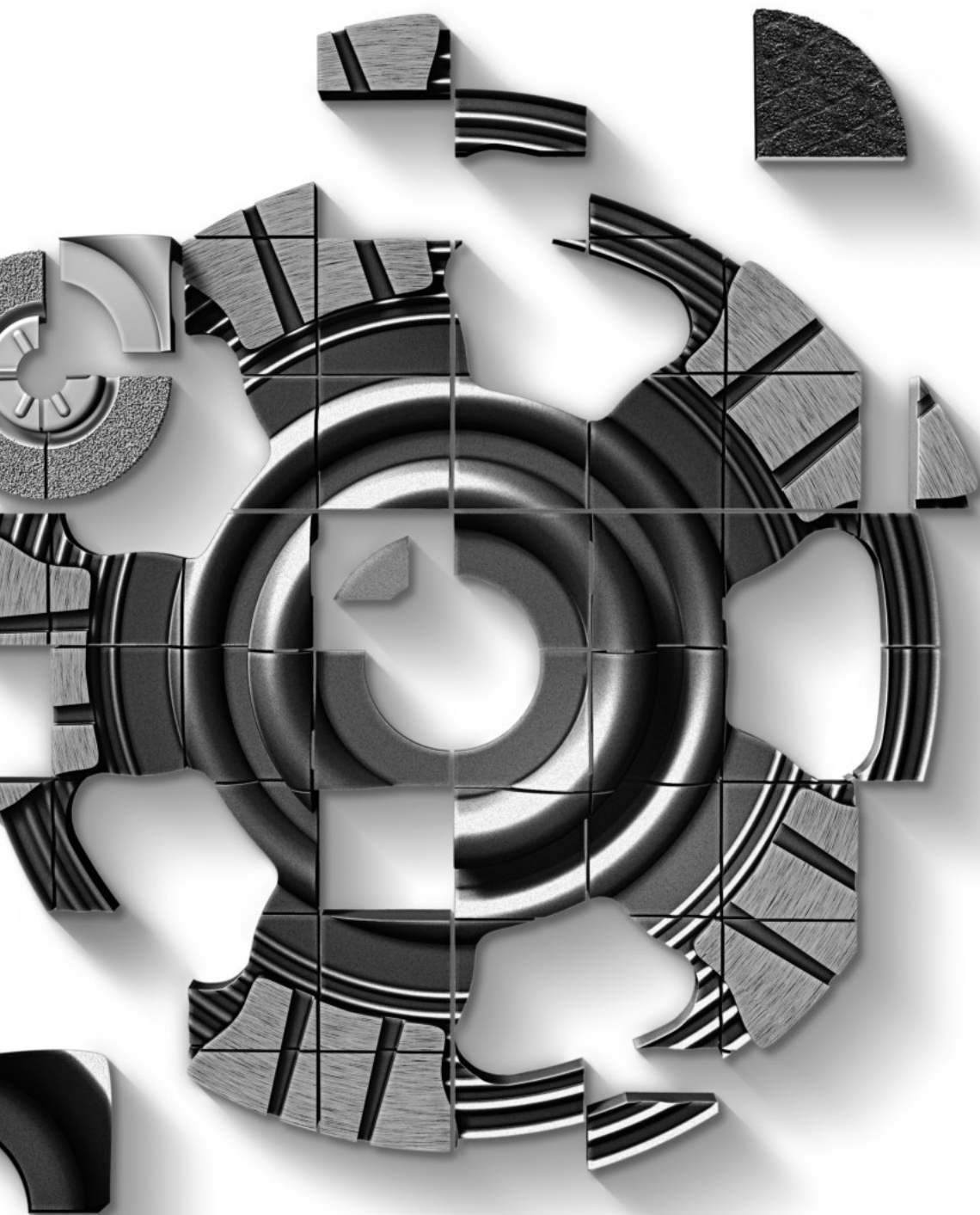


ROUGH GRINDING



6.1.1 Cupstones, snagging wheels, rubbing bricks 1–10

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS cupstone and snagging wheels

