pneumatic grinders



Cup stone grinding wheels for machining steel

- high stock removal
- long tool life
- less vibration
- aggressive cut
- allows ergonomical working with little use of force

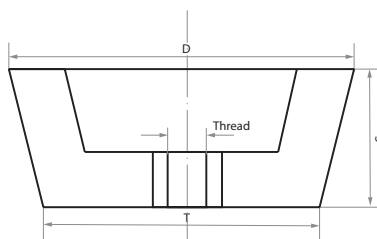


★★☆

| Product number | Description | Quality | D mm | T mm | S mm | Thread | n_{max} rpm | Pack contains |
|-----------------|-------------------------------|-----------|---------|---------|---------|--------|------------------|------------------|
| 5CA125501415051 | T11 125x50 M14 steel cupstone | 18A16T5BD | 125 | 100 | 50.0 | M14 | 6,400 | 8 |
| 5CA125505815051 | T11 125x50 5/8 steel cupstone | 18A16T5BD | 125 | 100 | 50.0 | 5/8" | 6,400 | 8 |
| 5CA150501415051 | T11 150x50 M14 steel cupstone | 18A16T5BD | 150 | 120 | 50.0 | M14 | 6,400 | 8 |
| 5CA15050585051 | T11 150x50 5/8 steel cupstone | 18A16T5BD | 150 | 120 | 50.0 | 5/8" | 6,400 | 8 |

Recommended for: ● Steel

Cup stone grinding wheels for machining non ferrous metal and masonry



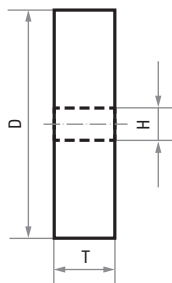
★★☆

- high stock removal
- long tool life
- less vibration
- aggressive cut
- allows ergonomical working with little use of force

| Product number | Description | Quality | D mm | T mm | T mm | Thread/bore | n _{max} rpm | Pack contains |
|-----------------|-----------------------------------|----------|------|------|------|-------------|----------------------|---------------|
| 5CC12550148051 | T11 125x50 M14 masonry cupstone | 18C16V5 | 125 | 100 | 50.0 | M14 | 6,400 | 8 |
| 5CC12550148351 | T11 125x50 M14 masonry cupstone | 18C46V5 | 125 | 100 | 50.0 | M14 | 6,400 | 8 |
| 5CC12550148451 | T11 125x50 M14 masonry cupstone | 18C60V5 | 125 | 100 | 50.0 | M14 | 6,400 | 8 |
| 5CC125503236051 | T11 125x50 31.75 masonry cupstone | 18C36R2B | 125 | 100 | 50.0 | 31,75 mm | 6,400 | 8 |
| 5CC15050148051 | T11 150x50 M14 masonry cupstone | 18C16VS | 150 | 120 | 50.0 | M14 | 6,400 | 8 |

Recommended for: ● Stone ● Cast material

Snagging wheels for machining steel



★★☆

- high stock removal
- well suited for harder materials
- no fibre reinforcing
- aggressive cut
- allows ergonomical working with little use of force

| Product number | Description | Quality | D mm | T mm | H mm | n _{max} rpm | Pack contains |
|----------------|-------------------------------|---------|------|------|------|----------------------|---------------|
| 5SA10025127051 | T1 100.25.12,7 snagging wheel | A24Q | 100 | 25.0 | 12.7 | 8,600 | 8 |
| 5SA10025204051 | T1 100.25.20 snagging wheel | A24Q | 100 | 25.0 | 20 | 8,600 | 8 |
| 5SA12525162051 | T1 125.25.16 snagging wheel | A24Q | 125 | 25.0 | 16 | 6,900 | 8 |

Recommended for: ● Steel

LUKAS RUBBING BRICKS FOR HEAVY-DUTY APPLICATIONS

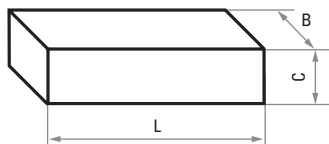
SILICON CARBIDE GRAIN FOR LEVELING OR GRINDING OF CONCRETE OR MASONRY MATERIALS



Rubbing bricks

Suitable for:

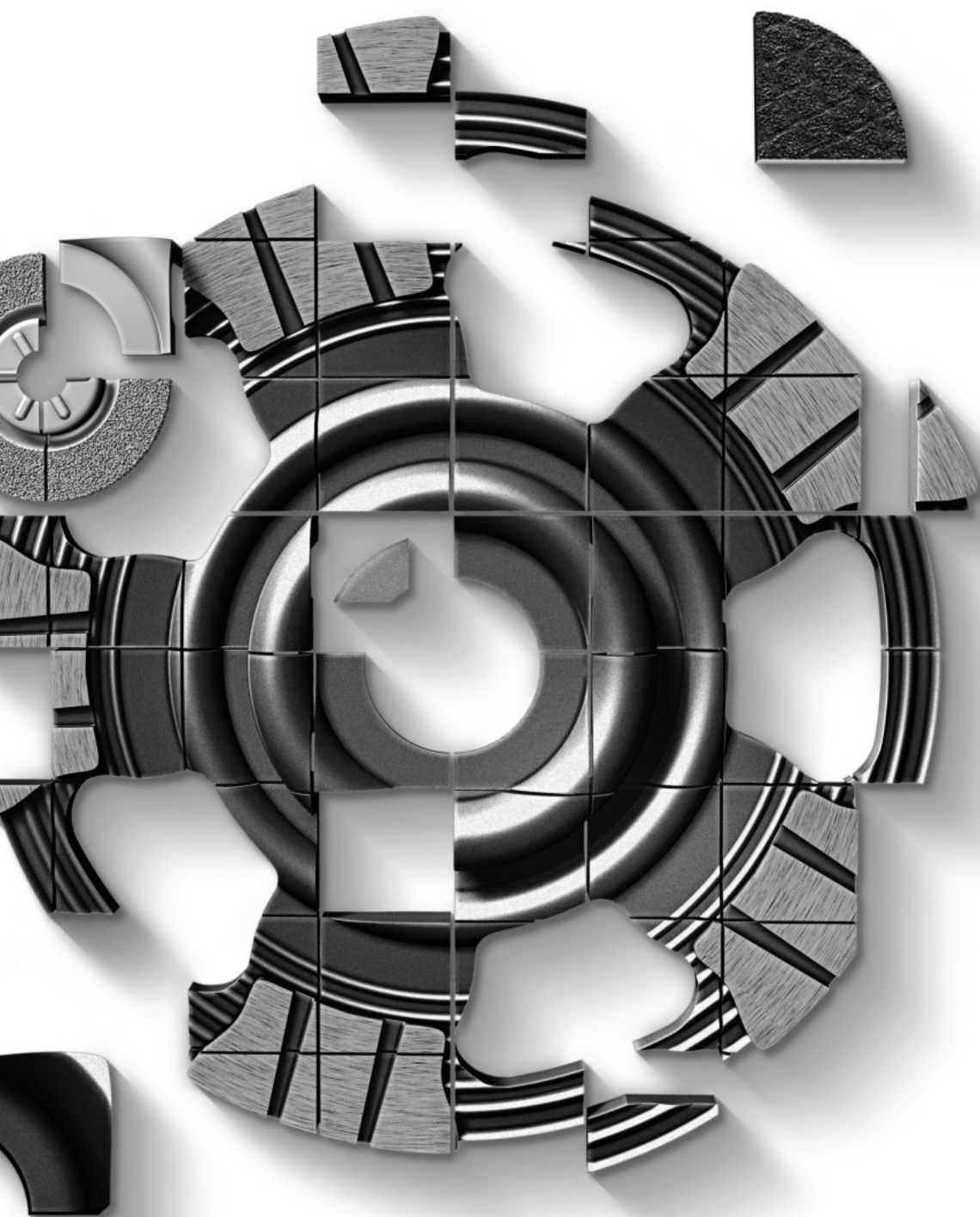
- rubbing down concrete
- cleaning castings
- scouring castings
- removing mold marks
- dressing of bonded grinding and polishing tools



