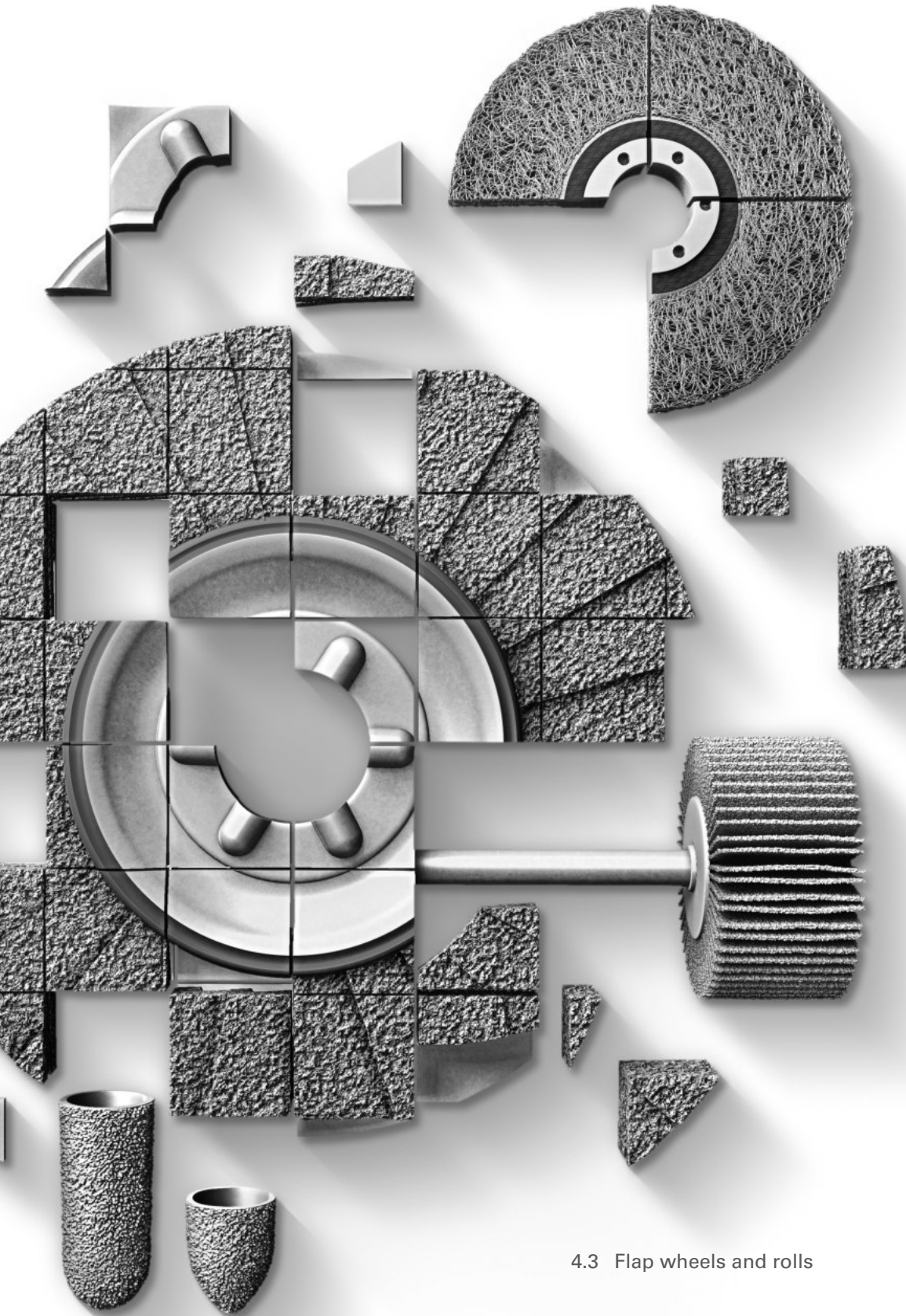


# GRINDING AND POLISHING

(with flexible tools)

GRINDING AND POLISHING  
(with flexible tools)



4.3 Flap wheels and rolls

1–8

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Flap wheels and rolls 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!

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

## 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

These rolls have a 19 mm bore and four keyways for use on handheld surface grinding machines (burnishing machines).

## LWL, FLAP ROLLS MADE OF ABRASIVE CLOTH FOR BURNISHING MACHINES

These tools are comprised of single flaps that are radially fixed around the axis in a plastic core. Please pay attention to the rotational direction of the tool!

### Application examples:

- Cleaning
- Deburring
- Derusting
- Preparation
- Texturing
- Roughening

## LWV, FLAP ROLLS MADE OF ABRASIVE FLEECE FOR BURNISHING MACHINES

This design is comprised 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.

