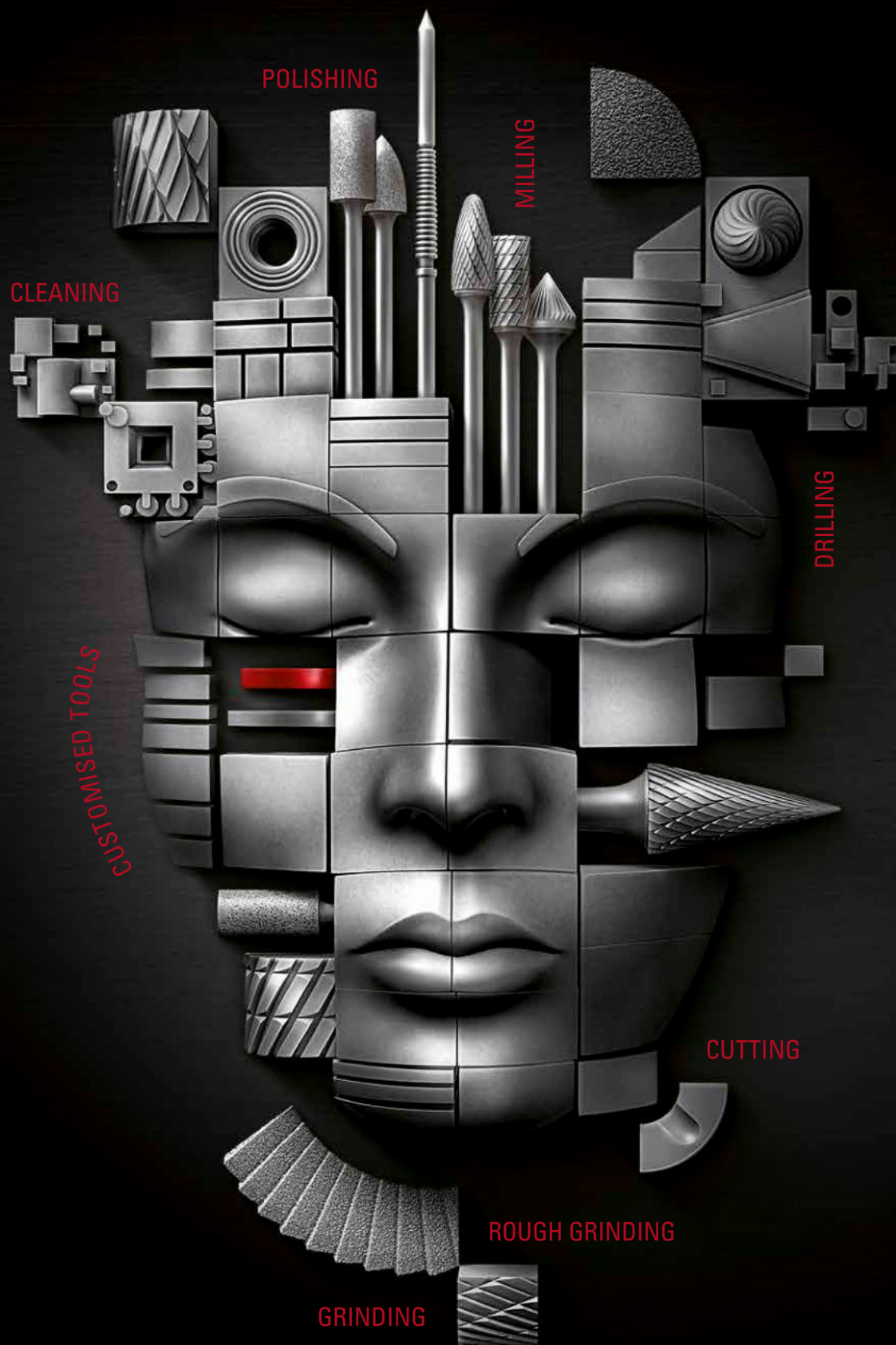


PRODUCT RANGE 2020 / 2021



1 MILLING FROM 11

2 GRINDING AND POLISHING (WITH BONDED TOOLS) FROM 23

2.1 Mounted points	24–35
2.2 Polishing tools	36–47

3 GRINDING AND POLISHING (WITH FLEXIBLE TOOLS) FROM 49

3.1 Lamellar flap discs	53–65
3.2 Flap wheels	66/67
3.3 Mounted flap wheels	68–72
3.4 Abrasive bands and mandrels	73–76
3.5 Abrasive caps and mandrels	77–80
3.6 Abrasive discs and carriers	81–88
3.7 Fibre discs and backing pads	89/90

4 CUTTING FROM 91

5 ROUGH GRINDING FROM 101

6 CLEANING FROM 109

7 POWER TOOLS FROM 113



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As a technologically leading manufacturer of powerful and innovative milling, grinding, polishing and cutting tool solutions, LUKAS-ERZETT GmbH & Co. KG from Germany, based in the greater Cologne area, always focuses on the requirements of its customers and the latest developments in many different industries worldwide. **AGILE, SUSTAINABLE, RELIABLE and FUTURE-ORIENTED** – LUKAS thinks further, develops tailor-made solutions, and is always one step ahead of market requirements.

LUKAS has maintained an official representative office in China since 2006 and has also had its own branch office, including a product warehouse, in Shanghai since 2020. This guarantees direct local points of contact and fast delivery times. The internationally operative company with branches and agencies on every continent has been active throughout Asia for several years now, convincing industrial customers and dealers with quality tools manufactured in Germany, its own patents, special solutions, and new tool innovations on a regular basis.

TOOLS MADE IN GERMANY

LUKAS-ERZETT SETS STANDARDS WORLDWIDE IN MATERIAL PROCESSING

IMPRESSIVE TOOL SOLUTIONS TAILORED TO THE ASIAN REGION

In this catalogue, you will find our highest quality products compiled specifically for the Asian region. Discover the entire product range produced by the German manufacturer from LUKAS burrs through to polishing tools and the very latest flap disc.

The LUKAS carbide burrs shown on **pages 11 to 23** are manufactured using high-quality solid carbides on modern CNC automatic grinding machines – with these, LUKAS always guarantees you the highest degree of manufacturing precision and repeatability of cutting angle, tooth profile and twist actions. LUKAS burrs can also be individually optimised with modern coatings (**page 16**).

LUKAS bundles tools from its proprietary high-performance line under the family name “iQ-Serie” (**shown on pages 54 to 62**). Among them are our lamellar flap discs, which feature LUKAS’s patented flap shape and arrangement for ultimate grinding performance. The latest product from this innovative series is the Steel Profi Hybrid-Perfection on **page 57**.

All of the products that we manufacture and sell stand for outstanding quality characteristics such as powerful working, a long service life, excellent ergonomics and the very best results. Let the LUKAS quality convince you.





20

SECTORS AND INDUSTRIES
PUT THEIR TRUST IN OUR
QUALITY AND EXPERIENCE

TOP-LEVEL QUALITY

LUKAS IS DEDICATED TO QUALITY

We don't talk about quality, we let it speak for itself, every day, and in everything we do. This practice makes LUKAS tools a safe, reliable factor in your manufacturing process and ensures the best possible production quality.



- made in Germany
- premium raw materials
- modern testing facilities
- quality management system to ISO 9001:2015
- active member of industry associations



NEXT LEVEL SOLUTIONS

EXCELLENT AVAILABILITY • BROAD RANGE OF PRODUCTS • CUSTOMISED PRODUCTION

700
EMPLOYEES

TAKE THE FUTURE INTO YOUR HANDS TODAY

LUKAS has been manufacturing leading-edge tools for over 80 years. We know that new challenges call for new solutions – so that's exactly what we're working on every day. We combine quality and safety with forward-thinking solutions that always keep new developments in different industries in mind. This focus gave us the lead early in the market and still does to this day.

30000
CUSTOMERS WORLD-WIDE

FIRMLY ESTABLISHED ON THE MARKET

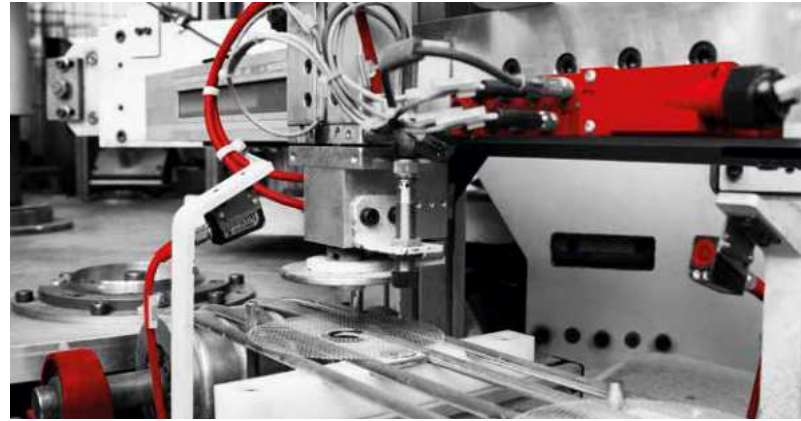
With around 700 employees, state-of-the-art production sites, an enormous wealth of experience and a broad product portfolio, LUKAS is well established on the market. We focus on our customers, combining a pioneering spirit with flexibility and a human touch.



MILLING • GRINDING

DEVELOPING
TOOLS FOR**80** YEARS

• POLISHING • CUTTING • CUSTOMISED TOOLS

**SPECIALIST FOR INNOVATIVE SOLUTIONS**

Today, we are known around the world for our innovative solutions and high-performance tools. If standard solutions don't suit, we develop customised solutions to satisfy every application. This way, both your products and ours will always be ready for whatever the future holds.

EXPERTISE ON CALL

Our development team has many years of experience and a deep knowledge of customers, production and industry. This expertise allows us to help you on site with whatever challenges you are facing. Our experienced experts familiarise themselves with your tasks, applications and processes, so that they can develop a solution that fits perfectly. From developing new products or variations to testing and optimisation, we make sure that your products and services are successful.

10 000CUSTOMISED SOLUTIONS AND NUMEROUS
INNOVATIONS DEPLOYED WORLDWIDE



MODERN LOGISTICS

OPTIMISED PROCESSES FOR ON-DEMAND DELIVERY

FAST, FLEXIBLE AND ON TIME

Our smart logistics system simplifies your warehouse management. High delivery capability, an ultra-modern logistics centre and our speedy shipping agents ensure that the right tool is always there at the right time.

8000

SQUARE METERS OF LOGISTICS SPACE



PERSONAL ON-SITE CONSULTATION

WE SHARE OUR KNOWLEDGE FOR YOUR SUCCESS

SHARING OUR KNOWLEDGE

Visit our TECHNIKUM – where you can have our expertise at your fingertips. Straight after the training class, you'll have a chance to put the theory into practice in our grinding centre next door. And if you have any specific application problems, our application and design engineers have an answer to (almost) every question.

Make the most of our "mobile TECHNIKUM", too. The LUKAS van contains everything you need for a professional tool seminar. Why not use the LUKAS van for a time-saving staff training session at your own premises?

Our popular LUKAS training courses and knowledge transfers are also available in digital form, e.g. as online seminars. Please ask us for details!

200

PEOPLE ATTEND OUR SEMINARS EVERY YEAR



EXPERTISE WITH A HUMAN TOUCH

LUKAS SERVICE AND SALES STAFF ARE JUST A CALL AWAY WORLDWIDE

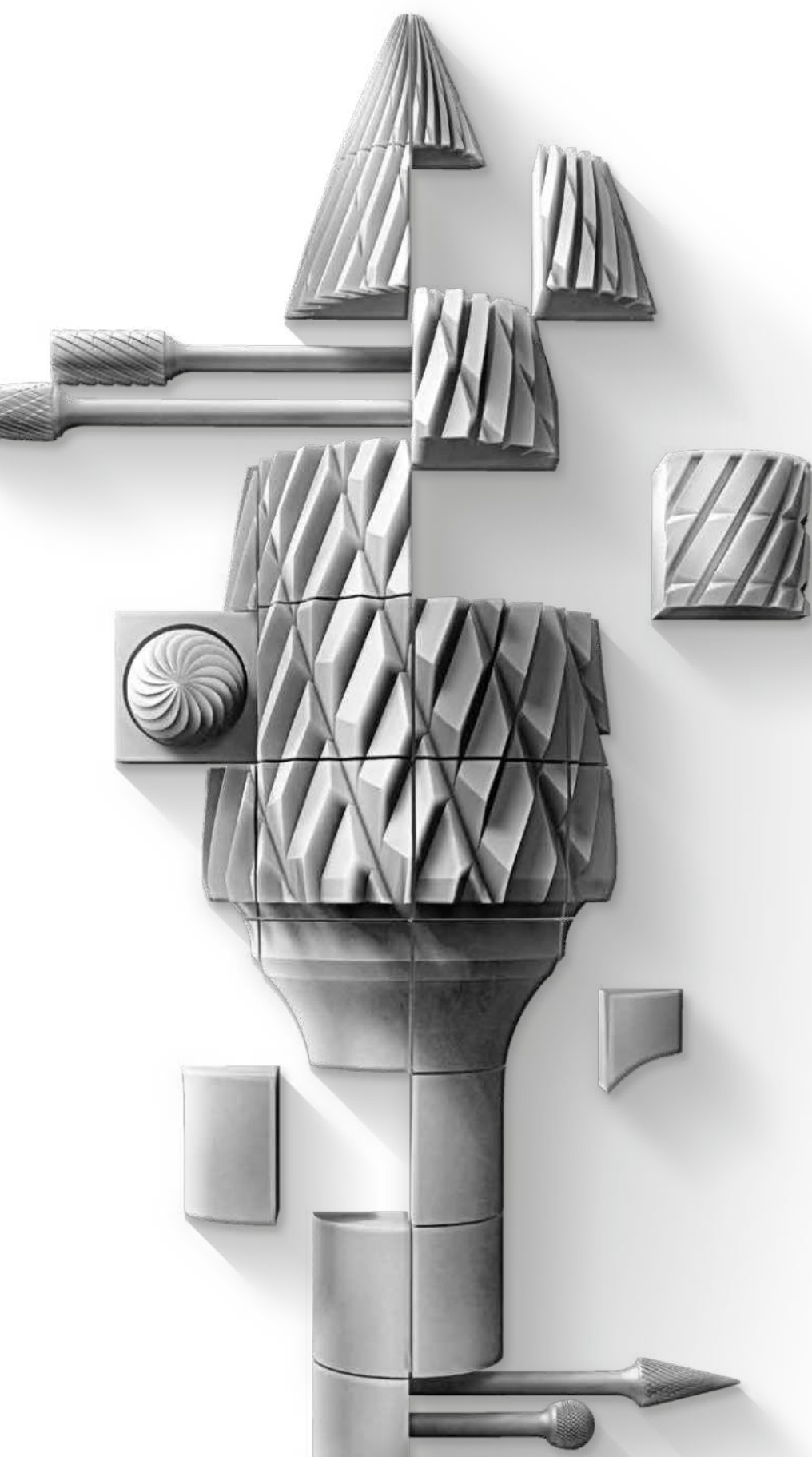
We want our tools to increase your efficiency and success. We know the challenges you face in your day-to-day work. Our experienced LUKAS sales staff have the technical expertise required to give you advice on the phone. They can also come to you

to co-develop the right product and application solutions with you. We speak your language and can help you find the right tool for the job. Get in touch with us!

- expert technical consultation
- local contact partners
- collaborative consultation
- excellent service
- personal customer relations
- help and advice in the event of problems

Contact our sales team at:

le@lukas-erzett.de



MILLING

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS tungsten carbide burrs

QUALITY

LUKAS carbide burrs are manufactured using high-quality solid carbides on modern CNC automatic grinding machines in order to guarantee precision and repeatability of angle, profile and twist. We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

APPLICATION

Selecting the right cut and speed is key for achieving the best results when working with a variety of materials. Please refer to the tables for cut and cutting speed on **page 15**.

POWER TOOLS

Electrical or pneumatic tools, with bearings and collets that are in good condition and run true, are key to getting perfect results. Vibration and chatter will cause premature wear and tooth breakage. Excessive working pressure will increase wear but not increase performance.

SHANKS

For safety reasons, always choose the largest shank diameter available from the table. All burr shanks from LUKAS have a shank diameter tolerance of h9 to ensure safe and smooth assembly. Other shank lengths and diameters are available upon request. See **page 18** for a selection of burrs with extra-long shank.

ROBOT APPLICATION

LUKAS solid carbide burrs are precision tools that have proven themselves in deburring work with industrial robots. We can also develop the perfect tool to suit your application.

SPECIAL TOOLS

We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

PACKAGING

We use plastic packaging. Please refer to the product tables for the respective packaging units.

RECOMMENDATIONS FOR USE

Select the cut according to the material to be machined. The rule of thumb is: **the harder the material, the finer the cut.**


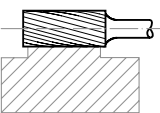
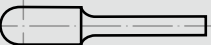
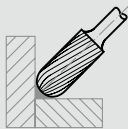
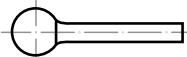
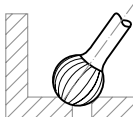

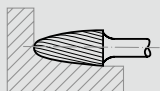

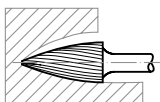

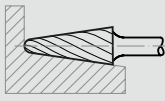
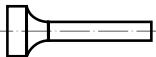
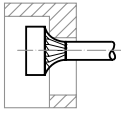
Selecting the right speed is key when it comes to achieving perfect working results and long tool life. The following pages contain information that can help you determine the right speed for your process.


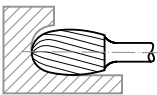


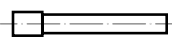
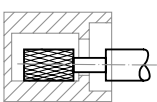
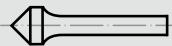
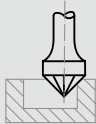

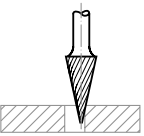
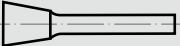
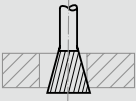

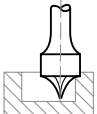
Use the highest speeds possible within the ranges listed. **Speeds that are too low cause vibration, chipping and premature wear!** Reduce the speed of the burrs only when working with large contact angles or materials with low heat conductivity. **Never allow blue discolouration to appear on the shank and head.** For safety reasons, the use of longer shanks requires lower speeds.

Always ensure the settings of your power tool are properly adjusted for the job and material at hand. Avoid a reduction in speed caused by insufficient drive power, especially when using pneumatic machines. Only use collets that run true. Run-out and vibration will result in chipping and premature wear. For the same reasons, make sure that the machine bearings are in perfect condition. To avoid vibrations and shank breakage, select the shortest shank overhang possible.

SHAPE

A summary of available shapes

Shape		Application
	HFA Cylindrical	
	HFC Cylindrical round nose	
	HFD Spherical	
	HFF Arch round nose	
	HFG Arch pointed nose	
	HFL Conical round nose	
	Burrs for radius trimming (internal)	

Shape upon request*		Application
	HFE Oval	
	HFH Flame	
	HFI Internal	
	HFJ Counter sink	
	HFM Conical pointed nose	
	HFN Inverted cone	
	Burrs for radius trimming (external)	

LUKAS BURR SETS

Have the right tool for any application. Choose from our assortment of burrs to try out, test, for your toolbox and much more on **page 21**.

POWER TOOLS

You can find the right power tools for our LUKAS tools on **pages 113–122**. Our power tools are designed for use with LUKAS tools and ensure highly efficient use.

***THE SHAPES ON THE RIGHT ARE AVAILABLE UPON REQUEST!**

RECOMMENDATIONS FOR USE AND CUTS

Three steps to your perfect tungsten carbide burr

STEP 1

Begin by selecting the right **material** and **machining mode** (coarse to fine) from the table.

STEP 2

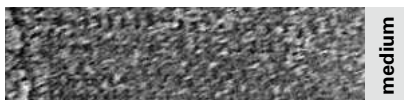
Read off the recommended **cut** and **cutting speed**.

Material	Strength (N/mm ²)	Machining	Cut	Recommended cutting speed v_c (m/min)
● Steel, cast steel	up to 800	coarse	Z3, Z7 Steel, ZX	500–700
		medium	Z5, Z42 Inox/Steel	300–500
		fine	ZF3	500–700
	800 to 1,200	coarse	Z7 Steel, ZX	400–600
		medium	Z5	300–400
		fine	ZF3	400–600
	from 1,200	coarse	Z7 Steel, Z4	300–500
		medium	Z5	300–400
		fine	ZF3	400–600
● Stainless steel	up to 800	coarse	Z2, Z6	400–500
		medium	Z3, Z7 Steel, Z4, Z5, Z42 Inox/Steel	300–500
		fine	ZF3	400–600
● Cast material	150 to 300	coarse	Cast, Z6	400–600
		medium	Z7 Steel	300–500
	300 to 450	coarse	Cast, Z7 Steel	300–500
		medium	Z5	300–500
		fine	ZF3	400–700
● Aluminium	up to 450	coarse	Z9 Alu	600–1,000
		medium	Z1	500–900
● Brass and bronze	up to 450	coarse	Z9 Alu, Z1	400–800
	from 450	medium	Z2	400–600
		fine	ZF3	500–600
● Titanium	up to 900	coarse	Z6	300–500
		medium	Z7 Steel	300–400
		fine	ZF3	500–700
	900 to 1,500	coarse	Z4	300–400
		medium	Z5	400–500
		fine	ZF3	400–600
● Plastic and wood	20 to 400	coarse	Composite coarse/fine, Z1, Z9 Alu	600–1,000
		fine	Composite coarse/fine, Wood	500–900
	400 to 1,000	coarse	Composite coarse/fine, Z1	500–800
		fine	Composite coarse/fine, Z2, Wood	400–800

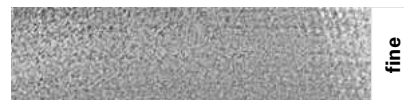
MACHINING



coarse



medium



fine

STEP 3








Determine the appropriate **speed** for your power tool in the second table, based on the tool diameter and cutting speed.








Recommended cutting speed v_c (m/min)									
		300	400	500	600	700	800	900	1,000
Tool diameter (mm)	2	48,000	64,000	80,000	95,000	111,000	127,000	143,000	159,000
	3	32,000	42,000	53,000	64,000	74,000	85,000	95,000	106,000
	4	24,000	32,000	40,000	48,000	56,000	64,000	72,000	80,000
	6	16,000	21,000	27,000	32,000	37,000	42,000	48,000	53,000
	8	12,000	16,000	20,000	24,000	28,000	32,000	36,000	40,000
	10	10,000	13,000	16,000	19,000	22,000	25,000	29,000	32,000
	12	8,000	11,000	13,000	16,000	19,000	21,000	24,000	27,000
	16	6,000	8,000	10,000	12,000	14,000	16,000	18,000	20,000
	20	5,000	6,000	8,000	10,000	11,000	13,000	14,000	16,000
Speed (rpm)									

TIP: You can find the full overview of shapes for your perfect burr on **page 13**.



CUTS

Cut		Properties	Page
	Z9 Alu	very coarse single cut with faceting for soft materials	19
Other cuts are available upon request			
	Z1	coarse cut for soft materials	
	Z2 Brass	robust single cut for high stock removal	
	Z3	medium single cut	
	Z5 Hard	very fine single cut for high-quality surfaces	
	ZF1 to ZF3	fine cross cuts from coarse to very fine for perfect surfaces	
	Wood	rasp cut for pattern construction	

Cut		Properties	Page
	ZX	universal cross cut for almost all applications	17/18
Other cuts are available upon request			
	Z42 Inox/Steel	robust faceted toothing for Inox and steel	
	Z4	fine cross cut for hard materials	
	Z6	robust cross cut	
	Z7 Steel	medium cross cut	
	Cast	robust cross cut specially designed for cast materials	
	Composite Coarse and Fine	cross cut for machining plastic	

COATINGS






Custom optimisation with LUKAS coatings

The use of hard coatings like TiN, TiCN, TiAlN and LTE on cutting tools from LUKAS can help:

- increase tool life
- make the tool more efficient and reduce machine load
- improve chip removal

The increase in tool life is mainly the result of the considerably higher surface hardness of the coating in comparison to the base material of the tool itself. The high chemical stability of the coatings also minimises reactions between the cutting edge of the tool and the chip.

The reduction of machine load and the improvement in chip removal are achieved through a reduction in the friction between the free cutting zone of the tool and workpiece on the one hand, and the cutting edge of the tool and the chip removed on the other. The reduction in friction is due to the coating improving the surface finish and largely preventing chemical reactions. Our technicians would be pleased to help you in the selection of the correct coating.

	Special feature	Properties	Coating	Friction on steel μm
LightFlow 	easy chip removal	<ul style="list-style-type: none"> ■ combines high wear resistance with outstanding friction and non-stick properties when used on graphite, aluminium, copper, carbon, wood and titanium alloys ■ perfect surface treatment for significantly reduced wear 	TT®-ta-C (carbon layer made from solid carbon) see page 19	0.05–0.10 (dry)
AllCoat* 	general purpose	<ul style="list-style-type: none"> ■ general-purpose wear protection when machining ferrous metals (like steel and cast iron) and plastic ■ high toughness ■ food safe ■ biocompatible 	TiN (titanium nitride)	0.65–0.70
HeavyDuty* 	suitable for extreme thermal and mechanical shock loads	<ul style="list-style-type: none"> ■ high-performance coating with high hardness and low heat conductivity for use when machining highly abrasive and hard materials (such as steel, non-rusting steels and stainless steel) ■ for milling under extreme conditions ■ for high-performance cutting 	TiAlN (titanium aluminium nitride)	0.30–0.35
ThermoShock* 	high and sudden thermal shock loads	<ul style="list-style-type: none"> ■ wear-resistant coating, particularly well suited to machining difficult-to-process steel alloys (high and low-alloy steels) ■ for fine deburring 	TiCN (titanium carbon nitride)	0.10–0.20
LowFriction* 	lotus effect	<ul style="list-style-type: none"> ■ special coating with lotus effect for long chip and smearing non-ferrous metals, especially aluminium alloys ■ significantly reduces friction and adhesive wear ■ reduces loading 	LTE (hard, carbon-based coating)	0.10–0.20

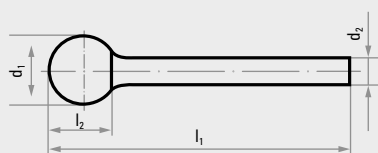
* upon request

ZX UNIVERSAL – SUCCESSFUL ON EVERY MATERIAL

KEEP TOOL CHANGES TO A MINIMUM WITH UNIVERSAL CROSS CUT



ZX Universal burr



- the all-rounder for universal applications
- with cross cut for high performance

★☆☆

Product number	Description	Shape	Cut	Similar to DIN 8033	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	Pack contains
A10010616622	HFA 0616.06 BASE-X		ZX Universal	ZYA 0616	6	16	6	50	10
A10011020622	HFA 1020.06 BASE-X		ZX Universal	ZYA 1020	10	20	6	60	10
A10011225622	HFA 1225.06 BASE-X		ZX Universal	ZYA 1225	12	25	6	65	5
A10020613322	HFC 0613.03 BASE-X		ZX Universal	WRC 0613	6	13	3	43	10
A10020820622	HFC 0820.06 BASE-X		ZX Universal	WRC 0820	8	20	6	60	10
A10021020622	HFC 1020.06 BASE-X		ZX Universal	WRC 1020	10	20	6	60	10
A10021225622	HFC 1225.06 BASE-X		ZX Universal	WRC 1225	12	25	6	65	5
A10030403322	HFD 0403.03 BASE-X		ZX Universal	KUD 0403	4	3	3	34	10
A10030807622	HFD 0807.06 BASE-X		ZX Universal	KUD 0807	8	7	6	47	10
A10031210622	HFD 1210.06 BASE-X		ZX Universal	KUD 1210	12	10	6	51	5
A10100313322	HFF 0313.03 BASE-X		ZX Universal	RBF 0313	3	13	3	40	10
A10100618622	HFF 0618.06 BASE-X		ZX Universal	RBF 0618	6	18	6	50	10
A10101225622	HFF 1225.06 BASE-X		ZX Universal	RBF 1225	12	25	6	65	5
A10040313322	HFG 0313.03 BASE-X		ZX Universal	SPG 0313	3	13	3	40	10
A10040613322	HFG 0613.03 BASE-X		ZX Universal	SPG 0613	6	13	3	43	10
A10040820622	HFG 0820.06 BASE-X		ZX Universal	SPG 0820	8	20	6	60	10
A10041020622	HFG 1020.06 BASE-X		ZX Universal	SPG 1020	10	20	6	60	10
A10041225622	HFG 1225.06 BASE-X		ZX Universal	SPG 1225	12	25	6	65	5
A10041230622	HFG 1230.06 BASE-X		ZX Universal	SPG 1230	12	30	6	65	5

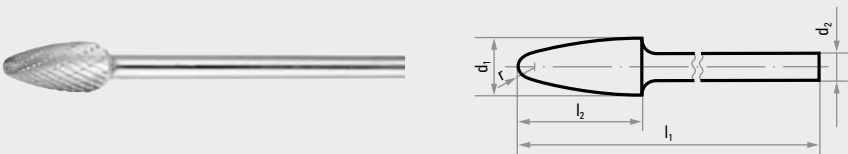
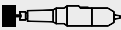
Recommended for: Steel Cast material Inox/Steel Titanium

CUTTING EVEN IN HARD-TO-REACH PLACES

WITH AN EXTRA-LONG SHANK AND UNIVERSAL TOOTHING



ZX Universal burr with extra-long shank



- shank length: 150 mm
- the all-rounder for universal applications
- with cross cut for high performance

Product number	Description	Shape	Cut	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	n _{max} rpm	Pack contains
A10020820622150	HFC 0820.06 BASE-X		ZX Universal	8	20	6	170	5,500	1
A10021225622150	HFC 1225.06 BASE-X		ZX Universal	12	25	6	175	3,600	1
A10030807622150	HFD 0807.06 BASE-X		ZX Universal	8	7	6	157	7,900	1
A10031009622150	HFD 1009.06 BASE-X		ZX Universal	10	9	6	159	6,600	1

Recommended for: Steel Cast material Inox/Steel Titanium



SAFETY ADVICE

To prevent shank breakage, never exceed the maximum permitted speed when there is no tool contact (see product table). You may work at twice the maximum permitted speed only if the burr is in contact

with the workpiece or inserted into a channel or borehole before the power tool is switched on, and remains there until the power tool comes to a complete standstill.