★★☆

| Product number | Description | Quality | L mm | B mm | C mm | Pack contains |
|-----------------|-------------|---------|---------|---------|---------|---------------|
| 5BS050501005051 | 50x50x100 | COURSE | 100 | 50 | 50 | 30 |
| 5BS050501005151 | 50x50x100 | MEDIUM | 100 | 50 | 50 | 30 |
| 5BS050501005251 | 50x50x100 | FINE | 100 | 50 | 50 | 30 |
| 5BS050502005051 | 50x50x200 | COARSE | 200 | 50 | 50 | 30 |
| 5BS050502005151 | 50x50x200 | MEDIUM | 200 | 50 | 50 | 30 |
| 5BS050502005251 | 50x50x200 | FINE | 200 | 50 | 50 | 30 |

Recommended for: ● Steel ● Stone/Construction material



ROUGH GRINDING

ROUGH GRINDING

6.2 Diamond grinding discs

1-3

TECHNICAL INFORMATION AND PRODUCT INFORMATION

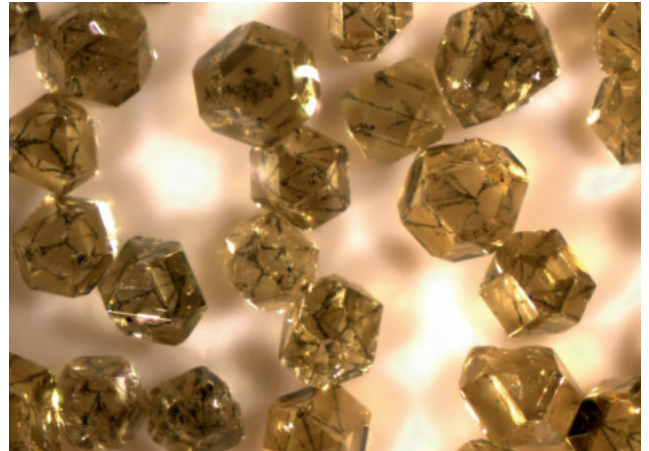
LUKAS diamond grinding discs**DIAMOND**

Diamond is the hardest material in the world. The type of diamond chosen depends on what it is used for. Only synthetic diamonds are used for the diamond grinding discs. Unlike natural diamonds, their properties can be reproduced and controlled.

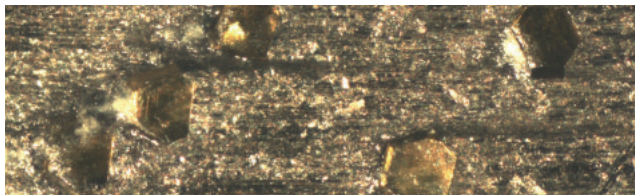
The following characteristics are significant when selecting diamonds:

- degree of purity
- defined fracture strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grit sizes.

**SEGMENT**

The segments consist of a diamond-embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists of bronze, cobalt, iron, carbide, or tungsten carbide, for example. The various characteristics of the metal powder give the segment sharpness and the all-important wear resistance. The segment coating is produced by a sintering process. A hard bond is selected for abrasive construction materials, while a soft bond is needed for hard structural materials.

**SEGMENT GEOMETRY**

The patented forged segment geometry allows even tall segments to be arranged very close to each other. This significantly reduces vibration for the user. Another crucial advantage is safety. The dense, porelessly forged segments have welds that provide much more safety against fracturing compared to the usual sintered segments.

- universal and fast due to new types of alloys in the segments
- less vibration through trapezium segment geometry
- more safety due to segment feet that are poreless and provide the utmost safety against fracturing
- long tool life thanks to taller segments and slower rate of diamond shedding

APPLICATIONS

- Grinding of granite, Porphyry and Clinker bricks
- Grinding of Concrete products, reinforced concrete and exposed aggregate concrete
- Grinding of Bricks, masonry, roof tiles, sand-lime brick
- Natural stone

THE DIAMOND CUP WHEEL FOR UNIVERSAL USE

EFFICIENT AND FLEXIBLE GRINDING OF BUILDING MATERIALS

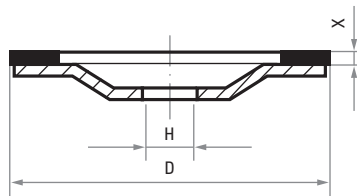
The diamond cup wheels are used with an angle grinder to create fine surfaces on granite building materials, artificial stone and concrete. The surrounding turbo grinding ring yields fine grinding results for finish work.

A diamond cup wheel grinds, rather than cuts through material. The Diamond cup wheels have segments which contain diamond crystals embedded throughout the segment for grinding through very hard materials

- Optimized bond and formula for longer life
- Optimized segment height minimizes dust and debris
- Turbo design for smooth, consistent finish
- Precision balanced – designed for less vibration and a smooth final grind for concrete
- Robust construction – more durable than bonded abrasive wheels
- Does not expire like typical bonded grinding wheels



- the inexpensive cup wheel for many different applications
- suitable for concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice), dense sand-lime brick and natural stone



Diamond grinding discs

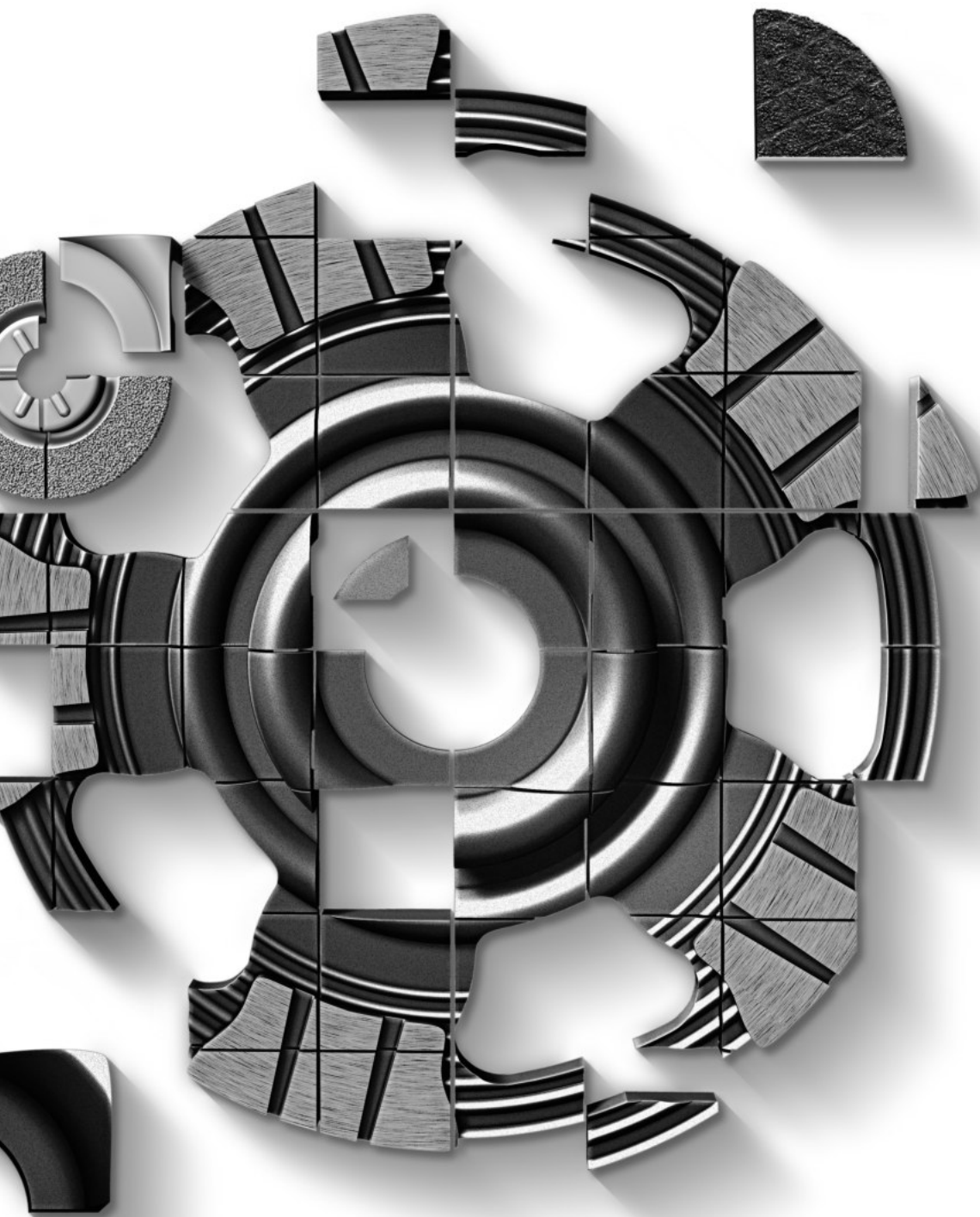


★★☆

| Product number | Description | D mm | Segment height X mm | H Thread | n _{max} rpm | Pack contains |
|-----------------|--------------------------------|---------|------------------------|-------------|-------------------------|------------------|
| 7CB100140020003 | 100 M14 Diamond turbo grinding | 100 | 5.0 | M14 | 15,200 | 1 |
| 7CB180140020003 | 180 M14 Diamond turbo grinding | 180 | 5.0 | M14 | 8,400 | 1 |

Recommended for: ● Stone

ROUGH GRINDING



6.3 Tungsten grinding discs

1-2

FROM ANIMAL HOOVES TO MACHINING STONE

TUNGSTEN CARBIDE GRANULATE-TIPPED DISCS FOR A WIDE VARIETY OF APPLICATIONS

Tungsten carbide granulate-tipped tools (HGW) from LUKAS are available in grit sequences from very coarse to extra fine with dense and open coating. Simply find the grit you require in the illustration below.

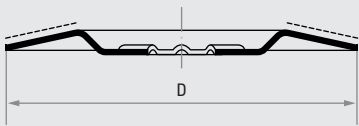
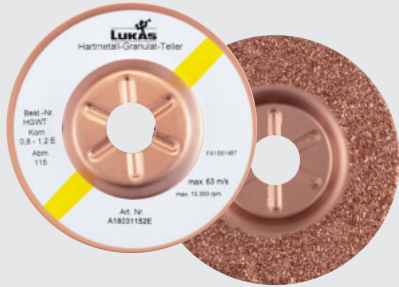


APPLICATIONS

Coarse grit is suitable for machining soft materials. **The harder the material, the finer the required grit.** The LUKAS tungsten carbide granulate-tipped flap disc can be used for many applications. It can be used to roughen rubber (e.g. when repairing conveyor belts), remove residues from cladding or to clean the hooves of horses and cows. It can also be used on glass, ceramic and stone.

The grit of the granulate-tipped disc ranges from extra fine to very coarse, meaning you have the right tool for every application. In addition to the standard product offering, the LUKAS tungsten carbide granulate-tipped disc can be specially coated to meet your needs.