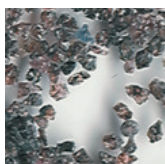
SHELF LIFE

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

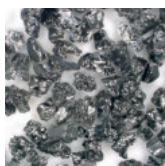
LABELLING SYSTEM FOR RESIN-BONDED GRINDING WHEELS

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

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



A
Semi-friable
aluminium oxide



C
Silicon carbide

ABRASIVE

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

Abrasive	
A	Aluminium oxide
C	Silicon carbide

HARDNESS

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

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

GRIT

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

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




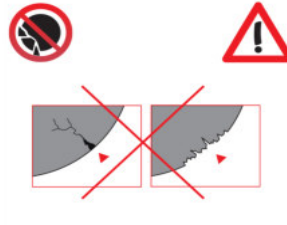
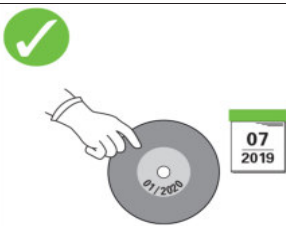

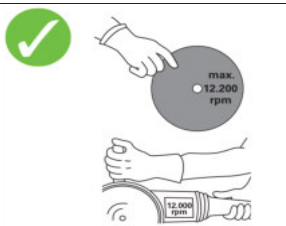



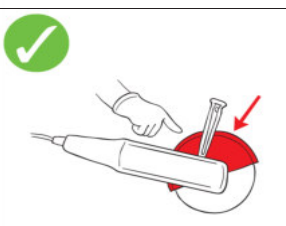
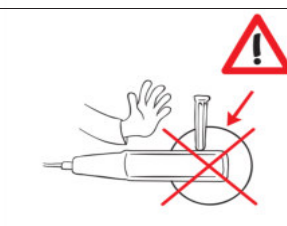
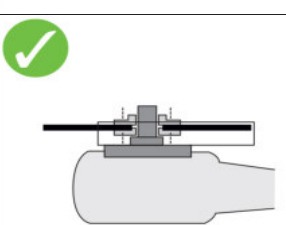
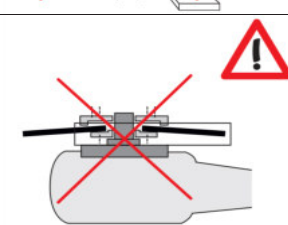
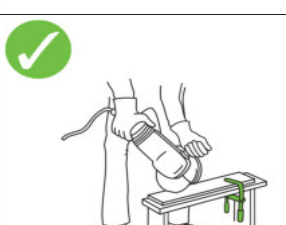


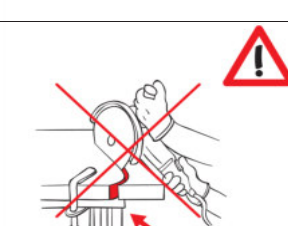
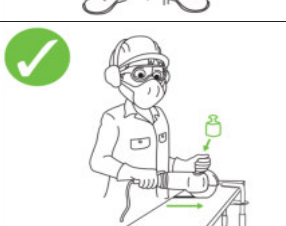




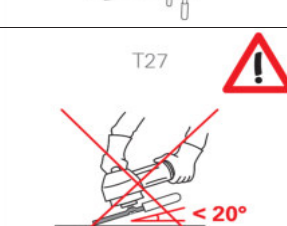
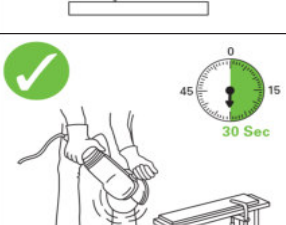
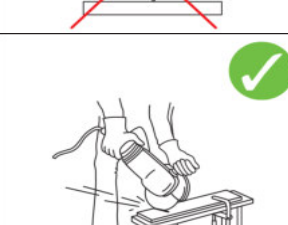






BOND

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

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

WORK SAFETY

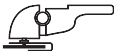


Safe instructions

AREA OF USE

Overview of types of LUKAS cupstones and snagging wheels

■ best suitable ■ suitable

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

OPERATING SPEED

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

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

LUKAS CUP STONE SNAGGING WHEELS FOR HEAVY-DUTY GRINDING

EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE

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

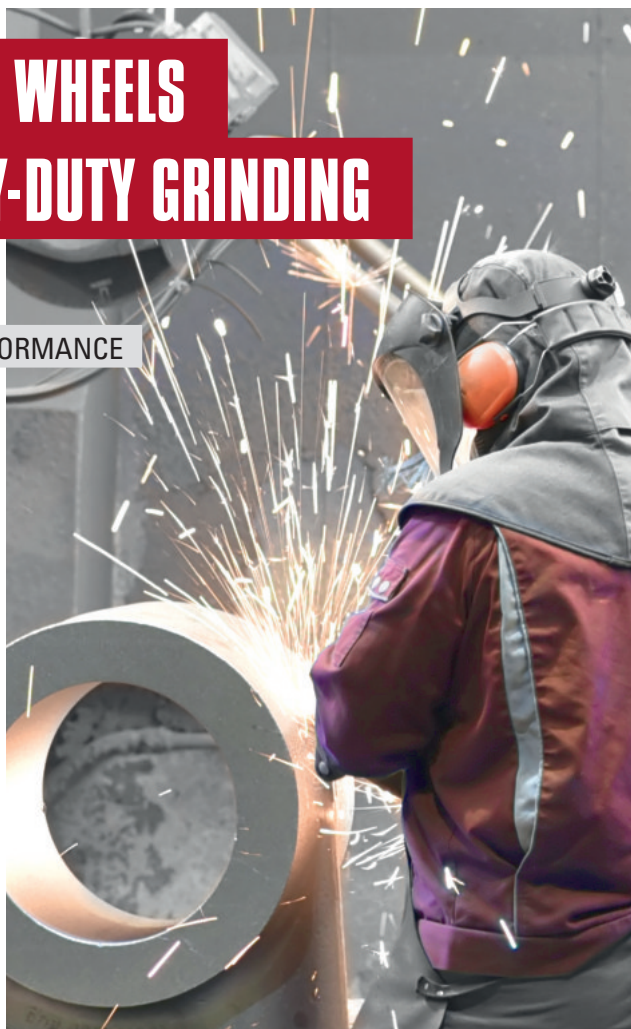
DIFFERENT GRAIN QUALITIES

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

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

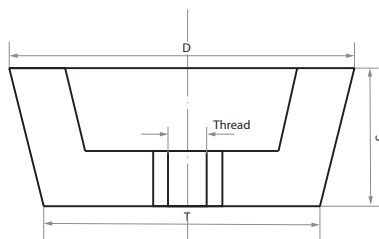
CAN BE USED ON STANDARD ELECTRIC MACHINES

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



Cup stone grinding wheels for machining steel

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

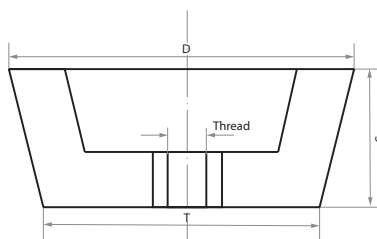


★★☆

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

Recommended for: ● Steel

Cup stone grinding wheels for machining non ferrous metal and masonry



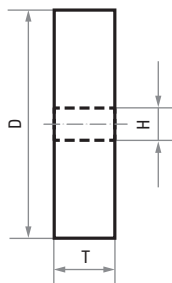
★★☆

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

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

Recommended for: ● Stone ● Cast material

Snagging wheels for machining steel



★★☆

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

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

Recommended for: ● Steel

LUKAS RUBBING BRICKS FOR HEAVY-DUTY APPLICATIONS

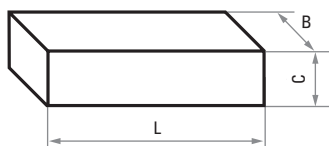
SILICON CARBIDE GRAIN FOR LEVELING OR GRINDING OF CONCRETE OR MASONRY MATERIALS



Rubbing bricks

Suitable for:

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



★★☆

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

Recommended for: ● Steel ● Stone/Construction material