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

## LWM, FLAP ROLLS FOR BURNISHING MACHINES MADE OF ABRASIVE FLEECE/CLOTH IN COMBINATION

These rolls with a 19 mm bore and four keyways are specially designed for use on non-rusting materials. The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LWV. Please pay attention to the rotational direction of the tool!

- Cleaning
- Derusting
- Surface preparation
- Texturing
- Roughening






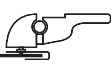


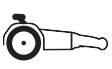
## TECHNICAL INFORMATION

## Qualities and areas of application

We have a range of abrasive rolls in proven qualities from the full spectrum of possibilities described here. These rolls can be purchased individually or used to be converted in belts or discs

Quality recommendations apply for ideal operating conditions.

 best suitable  suitable

Type	Page	Reference/ Qualities	Product line	Materials								
												
				Inox/Stainless- Rust-, acid- and heat-resistant steel	General pur- pose Steel	Alloyed/ tempered steels	Tool steels	Aluminium, magnesium and copper alloys	Stone/ Construction material	Cast iron	Titanium and nickel alloys	Plastic/Wood
	4	LSL Flap wheel thread	★★☆									
	5	LSL Flap wheel bore	★★☆									
	6	LSV Flap wheel bore	★★☆									
	7	LWL Flap roll	★★☆									
	8	LWV Flap roll	★★☆									
	8	LWM Flap roll	★★☆									

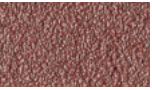
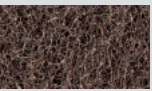

GRINDING AND POLISHING  
(with flexible tools)

## 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
	<b>NK</b> 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	LSL Flap wheel thread LSL Flap wheel bore LWL Flap roll
	<b>NK</b> 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	LSV Flap wheel bore LWV Flap roll
	<b>TF</b> 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	LWM Flap roll

## FLAP WHEELS FOR ANGLE GRINDERS

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

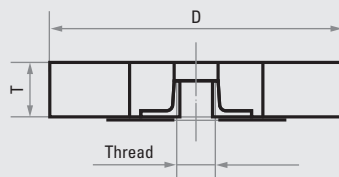
Each flap of this wheel of abrasive cloth is embedded radially to the axis in a solid plastic core. Used with a handheld tool, it is therefore ideal for derusting, removing paint and lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly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



## 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 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	D mm	T mm	Thread	Grit	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
6FG1252014004024	LSL 125.20 M14 P40	125	20	M14	NK 40	9,600	12,200	1
6FG1252014006024	LSL 125.20 M14 P60	125	20	M14	NK 60	9,600	12,200	1
6FG1252014008024	LSL 125.20 M14 P80	125	20	M14	NK 80	9,600	12,200	1
6FG1252014012024	LSL 125.20 M14 P120	125	20	M14	NK 120	9,600	12,200	1
Recommended for: <span>●</span> Inox/Steel <span>●</span> Steel <span>●</span> Aluminium <span>●</span> Cast material <span>●</span> Plastic/ Wood <span>●</span> Titanium								



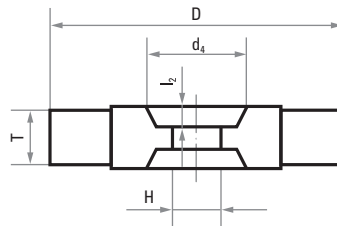
# LUKAS FLAP WHEEL MADE OF NK ABRASIVE MATERIAL

ACHIEVE CONSISTANT BRUSH FINISH EFFECT ON STAINLESS STEEL



LSL, flap wheel of abrasive cloth

- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- Other dimensions, bores or qualities are available on request. Available diameters 80 mm to max. 400 mm..
- $v_{recom}$  30 m/s in handheld use
- $v_{max}$  50 m/s in stationary use
- $n_{max}$  (rpm) applies for stationary use