HWGT tungsten carbide granulate-tipped disc

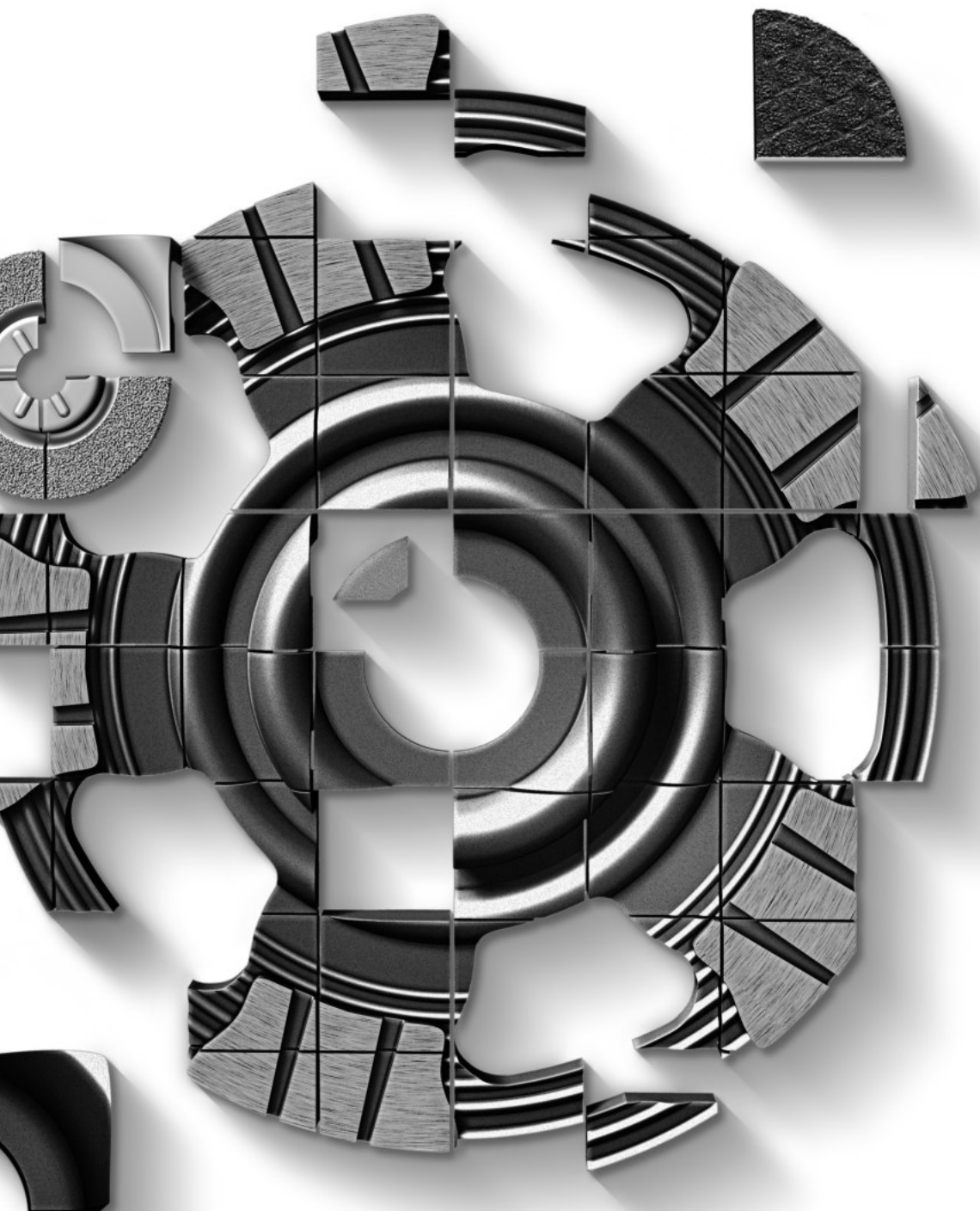


- extremely versatile grinding tool
- perfect as a hoof disc for grinding animal hooves
- also suitable for machining glass, ceramic and stone

| Product number | Description | Grit | Shape | Type | D mm | Bore mm | n max rpm | Pack contains |
|-----------------|----------------|-------------|-------|--------|------|---------|-----------|---------------|
| 5DT115081222524 | HGWT 115 0812S | 0.8 – 1.2 E | | dished | 115 | 22.2 | 10,500 | 1 |
| 5DT115121822524 | HGWT 115 1218S | 1.2 – 1.8 E | | dished | 115 | 22.2 | 10,500 | 1 |

Recommended for: ● Stone/Construction material ● Plastic/Wood

ROUGH GRINDING



6.4 Grinding vitrified bond

1–10

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS vitrified grinding wheels

EFFICIENT AND PROFESSIONAL GRINDING

LUKAS vitrified grinding wheels are premium grinding tools with a long tool life that deliver high removal performance. They are perfect for efficient and effective grinding of various materials in numerous applications

From rough grinding to fine machining, we offer a range of grinding wheels in various shapes, sizes and qualities so that you always have the right grinding wheel for the job. LUKAS grinding wheels are designed for grinding all kinds of material (steel, cast steel, tool steel, cast iron, aluminium alloys, titanium and nickel alloys, plastic, glass, ceramic and many more).

QUALITY

Grinding covers a broad spectrum of processes, from rough grinding to fine machining. This requires grinding wheels that deliver the right balance of machining performance and tool life, while achieving the desired surface quality. Manufacturing quality grinding wheels involves knowing the conditions in which the tools will be used, selecting the raw materials and understanding how to combine them in the right specification. We stock a large assortment of sizes and qualities, however if these stock wheels do not meet your requirements we can manufacture wheels to meet your individual requirements

A ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with. The following overview contains all raw materials for LUKAS vitrified grinding wheels. The abbreviations for the respective abrasives can be found in the quality designation of the LUKAS vitrified grinding wheels (see right).

Aluminum oxide is generally used for grinding:

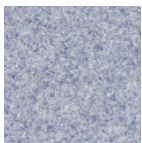
- Carbon steel
- Alloy steel
- High speed steel
- Wrought iron
- Hard bronzes

Silicone carbide is generally used for grinding:

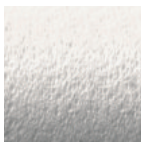
- Grey iron
- Non ferrous metals
- Stone
- Marble



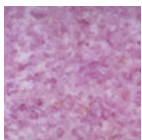
A
Regular Brown
Aluminum Oxide



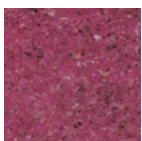
M
Mono Crystalline
Aluminum Oxide



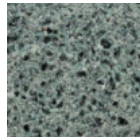
WA
Mono Crystalline White
Aluminum Oxide



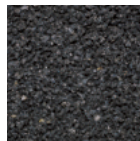
PA
Pink
Aluminum Oxide



RA
Ruby
Aluminium Oxide



GC
Green Silicone Carbide



C
Black Silicon carbide

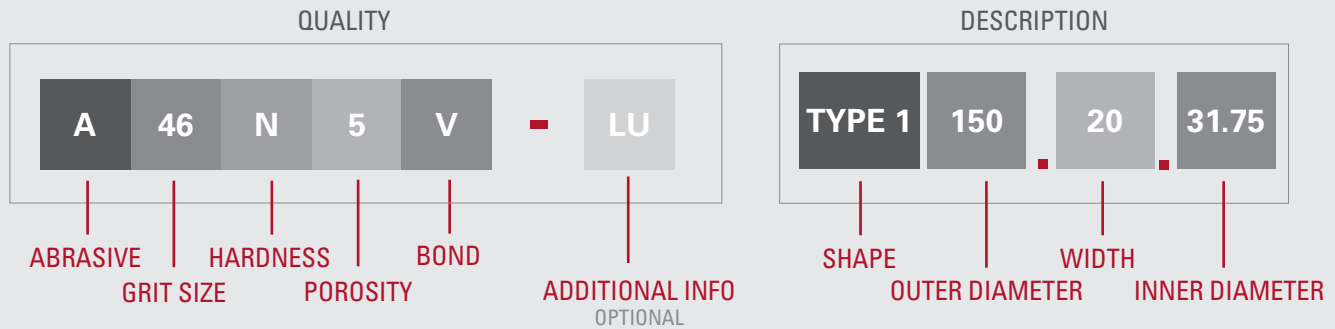
WE CAN MANUFACTURE WHEELS TO MEET YOUR
INDIVIDUAL REQUIREMENTS

DESIGNATION OF GRINDING WHEELS

All the important information in the product designation

All of the important quality information about your LUKAS grinding wheel is stated on the label: abrasive material, grit size, hardness, porosity and type of bond.

The following overview provides all the information concerning the abbreviations and markings.



46

GRIT SIZES AS PER ISO 525

From coarse to very fine, the numerical grit size value is clearly displayed in the quality designation.

| coarse | medium | fine | very fine |
|--------|--------|------|-----------|
| 14 | 46 | 80 | 220 |
| 16 | 54 | 90 | 240 |
| 20 | 60 | 100 | 280 |
| 24 | 70 | 120 | 320 |
| 30 | – | 150 | 400 |

N

HARDNESS AS PER ISO 525

The hardness indicates the strength holding the abrasive grain bonded to the grinding wheel. It is determined using special measuring tools. Letters are used to indicate the hardness grade. The hardness increases with alphabetical order.

| extreme soft | very soft | soft | medium | hard | very hard | extreme hard |
|--------------|-----------|------|--------|------|-----------|--------------|
| A | E | G | K | N | R | U |
| B | F | H | L | O | S | V |
| C | – | I | M | P | T | W |
| D | – | J | – | Q | – | X |
| – | – | – | – | – | – | Y |
| – | – | – | – | – | – | Z |

ADDITIONAL INFORMATION (OPTIONAL)

Impregnation can improve the grinding properties of all vitrified bonds, especially for processing certain steels:

- **Lu** = with resin
- **W** = with wax

5

POROSITY

From extremely dense (1) to extremely porous (12), the numerical value increases proportionally with the increase porosity structure. If the porosity value is not displayed it is considered a medium porosity of 7.

| Dense | Normal | Porous |
|-------|--------|--------|
| 0 | 4 | 10 |
| 1 | 5 | 11 |
| 2 | 6 | 12 |
| 3 | 7 | – |
| – | 8 | – |
| – | 9 | – |

V

BOND

The bond holds the abrasive grain to the grinding wheel.

Vitrified bond:

- **V** = vitrified bond

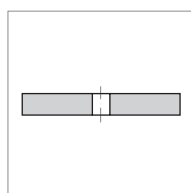
Organic bond:

- **B** = resin bond
- **BF** = fibre-reinforced resin bond
- **BFI** = internally fibre-reinforced resin bond
- **R** = rubber bond or bond using other elastomers
- **RF** = rubber bond, reinforced

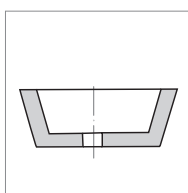
The code following the bond identifier is a factory-internal designation.

SHAPE

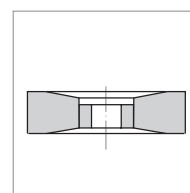
Summary of available shapes



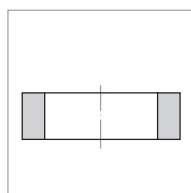
TYPE 1
Straight grinding wheel



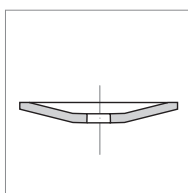
TYPE 11
Flaring cup wheel



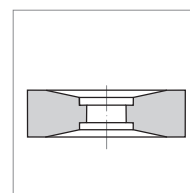
TYPE 25
Grinding wheel recessed one side and relieved both sides



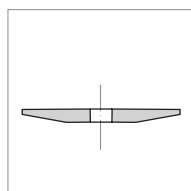
TYPE 2
Grinding cylinder



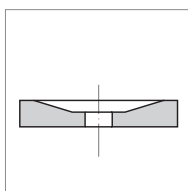
TYPE 12
Dish wheel



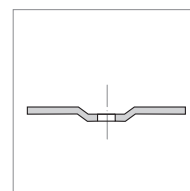
TYPE 26
Grinding wheel recessed and relieved both sides



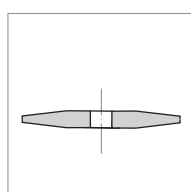
TYPE 3
Grinding wheel tapered one side



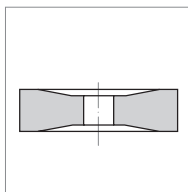
TYPE 20
Grinding wheel relieved one side



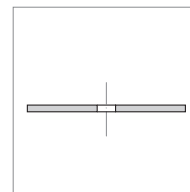
TYPE 27
Depressed centre wheel



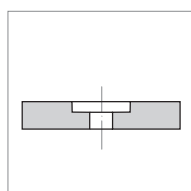
TYPE 4
Grinding wheel tapered both sides



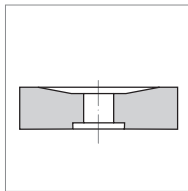
TYPE 21
Grinding wheel relieved both sides



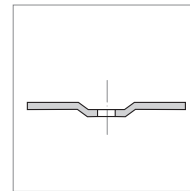
TYPE 41
Straight cutting wheel



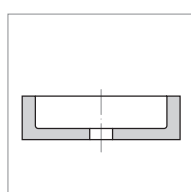
TYPE 5
Straight grinding wheel recessed one side



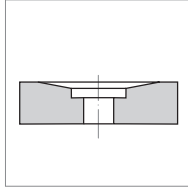
TYPE 22
Grinding wheel recessed one side and relieved other side



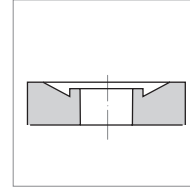
TYPE 42
Cutting wheel depressed centre



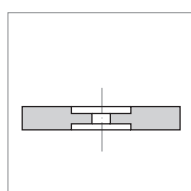
TYPE 6
Straight cup wheel



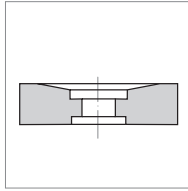
TYPE 23
Grinding wheel recessed and relieved one side



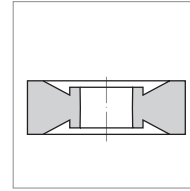
TYPE 115
Grinding wheel relieved one side raised boss



TYPE 7
Straight grinding wheel recessed both sides



TYPE 24
Grinding wheel recessed both sides and relieved one side





TYPE 116
Grinding wheel relieved both sides raised boss

AREA OF USE

Overview of types of LUKAS grinding wheels

■ best suitable ■ suitable

| Type | Page | Symbol | Abrasive type | Colour | Materials | | | | | | | |
|--|------|--------|--|------------|--|-----------------------|-------------------------|-------------|--|-----------------------------|-----------|----------------------------|
| | | | | | ● | ● | | ● | ● | ● | ● | ● |
| | | | | | Inox/Stainless-Rust-, acid- and heat-resistant steel | General purpose Steel | Alloyed/Hardened steels | Tool steels | Aluminium, magnesium and copper alloys | Stone/Construction material | Cast iron | Titanium and nickel alloys |
|   | 3 | A | Regular Brown Aluminium Oxide | Grey | | ■ | | ■ | | | | |
| | 4 | GC | Green Silicone Carbide | Green | ■ | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | * | WA | Mono Crystalline White Aluminium Oxide | White | ■ | ■ | ■ | ■ | | | ■ | ■ |
| | * | 38A | White Aluminium Oxide | Blue/White | ■ | | ■ | ■ | | | ■ | ■ |
| | * | C | Black Silicone Carbide | Black | ■ | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | * | M | Mono Crystalline Aluminium Oxide | Blue | ■ | ■ | ■ | ■ | ■ | | | |
| | * | PA | Pink Aluminium Oxide | Pink | ■ | ■ | ■ | ■ | | | ■ | ■ |
| | * | RA | Ruby Aluminium Oxide | Ruby | ■ | ■ | ■ | ■ | | | ■ | ■ |

OPERATING SPEED

LUKAS grinding wheels are developed and tested for specified maximum operating speeds and grinding processes. Before fixing the grinding tool to the machine, always check that the nominal speed of the machine (nameplate) is not high-

er than the maximum speed specified on the grinding wheel. Lukas produce grinding wheels with a maximum peripheral speed of 35 m/s.

| Maximum operating speed | Grinding disc diameter (mm) | | | | | | | | | |
|-------------------------|-----------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 125 | 150 | 180 | 200 | 250 | 300 | 350 | 400 | 450 | 500 |
| 35 m/s | 5,300 | 4,400 | 3,700 | 3,300 | 2,600 | 2,200 | 1,900 | 1,650 | 1,400 | 1,300 |
| rpm | | | | | | | | | | |

WORK SAFETY

Safely grinding with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. Safety is an essential mark of quality for any grinding tool.

When using and storing grinding wheels, always observe the safety and accident prevention regulations, along with the FEPA safety recommendations.

Our products are clearly labeled with all important in-

formation, which indicates the maximum permitted speed for the specific wheel

We do not use raw materials in our grinding wheels that are hazardous to health.

APPLIED STANDARDS

- Safety requirements for bonded abrasive products: EN 12413

SAFETY INFORMATION

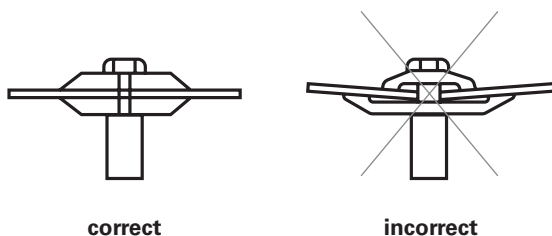
- Store discs **in a dry place at room temperature** that is protected from vibration
- **Avoid improper handling of the grinding wheels** as these wheels are extremely brittle
- Never exceed the maximum permitted speed specified **on the wheel**.
- Only use wheels that can be mounted on the machine without requiring force
- Always perform a **ring test** prior to use
- **Inspect wheels for possible cracks or damage** prior to mounting
- Don't overtighten the mounting nut or locking flange, as this may lead to fracturing of the wheel.
- Ensure correct **mounting of wheel and correct sizes**

of flanges

- Never use **damaged, dirty or uneven mounting flanges**
- A new wheel should always **run free at full speed** for five minutes prior to use
- Don't **use damaged wheels**.
- **Readjustment of the work rest and wheelguard** as wheel wears, ensure that the tool rest is no more than 3mm from the grinding surface
- All wheels may only be used with the appropriate **grinding wheel protective cover**, the guard should cover 75% of the wheels surface.
- Do not grind on the side of the wheel
- **Wear the correct personal protection equipment**
- Don't jam the work into the wheel.

CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).

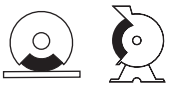


RING TEST

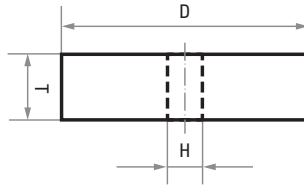
The ring test should be carried out immediately before mounting a new or used grinding wheel. Balance the grinding wheel on the finger or on a mandrel, larger wheels can be rested on the floor and tilted on edge. Then lightly tap the grinding wheel on one side and listen for a "ringing" noise; this indicates that portion of the wheel is not cracked. But if you hear a dead "thud" sound, this means the wheel could be cracked and shouldn't be used. Repeat this test by rotating the wheel and "sounding" it repeatedly until all areas of the wheel have been checked

LUKAS VITRIFIED GRINDING WHEELS

EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE



- grinding carbon steel, alloy steel, high speed steel, annealed malleable iron, wrought iron, hard bronzes
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels
- allows for ergonomical working with little use of force



Aluminum oxide grinding wheels



★★☆

| Product number | Description | Quality | D mm | T mm | H mm | Grit | n _{max} rpm | Pack contains |
|-----------------|---------------------------------|---------|------|------|-------|------|----------------------|---------------|
| 5ZA125203236015 | 125x20x31.75 A36 GRIND WHEEL | A36 P5V | 125 | 20 | 31.75 | A36 | 5,300 | 1 |
| 5ZA125203246015 | 125x20x31.75 A46 GRIND WHEEL | A46 N5V | 125 | 20 | 31.75 | A46 | 5,300 | 1 |
| 5ZA125203260015 | 125x20x31.75 A60 GRIND WHEEL | A60 N5V | 125 | 20 | 31.75 | A60 | 5,300 | 1 |
| 5ZA150163203615 | 150x16x31.75 A36 GREY WHEEL | A36 P5V | 150 | 16 | 31.75 | A36 | 4,400 | 1 |
| 5ZA150163204615 | 150x16x31.75 A46 N5V GREY WHEEL | A46 N5V | 150 | 16 | 31.75 | A46 | 4,400 | 1 |
| 5ZA150163206068 | 150x16x31.75 A60 GREY WHEEL | A60 N5V | 150 | 16 | 31.75 | A60 | 4,400 | 1 |
| 5ZA150203236015 | 150x20x31.75 A36 P5V GREY WHEEL | A36 N5V | 150 | 20 | 31.75 | A36 | 4,400 | 1 |
| 5ZA150203246015 | 150x20x31.75 A46 N5V GREY WHEEL | A46 N5V | 150 | 20 | 31.75 | A46 | 4,400 | 1 |
| 5ZA150203260015 | 150x20x31.75 A60 N5V GREY WHEEL | A60 N5V | 150 | 20 | 31.75 | A60 | 4,400 | 1 |
| 5ZA150203280015 | 150x20x31.75 A80 N5V GREY WHEEL | A80 N5V | 150 | 20 | 31.75 | A80 | 4,400 | 1 |
| 5ZA150253236015 | 150x25x31.75 A36 P5V GREY WHEEL | A36 P5V | 150 | 25 | 31.75 | A36 | 4,400 | 1 |
| 5ZA150253246015 | 150x25x31.75 A46 N5V GREY WHEEL | A46 N5V | 150 | 25 | 31.75 | A46 | 4,400 | 1 |
| 5ZA150253260015 | 150x25x31.75 A60 N5V GREY WHEEL | A60 N5V | 150 | 25 | 31.75 | A60 | 4,400 | 1 |
| 5ZA180203236015 | 180x20x31.75 A36 P5V GREY WHEEL | A36 P5V | 180 | 20 | 31.75 | A36 | 3,700 | 1 |
| 5ZA180203246015 | 180x20x31.75 A46 N5V GREY WHEEL | A46 N5V | 180 | 20 | 31.75 | A46 | 3,700 | 1 |
| 5ZA180203260015 | 180x20x31.75 A60 N5V GREY WHEEL | A60 N5V | 180 | 20 | 31.75 | A60 | 3,700 | 1 |
| 5ZA180253236015 | 180x25x31.75 A36 GREY WHEEL | A36 P5V | 180 | 25 | 31.75 | A36 | 3,700 | 1 |
| 5ZA180253246015 | 180x25x31.75 A46 N5V GREY WHEEL | A46 N5V | 180 | 25 | 31.75 | A46 | 3,700 | 1 |
| 5ZA180253260015 | 180x25x31.75 A60 N5V GREY WHEEL | A60 N5V | 180 | 25 | 31.75 | A60 | 3,700 | 1 |
| 5ZA200203236015 | 200x20x31.75 A36 P5V GREY WHEEL | A36 P5V | 200 | 20 | 31.75 | A36 | 3,300 | 1 |
| 5ZA200203246015 | 200x20x31.75 A46 N5V GREY WHEEL | A46 N5V | 200 | 20 | 31.75 | A46 | 3,300 | 1 |
| 5ZA200203260015 | 200x20x31.75 A60 N5V GREY WHEEL | A60 N5V | 200 | 20 | 31.75 | A60 | 3,300 | 1 |
| 5ZA200253236015 | 200x25x31.75 A36 P5V GREY WHEEL | A36 P5V | 200 | 25 | 31.75 | A36 | 3,300 | 1 |
| 5ZA200253246015 | 200x25x31.75 A46 N5V GREY WHEEL | A46 N5V | 200 | 25 | 31.75 | A46 | 3,300 | 1 |

Recommended for: ● Steel

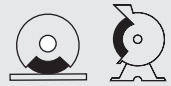
| Product number | Description | Quality | D mm | T mm | H mm | Grit | n _{max} rpm | Pack contains |
|------------------|---------------------------------|---------|---------|---------|---------|------|-------------------------|------------------|
| 5ZA200253260015 | 200x25x31.75 A60 N5V GREY WHEEL | A60 N5V | 200 | 25 | 31.75 | A60 | 3,300 | 1 |
| 5ZA200255146015 | 200x25x50.8 A46 N5V GREY WHEEL | A46 N5V | 200 | 25 | 50.8 | A46 | 3,300 | 1 |
| 5ZA200255160015 | 200x25x50.8 A60 N5V GREY WHEEL | A60 N5V | 200 | 25 | 50.8 | A60 | 3,300 | 1 |
| 5ZA200323236015 | 200x32x31.75 A36 P5V GREY WHEEL | A36 P5V | 200 | 32 | 31.75 | A36 | 3,300 | 1 |
| 5ZA200323246015 | 200x32x31.75 A46 N5V GREY WHEEL | A46 N5V | 200 | 32 | 31.75 | A46 | 3,300 | 1 |
| 5ZA200323260015 | 200x32x31.75 A60 N5V GREY WHEEL | A60 N5V | 200 | 32 | 31.75 | A60 | 3,300 | 1 |
| 5ZA200325136068 | 200x32x50.8 A36 GREY WHEEL | A36 P5V | 200 | 32 | 50.8 | A36 | 3,300 | 1 |
| 5ZA200325160068 | 200x32x50.8 A60 GREY WHEEL | A60 N5V | 200 | 32 | 50.8 | A60 | 3,300 | 1 |
| 5ZA250253236015 | 250x25x31.75 A36 P5V GREY WHEEL | A36 P5V | 250 | 25 | 31.75 | A36 | 2,600 | 1 |
| 5ZA250253246015 | 250x25x31.75 A46 N5V GREY WHEEL | A46 N5V | 250 | 25 | 31.75 | A46 | 2,600 | 1 |
| 5ZA250253260015 | 250x25x31.75 A60 N5V GREY WHEEL | A60 N5V | 250 | 25 | 31.75 | A60 | 2,600 | 1 |
| 5ZA250257660015 | 250x25x76.2 A60 N5V GREY WHEEL | A60 N5V | 250 | 25 | 76.2 | A60 | 2,600 | 1 |
| 5ZA250323236015 | 250x32x31.75 A36 P5V GREY WHEEL | A36 P5V | 250 | 32 | 31.75 | A36 | 2,600 | 1 |
| 5ZA250323246015 | 250x32x31.75 A46 N5V GREY WHEEL | A46 N5V | 250 | 32 | 31.75 | A46 | 2,600 | 1 |
| 5ZA250323260015 | 250x32x31.75 A60 N5V GREY WHEEL | A60 N5V | 250 | 32 | 31.75 | A60 | 2,600 | 1 |
| 5ZA250325136068 | 250x32x50.8 A36 GREY WHEEL | A36 P5V | 250 | 32 | 50.8 | A36 | 2,600 | 1 |
| 5ZA250325146068 | 250x32x50.8 A46 GREY WHEEL | A46 N5V | 250 | 32 | 50.8 | A46 | 2,600 | 1 |
| 5ZA250325160068 | 250x32x50.8 A60 GREY WHEEL | A60 N5V | 250 | 32 | 50.8 | A60 | 2,600 | 1 |
| 5ZA250405136015 | 250x40x50.8 A36 P5V GREY WHEEL | A36 P5V | 250 | 40 | 50.8 | A36 | 2,600 | 1 |
| 5ZA250405146015 | 250x40x50.8 A46 N5V GREY WHEEL | A46 N5V | 250 | 40 | 50.8 | A46 | 2,600 | 1 |
| 5ZA250405160015 | 250x40x50.8 A60 N5V GREY WHEEL | A60 N5V | 250 | 40 | 50.8 | A60 | 2,600 | 1 |
| 5ZA250407660015 | 250x40x76.2 A60 N5V GREY WHEEL | A60 N5V | 250 | 40 | 76.2 | A60 | 2,600 | 1 |
| 5ZA300401274615 | 300x40x127 A46 N5V GREY WHEEL | A46 N5V | 300 | 40 | 127 | A46 | 2,200 | 1 |
| 5ZA300405136015 | 300x40x50.8 A36 P5V GREY WHEEL | A36 P5V | 300 | 40 | 50.8 | A36 | 2,200 | 1 |
| 5ZA300405146015 | 300x40x50.8 A46 N5V GREY WHEEL | A46 N5V | 300 | 40 | 50.8 | A46 | 2,200 | 1 |
| 5ZA300405160015 | 300x40x50.8 A60 N5V GREY WHEEL | A60 N5V | 300 | 40 | 50.8 | A60 | 2,200 | 1 |
| 5ZA300407636015 | 300x40x76.2 A36 P5V GREY WHEEL | A36 P5V | 300 | 40 | 76.2 | A36 | 2,200 | 1 |
| 5ZA300407646015 | 300x40x76.2 A46 N5V GREY WHEEL | A46 N5V | 300 | 40 | 76.2 | A46 | 2,200 | 1 |
| 5ZA300407660015 | 300x40x76.2 A60 N5V GREY WHEEL | A60 N5V | 300 | 40 | 76.2 | A60 | 2,200 | 1 |
| 5ZA300505136015 | 300x50x50.8 A36 P5V GREY WHEEL | A36 P5V | 300 | 50 | 50.8 | A36 | 2,200 | 1 |
| 5ZA300505146015 | 300x50x50.8 A46 N5V GREY WHEEL | A46 N5V | 300 | 50 | 50.8 | A46 | 2,200 | 1 |
| 5ZA300505160015 | 300x50x50.8 A60 N5V GREY WHEEL | A60 N5V | 300 | 50 | 50.8 | A60 | 2,200 | 1 |
| 5ZA300507636015 | 300x50x76.2 A36 P5V GREY WHEEL | A36 P5V | 300 | 50 | 76.2 | A36 | 2,200 | 1 |
| 5ZA350405136015 | 350x40x50.8 A36 N5V GREY WHEEL | A36 N5V | 350 | 40 | 50.8 | A36 | 1,900 | 1 |
| 5ZA350405146015 | 350x40x50.8 A46 N5V GREY WHEEL | A46 N5V | 350 | 40 | 50.8 | A46 | 1,900 | 1 |
| 5ZA350405160015 | 350x40x50.8 A60 N5V GREY WHEEL | A60 N5V | 350 | 40 | 50.8 | A60 | 1,900 | 1 |
| 5ZA350407636015 | 350x40x76.2 A36 P5V GREY WHEEL | A36 P5V | 350 | 40 | 76.2 | A36 | 1,900 | 1 |
| 5ZA350407646015 | 350x40x76.2 A46 N5V GREY WHEEL | A46 N5V | 350 | 40 | 76.2 | A46 | 1,900 | 1 |
| 5ZA350407660015 | 350x40x76.2 A60 N5V GREY WHEEL | A60 N5V | 350 | 40 | 76.2 | A60 | 1,900 | 1 |
| 5ZA3505012736015 | 350x50x127mm A36 N5V GREY WHEEL | A36 N5V | 350 | 50 | 127 | A36 | 1,900 | 1 |
| 5ZA3505012760015 | 350x50x127 A60 GRINDING WHEEL | A60 N5V | 350 | 50 | 127 | A60 | 1,900 | 1 |
| 5ZA350505136015 | 350x50x50.8 A36 P5V GREY WHEEL | A36 P5V | 350 | 50 | 50.8 | A36 | 1,900 | 1 |
| 5ZA350505146015 | 350x50x50.8 A46 N5V GREY WHEEL | A46 N5V | 350 | 50 | 50.8 | A46 | 1,900 | 1 |
| 5ZA350505160015 | 350x50x50.8 A60 N5V GREY WHEEL | A60 N5V | 350 | 50 | 50.8 | A60 | 1,900 | 1 |
| 5ZA400501273615 | 400x50x127 A36 GREY WHEEL | A36 P5V | 400 | 50 | 127 | A36 | 1,650 | 1 |
| 5ZA400501274615 | 400x50x127 A46 GREY WHEEL | A46 N5V | 400 | 50 | 127 | A46 | 1,650 | 1 |
| 5ZA400501276068 | 400x50x127 A60 GREY WHEEL | A60 N5V | 400 | 50 | 127 | A60 | 1,650 | 1 |
| 5ZA400502034615 | 400x50x203.2 A46 GREY WHEEL | A46 N5V | 400 | 50 | 203.2 | A46 | 1,650 | 1 |
| 5ZA400502036068 | 400x50x203.2 A60 GREY WHEEL | A60 N5V | 400 | 50 | 203.2 | A60 | 1,650 | 1 |
| 5ZA450655136015 | 450x65x50.8 A36 GREY WHEEL | A36 P5V | 450 | 65 | 50.8 | A36 | 1,400 | 1 |

Recommended for: ● Steel

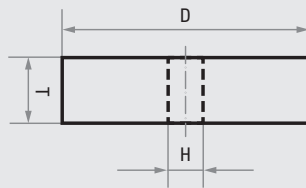
LUKAS VITRIFIED GRINDING WHEELS

MANUFACTURED TO MEET YOUR APPLICATION NEEDS

Silicone carbide grinding wheels



- grinding grey iron, chilled iron, brass, soft bronze, copper, aluminium, stone, marble, rubber, hard facing alloys and glass
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels
- allows for ergonomical working with little use of force

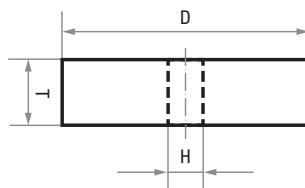


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| Product number | Description | Quality | D mm | T mm | H mm | Grit | n _{max} rpm | Pack contains |
|-----------------|----------------------------------|-----------|------|------|-------|-------|----------------------|---------------|
| 5ZC150203260015 | 150x20x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 150 | 20 | 31.75 | GC60 | 4,400 | 1 |
| 5ZC150203280015 | 150x20x31.75 GC80 J5V GRN WHEEL | GC80 J5V | 150 | 20 | 31.75 | GC80 | 4,400 | 1 |
| 5ZC150253260015 | 150x25x31.7 GC60 J5V GRN WHEEL | GC60 J5V | 150 | 25 | 31.75 | GC60 | 4,400 | 1 |
| 5ZC150253280015 | 150x25x31.75 GC80 GRND WHEEL | GC80 J5V | 150 | 25 | 31.75 | GC80 | 4,400 | 1 |
| 5ZC180253260015 | 180x25x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 180 | 25 | 31.75 | GC60 | 3,700 | 1 |
| 5ZC200203260015 | 200x20x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 200 | 20 | 31.75 | GC60 | 3,300 | 1 |
| 5ZC200253260015 | 200x25x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 200 | 25 | 31.75 | GC60 | 3,300 | 1 |
| 5ZC200253280015 | 200x25x31.75 GC80 J5V GRN WHEEL | GC80 J5V | 200 | 25 | 31.75 | GC80 | 3,300 | 1 |
| 5ZC200253210015 | 200x25x31.75 GC100 J5V GRN WHEEL | GC100 J5V | 200 | 25 | 31.75 | GC100 | 3,300 | 1 |
| 5ZC200323260015 | 200x32x31.75 GC60 GREEN WHL J5V | GC60 J5V | 200 | 32 | 31.75 | GC60 | 3,300 | 1 |
| 5ZC200323210015 | 200x32x31.75 GC100 GREEN WHEEL | GC100 J5V | 200 | 32 | 31.75 | GC100 | 3,300 | 1 |
| 5ZC200325106068 | 200x32x50.8 GC60 GRINDING WHL | GC60 J5V | 200 | 32 | 50.8 | GC60 | 3,300 | 1 |
| 5ZC250253260015 | 250x25x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 250 | 25 | 31.75 | GC60 | 2,600 | 1 |
| 5ZC250253280015 | 250x25x31.75 GC80 GREEN WHL | GC80 J5V | 250 | 25 | 31.75 | GC80 | 2,600 | 1 |
| 5ZC250323260015 | 250x32x31.75 GC60 J5V GRN WHEEL | GC60 J5V | 250 | 32 | 31.75 | GC60 | 2,600 | 1 |
| 5ZC250405160068 | 250x40x50.8 GC60 GRIND WHEEL | GC60 J5V | 250 | 40 | 50.8 | GC60 | 2,600 | 1 |
| 5ZC300253260015 | 300x25x31.75 GRIND WHEEL GC60 | GC60 J5V | 300 | 25 | 31.75 | GC60 | 2,200 | 1 |
| 5ZC300405160015 | 300x40x50.8 GC60 J5V GRN WHEEL | GC60 J5V | 300 | 40 | 50.8 | GC60 | 2,200 | 1 |
| 5ZC300505160015 | 300x50x50.8 GC60 J5V GRN WHL | GC60 J5V | 300 | 50 | 50.8 | GC60 | 2,200 | 1 |
| 5ZC350405160015 | 350x40x50.8 GC60 JV GREEN WHL | GC60 J5V | 350 | 40 | 50.8 | GC60 | 1,900 | 1 |
| 5ZC350407660015 | 350x40x76 GC60 GRIND WHEEL | GC60 J5V | 350 | 40 | 76 | GC60 | 1,900 | 1 |

Recommended for: ● Steel

Reducer bushes



| Product number | Description | D mm | T mm | H mm | Pack contains |
|----------------|------------------------------------|---------|---------|---------|------------------|
| 5ZR321360068 | 31.75x12.7x6.3 Wheel bore reducer | 31.75 | 6.3 | 12.7 | 1 |
| 5ZR321660068 | 31.75x15.88x6.3 Wheel bore reducer | 31.75 | 6.3 | 15.88 | 1 |
| 5ZR321960068 | 31.75x19.05x6mm Wheel bore reducer | 31.75 | 6.0 | 19.05 | 1 |
| 5ZR322260068 | 31.75x22.23x6mm Wheel bore reducer | 31.75 | 6.0 | 22.23 | 1 |
| 5ZR322560068 | 31.75x25.4x6mm Wheel bore reducer | 31.75 | 6.0 | 25.4 | 1 |
| 5ZR513290068 | 51x32x9mm Wheel bore reducer | 51.00 | 9.0 | 32.0 | 1 |