REDUCING WEAR WITH LIGHTFLOW

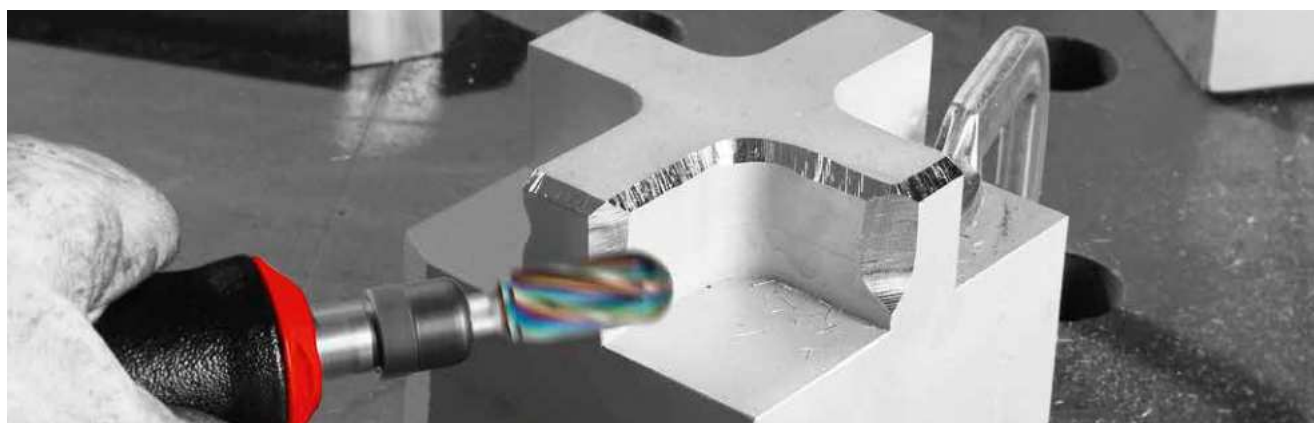
IDEAL SURFACE TREATMENT WITH OUTSTANDING NON-STICK PROPERTIES

The new LightFlow coating from LUKAS is perfect for reducing friction between the tool and the material surface. It lets you create excellent surfaces while also extending the tool life of the burr. This coating prevents the burr from becoming clogged with aluminium chips, therefore reducing machine load and maintaining a consistent speed. There is no sticking or smear-

ing. This lets you work for longer without having to clean or replace the tool.

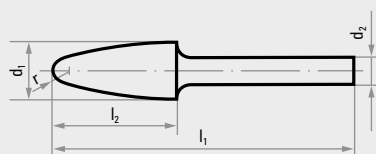
Application areas of the coating:

cutting graphite, aluminium, copper, carbon composites and wood



Z9 Alu burr with LightFlow coating **NEW**

- process aluminium with razor-sharp cutting edges
- the perfect synergies between burr and LightFlow coating
- high chip volume thanks to coarse cut for quick work
- faceted toothing for perfect surface results
- maximum cutting cross section for effortless processing



★★★

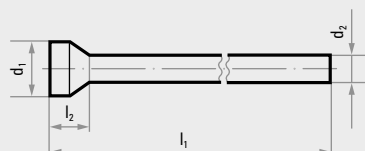
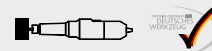
Product number	Description	Shape	Cut	Similar to DIN 8033	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	Pack contains
A10020616609LF	HFC 0616.06		Z9 Alu	WRC 0616	6	16	6	50	1
A10021225609LF	HFC 1225.06		Z9 Alu	WRC 1225	12	25	6	65	1
A10100618609LF	HFF 0618.06		Z9 Alu	RBF 0618	6	18	6	50	1
A10101225609LF	HFF 1225.06		Z9 Alu	RBF 1225	12	25	6	65	1
A10071230609LF	HFL 1230.06		Z9 Alu	KEL 1230	12	30	6	70	1

Recommended for: ● Aluminium ● Plastic/Wood

BACK DEBURRING MADE EASY

CREATE CHAMFERS IN PIPES, CONTAINERS AND DESIGN COMPONENTS

Z3 Universal inverse deburring tool (internal)



- defined 45° bevel
- for different bore diameters
- variable chamfer width
- fast work result

Applications:

- back deburring of boreholes on difficult-to-reach areas
- excellent for use in pipes, containers and design components
- back chamfering of boreholes

★★☆

Product number	Description	Cut	d ₁ mm	l ₂ mm	d ₂ mm	l ₁ mm	Pack contains
A10170504303	HFT 0504.03	Z3 Universal	5	4	3	40	1
A10170705303	HFT 0705.03	Z3 Universal	7	5	3	40	1
A10171006603	HFT 1006.06	Z3 Universal	10	6	6	60	1
A10171207603	HFT 1207.06	Z3 Universal	12	7	6	65	1
A10171811803	HFT 1811.08	Z3 Universal	18	11	8	120	1

Recommended for: ● Steel ● Inox/Steel ● Aluminium ● Cast material ● Titanium



SAFETY ADVICE

Reduced speed for burrs with a total length $l_1 = 120$ mm: max. 11,000 m²

Carbide burrs assortments



- Always the right tool at hand. With our practical tool assortments, you can always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry



Set HM INOX S6



Set HM ALU S6

★★☆

Product number	Description	Cut	Shank Ø mm	Content 1 per pack			Pack contains
A1039001020	Set HM INOX S6	Z42 Inox/Steel	6	10 parts: HFA 0616 HFC 1225 HFG 0618 HFF 1225	HFA 1225 HFD 0605 HFG 1225	HFC 0616 HFD 1210 HFF 0618	1
Recommended for: ● Inox/Steel ● Steel ● Cast material							
A10390005096	Set HM ALU S6	Z9 Alu	6	5 parts: HFA 0616 HFF 0618	HFC 0616 HFD 0605	HFM 0618	1
Recommended for: ● Aluminium ● Plastic/Wood							



ZX Universal carbide burrs assortments

- Always the right tool at hand. With our practical tool assortments, you can always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry
- the all-round burr for universal applications, with cross cut for high performance



F5 S3 BASE-X

★★☆☆

Product number	Description	Cut	Shank Ø mm	Content 1 per pack			Pack contains
A10390053	F5 S3 BASE-X	ZX Universal	3	5 parts: HFA 0313 HFF 0313	HFC 0313 HFG 0313	HFD 0605	1
A10390056	F5 S6 BASE-X	ZX Universal	6	5 parts: HFA 1225 HFF 1225	HFC 1225 HFG 1225	HFD 1210	1
Recommended for: ● Steel ● Cast material ● Inox/Steel ● Titanium							



- 2.1 Mounted points
- 2.2 Polishing tools

GRINDING AND POLISHING

(with bonded tools)

24–35
36–47

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Mounted points from LUKAS

EFFICIENT AND PROFESSIONAL GRINDING

LUKAS mounted points are premium grinding tools with a long tool life that deliver high removal performance. They are perfect for efficient and effective rough processing, fettling, preparing and reworking weld seams, and for deburring.

From cutting to fine machining, we offer a range of mounted points in various shapes, sizes and finishes so that you always have the right grinding tool for the job. LUKAS mounted points 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 cutting to fine machining. This requires mounted points that deliver the right balance of machining performance and tool life, while achieving the desired surface quality. Manufacturing quality mounted points 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.

EKR

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 mounted points. The abbreviations for the respective abrasives can be found in the quality designation of the LUKAS tools (see right).

These qualities are available upon request



EKR

Pink aluminium oxide

★★☆



NK

Regular aluminium oxide

★★☆



HK

Mixture EKW/NK

★★☆



SIC-ALU

Green silicon carbide

★★★



CERAMIC

Ceramic grain and monocrystal aluminium oxide

★★★



EKD

Dark red aluminium oxide

★★☆



EKbr

Pink aluminium oxide, type brown

★★☆



HKD

Mixture EKW/EKD

★★☆



RKD

Mixture of dark red and pink aluminium oxide

★★☆



NDW

Mixture of regular aluminium oxide, dark red aluminium oxide and white monocrystal aluminium oxide

★★★



EKW

White aluminium oxide

★★☆



MK

Mixture EKR/NK

★★☆



MKD

Mixture NK/EKD

★★☆



SICdki

Dark silicon carbide

★★☆



HOK

Mixture of spherical aluminium oxide

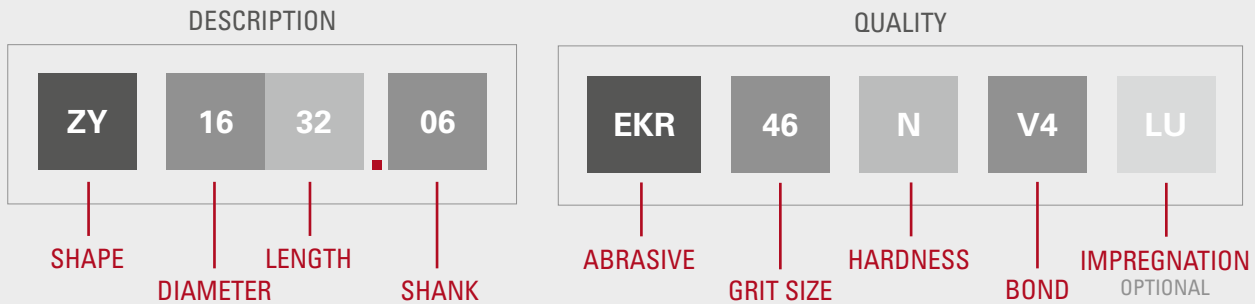
★★☆

DESIGNATION OF MOUNTED POINTS

All the important information in the product designation

LUKAS bonded grinding and polishing tools have all the important values and identifiers in the product designation, making it easy for you to find the right one for your requirements.

The overview below shows the individual elements and their content.



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
4	30	70	230
5	36	80	240
6	46	90	280
7	54	100	320
8	60	120	360
10	–	150	400
12	–	180	500
14	–	220	800
16	–	–	1.200
20	–	–	2.000
24	–	–	–

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	H	L	P	T	X
B	F	I	M	Q	U	Y
C	G	Jot	N	R	V	Z
D	–	K	O	S	W	–

V4

BOND

The bond holds the abrasive grain to the grinding wheel. The most important bond types as per ISO 525 are:

Vitrified bond:

- **V** = vitrified bond

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

Organic bond:

- **BA** = resin bond
- **R** = rubber bond or bond using other elastomers
- **RF** = rubber bond, reinforced

LU

IMPREGNATION (OPTIONAL)

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

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

TECHNICAL INFORMATION

Qualities and areas of application

We have created a range of different shapes and dimensions in proven qualities from the full spectrum of possibilities described here. These mounted points are available from stock.














Quality recommendations apply for ideal operating conditions.



best suitable



suitable

Page		Reference/ Qualities	Cutting speed v_c m/s	Materials							
				Steel/ cast steel	Alloyed/ tempered steels	Tool steels	Rust-, acid- and heat-resistant steel and cast steel	Cast iron	Aluminium, magnesium and copper alloys	Titanium and nickel alloys	Plastic/ wood/ rubber
32/33		EKR Pink aluminium oxide	approx. 20–35								
34		NK-BA soft Regular aluminium oxide iron- and sulphur-free	approx. 40–50								
35		HK White aluminium oxide and regular aluminium oxide	approx. 40–50								
30		Ceramic Ceramic grain and monocrystal aluminium oxide	approx. 30–50								
31		SIC-ALU Green silicon carbide	approx. 25–40								
These qualities are available upon request											
		EKWbr White aluminium oxide type brown	approx. 25–40								
		RKD Dark red and pink aluminium oxide	approx. 30–50								
		NK-BA hard Regular aluminium oxide	approx. 40–50								
		MK Pink aluminium oxide and regular aluminium oxide	approx. 30–50								
		NDW Dark red aluminium oxide, regular and monocrystal aluminium oxide	approx. 10–30								
		EKW White aluminium oxide	approx. 20–35								
		EKbr Pink aluminium oxide, type brown	approx. 40–50								
		HOK Spherical aluminium oxide	approx. 5–20								

TECHNICAL INFORMATION

Speeds for grinding tools

GRINDING AND POLISHING
(with bonded tools)

Recommended cutting speed v_c (m/s)									
		5	10	20	30	40	50	63	80
Tool diameter (mm)	2	47,700	95,500	191,000	286,500	382,000	477,500	601,600	763,900
	3	31,800	63,700	127,300	191,000	254,600	318,300	601,600	509,300
	4	23,900	47,700	95,500	143,200	191,000	238,700	300,800	382,000
	5	19,100	38,200	76,400	114,600	152,800	191,000	240,600	305,600
	6	15,900	31,800	63,700	95,500	127,300	159,200	200,500	254,600
	8	11,900	23,900	47,700	71,600	95,500	119,400	150,400	191,000
	10	9,500	19,100	38,200	57,300	76,400	95,500	120,300	152,800
	13	7,300	14,700	29,400	44,100	58,800	73,500	92,600	117,500
	20	4,800	9,500	19,100	28,600	38,200	47,700	60,200	76,400
	25	3,800	7,600	15,300	22,900	30,600	38,200	48,100	61,100
	32	3,000	6,000	11,900	17,900	23,900	29,800	37,600	47,700
	40	2,400	4,800	9,500	14,300	19,100	23,900	30,100	38,200
	50	1,900	3,800	7,600	11,500	15,300	19,100	24,100	30,600
	60	1,600	3,200	6,400	9,500	12,700	15,900	20,100	25,500
	80	1,200	2,400	4,800	7,200	9,500	11,900	15,000	19,100
	100	1,000	1,900	3,800	5,700	7,600	9,500	12,000	15,300
Speed (rpm)									

SAFETY ADVICE

Safe grinding

PERIPHERAL SPEEDS

Our mounted points are manufactured to state-of-the-art standards, and carefully checked and tested. Their safety corresponds to EN 12413.

We produce mounted points with vitrified and resin bonds for an increased maximum peripheral speed of 50 m/s.

The maximum peripheral speed is limited by the following criteria:

1. Mass (weight) of the mounted point
2. Shape of the mounted point
3. Shank diameter
4. Shank overhang
5. Shank material
6. The concentricity of the mounted point



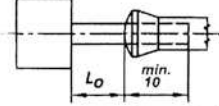

SAFETY

Safety is an essential mark of quality for any grinding tool. When using and storing mounted points, always observe the safety and accident prevention regulations, along with the FEPA safety recommendations.

Our products are delivered with a safety ticket, as shown below, which indicates the maximum permitted speed for a certain overhang length (open shank length).

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

MULTILINGUAL
PRODUCT DESIGNATIONPRODUCT NUMBER AND
PRODUCT SPECIFICATIONTECHNICAL
INFORMATION

Schleifkörper keramisch Brousicí tělíska keramická Mounted points - vitrified Muelas cerámicas Meules vitrifiées Sciernice spojone ceramiczne		 ★★★☆☆	
A200002032602 ZY 2032.06 EKR 36 N V4		Menge / VPE 20	 EN 12413
L _o (mm) max. rpm 10 40.600 15 34.500 20 29.700			FA1488310  4 027497 013296
LUKAS-ERZETT Vereinigte Schleif- und Fräswerkzeugfabriken GmbH & Co. KG Gebrüder-Lukas-Straße 1 - 51766 Engelskirchen Made in Germany			

PRODUCT LINE

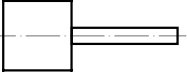
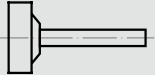
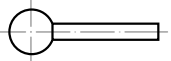
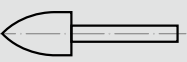

SAFETY STANDARD

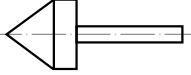
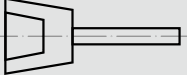
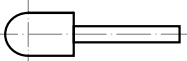
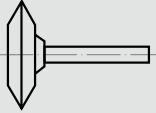
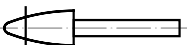
SERIAL NUMBER

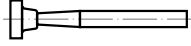

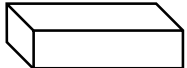
EAN CODE

SHAPE

Summary of available shapes

Shape	
	ZY Cylindrical, type 1
	ZY2 Cylindrical, type 1
	KU Spherical
	SP Arch pointed nose
	KE Conical round nose

Other shapes are available upon request*	
	WKS Cylindrical pointed nose
	TO Cup
	WR Cylindrical round nose
	American shape A
	American shape B

Other shapes are available upon request*	
	Miniature mounted points
	SE Taper-sided grinding wheel
	RU Sharpening stones

*THIS SHAPES ARE **AVAILABLE**
UPON REQUEST!

POWER TOOLS

You can find the right power tools for our LUKAS tools on **pages 113–122**. Our power tools are designed for use with LUKAS tools and ensure highly efficient use.

QUALITIES AND PROPERTIES

Mounted points for machining tool steels

**CERAMIC**

Mixture of ceramic grain and monocrystal aluminium oxide

★★★

MATERIAL PROPERTIES

In the mould and die industry it is all about precision. Tool steels are produced to be hard and strong enough for their purpose. As a result, special grinding tools are required to process workpieces to the limits of their tolerances.

INDUSTRIES

- Tool construction
- Pattern construction
- Mould-making
- Aerospace engineering

PROCESSING EXAMPLES

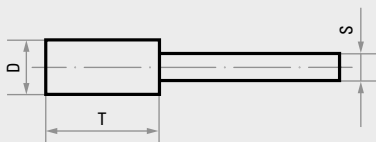
- Re-grinding transitions
- Groove grinding
- Fine deburring
- Fine grinding

- Lap grinding
- Coordinate grinding
- Ball bearing grinding
- Turbine blades

LUKAS GRINDING TOOLS

LUKAS mounted points for mould and die industry are extremely dimensionally stable and can cut even the hardest materials. Ceramic grain is extremely friable due to its microcrystal structure, making it self-sharpening. Materials that are difficult to cut (e.g. nickel-based alloys) can therefore be machined without any problems. Moreover, the use of special grain qualities ensures a long tool life. Our comprehensive product range lets you reach and process even the most inaccessible areas.

Ceramic mounted point



★★★

- maximum sharpness and hardness with ceramic self-sharpening effect
- impressive tool life
- high and fast removal rate, especially on hardened surfaces, scale, hard coatings and reinforced weld seams

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000613377	ZY 0613.03		Ceramic 80 LV118	6	13	3 x 30	20
A200001325677	ZY 1325.06		Ceramic 46 LV118	13	25	6 x 40	20
A200001632677	ZY 1632.06		Ceramic 46 LV118	16	32	6 x 40	20
A200200816377	SP 0816.03		Ceramic 80 LV118	8	16	3 x 30	20
A200201320677	SP 1320.06		Ceramic 80 LV118	13	20	6 x 40	20
A201101010677	KU 1010.06		Ceramic 46 LV118	10	10	6 x 40	20

Recommended for: Inox/Steel Steel Titanium

QUALITIES AND PROPERTIES

Mounted points for machining non-ferrous metals

**SIC-ALU**

Green silicon carbide

★★★

MATERIAL PROPERTIES

Aluminium and its respective alloys have many varied and positive characteristics, making it the second most widely used metal after steel.

Aluminium has only 1/3 the density of steel. The purer the metal, the weaker it becomes, but this allows for better shape forming. Using unsuitable mounted points, however, can lead to smearing and clogging.

INDUSTRIES

- Transportation (railways, ships, automotive, aerospace)
- Metal construction (bridges, cranes, silos)
- Apparatus engineering
- Aluminium die-cast

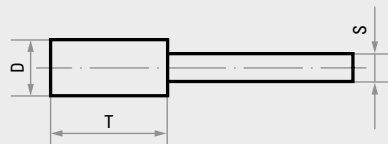
- Chemical industry (vessels, pumps, pipes)
- Engines, transmission parts
- and many more

PROCESSING EXAMPLES

- Deburring
- Fettling
- Finishing
- Surface finishing

LUKAS GRINDING TOOLS

Our SIC-ALU mounted points were developed specifically for this application. A special structure ensures maximum tool life whilst preventing material from clogging the pores. The self-sharpening effect is aided by the use of a special impregnation.

**SIC-ALU mounted point**

- special quality for grinding aluminium

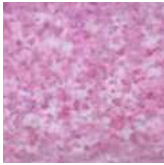
★★★

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200001013618A	ZY 1013.06		SIC-ALU 80 V27 W	10	13	6 x 40	20
A200001332618A	ZY 1332.06		SIC-ALU 80 V27 W	13	32	6 x 40	20
A200001632618A	ZY 1632.06		SIC-ALU 80 V27 W	16	32	6 x 40	20
A201501632618A	KE 1632.06		SIC-ALU 80 V27 W	16	32	6 x 40	20

Recommended for: Aluminium

QUALITIES AND PROPERTIES

Mounted points for machining steel and cast steel

**EKR**

Pink aluminium oxide

★★☆

MATERIAL PROPERTIES

The wide range of different steel types and workpieces made from them require mounted points with properties that cover this broad spectrum as much as possible.

PROCESSING EXAMPLES

- General rough grinding
- Fettling
- Rough grinding of weld seams
- Finish grinding of weld seams
- Deburring

INDUSTRIES

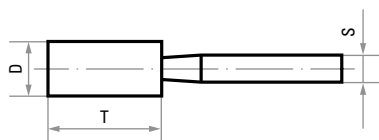
- Mechanical engineering
- Automotive engineering
- Toolbuilding
- Vessel and equipment manufacturing
- Shipyards
- and many more

LUKAS GRINDING TOOLS

The wide selection of LUKAS grinding tools includes countless shapes, sizes and qualities. You will find the correct tool from our standard range to solve most grinding problems, irrespective of the material, type of power tool or any other influencing factors. These mounted points are designed for high stock removal and long tool life.



EKR mounted point



- perfect results on structural steel and for rough grinding with aluminium oxide
- extremely hard and sharp for a long tool life
- also cuts harder materials efficiently

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000306302	ZY 0306.03		EKR 100 NV4	3	6	3 x 30	20
A200000510302	ZY 0510.03		EKR 80 NV4	5	10	3 x 30	20
A200000610302	ZY 0610.03		EKR 60 NV4	6	10	3 x 30	20
A200000816602	ZY 0816.06		EKR 60 NV4	8	16	6 x 40	20
A200001013302	ZY 1013.03		EKR 60 NV4	10	13	3 x 30	20
A200001020602	ZY 1020.06		EKR 60 NV4	10	20	6 x 40	20
A200001320602	ZY 1320.06		EKR 46 NV4	13	20	6 x 40	20
A200001632602	ZY 1632.06		EKR 46 NV4	16	32	6 x 40	20
A200002032602	ZY 2032.06		EKR 36 NV4	20	32	6 x 40	20
A200002040602	ZY 2040.06		EKR 36 NV4	20	40	6 x 40	20
A200002532602	ZY 2532.06		EKR 36 NV4	25	32	6 x 40	20
A200003232602	ZY 3232.06		EKR 30 NV4	32	32	6 x 40	20
A200004040602	ZY 4040.06		EKR 30 NV4	40	40	6 x 40	20
A201301303302	ZY2 1303.03		EKR 80 NV4	13	3	3 x 30	20
A201302506602	ZY2 2506.06		EKR 60 NV4	25	6	6 x 40	20
A201303208602	ZY2 3208.06		EKR 46 NV4	32	8	6 x 40	20
A201305010602	ZY2 5010.06		EKR 30 NV4	50	10	6 x 40	20
A200200510302	SP 0510.03		EKR 80 NV4	5	10	3 x 30	20
A200200816302	SP 0816.03		EKR 60 NV4	8	16	3 x 30	20
A200201320602	SP 1320.06		EKR 46 NV4	13	20	6 x 40	20
A200202032602	SP 2032.06		EKR 36 NV4	20	32	6 x 40	20
A201100808302	KU 0808.03		EKR 60 NV4	8	8	3 x 30	20
A201101010602	KU 1010.06		EKR 60 NV4	10	10	6 x 40	20
A201101616602	KU 1616.06		EKR 46 NV4	16	16	6 x 40	20
A201102020602	KU 2020.06		EKR 36 NV4	20	20	6 x 40	20
A201102525602	KU 2525.06		EKR 36 NV4	25	25	6 x 40	20
A201501632602	KE 1632.06		EKR 46 NV4	16	32	6 x 40	20
A201502032602	KE 2032.06		EKR 36 NV4	20	32	6 x 40	20
A201502570602	KE 2570.06		EKR 36 NV4	25	70	6 x 40	20

Recommended for: ● Steel

QUALITIES AND PROPERTIES

Mounted points for machining non-rusting steels

**NK-BA SOFT**

Regular aluminium oxide with resin bond, iron- and sulphur-free

★★☆

MATERIAL PROPERTIES

Non-rusting steels are difficult to machine. They tend to smear due to the nickel content, while their poor heat conductivity often causes the material to overheat within the grinding contact zone.

PROCESSING EXAMPLES

- Rough and finish grinding
- Deburring
- Fettling
- Finishing weld seams
- Surface finishing

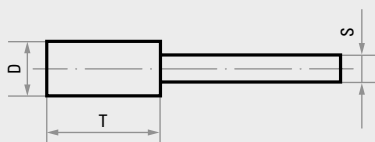
INDUSTRIES

- Steel construction and fabrication (façades, handrails, sanitary equipment)
- Vessel manufacturing
- Casings and panelling
- Medical technology
- Shipyards
- Food industry
- and many more

LUKAS GRINDING TOOLS

LUKAS has developed particularly high-performance tools for non-rusting steels that deliver exceptional stock removal, even under adverse conditions.

These tools do not contain any iron, sulphur or halogens. This generally prevents chemical reactions (corrosion) of the workpiece material in the grinding contact zone.

NK soft mounted point

★★☆

- for non-rusting steels
- excellent removal rates, also under difficult conditions

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200001632627W	ZY 1632.06		NK 24 N BA soft	16	32	6 x 40	20
A200002040627W	ZY 2040.06		NK 24 N BA soft	20	40	6 x 40	20
A200002532627W	ZY 2532.06		NK 24 N BA soft	25	32	6 x 40	20
A200003232627W	ZY 3232.06		NK 24 N BA soft	32	32	6 x 40	20
A200004020627W	ZY 4020.06		NK 24 N BA soft	40	20	6 x 40	20
A200005020627W	ZY 5020.06		NK 24 N BA soft	50	20	6 x 40	20
A201305004627W	ZY2 5004.06		NK 24 N BA soft	50	4	6 x 40	20
A201305010627W	ZY2 5010.06		NK 24 N BA soft	50	10	6 x 40	20

Recommended for: ● Inox/Steel ● Steel ● Aluminium

QUALITIES AND PROPERTIES

Mounted points for machining cast materials

**HK**

Mixture of white aluminium oxide and regular aluminium oxide

★★☆

MATERIAL PROPERTIES

The characteristics of the various types of cast materials are normally determined by their carbon content and the way in which the carbon is removed from the material structure. Cast materials are generally rough machined. The skin contains inclusions of sand from the casting process; large burrs, sprues and risers, holes and cracks must all be removed by grinding. These areas to be ground are often difficult to reach.

INDUSTRIES

Manufacturers of cast components such as engine blocks, gear box casings, cylinder heads, frames, stands, machine slides, gears, crankshafts, pump and turbine housings, machine tool components and many more.

PROCESSING EXAMPLES

- Deburring
- Fettling
- Polishing
- Finish grinding of repair welds
- Removing holes and cracks

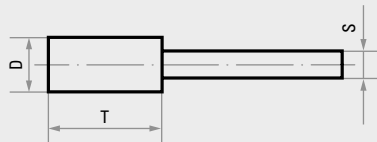
LUKAS GRINDING TOOLS

LUKAS mounted points for grinding cast materials contain special grain mixtures and tough bonding systems, delivering excellent performance in the applications mentioned above.

The aggressiveness of the abrasive grain and the smooth running of the mounted points allow for ergonomic machining with minimum force. Mounted points with specially extended shanks are also available on request.



- perfect for grinding cast materials
- special grain mixture ideally suited to the material
- for ergonomical working with minimum force

**HK mounted point**

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200001632633	ZY 1632.06		HK 30 N V13	16	32	6 x 40	20
A200002032633	ZY 2032.06		HK 30 N V13	20	32	6 x 40	20
A200002532633	ZY 2532.06		HK 30 N V13	25	32	6 x 40	20
A200004020633	ZY 4020.06		HK 30 N V13	40	20	6 x 40	20
A201305010633	ZY2 5010.06		HK 30 N V13	50	10	6 x 40	20

Recommended for: ● Cast material ● Inox/Steel

GENERAL INFORMATION AND PRODUCT INFORMATION

Polishing tools from LUKAS – groups P1 to P7

Whether you need to achieve certain technical surface values for your product or just want to make it shine, there are many good reasons to choose polishing tools from LUKAS.

In sectors such as the automotive industry, aerospace, and pump and turbine engineering, there are plenty of sealing surfaces and fits that must be produced with high precision to achieve the right result. In the food and pharmaceutical industries, polished surfaces ensure hygienic clean working conditions. In mould and die industry, surfaces are polished to a mirror finish; with any casting, the result is a perfect end product.

In response to the growing importance of fine machining, LUKAS has developed a wide range of polishing tools, featuring a variety of raw materials, grain combinations and hardness levels. LUKAS polishing tools are categorised into groups P1 to P7 according to the respective application. These tools include polishing wheels, points and sticks to cover a wide variety of applications. The diagram on the next page provides an overview.

Bonding type	Properties	Page
P1*	Polishing points consist of a hard rubber bonding with size 100 abrasive grains. They are suitable for fine finishing applications and the preparation of surfaces that require further polishing.	–
P2	Polishing points and wheels are manufactured using a soft rubber bond in grit sizes 46 to 800. These tools are perfect for creating grained to dash-dot matted finishes on small surface areas. To achieve the required result, tools with different grit sizes should be used one after the other.	39 / 40
P3	Felt polishing tools are used in combination with SIC or diamond polishing paste to achieve the best results, even up to a mirror finish.	41–43
P4*	Polishing sticks are manufactured from polyurethane (PU). Areas of application and the results are similar to those detailed in group P2. Polishing sticks are used manually.	–
P5*	Polishing points contain a fibre reinforcement for a longer tool life. The surface finish achieved lies between group P1 and P2.	–
P6	Polishing tools are available in various forms – polishing points, marbling points, rolls for satin finishes, polishing wheels and polishing discs. The hardness of the polyurethane bonding (PU) can be divided into seven grades, from soft to hard, with available grit sizes of SIC 24 to F1200. This makes the tools suitable for many different uses, including larger surfaces. The main application with polishing wheels is on stationary polishing machines, e.g. cylindrical polishing of tubes.	44–48
P7*	Polishing points with a 2.35 mm shank diameter use SIC grain in sizes 240 or 400 in a silicon bond. These small tools are very soft and are ideal for polishing jewellery and other small parts.	–
* upon request		

SAFETY INSTRUCTIONS AND AREAS OF APPLICATION

Safe polishing with tested tools

SAFETY INSTRUCTIONS

The LUKAS polishing points in groups P1 and P5 are manufactured according to EN 12413 and have a maximum permitted peripheral speed of 50 m/s. Products in group P2 may be operated up to a maximum speed of 16 m/s. The maximum permitted peripheral speed of product group P6 depends on the tool hardness. For MWP, for example, this is 20 m/s.

The ideal speed generally lies below the maximum permitted speed, however. This reduces the generated heat and

prolongs the increases tool life. LUKAS polishing points are delivered with a safety ticket indicating the maximum speeds for the various shank overhangs.

To ensure safe use of polishing points and wheels, please observe the following operating instructions:

- FEPA safety recommendations for the correct use of abrasive products
- FEPA safety code for bonded abrasives

GRINDING AND POLISHING
(with bonded tools)

FIND THE RIGHT POLISHING TOOL FOR YOUR PROCESS STEP

The LUKAS range of polishing tools covers a variety of shapes and sizes. Specially developed for fine processing and polishing on surfaces, we offer a broad spectrum of polishing tools to help you achieve the desired result every time. Made from premium raw materials, our polishing points, wheels, sticks and rollers let

you polish in a way that's best suited to the application, all the way to a gloss or high-gloss polish. Simply choose your desired polishing finish from the table below and find the right LUKAS polishing tool group (P1 – P7) to achieve it.

	Polishing tool hardness				
	hard	medium	soft		
Mirror finish	P6 Polyurethane	P2 Soft rubber	P4 Polyurethane	P3 Felt and paste	2,000
					1,200
					800
					400
Matt finish	P5 Rubber with fibre reinforcement			P7 Soft elastomer	280
					220
					150
Dash-dot matting	P1 Hard rubber				120
					80
					46
Marbling					24
Polishing					18

Grit sizes (to ISO 525)

TECHNICAL INFORMATION

Speeds for polishing tools

		Recommended cutting speed v_c (m/s)								
		2	5	8	10	16	20	25	32	50
Polishing group (Bonds)		P1								
		P2/P4/P6 WP/P7					P5			
		P3			P6 MWP					
						P6 MP			P6 HP/P6 SHP	
								P6 SHP CG		
Tool diameter (mm)	4	9,500	23,800	38,100	47,700	76,300	95,400	119,300	152,700	238,700
	6	6,300	15,900	25,400	31,800	50,900	63,600	79,500	101,800	159,100
	8	4,700	11,900	19,000	23,800	38,100	47,700	59,600	76,300	119,300
	10	3,800	9,500	15,200	19,000	30,500	38,100	47,700	61,100	95,400
	16	2,300	5,900	9,500	11,900	19,000	23,800	29,800	38,100	59,600
	20	1,900	4,700	7,600	9,500	15,200	19,000	23,800	30,500	47,700
	25	1,500	3,800	6,100	7,600	12,200	15,200	19,000	24,400	38,100
	32	1,100	2,900	4,700	5,900	9,500	11,900	14,900	19,000	29,800
	40	900	2,300	3,800	4,700	7,600	9,500	11,900	15,200	23,800
	50	700	1,900	3,000	3,800	6,100	7,600	9,500	12,200	19,000
	75	500	1,200	2,000	2,500	4,000	5,000	6,300	8,100	12,700
	100	300	900	1,500	1,900	3,000	3,800	4,700	6,100	9,500
	150	200	600	1,000	1,200	2,000	2,500	3,100	4,000	6,300
	200	100	400	700	900	1,500	1,900	2,300	3,000	4,700
250	100	300	600	700	1,200	1,500	1,900	2,400	3,800	
		Speed (rpm)								



The ideal/recommended speed for polishing tools is usually lower than the maximum speed. Excessively high speeds generate more heat.

SHAPE

Summary of available shapes

Shape		Available in following product groups
	Cylindrical, type 1	P1*, P2, P3, P5*, P6*
	Cylindrical, type 2	P1*, P2
	Conical	P1*, P2, P3*
	Spherical	P2, P3, P5*
* upon request		
Other shapes are available upon request		
	Roll	P6
	Stick	P4

Shape		Available in following product groups
	Arch pointed nose	P2, P3, P5*
	Cylindrical round nose	P1*, P2
	Wheel	P3, P6*
	Flap disc	P6
* upon request		
Other shapes are available upon request		
	Disc	P7
	Lens	P7

POLISHING GROUP P2

Matt finish even on small surfaces

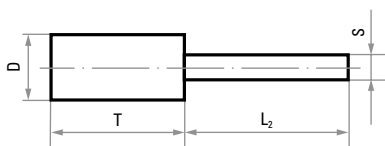
The polishing points in this group are available in the seven grit sizes shown below, and in a variety of shapes and sizes. They are colour-coded to prevent any confusion and to avoid any errors in the polishing process. The soft rubber bonding allows for a very soft grinding effect. Polishing points in the P2 group are mainly used on a pre-machined surface where a fine to gloss polished finish is required. Polishing wheels in this group are also available with a max. diameter of 200 mm in the indicated grit sizes. Exact dimensions and prices are available on request.

GRINDING AND POLISHING
(with bonded tools)

Product image				
Colour	black	pale grey	red	brown
Grit size	46	80	120	220

Product image			
Colour	green	white	orange
Grit size	280	400	600

P2 polishing point (as per DIN 69170)



★★☆

■ manufactured as per DIN 69170

Product number	Description	Shape	Grit size	D mm	T mm	S mm	L ₂ mm	Pack contains
A2610006103080	P2ZY 0610.03		80	6	10	3	30	20
A2610006103120	P2ZY 0610.03		120	6	10	3	30	20
A2610006103220	P2ZY 0610.03		220	6	10	3	30	20
A2610006103280	P2ZY 0610.03		280	6	10	3	30	20
A2610010103046	P2ZY 1010.03		46	10	10	3	30	20
A2610010103080	P2ZY 1010.03		80	10	10	3	30	20
A2610010103120	P2ZY 1010.03		120	10	10	3	30	20
A2610010103220	P2ZY 1010.03		220	10	10	3	30	20
A2610010103280	P2ZY 1010.03		280	10	10	3	30	20
A2610016206280	P2ZY 1620.06		280	16	20	6	40	10
NEW A2610016206400	P2ZY 1620.06		400	16	20	6	40	10
NEW A2610016206600	P2ZY 1620.06		600	16	20	6	40	10
A2610016326080	P2ZY 1632.06		80	16	32	6	40	10
A2610016326120	P2ZY 1632.06		120	16	32	6	40	10
A2610016326220	P2ZY 1632.06		220	16	32	6	40	10
A2611013206120	P2SP 1320.06		120	13	20	6	40	10
A2611020326220	P2SP 2032.06		220	20	32	6	40	10
A2615008083120	P2KU 0808.03		120	8	8	3	30	20
A2615016166120	P2KU 1616.06		120	16	16	6	40	10
A2615016166220	P2KU 1616.06		220	16	16	6	40	10
A2617032106120	P2ZY 3210.06		120	32	10	6	40	10
A2617032106220	P2ZY 3210.06		220	32	10	6	40	10
A2618016326120	P2WR 1632.06		120	16	32	6	40	10
A2619010206080	P2KE 1020.06		80	10	20	6	40	10
A2619010206120	P2KE 1020.06		120	10	20	6	40	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic

POLISHING GROUP P3

Excellent results all the way to a mirror finish



LUKAS felt polishing points are available in two qualities:

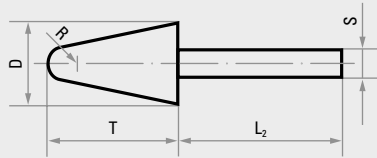
- H3 as per DIN 61200
- H3-S* super hard and particularly effective when used in combination with diamond paste (* upon request)

The ideal peripheral speed for LUKAS felt polishing points is 2 to 8 m/s.

The LUKAS range of felt polishing tools reflects our many years of experience in this field and covers all the most common shapes and sizes. Thanks to their extreme flexibility, felt polishing points used together with LUKAS diamond paste are ideally suited for polishing highly complex shapes like pressure and injection moulds, drawing, press and cutting tools, dies, bearings, spindles, rolls, gauges, etc.



P3 polishing point



- perfect for polishing highly complex shapes
- manufactured as per DIN 69170

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	L ₂ mm	Pack contains
A3700006103	P3ZY 0610.03		H3	6	10	3	40	20
A3700010123	P3ZY 1012.03		H3	10	12	3	38	20
A3700012153	P3ZY 1215.03		H3	12	15	3	40	20
A3700016206	P3ZY 1620.06		H3	16	20	6	40	10
A3700020256	P3ZY 2025.06		H3	20	25	6	40	10
A3700025306	P3ZY 2530.06		H3	25	30	6	40	10
A3700030406	P3ZY 3040.06		H3	30	40	6	40	10
A3701006103	P3SP 0610.03		H3	6	10	3	40	20
A3701010123	P3SP 1012.03		H3	10	12	3	40	20
A3701012206	P3SP 1220.06		H3	12	20	6	40	10
A3701020256	P3SP 2025.06		H3	20	25	6	40	10
A3701025306	P3SP 2530.06		H3	25	30	6	40	10
A3703006063	P3KU 0605.03		H3	6	5,5	3	39,5	20
A3703010106	P3KU 1009.06		H3	10	9	6	41	10
A3703012126	P3KU 1211.06		H3	12	11	6	39	10
A3703020206	P3KU 2019.06		H3	20	19	6	41	10

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium ● Aluminium

CAPABLE OF MACHINING THE MOST COMPLEX SHAPES

ELASTICALLY TO HIGH-GLOSS POLISHING

Thanks to its outstanding elasticity, the S1 shaped felt polishing disc from the P3 group is especially suited for polishing highly complex shapes such as pressure and injection moulds, drawing, press and cutting tools, cold heading dies, dies, bearings, spindles, rollers and gauges.

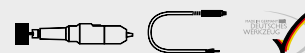
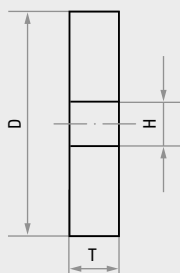
In combination with different diamond pastes, this polishing disc can be used with great flexibility.



Felt polishing wheel, shape S1



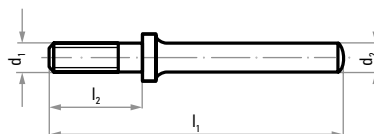
★★☆



Product number	Description	Quality	D mm	T mm	H mm	Pack contains
A3750040106	P3S1 4010.06	H3	40	10	6	10
A3750050206	P3S1 5020.06	H3	50	20	6	10
A3750060206	P3S1 6020.06	H3	60	20	6	10

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium ● Aluminium

Arbors for felt polishing wheels



★★☆

Delivery includes the following for each arbor:

- two washers, Ø 18 mm
- two washers, Ø 30 mm
- and one hex nut.

Product number	Description	d ₁ mm	l ₂ mm	d ₁ mm	l ₁ mm	n _{max} rpm	Pack contains
A1630780	ASB 780	M6	20	6	63	7,000	5
A1630781	ASB 781	M6	30	6	73	7,000	5

SUPER-E DIAMOND PASTE

GET THE GLOSS YOU WANT WITH JUST A TINY AMOUNT

Thanks to the high concentration of diamond grains, you can polish even the hardest materials quickly and efficiently. The optimal shape of the monocrystalline diamonds and the very narrow grain size distribution guarantee perfect polishing results. Because of

its agglomerate-free production and high viscosity – which can be gradually diluted with water, oil or alcohol – our diamond paste is also ideal for use in machines. The paste was specially developed for mould making.

FEATURES

- high grain concentration
- perfect grain size
- free from agglomerates
- narrow grain size distribution
- monocrystalline
- high viscosity

BENEFITS/USES

- polishes the hardest materials quickly and efficiently
- optimised for machine application
- highly effective
- ideal for mould making
- dilute with water, oil or alcohol



GRINDING AND POLISHING
(with bonded tools)

Monocrystalline diamond pastes



- highly versatile for both manual and machine polishing
- resists temperatures of up to 130 °C

★★☆

Product number	Description	Quality	Grain size in µm	Colour	Content g	Pack contains
A3410119105	E-091	Super-E	1	blue	5	1
A3410119110	E-091	Super-E	1	blue	10	1
A3410119205	E-092	Super-E	3	green	5	1
A3410119210	E-092	Super-E	3	green	10	1
A3410119305	E-093	Super-E	6	yellow	5	1
A3410119310	E-093	Super-E	6	yellow	10	1
A3410119405	E-094	Super-E	9	red	5	1
A3410119410	E-094	Super-E	9	red	10	1
A3410119505	E-095	Super-E	15	light brown	5	1
A3410119510	E-095	Super-E	15	light brown	10	1

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

POLISHING GROUP P6

Polishing with polyurethane bonding

Products in group P6 are manufactured with a polyurethane bond (PU) in different hardnesses.

These tools:

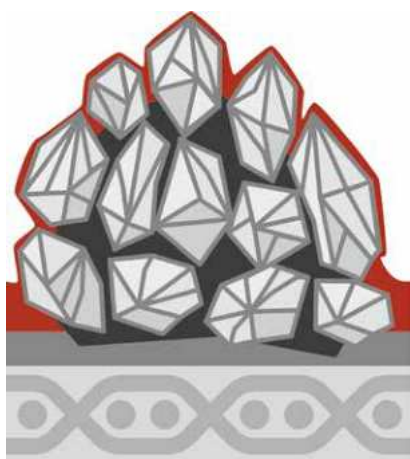
- can be easily profiled
- quickly generate an excellent surface finish
- do not tend to clog
- require no dressing
- contain no softeners
- do not increase in hardness after long storage
- are ideal for both stationary and manual application

These polishing tools are used to improve the surface finish and dimensional accuracy of polishing and finishing steel, brass, precious metals, sintered metals and plastic, as well as for very fine and effect grinding.

Due to their long tool life and a good edge-fray resistance, the tools are ideally suited for automated processes such as cylindrical polishing of tubes or marbling of high-alloyed steel plates.

COMPACT GRAIN

Many cutting edges combined in one grain



The compact grain (CG) consists of many abrasive grains and reactive filler, which are bonded to each other before adding them to the tool. During grinding, individual worn particles break out of the compact grain, exposing the underlying abrasive particles with new, sharp cutting edges. As a result, tools with compact grain do not clog even with softer or smearing materials.

Due to the double adhesive bonding in the compact grain and abrasive layer, the grinding particles adhere better than with just a single adhesive bonding. This means a longer useful life without premature tool changes. The high density of the cutting edges within the compact grain guarantees the very high stock removal rate, while the filler ensures a cool cut.

RECOMMENDED FOR

The right polishing tool for every job

Find the perfect tool for your application! Simply find your process and the corresponding material in the table to discover the perfect grit size for your LUKAS P6 polishing tool.

	Removing rust, cleaning, tarnish removal			Cylindrical and surface grinding			Sharpening, dressing		Marbling, dash-dot matting		Deburring, fettling, rounding off				Fine grinding				Pre-finishing				Polishing	
	MWP	MP	SHP CG	SHP	SHP CG	SHP+	SHP	SHP+	WP	MWP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP
Gold, silver, nickel, aluminium, brass														410									400	400
																			240	240			800	
																	150		150				1,200	
																120	120							
													80	80	80	80								
Structural steel		150	120		120	36																		
	46		60		60	30																		
Stainless steel, titanium							400																400	400
							240													240	240		800	240
		150												150			150		150	150			1,200	
			120		120	120										120	120		120					
					60		80			80	80	80		80	80	80	80	80						
			60					36		46		46			46	46	46	46						
Hardened steel, tungsten carbide				240																	240		400	
				150														150					800	
				120	120													120					1,200	
				80	60	36		36				80												
Glass																								
																		100		400				
																		80		240				
												80						46		150				
Rubber			60															80						
Wood																		80						
Paint	46	150																						
Solder	240				120																			
Tin						36																		
						30																		
Grit sizes																								

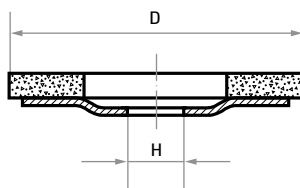
GRINDING AND POLISHING (with bonded tools)

The following grades are available:

- WP** = soft, very flexible
- MWP** = medium to soft
- MP** = medium for general application
- HP** = hard and resilient, mainly for flat surfaces
- SHP** = super hard, for stationary applications
- SHP CG** = super hard, with compact grain
- SHP+** = super hard, for manual applications

The bonding is mixed with silicon carbide "SIC", aluminium oxide white "EKW" or aluminium oxide "A" as abrasive in the FEPA grit sizes 24 to 1,200.

P6PT polishing disc, CG quality



- very hard PU bonding
- can be used on a variety of materials
- contains compact grain (CG)
- suitable for removing irregularities and defects before polishing
- produces good surfaces
- incredible tool life

★★★

Product number	Description	Quality/grit size	Type/surface result	D mm	H mm	n_{max} rpm	Pack contains
A671612506014	P6PT 125 (flat)	EKW 60 SHP CG	extra coarse	125	22.23	12,200	5
A671612512014	P6PT 125 (flat)	EKW 120 SHP CG	coarse	125	22.23	12,200	5

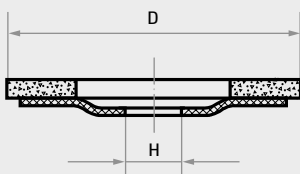
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium

The new tools in the P6 Compact Grain series let you remove scratches and irregularities on workpieces, whilst also creating a good surface. This helps you save time and removes the need for annoying tool changes. Their incredible tool life is down to the very hard PU bonding and the compact grain technology. P6 CG tools are perfect for grinding before polishing with other P6 tools with hardness ranging from WP to HP.

Ideal for:

- cleaning surfaces
- removing scratches
- removing paint and undercoats
- repairing surfaces for polishing

P6PT polishing discs



- polishing a wide range of surfaces
- cleaning and derusting
- removing paint and coatings
- replaces cloth discs, felt discs and polishing pastes
- for standard controlled angle grinders
- clean working conditions, as no grinding paste is required
- quicker work progress

★★☆

Product number	Description	Quality	Type/surface result	D mm	H mm	n_{max} rpm	n_{recom} rpm	Pack contains
A671612515014	P6PT 125 (flat)	SIC 150 MP	medium	125	22.23	4,800	2,700	5
A671612524014	P6PT 125 (flat)	SIC 240 MWP	fine	125	22.23	4,800	2,700	5
A671612540014	P6PT 125 (flat)	SIC 400 WP	very fine	125	22.23	4,800	2,700	5
A671612580014	P6PT 125 (flat)	SIC 800 WP	ultra-fine	125	22.23	4,800	2,700	5

Recommended for: ● Inox/Steel ● Cast material ● Titanium ● Steel ● Aluminium

FROM COARSE TO FINE – THE PERFECT POLISHING SET

TEST THE LUKAS POLISHING DISCS NOW!

The P6PT polishing disc makes improving the surface quality and dimensional accuracy of your workpiece easy. This disc with silicon carbide grinds cool and generates few sparks, making it suitable for use in aerospace engineering. Even hard materials like stone, glass and high-alloyed materials can be processed efficiently. The hard and sharp abrasive grain ensures a long tool life. Whether it's cleaning, grinding or polishing – this LUKAS polishing disc takes care of any job with flying colours. It is perfectly suited for working with a standard controlled angle grinder.

The polishing disc can be used for both wet and dry grinding and requires no additional grinding paste.

Its light, stable and flexible design lets you achieve outstanding surface results. The glass fibre carrier plays no role here. The disc is highly resistant to breakage and generates little vibration when working. Combined with its easy handling, it is ideal for manual use. The P6 group of polishing discs are perfect for quickly processing large metal surfaces.

THE LUKAS POLISHING DISC SET

Get the polishing result you want quickly with the polishing disc set from LUKAS. Simply use the various polishing discs in the set one after another. Go from rusty to a mirror finish quickly and easily with just a few tool changes and one machine.



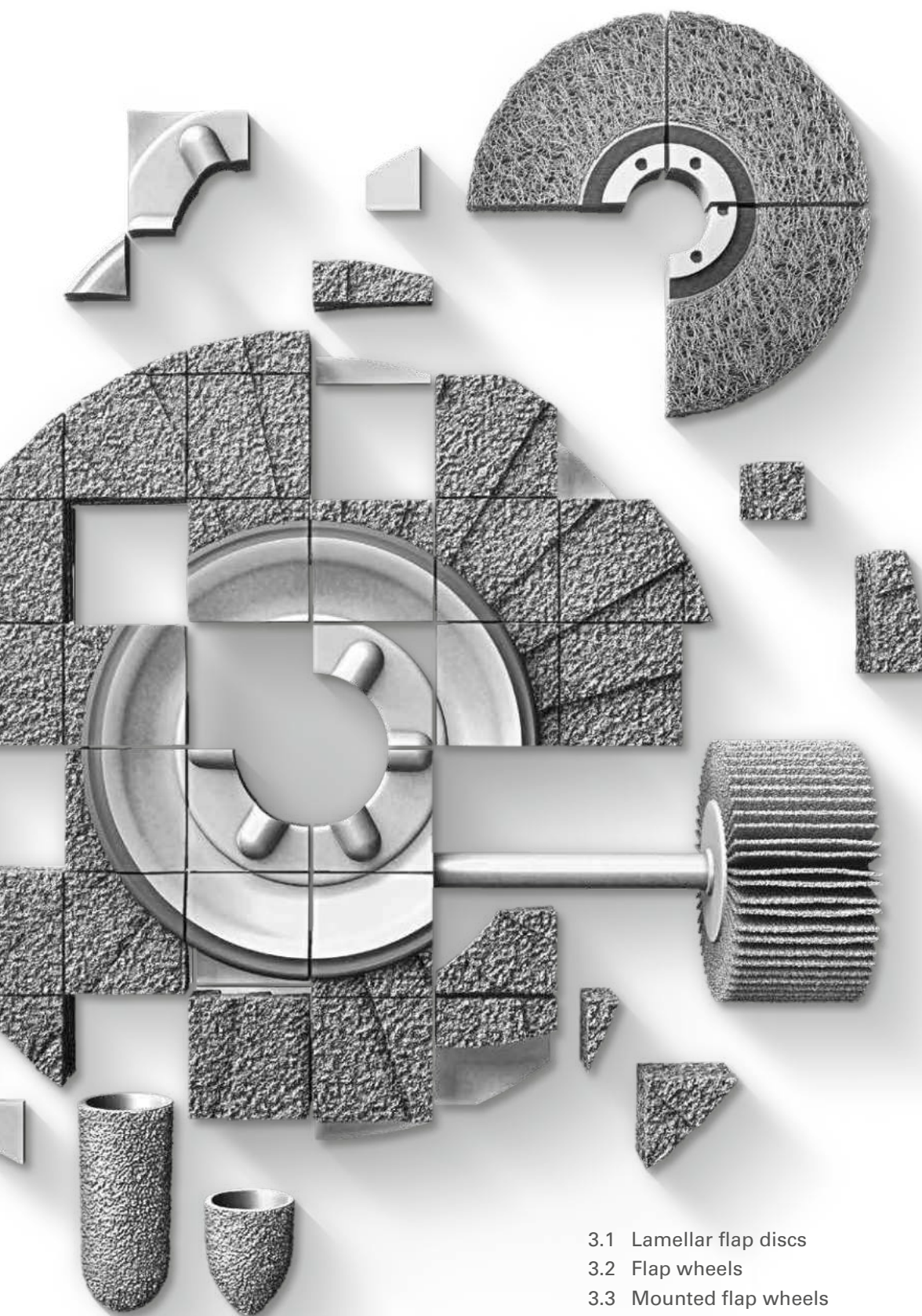
P6PT polishing disc set



- from rusty to a mirror finish with the LUKAS polishing disc set
- use these tools one after another to achieve the finish you want

★★★☆☆

Product number	Description	Shape	Quality	D mm	H mm	n _{max} rpm	n _{recom} rpm	Contents 1 per pack	Pack contains
A6700023	P6PT 125 (flat) SET		P6PT	125	22.23	4,800	2,700	P150, 240, 400, 800	1
Recommended for: ● Inox/Steel ● Cast material ● Titanium ● Steel ● Aluminium									



GRINDING AND POLISHING
(with flexible tools)

GRINDING AND POLISHING

(with flexible tools)

3.1 Lamellar flap discs	53–65
3.2 Flap wheels	66/67
3.3 Mounted flap wheels	68–72
3.4 Abrasive bands and mandrels	73–76
3.5 Abrasive caps and mandrels	77–80
3.6 Abrasive discs and carriers	81–88
3.7 Fibre discs and backing pads	89/91

TECHNICAL INFORMATION

The most important product information at a glance

GENERAL

Our flexible grinding and polishing tools are made of high quality abrasive cloth and abrasive fleece. They consist of a flexible backing coated with abrasive grain (see pages 51 to 52).

▪ Backings used:

cloth, polyester, fleece, fibre

▪ Grain types used:

regular aluminium oxide (NK), silicon carbide (SIC),
zirconia alumina (ZK), ceramic (Ceramic)

Our flexible grinding and polishing tools are available in many different shapes and dimensions. Applications range from high chip removal through to achieving an extremely fine surface finish.

SAFETY ADVICE

Please note our recommended operating speeds. Pay attention to the safety and accident prevention regulations, including the FEPA safety recommendations, when using and storing flexible grinding and polishing tools. The tools are marked with the appropriate pictograms for correct usage.

APPLICATION RECOMMENDATIONS

At high speed coarse grain produces a finer finish, while at low speed a fine grain produces a coarser finish.

Do not apply too much pressure when using LUKAS grinding tools: excessive pressure does not improve the performance, and will instead result in premature wear. Even if the chip removal is unsatisfactory, you do not apply more pressure. Use a coarser grain instead to prevent unnecessary tool wear and effort. Using grinding additives can also improve efficiency.

QUALITY AND APPLICATIONS

The right abrasive for every application

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high quality abrasives from LUKAS are ideal for many industries, areas and requirements, and therefore offer you a very wide choice.







The overview below lists all abrasives for use with flexible grinding and polishing tools. Read through the properties and application areas for various workpiece materials to establish the most suitable abrasive grain type and tools to meet your requirements.

Quality	Properties	Application areas/ machining	available as	Page	
	NK Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	forged steel, malleable iron, grey cast iron, carbon steel, deep-drawn steel, steel band, zinc die castings, non-ferrous metals, wood	Flap wheels Mounted flap wheels Abrasive bands Abrasive discs	67 69/70 75 85
	NKE Abrasive cloth Regular aluminium oxide with active abrasive surface layer	very tough abrasive, high resilience	chrome-nickel and other non-rusting steels, deep-drawn steel, titanium and titanium alloys, heat-resistant steel	Abrasive discs	86
	ZK Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs Mounted flap wheels Abrasive bands Fibre discs Abrasive discs	61 64/65 71 74 75 84
	Z-Power Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent removal rate, with long tool life	stainless steel	Lamellar flap discs Abrasive discs	61 84
	ZKS Abrasive cloth Zirconia alumina with active abrasive surface layer	with M-bonding on polyester backing for excellent removal rate with long tool life	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs	61
	NKS Abrasive cloth Regular aluminium oxide with active abrasive surface layer	excellent removal rate with long tool life	corrosion and heat-resistant steels, plastics, aluminium and non-ferrous metals	Abrasive caps	79
	SIC Abrasive cloth Silicon carbide	minimum heat generation, special quality for the aerospace industry	aluminium and alloys, titanium materials, glass, ceramic, heat-resistant steel, plastic	Lamellar flap discs	62
	Ceramic Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	non-rusting steels, nickel alloys	Lamellar flap discs Abrasive bands Abrasive caps Abrasive discs	60 74 79 83
	Ceramic4x Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	steel, rust- and acid-resistant steel	Lamellar flap discs	57 60 63
	PG Reinforced abrasive cloth with ceramic grain	maximum removal rate and tool life thanks to self-sharpening ceramic grain	inox, steel, hardened/coated surfaces	Lamellar flap discs	55
	A Mounted flap wheels Flap rolls	the combination with abrasive cloth enhances the grinding effect	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	Mounted flap wheels	72

FURTHER QUALITIES ON REQUEST

On request, we can also offer the following additional qualities which are not listed in this catalogue. If you want to order a prod-

uct of a different quality than the one listed in this overview, please do not hesitate to contact us!

Quality	Properties	Application areas/ machining	available as
 NK Abrasive fleece Regular aluminium oxide	polishing effect with the fibre structure, consistent results thanks to contin- uous exposure of new abrasive particles	chrome-nickel alloys and other non-rusting steels, zinc die castings, non- ferrous metals, wood	Mounted flap wheels Flap rolls
 SIC Abrasive fleece Silicon carbide	polishing effect with the fibre structure, consistent results thanks to contin- uous exposure of new abrasive particles	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Mounted flap wheels Flap rolls Semi-flexible grinding disc
 Z Abrasive fleece Zirconia alumina	polishing effect with the fibre structure, improved aggressiveness	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals	Mounted flap wheels
 TF Abrasive fleece/cloth Regular aluminium oxide reinforced fleece	with the combination mounted flap wheels, the abrasive cloth and fleece flaps wear more evenly, improved removal rate	ideal for surface finishing of sheet metal products made from non-rusting steel such as stainless steel sinks and containers	Mounted flap wheels Flap rolls
 C Abrasive fleece/cloth Silicon carbide	the combination with abrasive cloth enhances the grinding effect	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Lamellar flap discs Mounted flap wheels
 AS Polyamide fleece	impregnated with aggressive abrasive grain	removal of paint and adhesives, cement and concrete resitankss, derusting, cleaning and polishing a wide variety of surfaces, graining and cleaning of wood	Flap disc Grinding wheel

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS lamellar flap discs – from coarse cutting through to surface finishing

GENERAL

We offer lamellar flap discs for practically every requirement. These tools are manufactured with a wide selection of backing materials (e.g. glass fabric, plastic, metal, as well as renewable raw materials) to suit every application. The large selection of available grit sizes covers coarse grinding applications (from grit size 36) through to finishing (grit size 240).

ERGONOMICS

Using lamellar flap discs brings clear advantages in terms of ergonomics compared to conventional grinding discs. Noise levels during grinding are halved and vibrations are also significantly reduced. The tools are also lighter so less pressure needs to be applied. These advantages create a healthy and fatigue-free working environment.

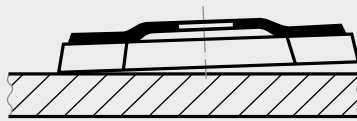
The lamellar flap discs are available in the diameters 100 mm (with 16 mm bore), 115 mm, 125 mm, 150 mm, 178 mm (22.23 mm bore) and 230 mm for use with commercially available angle grinders.

APPLICATION

You can choose between the flat or angled version depending on the job in hand.

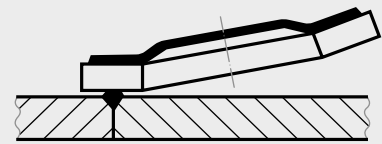
Application examples:

- deburring
- fettling
- derusting
- smoothening
- weld seam removal



Using the flat version

Use this version for grinding edges and flat surfaces with a working angle of 0 – 15°



Using the angled version

for spot grinding

e.g. a weld, with the ideal working angle of 15 – 25°

iQ SERIES FROM LUKAS

Developed for high-performance applications

Our high-performance tools are grouped together in our iQ series. Among them are the lamellar flap discs, which have a patented flap shape and arrangement for ultimate grinding performance.

This catalogue does not show all of our iQ-Series flap discs. The following products are available on request: V4 Purple Power, V4 Master, variants of the SLTT and the SLTflex.



Purple Grain

Powerful tools for heavy-duty applications

AGGRESSIVE. DURABLE. ERGONOMIC.

- high stability and durability
- integrated backing pad in recycled fibre
- even wearing without overheating, becoming brittle or shredding of the grain
- innovative ceramic grain: sharp to the end



innovative
Ceramic grain



operating
angle < 10°



no backing
pad required



low
vibration

WITH THE SELF-SHARPENING EFFECT

The self-sharpening ceramic grain ensures sustained cool grinding even at low grinding pressure. The tools retain their sharpness down to the last grain.



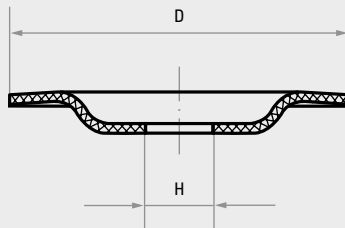
THE DYNAMIC ALL-ROUNDER WITH A LONG TOOL LIFE

FOR IMPRESSIVE REMOVAL RATES



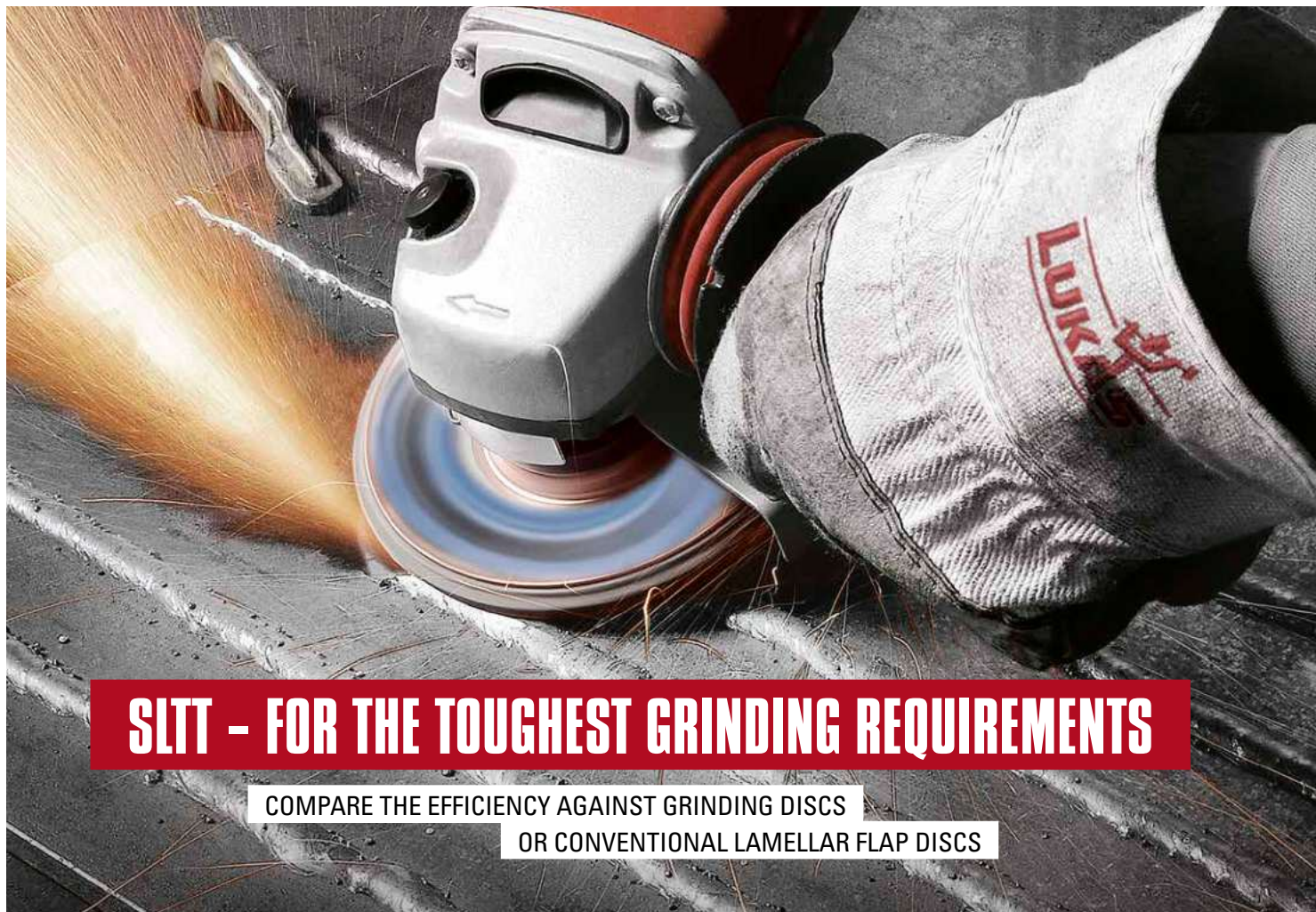
Purple Grain Single compact grinding disc

Even with a minimum effort, "Purple Grain Single" achieves stunning removal rates. The integrated backing pad made of eco-friendly recycled fibre assures high stability and durability. The innovative design provides for even wear without overheating, becoming brittle or shredding of the grain. The deep recess allows you to work at a flat angle. Thanks to its special tool geometry, the "Purple Grain Single" can also reach inaccessible areas, which offers more application possibilities than a conventional tool.



★★★

Product number	Description	Grit	D mm	H mm	n _{max} rpm	Pack contains
A27601250361547	Purple Grain Single 125	Ceramic 36	125	22.23	12,200	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium ● Cast material						



SLTT – FOR THE TOUGHEST GRINDING REQUIREMENTS

COMPARE THE EFFICIENCY AGAINST GRINDING DISCS
OR CONVENTIONAL LAMELLAR FLAP DISCS

70%

OF THE ABRASIVE MATERIAL IS
LOCATED ON THE OUTER AREA OF
THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE
WITH ITS INNOVATIVE FLAP ARRANGEMENT

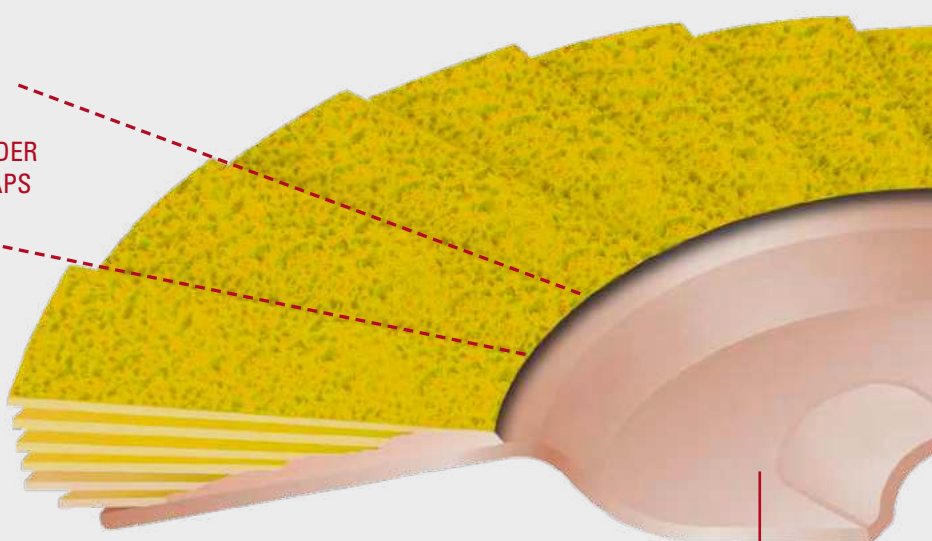
WIDER
FLAPS

UP TO

6

ABRASIVE LAYERS

ROBUST
STEEL BACKING PLATE



The efficient, high-performance SLTT lamellar flap discs from LUKAS are a better alternative to grinding discs and conventional lamellar flap discs.

Compared to grinding discs, the LUKAS patented flap shape and arrangement provides for 50 % lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

A particularly large concentration of abrasive grain on the outer perimeter of these tools results in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.



Patented LUKAS flap shape and arrangement with more abrasive grains than the norm

PROPERTIES

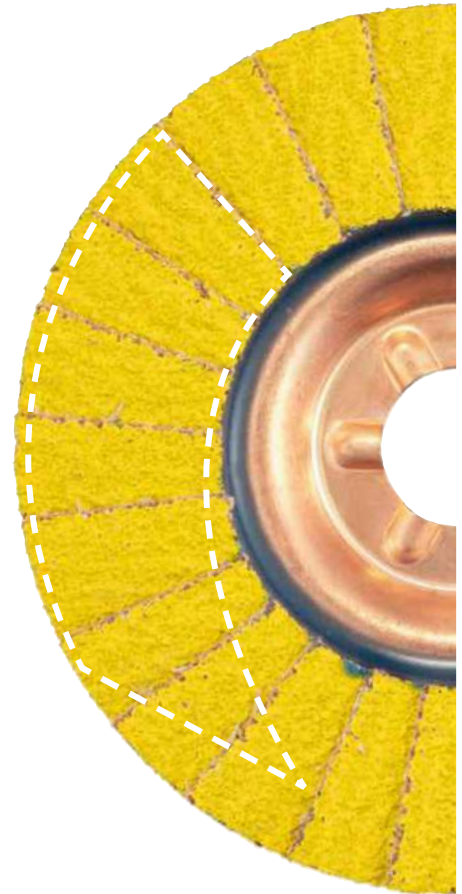
- outstanding cutting performance
- exceptional tool life
- robust steel back plate
- low noise and vibration levels

APPLICATION

Ideal for machining welds, deburring, derusting, fettling and smoothening. Thanks to its 22.23 mm bore, it fits onto all commonly used angle grinders.

OTHER SLTT VERSIONS

Our other SLTT variants (Heavy Duty, Inox and Steel) are available on request.



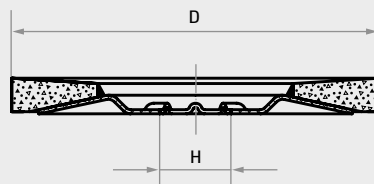
GRINDING AND POLISHING
(with flexible tools)



SLTT HybridPerfection^{Ceramic4x} lamellar flap discs

NEW

- the professional tool for the toughest jobs on steel, ship's steel plate and Hardox steel
- achieves impressively high stock removal rates when rough grinding steel, edging and removal of welds
- with additional active abrasive layer for stainless steel
- designed for endurance
- outstanding price-to-performance ratio



★★★

Product number	Description	Grit	D mm	H mm	n _{max} rpm	Pack contains
A27201150400044	HybridPerfection 115	Ceramic4x 40	115	22.23	13,300	10
A27201150600044	HybridPerfection 115	Ceramic4x 60	115	22.23	13,300	10
A27201250400044	HybridPerfection 125	Ceramic4x 40	125	22.23	12,200	10
A27201250600044	HybridPerfection 125	Ceramic4x 60	125	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood

UNBEATABLE ON STEEL: THE NEW LUKAS HYBRIDPERFECTION

Thanks to its innovative Ceramic4x abrasive cloth and patented flaps, this lamellar flap disc quickly achieves exceptionally high stock removal rates on steel.

EXPERIENCE AT FIRST HAND THE **IMPRESSIVE PERFORMANCE** OF THE NEW HYBRID PERFECTION AND TEST IT NOW FOR YOURSELF.



THE V2 POWER – FOR UNIVERSAL USE

EXPERIENCE THE EFFICIENCY COMPARED TO CONVENTIONAL LAMELLAR FLAP DISCS

70%

OF THE ABRASIVE MATERIAL IS
LOCATED ON THE OUTER AREA
OF THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE
THANKS TO THE SPECIAL FLAP CONFIGURATION

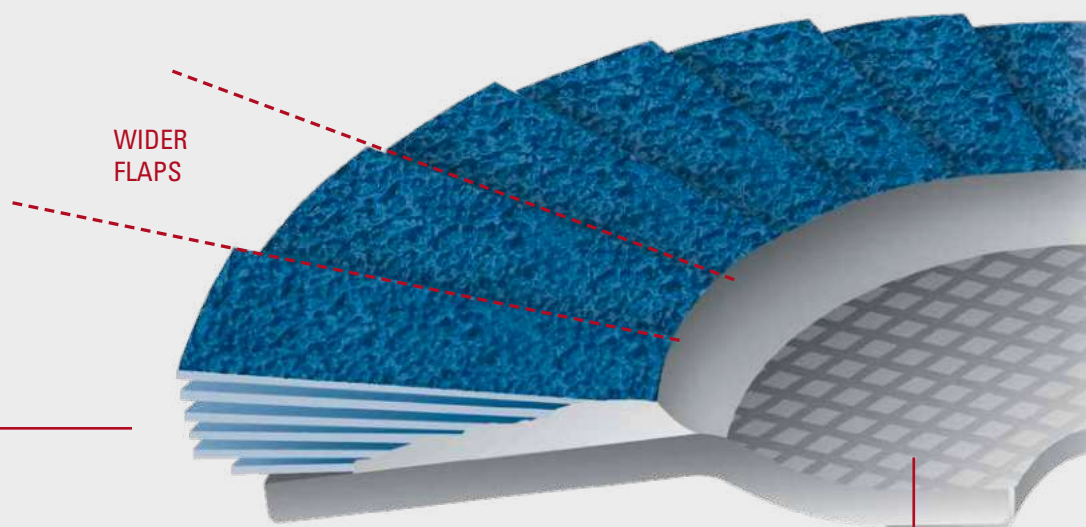
WIDER
FLAPS

UP TO

6

ABRASIVE LAYERS

GLASS FIBRE
BACKING PLATE



The efficient, high-performance LUKAS V2 Power lamellar flap discs with a glass fibre backing are a better alternative to grinding discs and conventional lamellar flap discs.



innovative patented LUKAS flap shape and arrangement
with more abrasive grains than usual

The flexibility, light weight and stability of the elastic glass fibre backing result in an exceptional surface finish. The high resistance to shredding and minimal vibration during operation, not to mention its easy handling, perfectly round off the characteristics of the V2 Power lamellar flap disc.

Compared to grinding discs, the LUKAS patented flap shape and arrangement gives 50% lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

A particularly large concentration of abrasive grains on the outer perimeter results

in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs additionally remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.

PROPERTIES

- exceptional grinding performance
- long tool life
- robust glass fibre backing

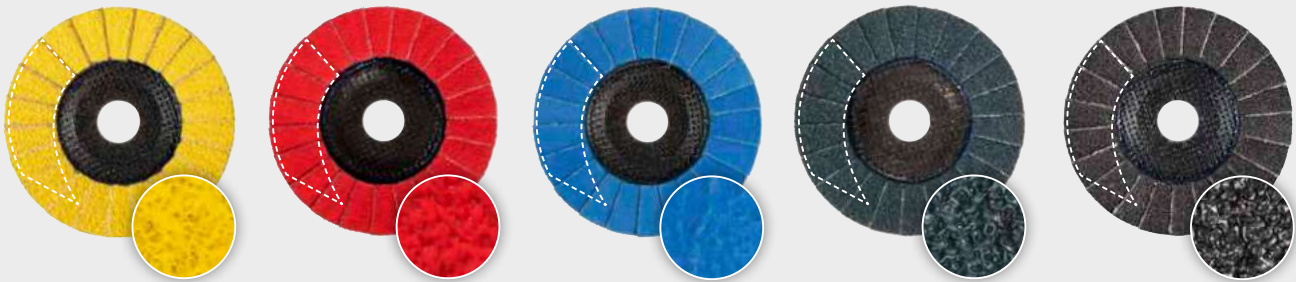
APPLICATION

Ideal for machining weld seams, deburring, derusting, fettling and smoothing.

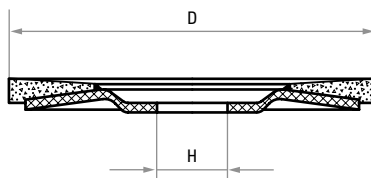


GRINDING AND POLISHING
(with flexible tools)

THE FIVE V2 POWER VERSIONS



Ceramic4x Ceramic4x abrasive cloth	Heavy Duty Ceramic abrasive cloth	Inox Z Power abrasive cloth	Steel ZK abrasive cloth	ALU SiC abrasive cloth
<ul style="list-style-type: none"> ■ all the benefits of the powerful LUKAS V2 Power flap disc coupled with the outstandingly innovative abrasive cloth ■ for the toughest jobs with steel, ship steel and Hardox steel ■ free of iron, sulphur and chlorine 	<ul style="list-style-type: none"> ■ developed for the most demanding and toughest grinding applications ■ especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces ■ free of iron, sulphur and chlorine 	<ul style="list-style-type: none"> ■ developed for grinding stainless steel ■ no glazing or heating of the flaps thanks to the active abrasive surface layer ■ equally efficient for edge and surface applications ■ free of iron, sulphur and chlorine 	<ul style="list-style-type: none"> ■ optimised for universal application on a wide variety of steels and aluminium ■ exceptionally tough grain and resistant to high pressure 	<ul style="list-style-type: none"> ■ particularly suitable for preparing welds and finishing aluminium ■ also ideal for fibre-reinforced materials such as CFRP and GFRP

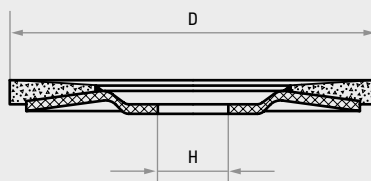
NEW V2 Power^{Ceramic4x} lamellar flap discs


- patented LUKAS flap shape and arrangement with a higher concentration of abrasive grains
- for the toughest jobs with steel, ship steel and Hardox steel
- innovative Ceramic4x abrasive cloth with an additional active abrasive layer for stainless steel
- achieves impressively high removal rates when coarse-machining steel and grinding edges and welds
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	n_{max} rpm	Pack contains
A6744100040141501	V2 Power 100	Ceramic4x 40	100	15.00	15,300	10
A6744100060141501	V2 Power 100	Ceramic4x 60	100	15.00	15,300	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood

V2 Power Heavy Duty lamellar flap disc


- especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

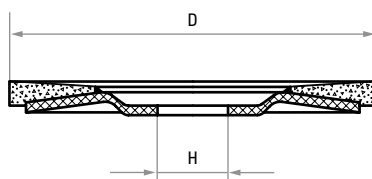
★★★

Product number	Description	Grit	D mm	H mm	n_{max} rpm	Pack contains
A27441250401450	V2 Power 125	Ceramic 40	125	22.23	12,200	10
A27441250601450	V2 Power 125	Ceramic 60	125	22.23	12,200	10
A27441780401450	V2 Power 178	Ceramic 40	178	22.23	8,500	10
A27441780601450	V2 Power 178	Ceramic 60	178	22.23	8,500	10
A27442300401428	V2 Power 230	Ceramic 40	230	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material ● Plastic/Wood



V2 Power Inox lamellar flap disc



- optimised for grinding stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

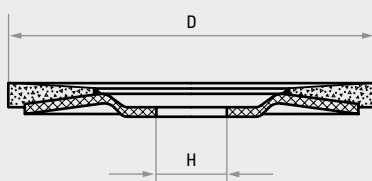
★★★

Product number	Description	Grit	D mm	H mm	n _{max} rpm	Pack contains
A67441000401445	V2 Power 100	Z-Power 40	100	15.00	15,300	10
A67441000601445	V2 Power 100	Z-Power 60	100	15.00	15,300	10

Recommended for: ● Inox/Steel ○ Steel

GRINDING AND POLISHING
(with flexible tools)

V2 Power Steel lamellar flap disc



- ideally suited for universal use on steel
- exceptionally tough grain and resistant to high pressure

★★★

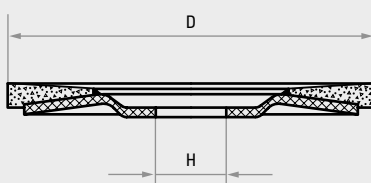
Product number	Description	Grit	D mm	H mm	n _{max} rpm	Pack contains
A67441000401465	V2 Power 100	ZK 40	100	15.00	15,300	10
A67441000601465	V2 Power 100	ZK 60	100	15.00	15,300	10
A27441000401465	V2 Power 100	ZK 40	100	16.00	15,300	10
A27441000601465	V2 Power 100	ZK 60	100	16.00	15,300	10
A27441250401465	V2 Power 125	ZK 40	125	22.23	12,200	10
A27441250601465	V2 Power 125	ZK 60	125	22.23	12,200	10
A27441780401465	V2 Power 178	ZK 40	178	22.23	8,500	10
A27441780601465	V2 Power 178	ZK 60	178	22.23	8,500	10
A27442300401418	V2 Power 230	ZKS 40	230	22.23	6,600	5

Recommended for: ○ Steel ● Inox/Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

MACHINING STATE-OF-THE-ART MATERIALS

OPTIMISED FOR A WIDE VARIETY OF ALUMINIUM ALLOYS: THE V2 POWER ALU

V2 Power Alu lamellar flap disc



- Silicon carbide (SiC) is ideally suited for the preparation and finishing of welds of various aluminium alloys.
- Silicon carbide (SiC) is also very suitable for machining modern materials such as CFRP and GFRP.

★★★

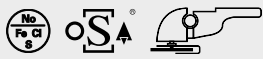
Product number	Description	Grit	D mm	H mm	n_{max} rpm	Pack contains
A67441000361434	V2 Power 100	SIC 36	100	15.00	15,300	10
A67441000401434	V2 Power 100	SIC 40	100	15.00	15,300	10

Recommended for: ● Aluminium ● Titanium ● Plastic/Wood

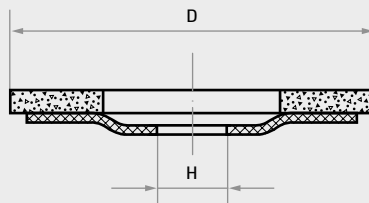
IMPRESSIVE TOOL LIFE

WITH HIGH ERGONOMICS

HIGH-PERFORMANCE LUKAS LAMELLAR FLAP DISCS WITH RECTANGULAR FLAPS

GRINDING AND POLISHING
(with flexible tools)
SLTO^{Ceramic4x} / SLTR^{Ceramic4x} lamellar flap disc **NEW**

- ideal for deburring, fettling, derusting, smoothening and weld seam machining
- for use on steel, ship's steel plate and Hardox steel
- achieves high removal stock rates when rough grinding steel
- with self-sharpening effect thanks to innovative Ceramic4x abrasive grain
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- Glass fibre backing
- the perfect alternative to grinding discs

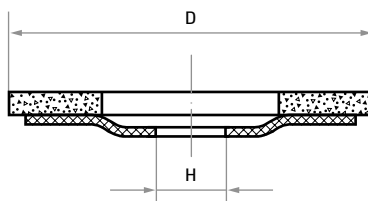


★★★

Product number	Description	Grit	Drawing	D mm	H mm	n _{max} rpm	Pack contains
A6715100040144401	SLTO 100	Ceramic4x 40		100	15.00	15,300	10
A6718100040144401	SLTR 100	Ceramic4x 40		100	15.00	15,300	10

 Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood

SLTO/SLTR lamellar flap disc, zirconia alumina



- achieves high removal rates on hard and tough materials and a long tool life
- for deburring, fettling, derusting, smoothing and weld seam machining
- very good price-to-performance thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing
- the efficient alternative to grinding discs

★★☆

Product number	Description	Grit	Drawing	D mm	H mm	n_{max} rpm	Pack contains
A67151000401435	SLTO 100	ZK 40		100	15.00	15,300	10
A67151000401465	SLTO 100	ZK 40		100	15.00	15,300	10
A27151250401406	SLTO 125	ZK 40		125	22.23	12,200	10
A27151250601406	SLTO 125	ZK 60		125	22.23	12,200	10
A27151250801406	SLTO 125	ZK 80		125	22.23	12,200	10
A27151780361401	SLTO 178	ZK 36		178	22.23	8,500	10
A27151780401401	SLTO 178	ZK 40		178	22.23	8,500	10
A27151781201401	SLTO 178	ZK 120		178	22.23	8,500	10
A67181000401435	SLTR 100	ZK 40		100	15.00	15,300	10
A67181000401465	SLTR 100	ZK 40		100	15.00	15,300	10
A27181000401423	SLTR 100	ZK 40		100	16.00	15,300	10
A27181000601423	SLTR 100	ZK 60		100	16.00	15,300	10
A27181000801423	SLTR 100	ZK 80		100	16.00	15,300	10
A27181250361406	SLTR 125	ZK 36		125	22.23	12,200	10
A27181250401406	SLTR 125	ZK 40		125	22.23	12,200	10
A27181250601406	SLTR 125	ZK 60		125	22.23	12,200	10
A27181250801406	SLTR 125	ZK 80		125	22.23	12,200	10
A27181251201406	SLTR 125	ZK 120		125	22.23	12,200	10
A27181500401416	SLTR 150	ZK 40		150	22.23	10,200	10
A27181500601416	SLTR 150	ZK 60		150	22.23	10,200	10
A27181500801416	SLTR 150	ZK 80		150	22.23	10,200	10
A27181780361401	SLTR 178	ZK 36		178	22.23	8,500	10
A27181780401401	SLTR 178	ZK 40		178	22.23	8,500	10
A27181780601401	SLTR 178	ZK 60		178	22.23	8,500	10
A27181780801401	SLTR 178	ZK 80		178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium



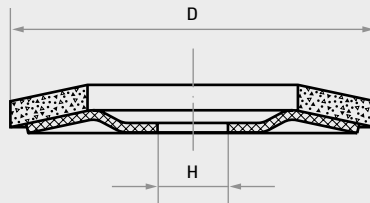
THE ECONOMICAL BASE-X

ACHIEVE HIGH REMOVAL RATES WITH HARD AND SHARP ZIRCONIA ALUMINA



SLTO/SLTR BASE-X lamellar flap disc **NEW**

- the economical alternative to grinding discs
- for deburring, fettling, derusting, smoothing and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing



★☆☆

Product number	Description	Grit	Drawing	D mm	H mm	n _{max} rpm	Pack contains
A27151250401535	SLTO 125 BASE-X	ZK 40		125	22.23	12.200	10
A27151250601535	SLTO 125 BASE-X	ZK 60		125	22.23	12.200	10
A27151250801535	SLTO 125 BASE-X	ZK 80		125	22.23	12.200	10
A27181250401535	SLTR 125 BASE-X	ZK 40		125	22.23	12.200	10
A27181250601535	SLTR 125 BASE-X	ZK 60		125	22.23	12.200	10
A27181250801535	SLTR 125 BASE-X	ZK 80		125	22.23	12.200	10
A27181251201535	SLTR 125 BASE-X	ZK 120		125	22.23	12.200	10
A27181780401535	SLTR 178 BASE-X	ZK 40		178	22.23	8.500	10
A27181780601535	SLTR 178 BASE-X	ZK 60		178	22.23	8.500	10
A27181780801535	SLTR 178 BASE-X	ZK 80		178	22.23	8.500	10
A27181781201535	SLTR 178 BASE-X	ZK 120		178	22.23	8.500	10

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Flap wheels from LUKAS

LSL, FLAP WHEELS OF ABRASIVE CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSL consists of single flaps which are embedded radially to the axis in a solid plastic core. Please pay attention to the rotational direction of the tool!

Application examples:

- Cleaning
- Deburring
- Derusting
- Surface preparation
- Texturing
- Roughening

These qualities are available upon request

LSV, FLAP WHEELS OF ABRASIVE FLEECE, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSV consist of abrasive fleece flaps. The use of fibre fleece makes the tool elastic and allows it to adapt itself to the shape of the workpiece.

Application examples:

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothening
- Final finishing of the workpiece surfaces

LSM, FLAP WHEELS MADE BY COMBINING ABRASIVE FLEECE AND CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore size, are designed to be used with both handheld and stationary machines. The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LSV. Please pay attention to the rotational direction of the tool!

Application examples:

- Cleaning
- Derusting
- Surface preparation
- Texturing
- Roughening

FLAP WHEELS FOR ANGLE GRINDERS

FOR DERUSTING, PAINT STRIPPING, WELD SEAM MACHINING AND MANY OTHER USES

Each flap of this wheel of abrasive cloth is embedded radially to the axis in a solid plastic core. Used with a handheld tool, it is therefore ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities.

The regular aluminium oxide used for this wheel boasts an impressive tool life on many materials and allows you to work in a cost-effective manner.

The integrated M14 thread means that no additional tool is required for fast and easy mounting of the flap wheel.

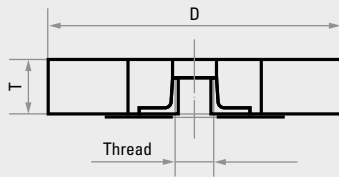


GRINDING AND POLISHING
(with flexible tools)



LSL, flap wheel of abrasive cloth with thread

- fits on commercially available angle grinders and is used in place of mounted flap wheels with shanks
- can be used without a clamping nut
- ideal for reworking weld seams on stainless steels
- ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities
- grinding is only permitted with the peripheral surface



★★☆

Product number	Description	Grit	D mm	T mm	Thread	n _{recom} rpm	n _{max} rpm	Pack contains
A2280125200040	LSL 125020	NK 40	125	20	M14	9,600	12,200	5
A2280125200040001	LSL 125020	NK 40	125	20	5/8"	9,600	12,200	5
A2280125200060	LSL 125020	NK 60	125	20	M14	9,600	12,200	5
A2280125200060001	LSL 125020	NK 60	125	20	5/8"	9,600	12,200	5
A2280125200080	LSL 125020	NK 80	125	20	M14	9,600	12,200	5
A2280125200080001	LSL 125020	NK 80	125	20	5/8"	9,600	12,200	5
A2280125200120	LSL 125020	NK 120	125	20	M14	9,600	12,200	5
A2280125200120001	LSL 125020	NK 120	125	20	5/8"	9,600	12,200	5
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium								

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Mounted flap wheels made of abrasive cloth, abrasive fleece and a combination of both

SFL, MOUNTED FLAP WHEEL MADE OF ABRASIVE CLOTH

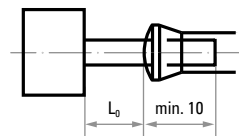
These tools comprise individual flaps which are radially fixed around the axis of the tool. They are mainly used on handheld power tools. We offer our mounted flap wheels made of abrasive cloth in the qualities Ceramic, NK, NKE and SIC.

Application examples:

- Smoothing
- Derusting
- Fettling
- Deburring
- Surface grinding
- Texturing
- Beveling

SPEED

The stated maximum permissible speeds apply for a maximum open shank length L_0 of 20 mm.



These qualities are available upon request

SFB, SLOTTED FLAP WHEEL

The slits around the circumference of the flaps add greater flexibility compared to a regular mounted flap wheel. This allows the slotted flap wheel to adapt itself even better to the contour of the workpiece.

SFT, MOUNTED FLAP WHEEL WITH RECESS

These tools are suitable for both face and peripheral grinding.

SFI AND SFA, MOUNTED FLAP WHEELS MADE OF ABRASIVE CLOTH WITH INTERNAL OR EXTERNAL THREAD INCL. TOOL ADAPTERS

In contrast to the SFL, these mounted flap wheels also have a thread. With the appropriate adapter, the tool can be changed quickly without removing the tool adapter from the power tool. The adapter extends the shaft and optimises set-up time.

SFV, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE

These tools comprise single fleece flaps fixed radially around the axis of the tool; they are available in regular aluminium oxide (A), silicon carbide (C) and zirconia aluminium oxide (Z). SFV are mainly used on handheld power tools.

SFR, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE DISCS

These special tools are comprised of individual elastic fleece discs staked one upon the other. This makes them particularly suitable for machining profiled workpieces.

SFM, MOUNTED FLAP WHEEL MADE OF COMBINED ABRASIVE FLEECE AND CLOTH

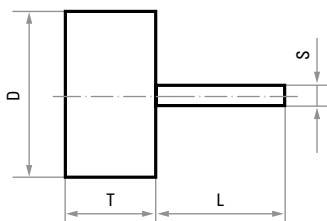
These tools comprise single fleece and cloth flaps radially fixed around the axis of the tool; they are available in regular aluminium oxide (A) and silicon carbide (C). The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared with type SFV. SFM are mainly used on handheld power tools.

SFM, MOUNTED FLAP WHEEL MADE OF TF MATERIAL

These tools are specially designed for use with non-rusting materials. The abrasive fleece with its reinforced backing guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotating direction of the tool!



- good tool life on different materials for rough and fine grinding
- regular aluminium oxide for cost-effective applications
- used as a handheld tool, ideal for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling



SFL mounted flap wheel



Product number	Description	Grit	D mm	T mm	S mm	L mm	n _{recom} rpm	n _{max} rpm	Pack contains
A2200010103080	SFL 01010.03	NK 80	10	10	3	40	26,000	35,000	10
A2200010103120	SFL 01010.03	NK 120	10	10	3	40	26,000	35,000	10
A2200010103150	SFL 01010.03	NK 150	10	10	3	40	26,000	35,000	10
A2200010103240	SFL 01010.03	NK 240	10	10	3	40	26,000	35,000	10
A2200020103080	SFL 02010.03	NK 80	20	10	3	40	20,000	28,000	10
A2200020103120	SFL 02010.03	NK 120	20	10	3	40	20,000	28,000	10
A2200020103150	SFL 02010.03	NK 150	20	10	3	40	20,000	28,000	10
A2200020106080	SFL 02010.06	NK 80	20	10	6	40	20,000	38,200	10
A2200020106120	SFL 02010.06	NK 120	20	10	6	40	20,000	38,200	10
A2200025103080	SFL 02510.03	NK 80	25	10	3	40	16,000	18,000	10
A2200025103120	SFL 02510.03	NK 120	25	10	3	40	16,000	18,000	10
A2200030053080	SFL 03005.03	NK 80	30	5	3	40	16,000	18,000	10
A2200030053150	SFL 03005.03	NK 150	30	5	3	40	16,000	18,000	10
A2200030156060	SFL 03015.06	NK 60	30	15	6	40	16,000	25,400	10
A2200030156080	SFL 03015.06	NK 80	30	15	6	40	16,000	25,400	10
A2200030156120	SFL 03015.06	NK 120	30	15	6	40	16,000	25,400	10
A2200030156150	SFL 03015.06	NK 150	30	15	6	40	16,000	25,400	10
A2200040206040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	10
A2200040206060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	10
A2200040206080	SFL 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A2200040206120	SFL 04020.06	NK 120	40	20	6	40	12,000	19,100	10
A2200040206150	SFL 04020.06	NK 150	40	20	6	40	12,000	19,100	10
A2200040206240	SFL 04020.06	NK 240	40	20	6	40	12,000	19,100	10
A2200050206040	SFL 05020.06	NK 40	50	20	6	40	9,000	15,300	10
A2200050206060	SFL 05020.06	NK 60	50	20	6	40	9,000	15,300	10
A2200050206080	SFL 05020.06	NK 80	50	20	6	40	9,000	15,300	10
A2200050206120	SFL 05020.06	NK 120	50	20	6	40	9,000	15,300	10
A2200060306040	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	10
A2200060306060	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	10
A2200060306080	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	10
A2200060306120	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	10
A2200060306150	SFL 06030.06	NK 150	60	30	6	40	8,000	12,700	10
A2200080506040	SFL 08050.06	NK 40	80	50	6	40	6,000	7,500	10
A2200080506060	SFL 08050.06	NK 60	80	50	6	40	6,000	7,500	10
A2200080506080	SFL 08050.06	NK 80	80	50	6	40	6,000	7,500	10
A2200080506120	SFL 08050.06	NK 120	80	50	6	40	6,000	7,500	10

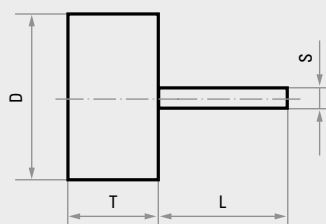
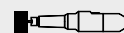
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

DEBURR EVEN THE SMALLEST BORES

LUKAS MINI FLAP WHEELS FOR FLEXIBLE AND FINE WORK

GRINDING AND POLISHING
(with flexible tools)

MFS mini flap wheel



- deburring bores
- manufacturing and cleaning of glass products
- internal pipe machining
- machining aluminium tyre rims
- machining bores in turbine blades
- versatile special applications

★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	n_{max} rpm	Pack contains
A2205015306150001	MFS 01530,06	NK 150	15	30	6	100	18,000	10
A2205020306150001	MFS 02030,06	NK 150	20	30	6	100	18,000	10
A2205025306150001	MFS 02530,06	NK 150	25	30	6	100	18,000	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium								



SAFETY INFORMATION

To safely use mini flap wheels with a long shan, they must be placed against the workpiece or inserted into bores or channels

before starting up the power tool. Contact with the workpiece must be assured until the power tool is switched off.

LUKAS MOUNTED FLAP WHEELS MADE OF ABRASIVE FLEECE

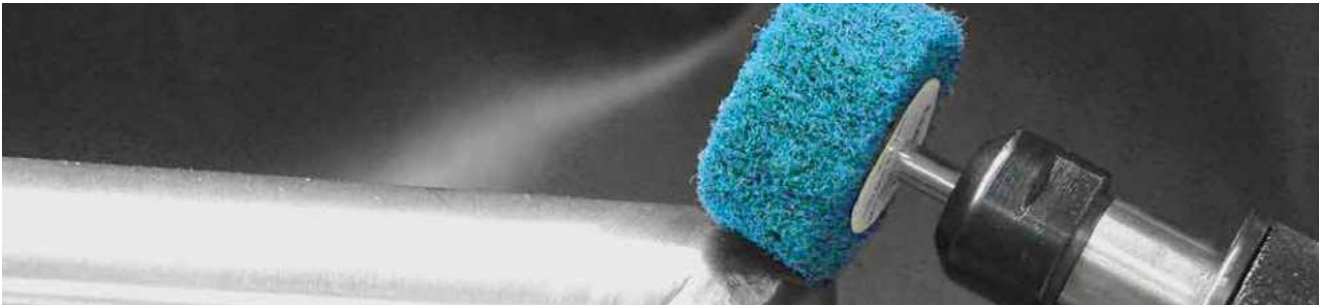
READY FOR EVERY WORK SCENARIO

The fleece flaps or discs of the LUKAS mounted flap wheels with abrasive fleece are made with regular aluminium oxide, zirconia alumina or silicon carbide. This means that LUKAS can cover a broad spectrum of machining materials from steel and titanium through to ceramics and tungsten carbide. Different designs allow you to specify the application even further.

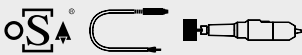
Abrasive fleece is probably the most flexible of all abrasives and can be used for many different jobs. Its wide variety of designs enables LUKAS to offer you a broad spectrum of machining

options: matt finishing, satin-matt finishing, polishing, smoothing and final surface finishing – with LUKAS mounted flap wheels made of abrasive fleece, you can master any scenario.

LUKAS mounted flap wheels made of abrasive fleece comprise individual flaps, which are fixed radially fixed around the axis of the tool. Thanks to the use of polyamide, the abrasive fleece also adapts itself perfectly to uneven surfaces. You need less effort and time for your work, and yet still achieve perfect surface results.

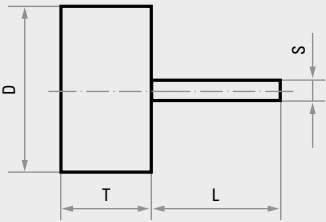


GRINDING AND POLISHING
(with flexible tools)



SFV mounted flap wheel, zirconia alumina

- achieves especially high stock removal rates on hard and tough materials such as stainless steel and a long tool life
- manufactured with zirconia alumina for extreme hardness and sharpness
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



★★★

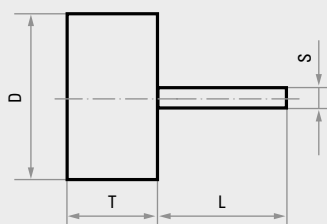
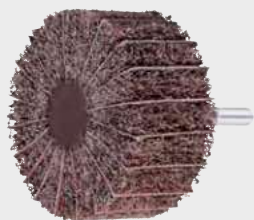
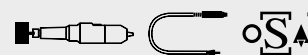
Product number	Description	Grit	D mm	T mm	S mm	L mm	n _{recom} rpm	n _{max} rpm	Pack contains
A2203040206306	SFV 04020.06	ZK 180	40	20	6	40	7,500	14,000	10
A2203060306306	SFV 06030.06	ZK 180	60	30	6	40	5,000	9,000	10
A2203080506306	SFV 08050.06	ZK 180	80	50	6	40	4,000	7,000	10

Recommended for: Inox/Steel Steel Aluminium Cast material Plastic/Wood Titanium

THE ABRASIVE COMBINATION FOR HIGH REMOVAL RATES

PERFECT MACHINING OF LARGE AND
UNEVEN SURFACES USING ABRASIVE FLEECE AND CLOTH

**SFM mounted flap wheel, combined abrasive fleece and cloth,
regular aluminium oxide**



★★☆

- for continuous working
- used as a handheld tool, ideal for the cleaning, derusting, surface preparation, texturing and roughening of workpiece surfaces

Product number	Description	Grit	D mm	T mm	S mm	L mm	n _{recom} rpm	n _{max} rpm	Pack contains
A2204030306104	SFM 03030.06	A 104/80	30	30	6	40	10,000	14,000	10
A2204040206104	SFM 04020.06	A 104/80	40	20	6	40	7,500	14,000	10
A2204040206106	SFM 04020.06	A 106/150	40	20	6	40	7,500	14,000	10
A2204040206107	SFM 04020.06	A 107/240	40	20	6	40	7,500	14,000	10
A2204050206104	SFM 05020.06	A 104/80	50	20	6	40	6,000	11,000	10
A2204060406104	SFM 06040.06	A 104/80	60	40	6	40	5,000	9,000	10
A2204080506104	SFM 08050.06	A 104/80	80	50	6	40	4,000	7,000	10
A2204080506106	SFM 08050.06	A 106/150	80	50	6	40	4,000	7,000	10
A2204080506107	SFM 08050.06	A 107/240	80	50	6	40	4,000	7,000	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Abrasive bands and mandrels from LUKAS

SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE

We offer a large selection of abrasive bands and matching mandrels. They are available in many different dimensions and qualities. Abrasive bands are made of abrasive cloth which is spirally wound onto a fabric with a backing. Mounted on matching mandrels, they are used with handheld machines (straight grinders or machines with a flexible shaft). **Pages 74–75**

Application examples:

- Cleaning
- Light deburring
- Refining
- Surface and contour grinding
- Fine grinding

STZY ABRASIVE BAND MANDRELS, CYLINDRICAL SHAPE

Our mandrels are used solely for mounting our cylindrical abrasive bands. Due to the special slots in the mandrel, the abrasive bands are firmly secured as speed increases. **Pages 76**

These qualities are available upon request

SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE WITHOUT LINING

These particularly flexible abrasive bands are made of abrasive cloth. They are used on handheld machines (straight grinders or machines with flexible shafts) and are mounted on matching soft mandrels.

SBKE ABRASIVE BANDS, CONICAL SHAPE

Conical abrasive bands are comparable in their design and usage with the cylindrical version. The taper (sleeve shape) allows the grinding of workpieces with hard-to-reach areas.

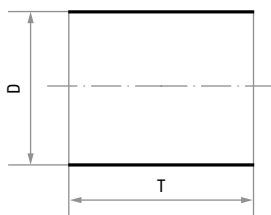
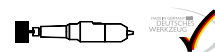
STKE ABRASIVE BAND MANDRELS, CONICAL SHAPE

Our mandrels are used solely for mounting our conical abrasive bands. Due to the special slot design, the abrasive bands are firmly secured as speed increases.

STWS ABRASIVE BAND MANDRELS FOR ABRASIVE BAND ROLLS

These especially soft mandrels are provided with a 19 mm bore and four keyways in order to be used with our corresponding abrasive band on handheld surface grinders (conditioning machines).

SBZY Ceramic abrasive band, cylindrical shape



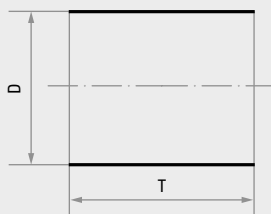
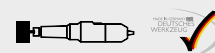
- especially robust ceramic grain for hard materials
- high stock removal rate and long tool life
- Hardened surfaces, wear-resistant steels, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- The matching mandrels can be found on **page 76**.

★★★

Product number	Description	Grit	D mm	T mm	Pack contains
A240603030040	SBZY 03030	Ceramic 40	30	30	50
A240603030060	SBZY 03030	Ceramic 60	30	30	50
A240606030040	SBZY 06030	Ceramic 40	60	30	25
A240606030060	SBZY 06030	Ceramic 60	60	30	25

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

SBZY zirconia alumina abrasive band, cylindrical shape

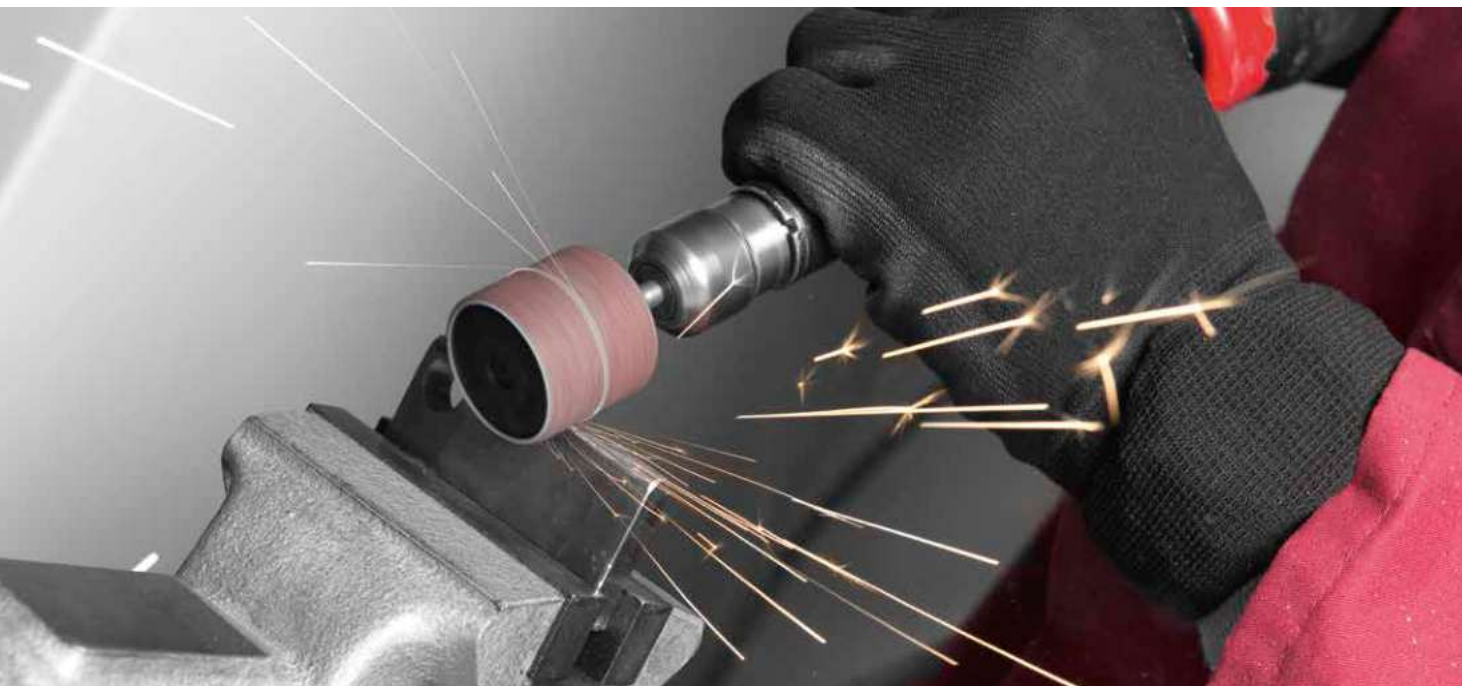


- made of abrasive cloth with zirconia alumina
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- The matching mandrels can be found on **page 76**.

★★☆

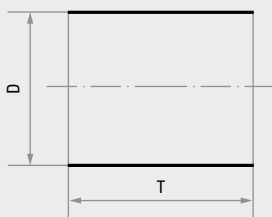
Product number	Description	Grit	D mm	T mm	Pack contains
A240201530050	SBZY 01530	ZK 50	15	30	50
A240201530060	SBZY 01530	ZK 60	15	30	50
A240203030036	SBZY 03030	ZK 36	30	30	50
A240203030050	SBZY 03030	ZK 50	30	30	50
A240204530036	SBZY 04530	ZK 36	45	30	50
A240204530050	SBZY 04530	ZK 50	45	30	50
A240204530060	SBZY 04530	ZK 60	45	30	50
A240206030036	SBZY 06030	ZK 36	60	30	50
A240206030050	SBZY 06030	ZK 50	60	30	50

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium



SBZY regular aluminium oxide abrasive band, cylindrical shape

- Regular aluminium oxide has good tool life when used on structural steel and for rough grinding.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- The matching mandrels can be found on **page 76**.

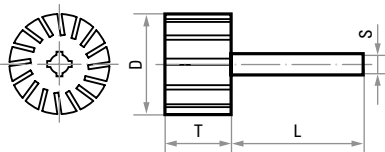
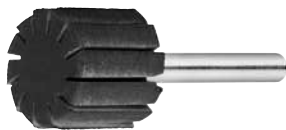
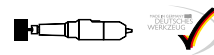


★★★☆☆

Product number	Description	Grit	D mm	T mm	Pack contains
A240001225080	SBZY 01225	NK 80	12	25	50
A240001225150	SBZY 01225	NK 150	12	25	50
A240001530040	SBZY 01530	NK 40	15	30	50
A240001530050	SBZY 01530	NK 50	15	30	50
A240001530060	SBZY 01530	NK 60	15	30	50
A240001530080	SBZY 01530	NK 80	15	30	50
A240001530150	SBZY 01530	NK 150	15	30	50
A240002220060	SBZY 02220	NK 60	22	20	50
A240002220080	SBZY 02220	NK 80	22	20	50
A240002220150	SBZY 02220	NK 150	22	20	50
A240003030040	SBZY 03030	NK 40	30	30	50
A240004530040	SBZY 04530	NK 40	45	30	50
A240004530060	SBZY 04530	NK 60	45	30	50
A240004530080	SBZY 04530	NK 80	45	30	50
A240004530150	SBZY 04530	NK 150	45	30	50
A240006030040	SBZY 06030	NK 40	60	30	50
A240006030060	SBZY 06030	NK 60	60	30	50
A240006030080	SBZY 06030	NK 80	60	30	50
A240006030150	SBZY 06030	NK 150	60	30	50
A240007530040	SBZY 07530	NK 40	75	30	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

STZY hard abrasive band mandrel, cylindrical shape



The stated maximum permissible speeds apply for a maximum overhang length L_0 of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!



Product number	Description	Type	D mm	T mm	S mm	L mm	n_{max} rpm	Pack contains
A2500012256	STZY 01225.06	hard	12	25	6	40	46,500	5
A2500015306	STZY 01530.06	hard	15	30	6	40	38,000	5
A2500022206	STZY 02220.06	hard	22	20	6	40	26,000	5
A2500025256	STZY 02525.06	hard	25	25	6	40	22,500	5
A2500030306	STZY 03030.06	hard	30	30	6	40	19,000	5
A25000453060001	STZY 04530.06	hard	45	30	6	40	13,000	5
A25000603060001	STZY 06030.06	hard	60	30	6	40	9,500	5
A25000753080001	STZY 07530.08	hard	75	30	6	40	6,500	2

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS abrasive caps and mandrels

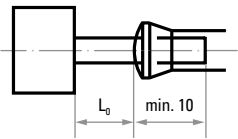
Our abrasive caps and sleeves consist of high-quality abrasive cloth and are manufactured to fit perfectly on our corresponding mandrels. We offer a large assortment of tools with the corresponding mandrel for various applications.

PERMISSIBLE SPEEDS

The maximum permissible speeds indicated in the respective table of abrasive cap mandrels apply for a maximum overhang length of 15 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

Application examples:

- Fine and ultra-fine grinding work, especially in hard-to-reach areas
- Machining in tool- and mouldmaking industry as well as pattern construction



ABRASIVE CAP CERAMIC	ABRASIVE CAP SPECIAL
<p>★★★</p>  <p>Self-sharpening ceramic grain for machining the most challenging materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem with this grain.</p>	<p>★★☆</p>  <p>Special quality for the machining of corrosion and heat-resistant steels in the tool- and mouldmaking industry as well as for the universal machining of plastics, aluminium and non-ferrous metals. The surface layer with active abrasive additives enables enhanced stock removal rate and a longer tool life.</p>

THE GRINDING TOOL WITH SELF-SHARPENING EFFECT

GRIND LONGER ON THE HARDEST METALS WITH THE LUKAS CERAMIC ABRASIVE CAP



Whether tool steel, cast steel or titanium alloys – an increasing amount of extremely hard and tough metals are machined in industry. With the ceramic abrasive cap, a tool for straight grinders is now available that makes machining smaller parts and deburring extremely easy. An extra-long tool life is an added bonus thanks to the self-sharpening effect.

These abrasive caps are perfect for grinding uneven surfaces, machining small parts, deburring and regrinding small radii. The abrasive caps can even be used for stainless steel because they generate little heat during grinding.

SELF-SHARPENING EFFECT REDUCES TOOL COSTS

Thanks to self-sharpening, Ceramic abrasive caps achieve a tool life many times that of ordinary caps. Tool changes are required much less frequently, thus reducing tool costs.

NO MORE GLAZING

The grinding particles embedded in a resin matrix break off when worn and make way for new particles with sharp cutting edges. The dulling known as “glazing” familiar with other grinding tools does not occur when machining hard materials. As a result, the Ceramic abrasive cap continues to work like new despite wear.

4 DIFFERENT
SHAPES
AVAILABLE



**AN ALL-ROUND TOOL
FOR DEBURRING, GRINDING,
BEVELLING AND REGRINDING**

MAXIMUM CUTTING PERFORMANCE

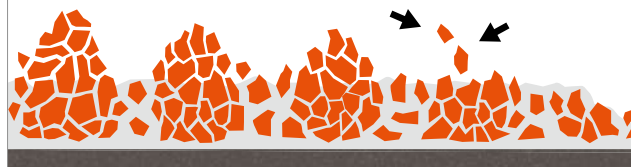
The abrasive caps with ceramic grain were developed for machining the most demanding materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem when using these abrasive caps. Due to its self-sharpening effect, this aggressive grinding behaviour is retained for a very long time.

THE TROUBLESHOOTER FOR MACHINING METAL

The Ceramic abrasive caps represent a valuable addition as a tool for all industries in which hard metals are machined. These include the tool and mould industries as well as demanding mechanical and steel engineering and also the aerospace industry.

THE SELF-SHARPENING EFFECT

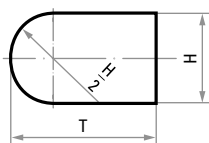
Worn grinding particles break off, exposing new particles with sharp cutting edges. That's why the abrasive cap remains as sharp as new for a long time.





SK Ceramic abrasive cap NEW

- self-sharpening
- for the hardest materials
- exceptionally long tool life
- precise fit
- also for stainless steel



★★★

Product number	Description	Shapes	Grit	H mm	T mm	Pack contains
A21120102080	SKWR 1015		Ceramic 80	10	15	100
A21120102150	SKWR 1015		Ceramic 150	10	15	100
A21120132080	SKWR 1319		Ceramic 80	13	19	100
A21120132150	SKWR 1319		Ceramic 150	13	19	100
A21120162080	SKWR 1626		Ceramic 80	16	26	100
A21120162150	SKWR 1626		Ceramic 150	16	26	100
A21120103080	SKWK 1015		Ceramic 80	10	15	100
A21120103150	SKWK 1015		Ceramic 150	10	15	100
A21120133080	SKWK 1319		Ceramic 80	13	19	100
A21120133150	SKWK 1319		Ceramic 150	13	19	100
A21120163080	SKWK 1626		Ceramic 80	16	26	100
A21120163150	SKWK 1626		Ceramic 150	16	26	100

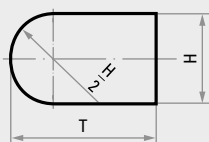
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

GRINDING AND POLISHING
(with flexible tools)



SKS Special abrasive cap

- enhanced stock removal rate using regular aluminium oxide with active abrasive surface layer
- suitable for corrosion and heat-resistant steels as well as for universal machining of plastics, non-ferrous metals and many other materials

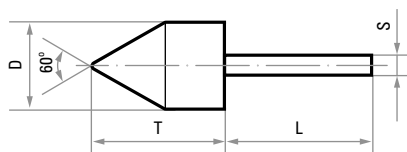
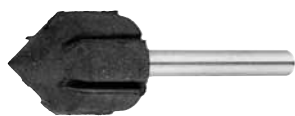
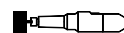


★★☆

Product number	Description	Shapes	Grit	H mm	T mm	Pack contains
A21020052080	SKWRS 0511		NKS 80	5	11	100
A21020052150	SKWRS 0511		NKS 150	5	11	100
A21020072080	SKWRS 0713		NKS 80	7	13	100
A21020072150	SKWRS 0713		NKS 150	7	13	100
A21020102060	SKWRS 1015		NKS 60	10	15	100
A21020102080	SKWRS 1015		NKS 80	10	15	100
A21020102150	SKWRS 1015		NKS 150	10	15	100
A21020132060	SKWRS 1319		NKS 60	13	19	100
A21020132080	SKWRS 1319		NKS 80	13	19	100
A21020132150	SKWRS 1319		NKS 150	13	19	100
A21020132320	SKWRS 1319		NKS 320	13	19	100

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

Abrasive cap mandrel



Product number	Description	Shapes	D mm	T mm	Shank diameter x length mm	n_{max} rpm	Pack contains
A250000521	GTWR 0511		5	11	1/8" x 25	95,000	5
A250000523	GTWR 0511		5	11	3 x 25	95,000	5
A250000721	GTWR 0713		7	13	1/8" x 25	65,000	5
A250000723	GTWR 0713		7	13	3 x 25	65,000	5
A250001021	GTWR 1015		10	15	1/8" x 25	45,000	5
A250001023	GTWR 1015		10	15	3 x 25	45,000	5
A250001323	GTWR 1319		13	19	3 x 25	35,000	5
A250001621	GTWR 1626		16	26	1/8" x 25	18,000	5
A250001623	GTWR 1626		16	26	3 x 25	18,000	5
A250001626	GTWR 1626		16	26	6 x 40	30,000	5
A250001033	GTWK 1015		10	15	3 x 25	45,000	5
A250001333	GTWK 1319		13	19	3 x 25	35,000	5
A250001633	GTWK 1626		16	26	3 x 25	18,000	5
A250001636	GTWK 1626		16	26	6 x 40	30,000	5

TECHNICAL INFORMATION AND PRODUCT INFORMATION

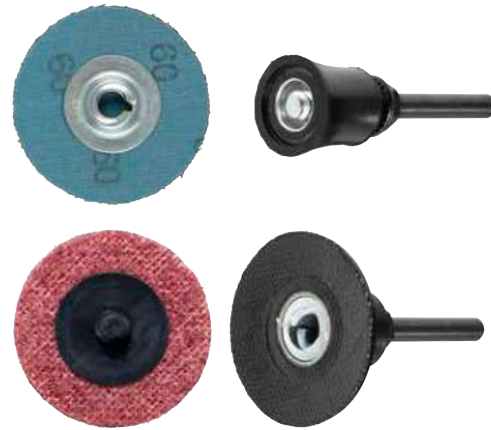
Abrasive discs and carriers from LUKAS

PSG/PSR* SELF-CLAMPING ABRASIVE DISCS

LUKAS abrasive discs – PSG/PSR – are self-clamping. The back of the abrasive discs is fitted with a “quick lock” made of metal or plastic (PSG) or a plastic thread (PSR*). The abrasive disc is attached to the corresponding carrier with a small twist. In this tool category, the PSG abrasive discs represents our most extensive range. Numerous diameters, many different grit sizes, and above all abrasive qualities for every application, help you to solve your grinding problem.

► Find out more about these abrasive discs on **pages 82–88**.

*upon request



These qualities are available upon request

PSK ADHESIVE ABRASIVE DISCS

LUKAS abrasive discs – PSK – are self-adhesive. The rubberised back of the abrasive discs is covered with a protective film. After removing this film, the abrasive discs are stuck to the respective carrier. These discs are suitable for machining many different surfaces. The adhesive bond does not permit reuse once the disc has been peeled off the carrier. These abrasive discs are available in regular aluminium oxide and silicon carbide as well as with different grit sizes, as illustrated in the following tables.



PSH SELF-FIXING ABRASIVE DISCS

LUKAS abrasive discs – PSH – are self-fixing. The abrasive discs have a Velcro backing, with the corresponding carriers covered with hooked fabric. These discs are suitable for machining both flat and concave surfaces. Abrasive discs that have not been completely worn down during machining can be removed and reused another time. These abrasive discs are available in a quality and grit size adapted to the respective application as illustrated in the following tables.





PSG ABRASIVE DISCS

Quality and applications

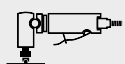
LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

You will find all abrasive discs from the PSG range in the following overview. Read through the properties and application details of the different workpiece materials to find the right quality to meet your requirements.

Quality		Properties	Application areas/machining	Page
	NK Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	85
	NKE Abrasive cloth Regular aluminium oxide with reinforced backing material	very tough abrasive, high resilience	The reinforcement makes these discs suitable for the toughest demands and beveling.	86
	ZK Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	ideal for Hastelloy, Inconel, non-rusting steel and metals that are difficult to machine	84
	Z-Power Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent stock removal rate, long tool life	ideal for machining non-rusting steel; special surface layer prevents clogging	84
	Ceramic Abrasive cloth Ceramic grain	excellent stock removal rate without grain shredding, particularly stable due to reinforced backing, cool cutting	ideal for machining non-rusting steel and nickel alloys	83
	SIC Abrasive cloth Silicon carbide	minimum heat accumulation, special quality for the aerospace industry	Ideal for machining titanium, titanium alloys and aluminium (aviation industry). Plastics and ceramics can also be processed.	88
	Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect with the fibre structure, consistent results due to continuous exposure of new grinding particles; long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of surface quality	87
	Abrasive fleece Regular aluminium oxide medium/red-brown			
	Abrasive fleece Regular aluminium oxide fine/blue			

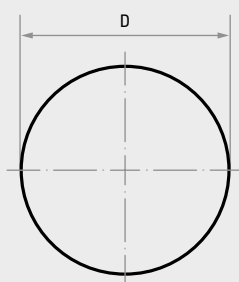
MACHINE ULTRA-HARD MATERIALS

INNOVATIVE CERAMIC GRAIN WITH SELF-SHARPENING EFFECT



PSG Ceramic self-clamping abrasive disc

- especially robust ceramic grain for hard materials
 - fitted with a "quick lock" – fastened to the respective carrier by a small twist
 - high stock removal rate and long tool life
 - Hardened surfaces, wear-resistant steel, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- The matching tool carriers can be found on **page 88**.

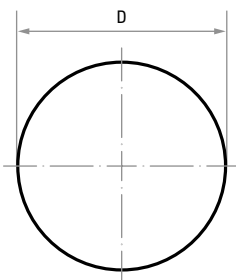
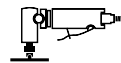


★★☆

Product number	Description	Quality/grit size	D mm	n _{max} rpm	Matching abrasive disc carrier	Pack contains	
A33790250360458	PSG 025	Ceramic 36	25	38,000	GTG 025	100	NEW
A33790250600458	PSG 025	Ceramic 60	25	38,000	GTG 025	100	NEW
A33790250800458	PSG 025	Ceramic 80	25	38,000	GTG 025	100	NEW
A33790251200458	PSG 025	Ceramic 120	25	38,000	GTG 025	100	NEW
A33790380360458	PSG 038	Ceramic 36	38	25,000	GTG 038	100	
A33790380600458	PSG 038	Ceramic 60	38	25,000	GTG 038	100	
A33790380800458	PSG 038	Ceramic 80	38	25,000	GTG 038	100	
A33790381200458	PSG 038	Ceramic 120	38	25,000	GTG 038	100	
A33790500360458	PSG 050	Ceramic 36	50	25,000	GTG 038 and GTG 050	100	
A33790500500458	PSG 050	Ceramic 50	50	25,000	GTG 038 and GTG 050	100	NEW
A33790500600458	PSG 050	Ceramic 60	50	25,000	GTG 038 and GTG 050	100	
A33790500800458	PSG 050	Ceramic 80	50	25,000	GTG 038 and GTG 050	100	
A33790501200458	PSG 050	Ceramic 120	50	25,000	GTG 038 and GTG 050	100	
A33790750360458	PSG 075	Ceramic 36	75	20,000	GTG 075	50	
A33790750600458	PSG 075	Ceramic 60	75	20,000	GTG 075	50	
A33790750800458	PSG 075	Ceramic 80	75	20,000	GTG 075	50	
A33790751200458	PSG 075	Ceramic 120	75	20,000	GTG 075	50	

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

PSG Z-Power self-clamping abrasive disc



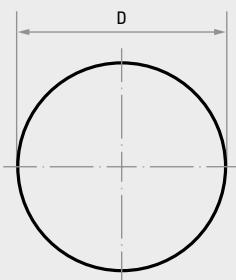
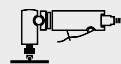
- made of zirconia alumina with active abrasive surface layer
- ideal for machining stainless steel
- special surface layer prevents clogging
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 88**.

★★☆

Product number	Description	Quality/grit size	D mm	n_{max} rpm	Matching abrasive disc carrier	Pack contains
A33770380360458	PSG 038	Z-Power 36	38	25,000	GTG 038	100
A33770380600458	PSG 038	Z-Power 60	38	25,000	GTG 038	100
A33770380800458	PSG 038	Z-Power 80	38	25,000	GTG 038	100
A33770381200458	PSG 038	Z-Power 120	38	25,000	GTG 038	100
A33770500360458	PSG 050	Z-Power 36	51	25,000	GTG 038 and GTG 050	100
A33770500600458	PSG 050	Z-Power 60	51	25,000	GTG 038 and GTG 050	100
A33770500800458	PSG 050	Z-Power 80	51	25,000	GTG 038 and GTG 050	100
A3377050360458	PSG 075	Z-Power 36	76	20,000	GTG 075	50
A3377050600458	PSG 075	Z-Power 60	76	20,000	GTG 075	50
A3377050800458	PSG 075	Z-Power 80	76	20,000	GTG 075	50
A3377051200458	PSG 075	Z-Power 120	76	20,000	GTG 075	50

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

PSG self-clamping zirconia alumina abrasive disc



- made from abrasive cloth with zirconia alumina
- ideal for Hastelloy, Inconel, stainless steel and metals that are difficult to machine
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 88**.

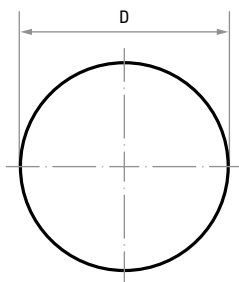
★★☆

Product number	Description	Quality/grit size	D mm	n_{max} rpm	Matching abrasive disc carrier	Pack contains
A33530250600458	PSG 025	ZK 60	25	38,000	GTG 025	100
A33530250800458	PSG 025	ZK 80	25	38,000	GTG 025	100
A33530380600458	PSG 038	ZK 60	38	25,000	GTG 038	100
A33530380800458	PSG 038	ZK 80	38	25,000	GTG 038	100
A33530500360458	PSG 050	ZK 36	51	25,000	GTG 038 and GTG 050	100
A33530500600458	PSG 050	ZK 60	51	25,000	GTG 038 and GTG 050	100
A33530500800458	PSG 050	ZK 80	51	25,000	GTG 038 and GTG 050	100
A33530750360458	PSG 075	ZK 36	76	20,000	GTG 075	50
A33530750600458	PSG 075	ZK 60	76	20,000	GTG 075	50

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium



PSG self-clamping regular aluminium oxide abrasive disc



- for universal grinding and deburring work
- fitted with a “quick lock” – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 88**.

★ ★ ☆

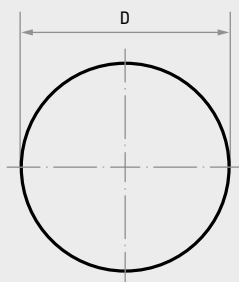
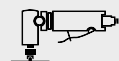
Product number	Description	Quality/grit size	D mm	n _{max} rpm	Matching abrasive disc carrier	Pack contains
A33510200600458	PSG 020	NK 60	19	47,000	GTG 020	100
A33510200800458	PSG 020	NK 80	19	47,000	GTG 020	100
A33510201200458	PSG 020	NK 120	19	47,000	GTG 020	100
A33510250360458	PSG 025	NK 36	25	38,000	GTG 025	100
A33510250600458	PSG 025	NK 60	25	38,000	GTG 025	100
A33510250800458	PSG 025	NK 80	25	38,000	GTG 025	100
A33510251200458	PSG 025	NK 120	25	38,000	GTG 025	100
A33510380360458	PSG 038	NK 36	38	25,000	GTG 038	100
A33510380600458	PSG 038	NK 60	38	25,000	GTG 038	100
A33510380800458	PSG 038	NK 80	38	25,000	GTG 038	100
A33510381200458	PSG 038	NK 120	38	25,000	GTG 038	100
A33510500360458	PSG 050	NK 36	51	25,000	GTG 038 and GTG 050	100
A33510500500458	PSG 050	NK 50	51	25,000	GTG 038 and GTG 050	100
A33510500600458	PSG 050	NK 60	51	25,000	GTG 038 and GTG 050	100
A33510500800458	PSG 050	NK 80	51	25,000	GTG 038 and GTG 050	100
A33510501200458	PSG 050	NK 120	51	25,000	GTG 038 and GTG 050	100
A33510501800458	PSG 050	NK 180	51	25,000	GTG 038 and GTG 050	100
A33510502400458	PSG 050	NK 240	51	25,000	GTG 038 and GTG 050	100
A33510750600458	PSG 075	NK 60	76	20,000	GTG 075	50
A33510750800458	PSG 075	NK 80	76	20,000	GTG 075	50
A33510751200458	PSG 075	NK 120	76	20,000	GTG 075	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

CAN ALSO HANDLE EDGES

THANKS TO THE REINFORCED BACKING MATERIAL
ALSO SUITABLE FOR THE TOUGHEST APPLICATIONS

PSG reinforced self-clamping regular aluminium oxide abrasive disc

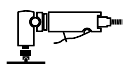


- made of abrasive cloth with regular aluminium oxide and reinforced backing material
- The reinforcement makes these discs suitable for the toughest applications and beveling.
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 88**.

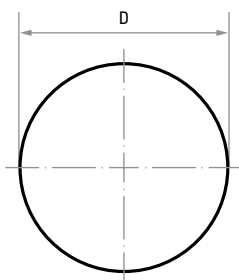
★★☆

Product number	Description	Quality/grit size	D mm	n _{max} rpm	Matching abrasive disc carrier	Pack contains
A33520250600458	PSG 025	NKE 60	25	38,000	GTG 025	100
A33520250800458	PSG 025	NKE 80	25	38,000	GTG 025	100
A33520251200458	PSG 025	NKE 120	25	38,000	GTG 025	100
A33520251800458	PSG 025	NKE 180	25	38,000	GTG 025	100
A33520252400458	PSG 025	NKE 240	25	38,000	GTG 025	100
A33520380600458	PSG 038	NKE 60	38	25,000	GTG 038	100
A33520380800458	PSG 038	NKE 80	38	25,000	GTG 038	100
A33520381200458	PSG 038	NKE 120	38	25,000	GTG 038	100
A33520500360458	PSG 050	NKE 36	51	25,000	GTG 038 and GTG 050	100
A33520500600458	PSG 050	NKE 60	51	25,000	GTG 038 and GTG 050	100
A33520500800458	PSG 050	NKE 80	51	25,000	GTG 038 and GTG 050	100
A33520501200458	PSG 050	NKE 120	51	25,000	GTG 038 and GTG 050	100
A33520501800458	PSG 050	NKE 180	51	25,000	GTG 038 and GTG 050	100
A33520502400458	PSG 050	NKE 240	51	25,000	GTG 038 and GTG 050	100
A33520750800458	PSG 075	NKE 80	76	20,000	GTG 075	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium



PSG self-clamping abrasive disc, abrasive fleece



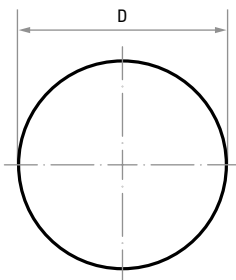
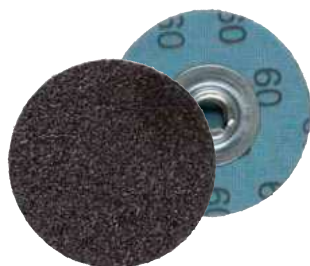
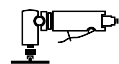
- ideal for removing rust or paint, scratches and pre-grinding marks
- Improvement of surface quality
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 88**.

★ ★ ☆

Product number	Description	Quality/grit size	D mm	n _{max} rpm	Matching abrasive disc carrier	Pack contains	
A33740250040458	PSG 025	P coarse	25	15,000	GTG 025	50	NEW
A33740250020458	PSG 025	P medium	25	15,000	GTG 025	50	NEW
A33740380050458	PSG 038	P fine	38	10,000	GTG 038	50	
A33740380040458	PSG 038	P coarse	38	10,000	GTG 038	50	
A33740380020458	PSG 038	P medium	38	10,000	GTG 038	50	
A33740500050458	PSG 050	P fine	50	7,500	GTG 038 and GTG 050	50	
A33740500040458	PSG 050	P coarse	50	7,500	GTG 038 and GTG 050	50	
A33740500020458	PSG 050	P medium	50	7,500	GTG 038 and GTG 050	50	
A33740750050458	PSG 075	P fine	75	5,000	GTG 075	25	
A33740750040458	PSG 075	P coarse	75	5,000	GTG 075	25	
A33740750020458	PSG 075	P medium	75	5,000	GTG 075	25	
A33550380040458	PSG 038	V coarse	38	10,000	GTG 038	50	NEW
A33550380020458	PSG 038	V medium	38	10,000	GTG 038	50	NEW
A33550380050458	PSG 038	V fine	38	10,000	GTG 038	50	NEW
A33550500040458	PSG 050	V coarse	50	8,000	GTG 038 and GTG 050	50	NEW
A33550500020458	PSG 050	V medium	50	8,000	GTG 038 and GTG 050	50	NEW
A33550500050458	PSG 050	V fine	50	8,000	GTG 038 and GTG 050	50	NEW

 Recommended for:
 ● Inox/Steel
 ● Steel
 ● Plastic/Wood
 ● Aluminium
 ● Cast material
 ● Titanium

PSG self-clamping silicon carbide abrasive disc

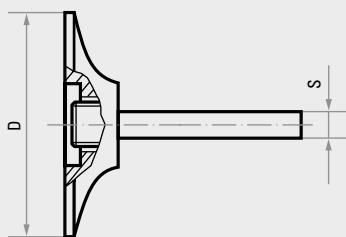
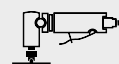


- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminium (aerospace industry), as well as plastics and ceramics
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found at the bottom of this page.

★★☆

Product number	Description	Quality / grit size	D mm	n _{max} rpm	Matching abrasive disc carrier	Pack contains
A33780380360458	PSG 038	SIC 36	38	25,000	GTG 038	100
A33780380600458	PSG 038	SIC 60	38	25,000	GTG 038	100
A33780380800458	PSG 038	SIC 80	38	25,000	GTG 038	100
A33780500600458	PSG 050	SIC 60	51	25,000	GTG 038 and GTG 050	100
A33780500800458	PSG 050	SIC 80	51	25,000	GTG 038 and GTG 050	100
A33780501200458	PSG 050	SIC 120	51	25,000	GTG 038 and GTG 050	100
Recommended for: ● Aluminium ● Plastic / Wood ● Titanium ● Inox/Steel ● Steel ● Cast material						

GTG abrasive disc carrier for self-clamping abrasive discs



The carriers are supplied in a universally-used medium hardness. This medium type is suitable for almost every application. Please use the hard type for the toughest machining jobs (Z-Power and Ceramic).

★★☆

Product number	Description	Type	D mm	S mm	n _{max} rpm	Pack contains
A335002000260458	GTG 020.06	medium	18	6	47,000	1
A335002500260458	GTG 025.06	medium	23	6	38,000	1
A335003800260458	GTG 038.06	medium	33	6	30,000	1
A335005000260458	GTG 050.06	medium	45	6	25,000	1
A335005000360458	GTG 050.06	hard	45	6	25,000	1
A335007500260458	GTG 075.06	medium	70	6	20,000	1
A335007500360458	GTG 075.06	hard	70	6	20,000	1

FINE AND CONSISTENT SURFACE FINISH

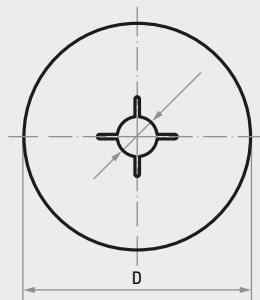
LUKAS FIBRE DISCS FOR YOUR REQUIRED SURFACE RESULTS

GRINDING AND POLISHING
(with flexible tools)



FIS zirconia alumina fibre disc with cross slot

- single layer of abrasive for the toughest applications
- made of exceptionally tough zirconia alumina with high resilience to pressure
- used together with a backing pad on angle grinders
- The matching tool carriers can be found on **page 90**.

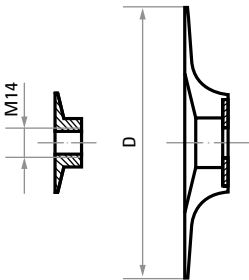


★★☆

Product number	Description	Grit	D mm	Bore mm	n _{max} rpm	Pack contains
A38301250362	FIS 125	ZK 36	125	22	12,200	50
A38301250402	FIS 125	ZK 40	125	22	12,200	50
A38301250602	FIS 125	ZK 60	125	22	12,200	50
A38301250802	FIS 125	ZK 80	125	22	12,200	50

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

STF fibre disc backing pad



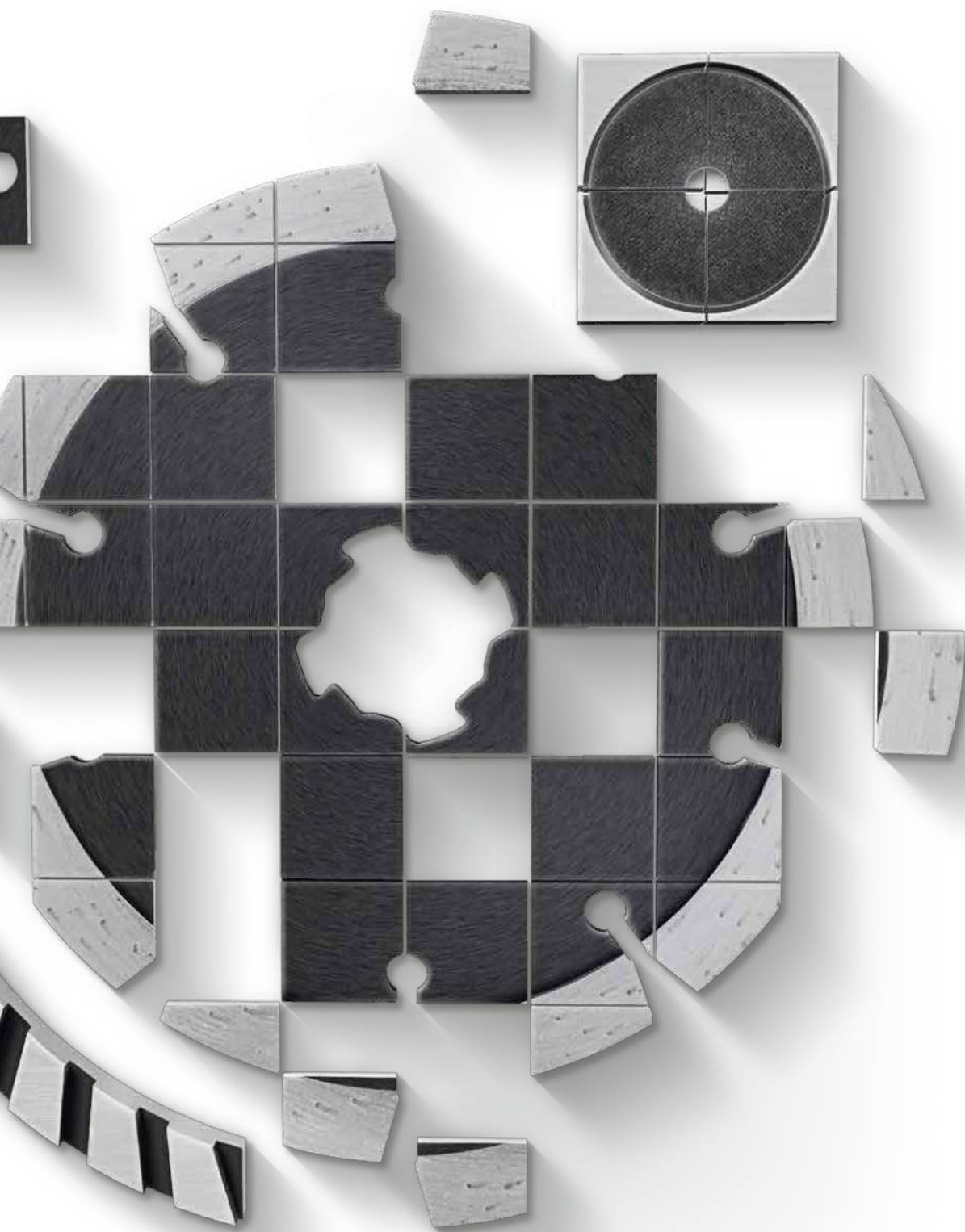
The carriers are supplied in a universally applicable degree of hardness; our medium type is suitable for almost every application. Other types are available on request for roughing work or radius grinding.

★★☆

■ nuts included

Product number	Description	D mm	Thread	n _{max} rpm	Pack contains
A38311251001	STF 125	123	M14	12,200	1

CUTTING



TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS cutting discs

SHELF LIFE

Resin-bonded cutting discs for handheld use may only be used for 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 CUTTING DISCS

All of the important information about your LUKAS cutting 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



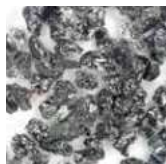
Z
Zirconia alumina



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

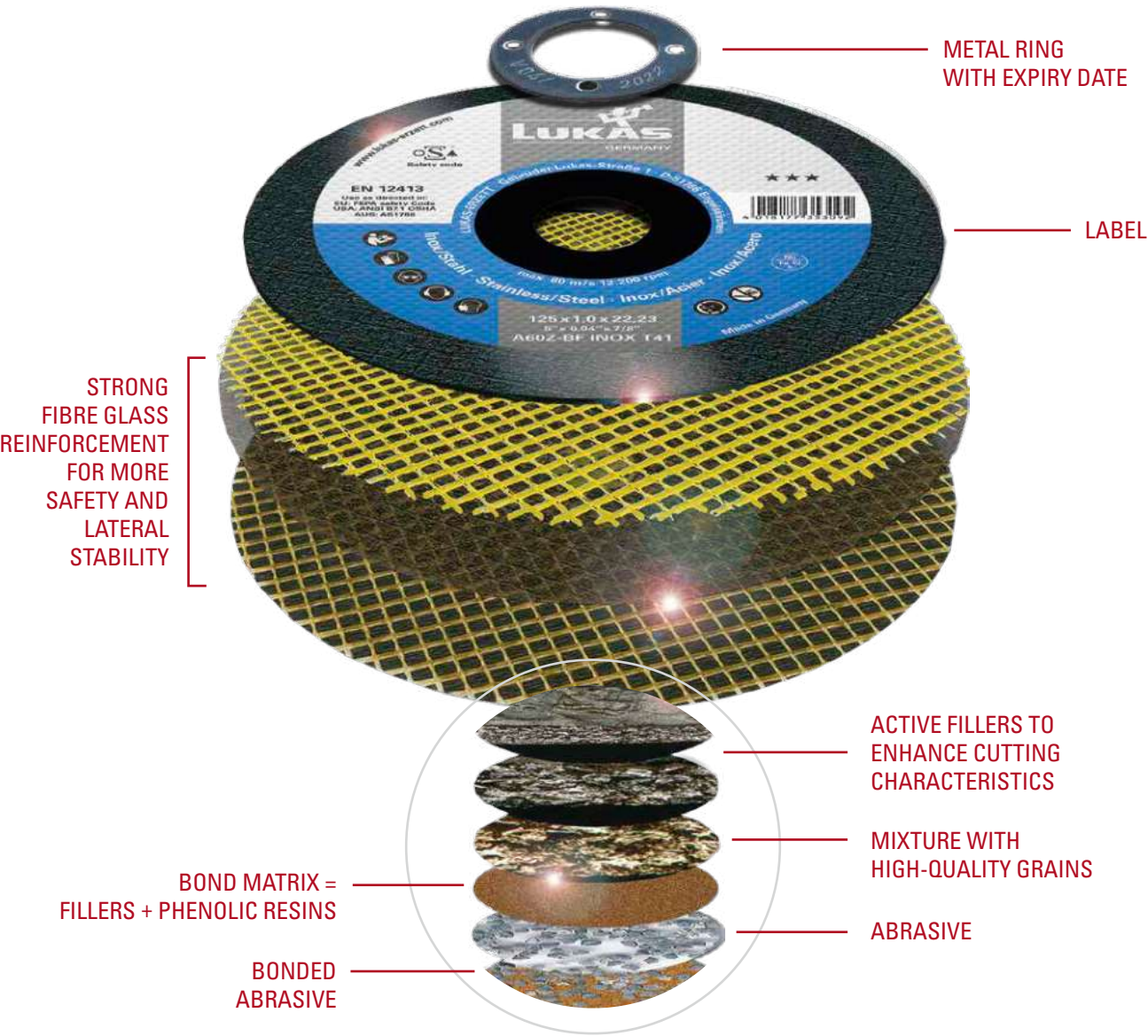
BOND

The bond is to hold the abrasive grain in the disc. LUKAS cutting discs are available with the following two types of bond:

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

TECHNICAL INFORMATION

Construction and components of LUKAS cutting discs



OPERATING SPEED

LUKAS cutting discs are developed and tested for specified maximum operating speeds and grinding processes. Before attaching 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 cutting disc.

Maximum operating speed	Cutting 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

Safe cutting 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

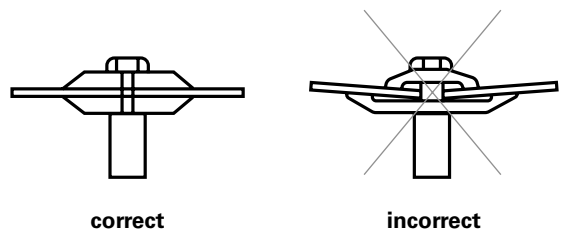
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced cutting discs on power tools.
- Store discs **in a dry place at room temperature.**
- Do not **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Use only 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.**
- Do not apply lateral pressure **to cutting discs.** Avoid bending the disc.
- Do not 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.
- **Do not cant and seize** the disc **when** cutting.
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Do not 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.
- Do only use the machine only in a position where you have full control and are well balanced.

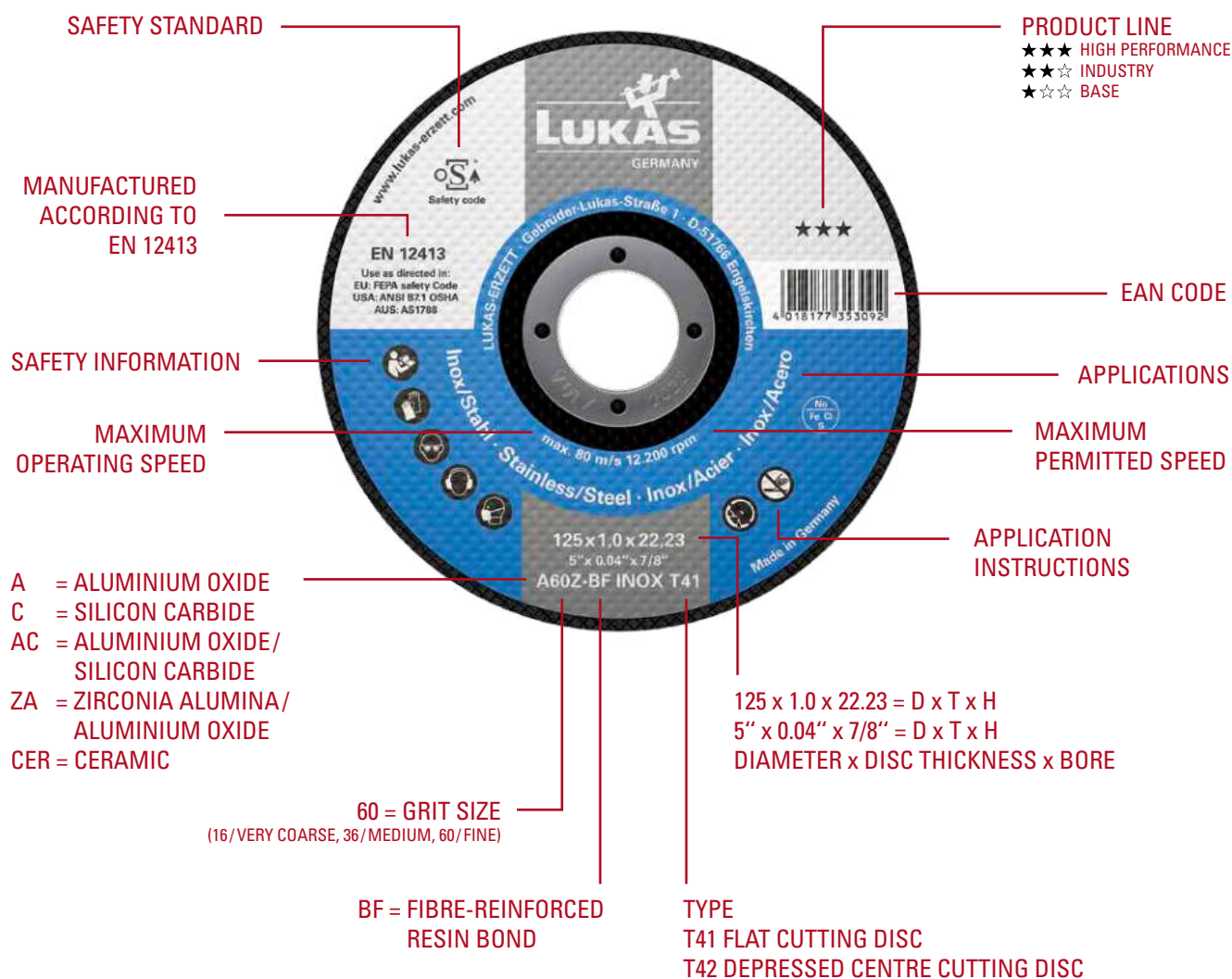
CLAMPING SYSTEM

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).



LABELLING

All important markings on the label

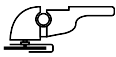


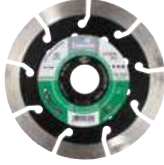




















TYPES OF RESIN-BONDED CUTTING DISCS

T41 Flat cutting discs	T42 Depressed centre cutting disc
<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 1)</p>	<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 27)</p>
<ul style="list-style-type: none"> Available in diameters from 50 mm (2") to 230 mm (9"), for handheld use From 300 mm (12") to 500 mm (20") for stationary machines 	<ul style="list-style-type: none"> Available in diameters from 76 mm (3") to 230 mm (9"), approved for handheld use

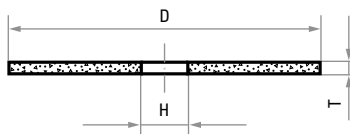
AREA OF USE

Overview of types of LUKAS cutting discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast metal/ Construction material
Handheld cutting discs for angle grinders Diameter 100–230 mm 	★★★	 Page 97	 upon request		 upon request	 upon request
	★★☆	 upon request	 upon request	 Page 99	 upon request	
	★☆☆	 Page 97	 upon request		 upon request	
Handheld cutting discs with X-LOCK system for angle grinders Diameter 115–125 mm 	★★☆	 Page 98			 upon request	
Stationary cutting discs Diameter Larger than 230 mm  	★★★				 upon request	 upon request
	★★☆				 upon request	
	★☆☆	 upon request	 upon request			



- iron-, chloride- and sulphur-free tool
- cuts precisely at a high cutting speed and low cutting temperature
- maximum tool life and cutting performance through innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



Cutting disc for stainless steel



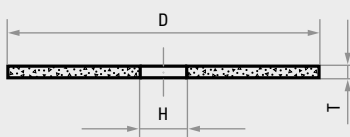
★★★

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT100010V9802	T41 100x1.0	A46Z-BF Inox	100	1.0	15.00	15,300	25
AT007233V9802	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	50
AT007237V9802	T41 125x1.6	A46Z-BF Inox	125	1.6	22.23	12,200	50
AT007243V9802	T41 180x1.6	A46Z-BF Inox	180	1.6	22.23	8,500	25

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material



- free of iron, chlorine and sulphur
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



Cutting disc for stainless steel



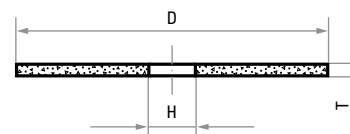
★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT003108V9802	T41 100x1.0	A60S-BF Inox	100	1.0	16.00	15,300	50

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium



- The handy choice, e.g. for the construction site
- cutting discs in a metal can
 - safely packed
 - moisture-proof



Cutting disc set



★★★

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT007233V9807010	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material



Photo: Bosch

TOOL CHANGE WITH JUST A CLICK

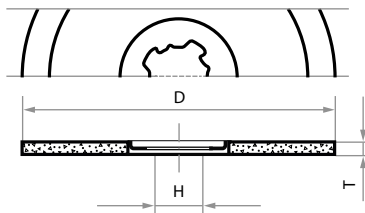
CHANGING CUTTING DISCS IS FASTER AND SIMPLER THAN EVER

With the new X-LOCK system, simply position the LUKAS cutting disc on the angle grinder's mounting fixture, allow it to engage and you're done. The click sound tells you the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

TOOL CHANGE IN NO TIME AT ALL

The X-LOCK allows you to change LUKAS cutting discs in seconds, as well as other LUKAS tool products such as the mounted flap discs which you can obtain on request.

NEW X-LOCK cutting disc



- faster and simpler tool changes thanks to the latest X-LOCK system
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT115010V980201	T41 115x1,0x22,23 X-LOCK	A46U-BF Inox	115	1.0	22.23	13,300	50
AT125010V980202	T41 125x1,0x22,23 X-LOCK	A46U-BF Inox	125	1.0	22.23	12,200	50

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material



**CUTS EVEN THE SOFTEST MATERIALS
WITHOUT ANY PROBLEMS**

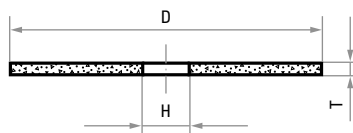
THE CUTTING DISC FOR ALUMINIUM

CUTTING



Cutting disc for machining non-ferrous metals **NEW**

- easily cuts soft, light metals
- no smearing when used on aluminium
- ideal combination of abrasive grit and bonding agent



★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT000950V9802	T41 125x1,0	A60N-BF Alu	125	1.0	22.23	12,200	50
AT001789V9802	T41 230x2,5	A36N-BF Alu	230	2.5	22.23	6,600	25

Recommended for: ● Aluminium



ROUGH GRINDING

ROUGH GRINDING

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



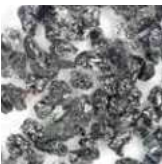
Z
Zirconia alumina



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

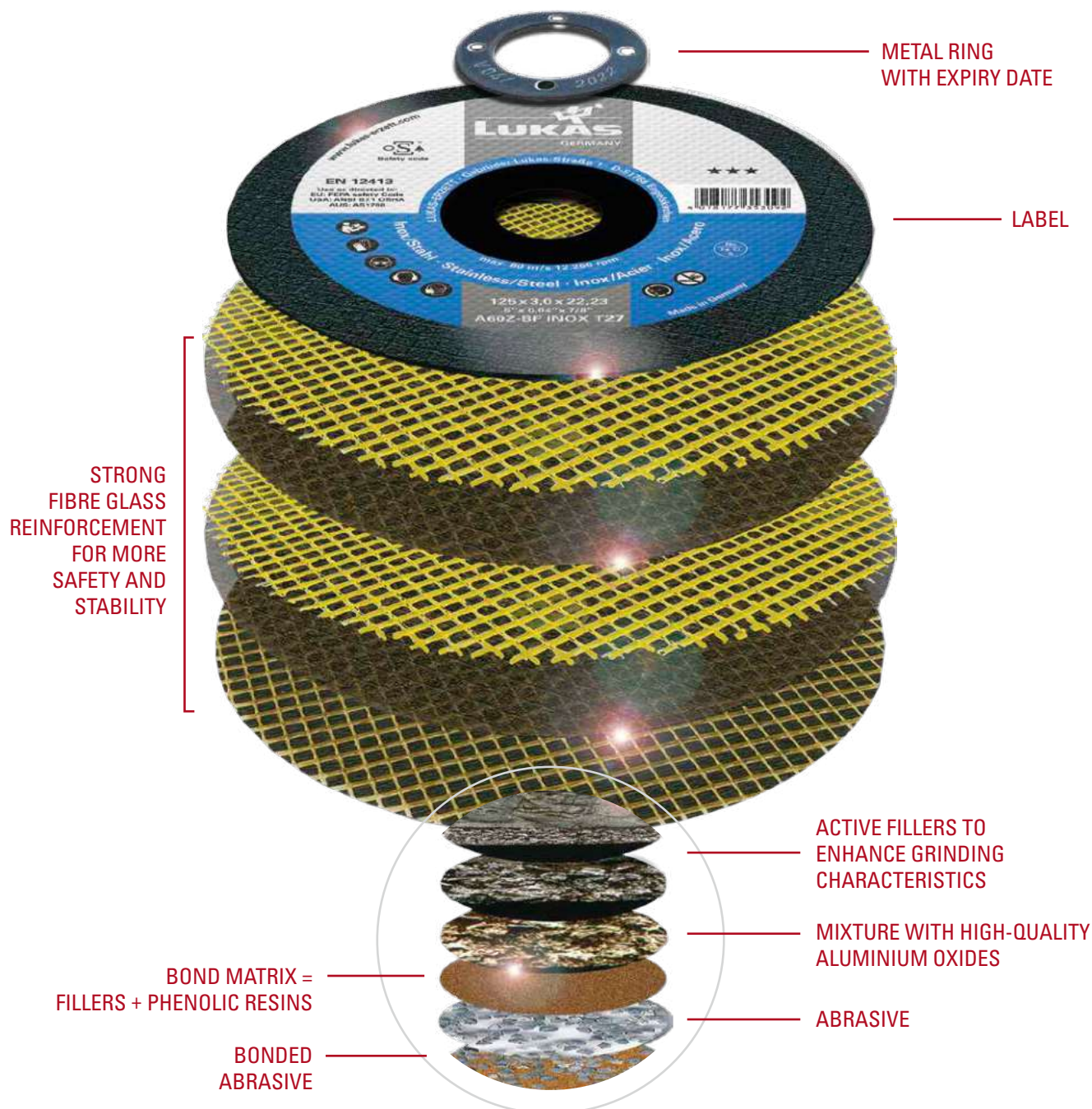
BOND

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

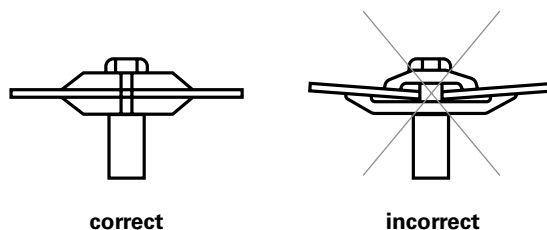
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

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.

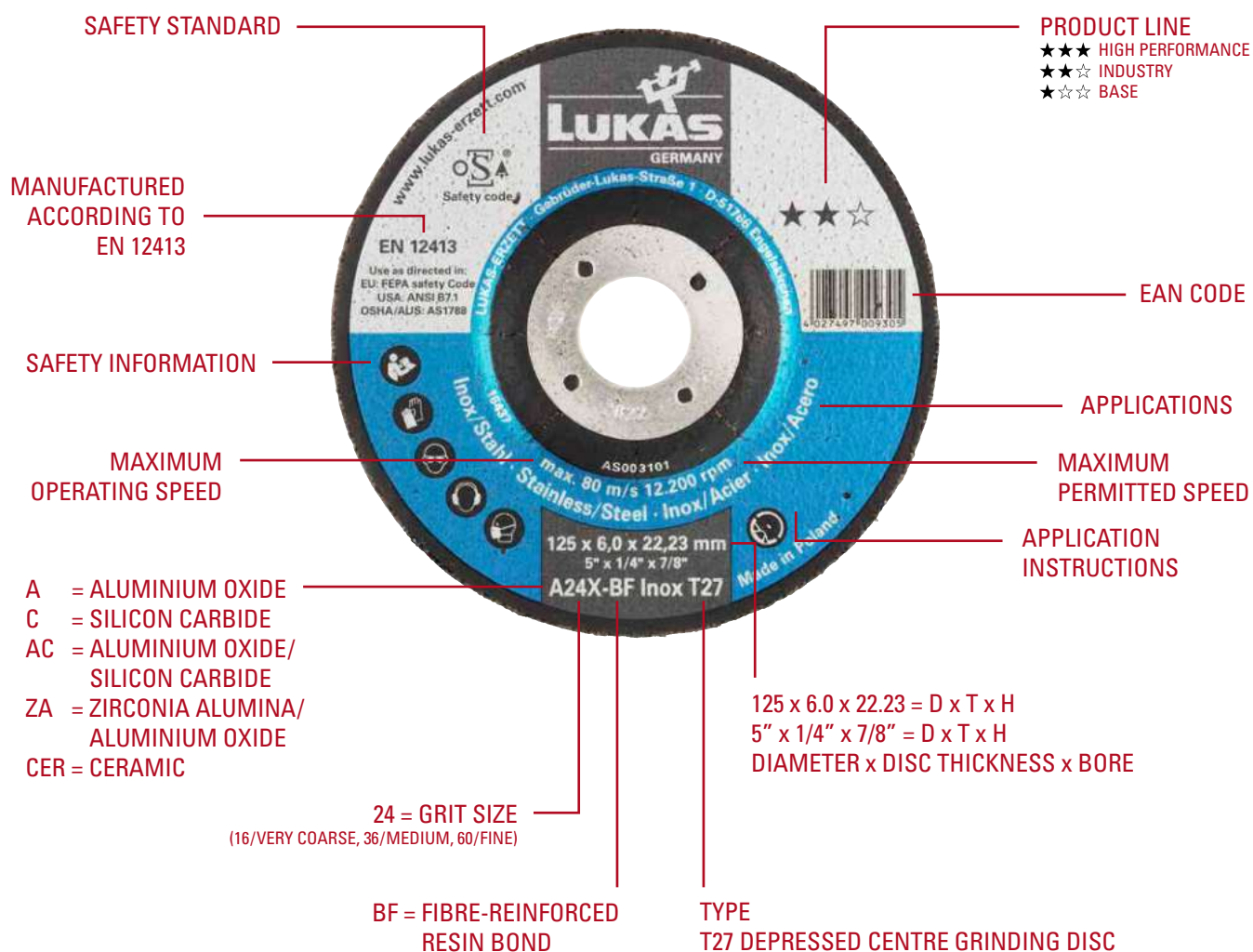
CLAMPING SYSTEM

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).

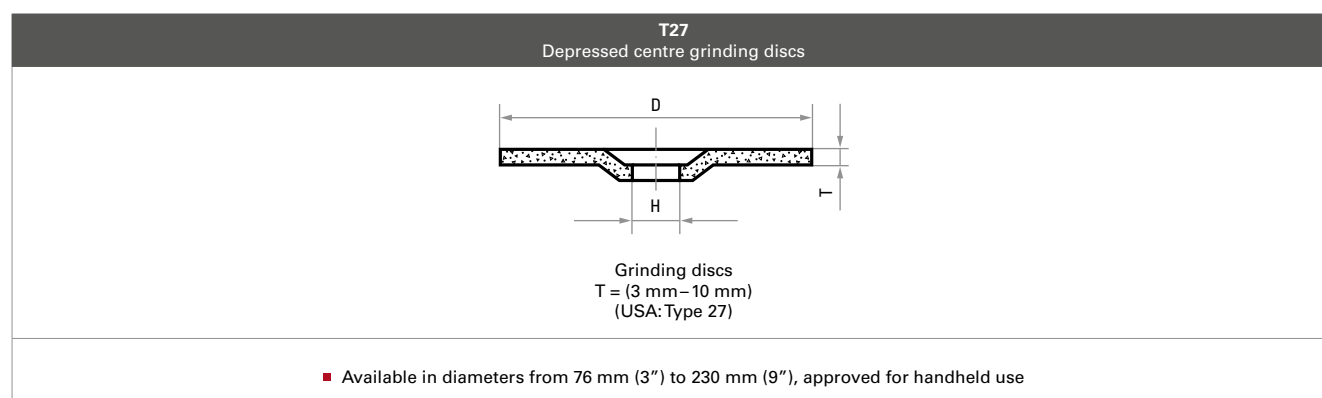


LABELLING

All important markings on the label

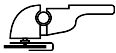









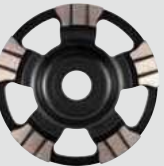




TYPES OF RESIN-BONDED GRINDING DISCS

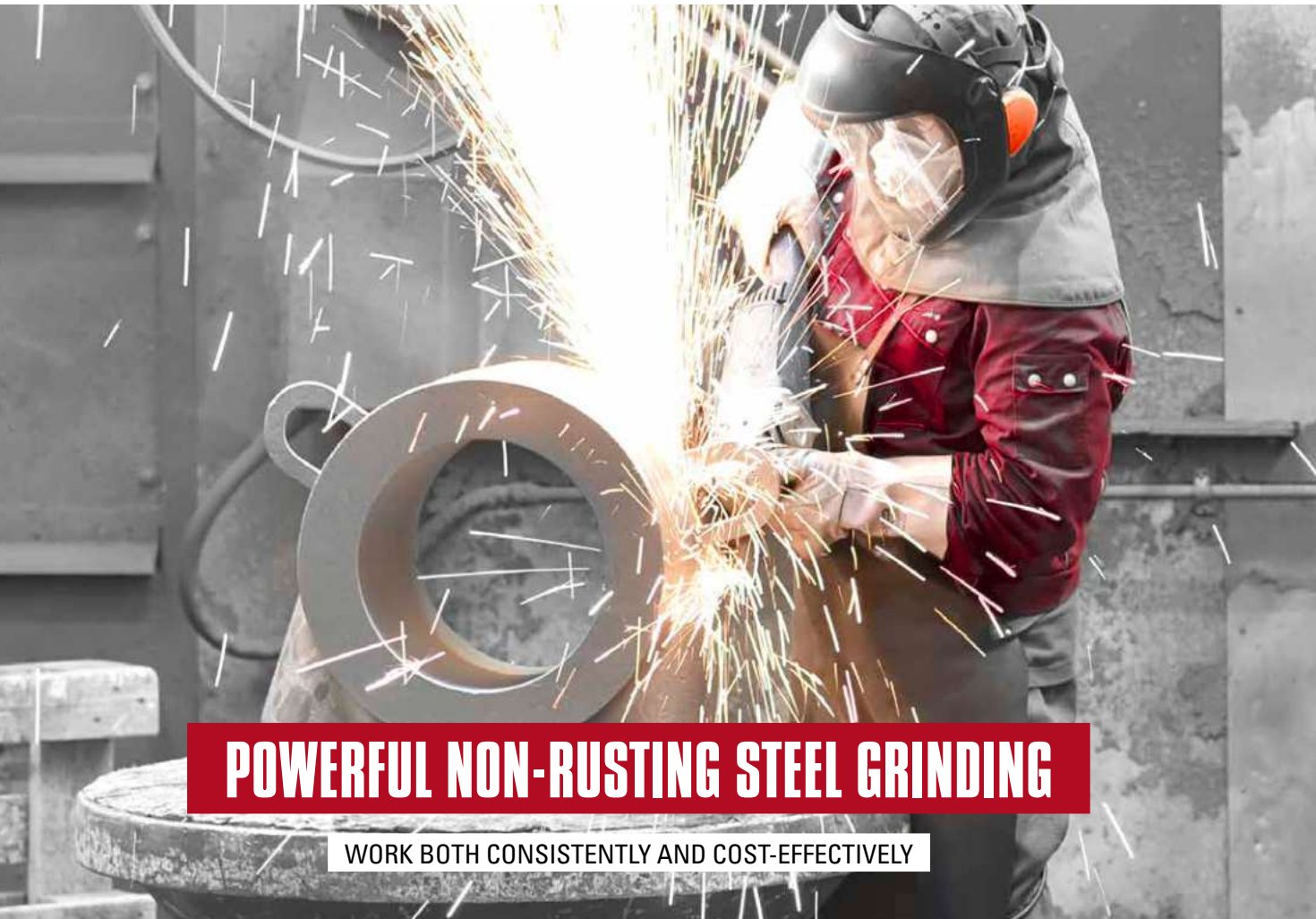


AREA OF USE

Overview of types of LUKAS grinding discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast material
Handheld grinding discs for angle grinders 	★★★	 upon request	 upon request			
	★★☆	 Page 107	 upon request	 Page 108	 upon request	 upon request
	★☆☆		 upon request			
Diamond cup wheels for angle grinders 	★★☆				 upon request	
Tungsten carbide granulate-tipped disc for angle grinders 	★★☆				 upon request	

THE PERFECT ALTERNATIVE TO THE GRINDING DISC: THE **iQ-SERIES FLAP DISK** FROM LUKAS!
GO TO **PAGES 54–62** AND TEST THEM NOW!



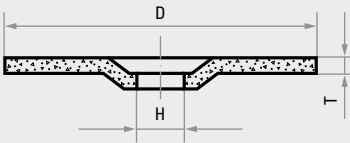
POWERFUL NON-RUSTING STEEL GRINDING

WORK BOTH CONSISTENTLY AND COST-EFFECTIVELY



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 ergonomical working with little use of force



★★☆

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AS003101V9802	T27 125x6,0	A24X-BF Inox	125	6.0	22.23	12,200	10
AS003103V9802	T27 180x6,0	A24X-BF Inox	180	6.0	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium

MACHINE SOFT LIGHT METALS TROUBLE-FREE

DESIGNED FOR PERFECTLY MACHINING ALUMINIUM

Aluminium and other non-ferrous metals are difficult to machine – especially because they are so soft. The LUKAS grinding disc for aluminium and non-ferrous metals machines light and non-ferrous metals without interruption.

GRINDING ALUMINIUM WITHOUT "SMEARING"

The major advantage of this grinding disc is that the "smearing" effect can be avoided. When machining pure aluminium and soft alloys, soft chips can stick to the aluminium edges if the tool is not designed specifically for this purpose. However, LUKAS grinding discs were developed and tested for aluminium. The special combination of abrasive grain and bonding agent is a reliable means to prevent this undesirable effect.

CAN BE USED ON STANDARD MACHINES

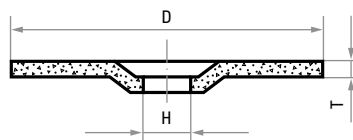
This tool can be used on standard angle grinders and is available in different sizes. This allows for light metals to be machined easily and above all with a high level of productivity.



NEW Grinding disc for machining non-ferrous metals



★★☆



- for perfectly machining aluminium and non-ferrous metals
- no clogging or smearing
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for economical working with little use of force

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS001708V9802	T27 125x7,0	A24N-BF Alu	125	7,0	22,23	12,200	10

Recommended for: ● Aluminium



CLEANING

GENERAL INFORMATION AND PRODUCT INFORMATION

LUKAS BRUSHES, FLEECE AND ABRASIVE CLOTH – ALL YOU NEED FOR CLEANING AND MORE

No matter whether you want to remove wood, car paint or concrete residue or prepare, roughen, derust, debur, clean, polish or texture a wide variety of materials like aluminium, stainless steel, cast material, steel or titanium, at LUKAS you will find the right tool to suit your application. From abrasive paper to cleaning fleece and wire brushes in a wide range of shapes and types, LUKAS offers you the right cleaning tool for construction sites, production lines or your DIY workshop at home.

MACHINE-POWERED CLEANING TOOLS

LUKAS cleaning tools can be used with standard power tools. For instance, you can use the wheel brushes on angle grinders or wire brushes on drilling machines and cordless screwdrivers. The shank dimensions make it easy to fit the brushes into commercially available drilling machines.

LUKAS end brushes let you easily clean even the most inaccessible areas. Depending on the required thickness and elasticity, they are available in both twist-knotted and crimped types.

TOOLS FOR MANUAL USE

In addition to hand wire brushes for cleaning surfaces or finishing weld seams, LUKAS also offers abrasive fleece and paper, both of which are ideal for manually removing old paint from both wood and metal or for cleaning stainless steel. LUKAS abrasive fleece is available in rolls or pads that are perfect for manual use.

**AS EXPERTS FOR CLEANING BRUSHES, WE CAN ALWAYS
SUPPLY YOU WITH JUST THE RIGHT TOOL FOR YOUR CHAL-
LENGE. ASK FOR YOUR INDIVIDUAL SOLUTION TODAY!**

GENERAL INFORMATION AND PRODUCT INFORMATION

LUKAS high-quality technical brushes

FILAMENT QUALITY

High quality steel wire

We use high-quality steel wire with high tensile strength, which ensures an exceptionally long and economical tool life.

Stainless steel wire

This wire is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.

Abrasive impregnated nylon filaments

Abrasive impregnated nylon filaments are very flexible and optimally follow the contour of the workpiece without being too aggressive. During use, new abrasive grains are constantly exposed, thus achieving a consistent performance and long tool life.

TYPES

We supply brushes in both wire qualities with crimped or twist-knotted filaments. Compared to crimped types, brushes with twist-knotted steel wire generally offer a longer tool life and more rugged abrasive performance and are thus suited for extreme requirements. We also supply brushes in high quality crimped steel wire embedded in a resin bond, thus enhancing their performance. These brushes are ideally suited for achieving uniform surfaces and precise edges.

APPLICATIONS

A wide range of jobs can be performed with steel wire brushes. Here are just a few examples: deburring, descaling, derusting, surface cleaning, roughening and paint stripping. Brushes with abrasive impregnated nylon filaments are perfect for removing stains on metal surfaces, graining soft wood, car body repair jobs, stripping off paint residues etc.

WORKING MODE AND POWER TOOLS

Technical brushes are flexible tools that follow the contours of the workpiece. In order to achieve best results, only the tip of the filament should be in contact with the workpiece. Elasticity of the brush depends on the exposed length of the filaments, and in the case of steel wire brushes, on the wire thickness. Brushes with very long filaments are very flexible and should only be used with low pressure. Excessive pressure reduces the life of the brush and results in premature wearing. Technical brushes can be used on stationary and handheld power tools.

OPERATING SPEEDS

Steel wire brushes have a harder effect at higher speeds and a softer effect at low speeds. We recommend the following operating speeds for crimped types to achieve the desired results:

- Machining steel: approx. 30 m/s
- Machining non-ferrous metals: approx. 18 – 20 m/s
- Machining plastic: approx. 15 m/s

Higher operating speeds can be selected for twist knotted types e.g.:

- Machining steel: approx. 40 m/s

Brushes made from nylon filaments achieve best results at operating speeds of 18 to 22 m/s, depending on the material to be machined.

SAFETY ADVICE

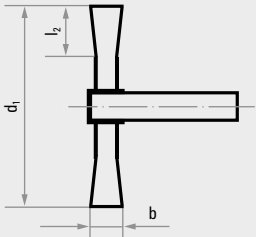
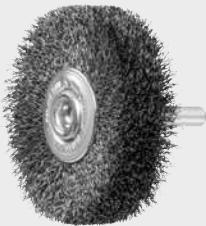
Technical brushes are manufactured according to a rigorous quality control (according to EN 1083-2). However, it is always advisable to wear safety clothing when working with technical brushes.



FLEXIBLE MACHINING OF THE MOST COMPLEX CONTOURS

CLEANING METAL SURFACES WITH LUKAS HIGH QUALITY STEEL WIRE

BS wheel brush with shank



- follow the contours of every workpiece thanks to their flexibility
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- “Stainless” quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.
- perfect dimensional stability: fits optimally into power tools
- shank diameter: 6 mm

★★☆

Product number	Description	Material	Type	d ₁ mm	b mm	l ₂ mm	Wire Ø mm	n _{max} rpm	Pack contains
A351004036	BSVW 04011	stainless	crimped	40	11	9	0.2	18,000	10
A350105014211	BSVW 05014	stainless	crimped	50	14	12	0.2	15,000	10
A351006036	BSVW 06018	stainless	crimped	60	16	17	0.2	15,000	10
A350107018213	BSVW 07018	stainless	crimped	70	16	19	0.3	15,000	10
A351007036	BSVW 07018	stainless	crimped	70	16	19	0.2	15,000	10

Recommended for: ● Inox/Steel ● Steel ● Titanium



POWER TOOLS

TECHNICAL INFORMATION

The most important product information at a glance

GENERAL

Our pneumatic power tools are characterised by high performance and low air consumption. The robust vane motors remain undamaged even when they stop under load.

The tools are fitted with a speed limiter, always keeping the idle speed within the specified tolerance. The service-friendly design allows wearing parts to be replaced quickly and easily.

COMPRESSED AIR SUPPLY

The motors operate at full power from a flow pressure of just 0.63 MPa (= 6.3 bar). We would be happy to advise you regarding the ideal specifications for the compressed air supply line. Please refer to the technical information for details about hose cross sections.

Air consumption (see machine data)	Connecting thread
0.05–0.5 m³/min	G 1/4"
0.15–0.9 m³/min	G 3/8"
0.5–1.5 m³/min	G 1/2"
0.8–6.0 m³/min	G 3/4"

VANE MOTOR LUBRICATION

A maintenance unit, comprising a water separator and an oiler, reliably protects the vane motors against wear, minimises the maintenance requirements, and prolongs their service life.

ERGONOMICS AND SAFETY

Vibration

To protect the operators, all of our power tools are tested and labelled in compliance with the current European Noise and Vibration Directive. The vibrations are recorded and calculated in three dimensions.

Ergonomics

Compared to electrical power tools, pneumatic motors offer greater performance at a lower weight. Thanks to their ergonomically shaped and insulated handles, the tools lie comfortably in the hand and won't tire the user.

Even difficult-to-access workpieces can be effortlessly machined using LUKAS pneumatic tools, as the spindle length, air outlet and valve design of many of the machine tools can be perfectly adapted to suit the user's requirements.

Safety

They can even be used in areas where there is a risk of explosion.

Quality

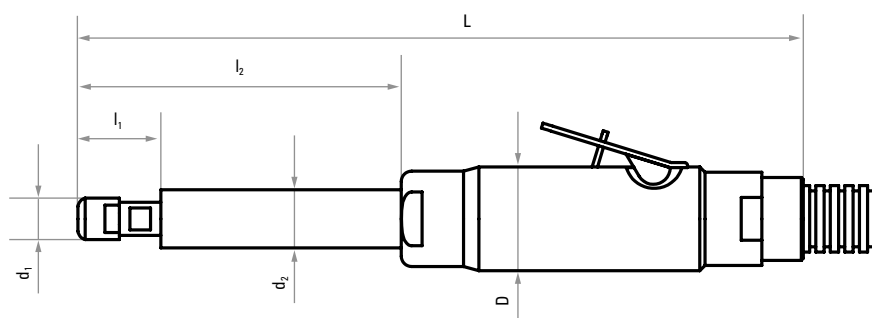
All of our power tools have a robust aluminium casing and are designed for use in harsh environments. The motors cannot overheat even when used continuously at maximum power. As part of our full quality control policy, all tools are subjected to speed and performance tests before they leave the factory.

Safety advice

Only tools that are suitable and approved in terms of safety for the peripheral speeds that can be attained with the respective machines may be used.

TECHNICAL INFORMATION

All LUKAS power tools at a glance



Power tool	Description	Speed rpm	Power kW	d_1 mm	l_1 mm	d_2 mm	l_2 mm	D mm	L mm	Page
Straight grinder, insulated	AMIN 20-030 GD	20,000	0.300	16	26	–	–	35	195	117
Straight grinder, insulated	AMIN 30-030 GD	30,000	0.300	14	16	–	–	36	190	118
Straight grinder, insulated	AMIN 32-027 GD	32,000	0.270	13	20	23	35	29	210	119
Straight grinder, insulated	AMIN 55-011 GD	55,000	0.110	9	14	–	–	20	125	120
Straight grinder, insulated	AMIN 72-013 GD	72,000	0.130	10	15	–	–	29	165	121
Conditioning machine	ESM 1310 S	1,300–3,050	1,300	–	–	–	–	–	–	122

These power tools are available upon request

Power tool	Description	Speed rpm	Power kW	d_1 mm	l_1 mm	d_2 mm	l_2 mm	D mm	L mm
Belt grinder, insulated	AMIN 30 BSH	30,000	0.300	19	28	h = 86		35	220
Straight grinder, insulated	AMIN 12-030 GD	12,000	0.300	16	26	–	–	35	195
	AMIN 15-030 GD	15,000	0.300	16	26	–	–	35	195
	AMIN 12-030 GH	12,000	0.300	16	26	–	–	35	195
Straight grinder with extension, insulated	AMIN 15-070 GH2L	15,300	0.700	24	35	24	440	46	630
Straight grinder, insulated	AMIN 19-100 GH	19,000	1.000	24	37	34	148	51	350
	AMIN 19-100 GHK	19,000	1.000	24	44	–	–	51	245
Straight grinder, insulated	AMIN 20-030 GH	20,000	0.300	16	26	–	–	35	195
Straight grinder, insulated	AMIN 30-030 GH	30,000	0.300	14	16	–	–	36	190
Straight grinder, insulated	AMIN 45-030 GD	45,000	0.300	14	16	–	–	36	190
	AMIN 45-030 GH	45,000	0.300	14	16	–	–	36	190

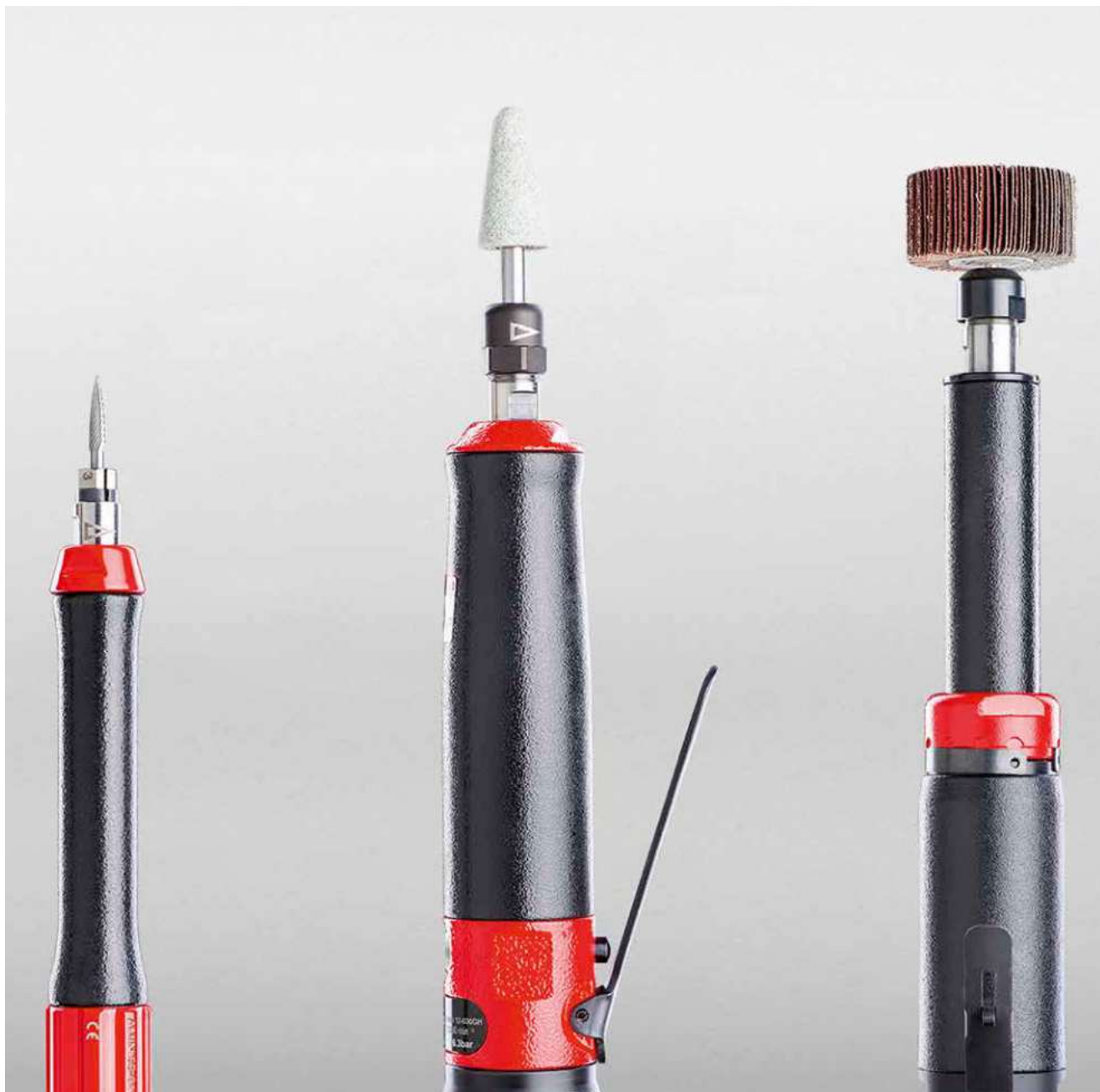
MADE TO TACKLE THE TOUGHEST CHALLENGES

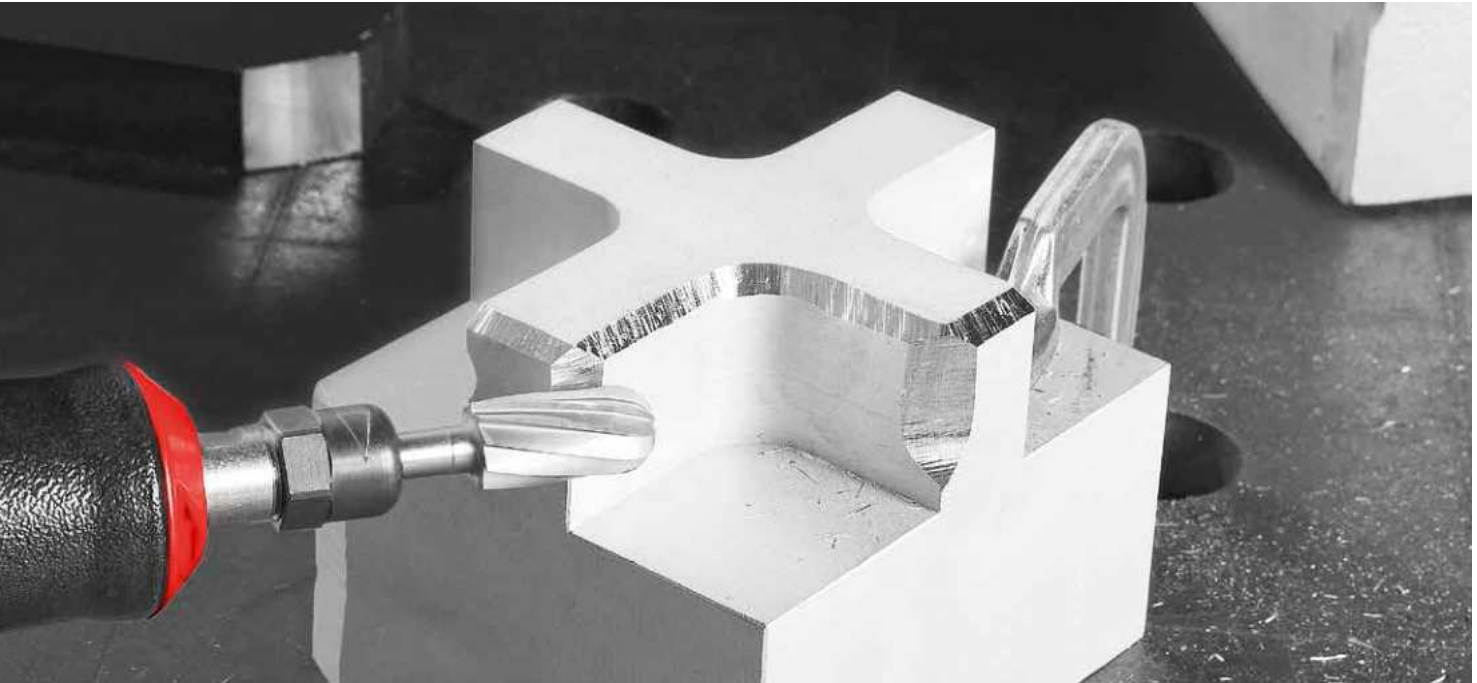
PREMIUM-QUALITY POWER TOOLS FOR PREMIUM-QUALITY TOOLS

A range of LUKAS pneumatic grinders and LUKAS pneumatic tools is available so that you can use LUKAS tools in the most effective way. Our range of pneumatic grinders and pneumatic tools includes angle grinders (with turbine drive), belt grinders and a wide variety of straight grinders.

LUKAS pneumatic grinders and pneumatic tools are designed according to the most stringent quality requirements for withstanding extreme strain and to get the most out of LUKAS

top-performance tools. LUKAS power tools are characterised by their high performance and low air consumption during use. The robust vane motors achieve steadfast performance, even for harder cutting work. Even stopping under load won't damage them! Speed limiters keep the idle speed within the design tolerances. As an added benefit, replacing the wearing parts of LUKAS pneumatic grinders and pneumatic tools can be done quickly and easily.





Straight grinder, insulated

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Special accessories:

- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.90 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 115**.



★★☆

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101120	AMIN 20-030 GD	Twist	20,000	0.3	0.53	6	8	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 20-030 GD	Tungsten carbide burrs		up to Ø 12 mm	17–21
	SFL mounted flap wheels		Ø 20 mm	69
	SBZY abrasive bands		up to Ø 19 mm	74/75
	SK/SKS abrasive caps		up to Ø 13 mm	79
	Mounted points, shank 6 mm		Ø 22 mm, 25 mm, 32 mm, 40 mm	33–35
	P2 polishing points		Ø 13 mm	40



Please pay attention to the respective speed specifications on our tool packaging.



Straight grinder, insulated



★★☆

Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.70 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 115**.

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Special accessories:

- collets for Ø 3 mm, 3.25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101130	AMIN 30-030 GD	Twist	30,000	0.3	0.45	6	6	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 30-030 GD	Tungsten carbide burs		up to Ø 8 mm	17–21
	Mounted points		up to Ø 32 mm	33–35
	P2 polishing points		up to Ø 10 mm	40
	P3 polishing points		up to Ø 10 mm	41
	SK/SKS abrasive caps		up to Ø 10 mm	79
	SBZY abrasive bands		up to Ø 12 mm	74/75



Please pay attention to the respective speed specifications on our tool packaging.



Straight grinder, insulated

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Technical details:

- length: approx. 206 mm
- casing diameter: approx. 30 mm
- spindle casing diameter: approx. 23 mm
- weight: approx. 0.40 kg
- drive type: vane motor
- frontal exhaust air (partial, can be shut off)



Special accessories:

- collets for Ø 3 mm, 1/8", 1/4"

► Further technical details can be found on **page 115**.



Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101132	AMIN 32-027 GD	Twist	32,000	0.27	0.3	6	6	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 32-027 GD	Tungsten carbide burrs	up to Ø 8 mm	17–21
	Mounted points	up to Ø 32 mm	33–35
	P2 polishing points	up to Ø 10 mm	40
	P3 polishing points	up to Ø 10 mm	41
	SK/SKS abrasive caps	up to Ø 10 mm	79
	SBZY abrasive bands	up to Ø 12 mm	74/75



Please pay attention to the respective speed specifications on our tool packaging.

Straight grinder, insulated



Technical details:

- length: approx. 130 mm
- casing diameter: 16 mm
- weight: approx. 0.24 kg
- drive type: vane motor

► Further technical details can be found on **page 115**.

Properties:

- most powerful tool in its class
- compact design
- lockable speed switch

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 3 mm
- operating tool/spanner

Special accessories:

- collets for Ø 2 mm, 3.25 mm, 1/8", 3/32"



Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101155	AMIN 55-011 GD	Twist	55,000	0.11	0.15	3	3	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 55-011 GD	Tungsten carbide burrs	up to Ø 5 mm	17–21
	Mounted points	up to Ø 16 mm	30–35
	P2 polishing points	up to Ø 5 mm	40
	SK/SKS abrasive caps	up to Ø 5 mm	79
	SBZY abrasive bands	up to Ø 10 mm	74/75



Please pay attention to the respective speed specifications on our tool packaging.

Straight grinder, insulated

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 3 mm
- operating tool/spanner

Technical details:

- length: approx. 154 mm
- casing diameter: 27.5 mm
- weight: approx. 0.45 kg
- drive type: vane motor



Special accessories:

- collets for Ø 2 mm, 3.25 mm, 1/8", 3/32"

► Further technical details can be found on **page 115**.

★★☆

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101172	AMIN 72-013 GD	Twist	72,000	0.13	0.21	3	5	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 72-013 GD	Tungsten carbide burrs	up to Ø 4 mm	17–21
	Mounted points	up to Ø 13 mm	30–35
	P2 polishing points	up to Ø 4 mm	40



Please pay attention to the respective speed specifications on our tool packaging.



Conditioning machine



★★☆

Technical details:

- weight: approx. 2.8 kg
- electronic control with soft start, infinitely variable speed control, temperature and overload cut-off

► Further technical details can be found on **page 115**.

Properties:

- heavy-duty motor (stable)
- double gear reduction (long service life)
- dust-protected bearings (low wear)
- Shadow-free metal, wood or plastic surfaces without transitions can be achieved with the ideal tool.

With the appropriate tool, perfect for:

- conditioning
- structuring
- polishing
- brushing
- smoothening
- deburring
- matt finishing

Product number	Description	Idle speed (rpm)	Power kW	Tool max. Ø mm	Tool width mm	Tool holder mm	Pack contains
A3995ESM1310	ESM 1310 S	1,300–3,050	1.3	120	100	19	1

A

Abrasive bands and mandrels	71–75
▪ SBZY Ceramic abrasive band, cylindrical shape	74
▪ SBZY regular aluminium oxide abrasive band, cylindrical shape	75
▪ SBZY zirconia alumina abrasive band, cylindrical shape ..	74
▪ STZY hard abrasive band mandrel, cylindrical shape	76
Abrasive caps and mandrels	77–80
▪ Abrasive cap mandrel	80
▪ SK Ceramic abrasive cap	79
▪ SKS Special abrasive cap	79
Abrasive discs and carriers	81–88
▪ GTG abrasive disc carrier for self-clamping abrasive discs	88
▪ PSG Ceramic self-clamping abrasive disc	83
▪ PSG reinforced self-clamping regular aluminium oxide abrasive disc	86
▪ PSG self-clamping abrasive disc, abrasive fleece	87
▪ PSG self-clamping regular aluminium oxide abrasive disc	85
▪ PSG self-clamping silicon carbide abrasive disc	88
▪ PSG self-clamping zirconia alumina abrasive disc	84
▪ PSG Z-Power self-clamping abrasive disc	84
Accessories	
▪ Arbors for felt polishing wheels	42
▪ Abrasive cap mandrel	80
▪ GTG abrasive disc carrier for self-clamping abrasive discs	88
▪ STF fibre disc backing pad	90
▪ STZY hard abrasive band mandrel, cylindrical shape	76
Assortments	21
▪ Carbide burrs assortments	21
▪ ZX Universal carbide burrs assortments	21

B

Burrs	10–42
▪ Carbide burrs assortments	21
▪ Z3 Universal inverse deburring tool (internal)	20
▪ Z9 Alu burr with LightFlow coating	19
▪ ZX Universal burr	17
▪ ZX Universal burr with extra-long shank	18
▪ ZX Universal carbide burrs assortments	21
Brushes	110–112
▪ BS wheel brush with shank	112

C

Ceramic products	
▪ Ceramic mounted point	30
▪ PSG Ceramic self-clamping abrasive disc	83
▪ SBZY Ceramic abrasive band, cylindrical shape	74

▪ SK Ceramic abrasive cap	79
▪ SLTO ^{Ceramic4x} / SLTR ^{Ceramic4x} lamellar flap disc	63
▪ SLTT HybridPerfection ^{Ceramic4x} lamellar flap discs	57
▪ V2 Power ^{Ceramic4x} lamellar flap discs	60
▪ V2 Power Heavy Duty lamellar flap disc	60
Compact grinding disc – Purple Grain Single	55
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▪ Cutting disc for machining non-ferrous metals	99
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D

Diamond pastes	43
▪ Monocrystalline diamond pastes	43

F

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▪ FIS zirconia alumina fibre disc with cross slot	89
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▪ LSL, flap wheel of abrasive cloth with thread	67

G

Grinding discs	102–108
▪ Grinding disc for machining non-ferrous metals	108
▪ Grinding disc for machining stainless steel	107
Grinding pastes	43
▪ Monocrystalline diamond pastes	43

I

iQ series	54–62
▪ Purple Grain Single compact grinding disc	55
▪ SLTT HybridPerfection ^{Ceramic4x} lamellar flap discs	57
▪ V2 Power Alu lamellar flap disc	62
▪ V2 Power Ceramic4x lamellar flap discs	60
▪ V2 Power Heavy Duty lamellar flap disc	60
▪ V2 Power Inox lamellar flap disc	61
▪ V2 Power Steel lamellar flap disc	61

L

Lamellar flap discs	53–65
SLTO/SLTR	63–65
▪ SLTO/SLTR BASE-X lamellar flap disc.....	65
▪ SLTO/SLTR lamellar flap disc, zirconia alumina.....	64
▪ SLTO ^{Ceramic4x} /SLTR ^{Ceramic4x} lamellar flap disc.....	63
SLTT	56/57
▪ SLTT HybridPerfection ^{Ceramic4x} lamellar flap discs.....	57
V2 Power	58–62
▪ V2 Power Alu lamellar flap disc.....	62
▪ V2 Power ^{Ceramic4x} lamellar flap discs.....	60
▪ V2 Power Heavy Duty lamellar flap disc.....	60
▪ V2 Power Inox lamellar flap disc.....	61
▪ V2 Power Steel lamellar flap disc.....	61

M

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▪ NK soft mounted point.....	34
▪ SIC-ALU mounted point.....	31

P

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▪ Monocrystalline diamond pastes.....	43
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▪ P6PT polishing discs.....	46
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▪ Conditioning machine.....	122
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▪ Purple Grain Single compact grinding disc.....	55

T

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▪ Carbide burrs assortments.....	21
▪ Z3 Universal inverse deburring tool (internal).....	20
▪ Z9 Alu burr with LightFlow coating.....	19
▪ ZX Universal burr.....	17
▪ ZX Universal burr with extra-long shank.....	18
▪ ZX Universal carbide burrs assortments.....	21

V

V2 Power	58–62
▪ V2 Power Alu lamellar flap disc.....	62
▪ V2 Power ^{Ceramic4x} lamellar flap discs.....	60
▪ V2 Power Heavy Duty lamellar flap disc.....	60
▪ V2 Power Inox lamellar flap disc.....	61
▪ V2 Power Steel lamellar flap disc.....	61

W

Wheel brushes	110–112
▪ BS wheel brush with shank.....	112

X

X-LOCK system	98
▪ X-LOCK cutting disc.....	98

General terms and conditions

I. SCOPE OF APPLICATION

1. The following conditions are final and an integral part of the contract. They apply to all (current and future) agreements, contracts and other services. All offers are exclusively based on our General Terms of Business which are deemed accepted upon order placement or acceptance of delivery. We shall not be bound to any conflicting or differing terms of business submitted to us by the buyer even if we do not expressly object to such other terms.
2. Oral ancillary agreements besides or in addition to these Terms of Business do not exist. Any ancillary agreements, differing terms or amendments to our General Terms of Business become applicable and binding only upon our written confirmation. This applies in particular to agreements regarding the quality and condition of our products.
3. These General Terms of Business only apply to companies, legal entities under public law or public special funds or assets ("Sondervermögen" pursuant to German law).

II. OFFERS AND PROPOSALS

1. Our offers and proposals are subject to change and not binding. Any documents in connection therewith, such as drawings, illustrations, technical data, references to applicable standards, and any information given in brochures, shall not be deemed an agreement regarding the quality and condition of the product, unless expressly designated as such in writing.
2. Any samples as well as specifications regarding the composition, quality and condition of our products are based on our experience and expertise, but do not constitute any guarantee or other binding commitment.
3. We reserve the right of ownership and copyright to all brochures, illustrations, drawings, sketches and any other documents. Any such materials may not be reproduced, copied from the Internet or made available to any third party without our prior permission, and must be returned to us immediately upon our request.

III. CONTRACT CONCLUSION

1. An order is deemed accepted if it has been confirmed in writing or delivered.
2. Content and scope of an order are subject to order confirmation.
3. The buyer is liable for the correctness of any documents to be supplied by them, such as drawings, samples, etc. Oral agreements about dimensions, etc. are required to be in writing.

IV. PRICING

1. Our prices are quoted in euros ex works Engelskirchen (pursuant to Incoterms 2020), excluding packaging, freight, postage, customs duties and tariffs, and insurance. Surcharges and discounts are based on the basic price. The same applies to any partial or express shipments requested by the buyer.
2. The minimum order value is EUR 130.00 net. For orders under EUR 130.00 we charge a handling fee of EUR 15.00.
3. All prices are net prices and subject to the currently applicable VAT.
4. The prices given in the order confirmation apply to deliveries with a delivery period of up to four months. Deliveries with a delivery period of more than four months are subject to the prices applicable at the day of delivery in case the cost price, material, labour and other production costs have changed and the applicable prices are within reason for the buyer.

V. TERMS OF PAYMENT

1. Payments are due within 14 days of the date of invoice less 2% discount or 30 days net. Payments are deemed to be made on time if they are received in our accounts no later than on the due date.
2. In the event of default, interest at the legal rate of currently 9% above the base rate of the European Central Bank (as of 2019) will be added. We retain the right to claim higher damages for default if applicable.
3. First deliveries are always required to be paid upfront or by cash on delivery.
4. If doubts arise regarding the solvency of the buyer, e.g. due to an application for the opening of insolvency proceedings, imminent suspension of payments or a significant deterioration of the financial status of the buyer, we are entitled to withhold further deliveries. In this case, we may declare the remaining debt due immediately, and set the customer a reasonable period for a delivery-against-payment transaction or the provision of collateral, even in the case of payment by check. After the fruitless expiry of such deadline, we are entitled to cease further fulfilment of our contractual obligations. In the event of an application for insolvency proceedings, we are entitled to immediately terminate the contract. This does not release the buyer from his or her duties and obligations arising in connection with those parts of the contract already fulfilled by us or in connection with earlier or not yet fulfilled contracts.
5. We retain the right to assign any accounts receivable to a third party.
6. The buyer is only entitled to a setoff if his counterclaims are res judicata, uncontested or accepted by us. Furthermore, the buyer is only entitled to a right of retention if his counterclaim is due and based on the same contractual relationship.

VI. RESERVATION OF TITLE

1. The delivered goods remain our property ("goods subject to retention of title") until full payment of all claims (current and future) has been made, including all ancillary claims (e.g. financing costs, interest, etc.) arising from the business relationship between us and the buyer. Payment is deemed to be made upon receipt of the countervalue of the delivered goods.
2. The buyer is obliged to treat any goods that are subject to retention of title with due care. We are entitled to insure any goods that are subject to retention of title against theft, breakage, fire, water and other damages at the buyer's expense unless they can demonstrate that they have taken out such insurance themselves.
3. The buyer is entitled to process, combine, mix and/or resell the delivery items within the ordinary course of business. Any such processing or transformation of the delivery items by the buyer is always carried out for us as the manufacturer. If the delivery items are processed together with other items not our own, we become co-owners of the new item, whereby the value of such ownership is based on the ratio of the delivery item's initial value to that of the other processed items at the time of processing. Furthermore, any stipulations applicable to the goods subject to retention of title also apply to the processed goods.
4. In the event that the buyer sells any delivery item prior to payment of all our accounts receivable secured by such delivery items, the buyer assigns to us, at the time of conclusion of the delivery contract, the associated receivables against any such purchaser or other third party in connection with the resale, as collateral for our accounts receivable. We accept any such assignment. We authorise the buyer, until further notice, to collect the assigned accounts receivable. We are entitled to revoke this authorisation if our secured accounts receivable are in jeopardy, including, but not limited to the buyer being in default with their payments. The authorisation to collect expires without further notice at the time at which the buyer stops their payments or files an application for the opening of insolvency proceedings. After the revocation or expiration of such authorisation, we are entitled and the buyer is obliged to notify the debtor of the assigned accounts receivable about such assignment. The buyer must refrain from any collection but keep incoming amounts in a separate account for us. At our request, the buyer must provide us in writing with the contact details of the buyer of the resold delivery items and hand over to us all information and documents regarding the assigned accounts receivable. Upon request of the buyer, we undertake to release any collateral we are entitled to, insofar as the value of such collateral exceeds the secured accounts receivable by more than 20%. We reserve the right to select which collateral shall be released.
5. Extraordinary disposal of the collateral, including but not limited to possessory or non-possessory liens or assignment and security agreements, requires our prior consent. In the event of liens or other third-party claims, the buyer must inform us immediately in writing and submit to us any documents and information required for us to protect our rights. This also applies if such measures are imminent. The enforcement officer or the respective third party must be informed of our ownership. The buyer bears all costs in connection with the suspension of the seizure, lien or other type of execution and the replacement of the goods subject to retention of title, insofar as these costs cannot be collected from any third party.
6. If the buyer is in breach of contract, including but not limited to default, we are, after issuing a reminder, entitled to claim the return of the goods and the buyer is obliged to return them to us. If we terminate the contract as per section V.4 above due to an application for insolvency proceedings, we are entitled to claim the immediate return of any goods subject to retention of title.

VII. DELIVERY PERIODS

1. Delivery periods may be agreed as binding or non-binding and are required to be in writing. They do not start before receipt of (i) all required documents from the buyer, (ii) all required releases and approvals, (iii) the agreed down payments and (iv) the fulfilment of all other obligations incumbent on the buyer.
2. The delivery date is considered to be met if, by that date, the delivery items have left our site or the buyer has been informed about the readiness for dispatch of the goods. In the case of unforeseeable events which we were unable to avert despite reasonable care, the delivery period can be reasonably extended – even within the scope of a default – irrespective of whether these circumstances occurred at our site or at our sub-suppliers' site(s), rendering them unable to supply us on time, including but not limited to operational disruptions, consequences of industrial or job actions, or similar.
3. The delivery period shall be extended in particular if our non-compliance with the delivery date is due to a late or defective delivery by our suppliers to us, which presupposes that we had concluded a so-called congruent or matching supply arrangement in good time ("kongruentes Deckungsgeschäft" as per German law) with our supplier at the time of contract conclusion with the buyer. We will prove to the buyer that we had concluded any such contract with our supplier upon request.
4. If the delivery or service becomes impossible due to the events mentioned in sections 2 and 3, or if the delivery or service is delayed by more than six weeks, both the buyer and we are entitled to terminate the contract without either being subject to any claims for damages.
5. To a reasonable extent, we are entitled to make partial deliveries.

VIII. SCOPE AND EXECUTION OF DELIVERY; TRANSFER OF RISK

1. The scope of delivery is subject to our delivery note. The minimum order quantity is one packaging unit.
2. Inconsistencies in quantity must be communicated within eight days upon receipt of goods.
3. Items on stock as listed in our catalogue are available in the specified packaging units and will be delivered and invoiced accordingly. We reserve the right to change the packaging units from time to time.
4. Due to manufacturing conditions, changes of up to +/- 15% of the ordered quantity are permissible for products not held in stock.
5. We reserve the right to technical modifications of our products resulting from continuous research and development.
6. Risk passes over to the buyer when the goods are handed over to the carrier or forwarding agent, but not later than at the time of departure from our warehouse or, in the case of drop-shipping, at the time of departure from the supplier's site. This also applies to any free-of-charge deliveries. Upon express request of the buyer, we will take out insurance against shipping damage at the buyer's expense.
7. In the case of call-off (aka blanket) orders, the goods are delivered upon call-off by the buyer. Call-off periods expire 12 months as of the date of order confirmation. We are entitled to manufacture the entire order quantity at once. Requests for changes to any order after order confirmation are not possible unless this has been expressly agreed upon beforehand. Any quantities that have not been called off by the buyer by the end of the call-off period will be shipped to the buyer and invoiced upon the expiration date.

IX. CLAIMS FOR DEFECTS

1. Claims for defects are only applicable if the buyer has fulfilled all obligations pursuant to the German Commercial Code to properly examine the goods and give notice of defects. If a delivery item is defective, we undertake, at our discretion, to either deliver a defect-free item (replacement) or rectify the defect. In the event of rectification, we bear all expenses incurring from such rectification provided that costs are not increased by the delivery item having been moved to a place other than the place of performance. If the rectification or the replacement ultimately fails or is considered to have failed, the buyer is entitled to either reduce the purchase price or rescind the contract, at their own discretion. As a rule, the seller is reasonably entitled to a minimum of two attempts to replace or rectify the defects.
2. Our liability for any replaced or rectified delivery items is equal to that for the originally delivered goods. In the event of a replacement delivery, the statute of limitations for claims for defects starts anew. The statute of limitations for claims for defects is 12 months as from the time of delivery of the goods to the buyer.
3. We do not assume any liability for damages caused by the following: unsuitable or improper storage or use, faulty assembly, implementation or commissioning by the buyer or third parties, natural wear and tear, faulty or negligent handling, unsuitable operating materials, and chemical, electrochemical or electrical influences, unless they are our fault. We are not liable for any consequential damages if such damages are caused by improper modifications or maintenance work by the buyer or any third party without our prior approval.

X. LIABILITY

1. We are fully liable for damages caused by our and our vicarious agents' (as per §278 German Civil Code) willful misconduct or gross negligence. We are furthermore liable (i) for any breach of warranty, (ii) when accepting a procurement risk or any other binding assurances, (iii) in the event of culpable personal injury to life, body or health or (iv) within the scope of the German Product Liability Act. In the event of culpable breach of material contractual duties, i.e. of any such obligation that renders the proper execution of the contract possible in the first place and the fulfilment of which the buyer can or does therefore reasonably expect, we accept liability in so far as the prerequisites for any such claim are fulfilled. The amount of liability is limited to the reasonably foreseeable damages typical for the relevant contract. We expressly exclude any further liability.
2. Insofar as our liability is excluded or limited, such exclusion or limitation also applies to the personal liability of our staff, employee representatives and vicarious agents.
3. These provisions are not intended to reverse the burden of proof.

XI. RETURN AND/OR REPLACEMENT

The buyer is entitled to return and/or have the goods replaced without stating any reason within four weeks after delivery quoting our consignment number. Goods are to be returned free of charge for us. The right to return or have the goods replaced does not affect any claims for defects pursuant to section IX above.

Processing costs will be charged at EUR 25.00. Custom-made articles are excluded from this right and may not be returned or replaced.

XII. DATA PRIVACY

1. Both the buyer and we undertake to comply with the applicable data protection laws and regulations, including but not limited to the GDPR and the Federal Data Protection Act of Germany.
2. Further information on how we process data is available in our Privacy Policy at <https://lukas-erzett.com/en/footer-navigation/privacy-note-gdpr.html> or as attached. To the extent required by the applicable data protection laws, the buyer will make such data privacy statement available to the respective employees, service providers or any other involved third parties.

XIII. PLACE OF PERFORMANCE, FORUM, APPLICABLE LAW AND PARTIAL UNENFORCEABILITY

1. Place of performance for all obligations under any contract is Engelskirchen, Germany.
2. The exclusive forum for any litigation with buyers who are registered merchants (as per German law), a legal entity under public law or so-called public special funds or assets ("öffentlich-rechtliches Sondervermögen" as per German law) is the court competent for our headquarters. We reserve the right, however, to file any action at the buyer's headquarters.
3. International deliveries are governed by German law. Regulations for the international sale or purchase of goods such as the CISG do not apply.
4. If individual provisions of these Terms or any delivery contract are or become invalid, the remaining provisions will continue to apply. If one of the provisions is or becomes partially invalid, the remaining part of such provision will continue to apply.

Issued: December 2019

SAFETY SYMBOLS

These may vary depending on the product



Wear eye protection



Wear ear protection



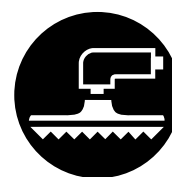
Wear a mask



Observe safety recommendations



Wear protective gloves



Only to be used with a back-up pad



Do not use for wet grinding



Do not use for face grinding



Do not use if damaged

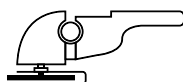


Do not use with hand-held grinding machine

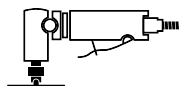
POWER TOOLS



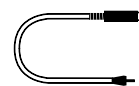
Straight grinder



Hand-held angle grinder



Pneumatic angle grinder



Flexible shaft grinder

OUR PRODUCT LINES

The product line is indicated with a simple star system:



High Performance



Industry



Base

OUR APPLICATION RECOMMENDATIONS

Our application recommendations are divided into

● **best suitable** and ● **suitable**.

● Inox/Steel

● Steel

● Aluminium

● Cast material

● Plastic/Wood

● Titanium

● Stone/Construction material

You can find the corresponding application recommendations for each product directly below every product table.

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