★★☆

Product number	Description	D mm	T mm	H mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	Grit	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
6FG150252506024	150.25 P60 Giant flapper	150	25	25	47	18	NK 60	3,800	6,300	1
6FG150252508024	150.25 P80 Giant flapper	150	25	25	47	18	NK 80	3,800	6,300	1
6FG150252512024	150.25 P120 Giant flapper	150	25	25	47	18	NK 120	3,800	6,300	1
6FG150252524024	150.25 P240 Giant flapper	150	25	25	47	18	NK 240	3,800	6,300	1
6FG150502506024	150.50 P60 Giant flapper	150	50	25	47	18	NK 60	3,800	6,300	1
6FG150502508024	150.50 P80 Giant flapper	150	50	25	47	18	NK 80	3,400	5,700	1
6FG150502512024	150.50 P120 Giant flapper	150	50	25	47	18	NK 120	3,400	5,700	1
6FG150502518024	150.50 P180 Giant flapper	150	50	25	47	18	NK 180	3,400	5,700	1
6FG150502524024	150.50 P240 Giant flapper	150	50	25	47	18	NK 240	3,400	5,700	1
6FG200252506024	200.25 P60 Giant flapper	200	25	25	71	10	NK 60	2,800	4,700	1
6FG200252508024	200.25 P80 Giant flapper	200	25	25	71	10	NK 80	2,800	4,700	1
6FG200252512024	200.25 P120 Giant flapper	200	25	25	71	10	NK 120	2,800	4,700	1
6FG200252524024	200.25 P240 Giant flapper	200	25	25	71	10	NK 240	2,800	4,700	1
6FG200502506024	200.50 P60 Giant flapper	200	50	25	71	18	NK 60	2,800	4,700	1
6FG200502508024	200.50 P80 Giant flapper	200	50	25	71	18	NK 80	2,800	4,700	1
6FG200502512024	200.50 P120 Giant flapper	200	50	25	71	18	NK 120	2,800	4,700	1

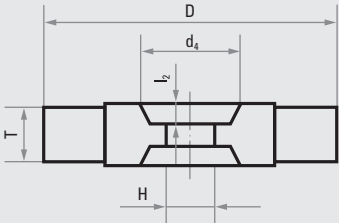
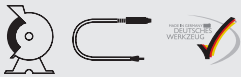
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

# LUKAS FLAP WHEEL MADE OF ABRASIVE FLEECE

ADAPTED TO HANDLE YOUR SPECIFIC CHALLENGES

GRINDING AND POLISHING  
(with flexible tools)

## LSV, flap wheel of abrasive fleece



- for matt finishing, satin finishing, polishing, smoothening and final surface finishing
- other dimensions, bores or qualities (e.g. “very hard” version or impregnated with polyurethane) are available upon request. Available diameters 80 mm to max. 400 mm.
- $v_{max}$  35 m/s

★★☆

Product number	Description	Qual-ity	D mm	T mm	H mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	Grit	Type	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
6FN150252510624	LSV 150.25 A106	A106 M	150	25	25	47	18	NK 180	Med	2,000	4,000	1
6FN150502510624	LSV 150.50 A106	A106 M	150	50	25	47	18	NK 180	Med	2,000	4,000	1
6FN150502510724	LSV 150.50 A107	A107 M	150	50	25	47	18	NK 280	Med	2,000	4,000	1

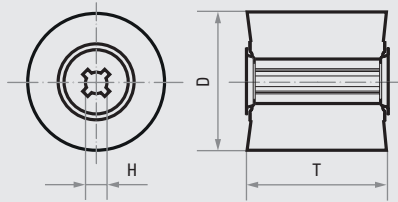
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

# LUKAS CONDITIONING MACHINES

THE MATCHING POWER TOOL FOR YOUR CONDITIONING ROLLS



LWL, flap roll made of abrasive cloth

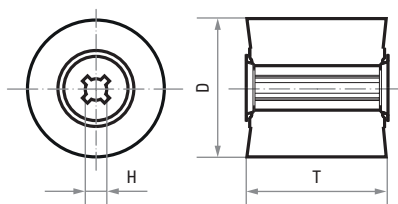


- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- for conditioning machines

★★☆

Product number	Description	D mm	T mm	H mm	Grit	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack con- tains
6FG1001001908024	LWL 100100 P80	100	100	19	NK 80	3,700	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: gray;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								

## LWV, flap roll made of abrasive fleece

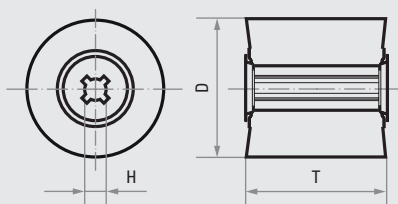


- for conditioning machines
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces

★★☆

Product number	Description	Quality	D mm	T mm	H mm	Grit	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
6FN1001001910424	LWV 100.100.19 A104	A104	100	100	19	NK 100	2,800	6,000	1
6FN1001001910624	LWV 100.100.19 A106	A106	100	100	19	NK 180	2,800	6,000	1
6FN1001001910724	LWV 100.100.19 A280	A107	100	100	19	NK 280	2,800	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium									

## LWM, flap roll made of abrasive fleece and cloth in combination



- for conditioning machines
- for continuous working
- better stock removal performance than flap rolls made solely with abrasive fleece
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

★★☆

Product number	Description	Quality	D mm	T mm	H mm	Grit	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
6FN100100198024	LWM 100.100.19 A104/NK	A104/80	100	100	19	NK 100/80	2,800	6,000	1
6FN100100191524	LWM 100.100.19 A106/NK	A106/150	100	100	19	NK 180/150	2,800	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium									