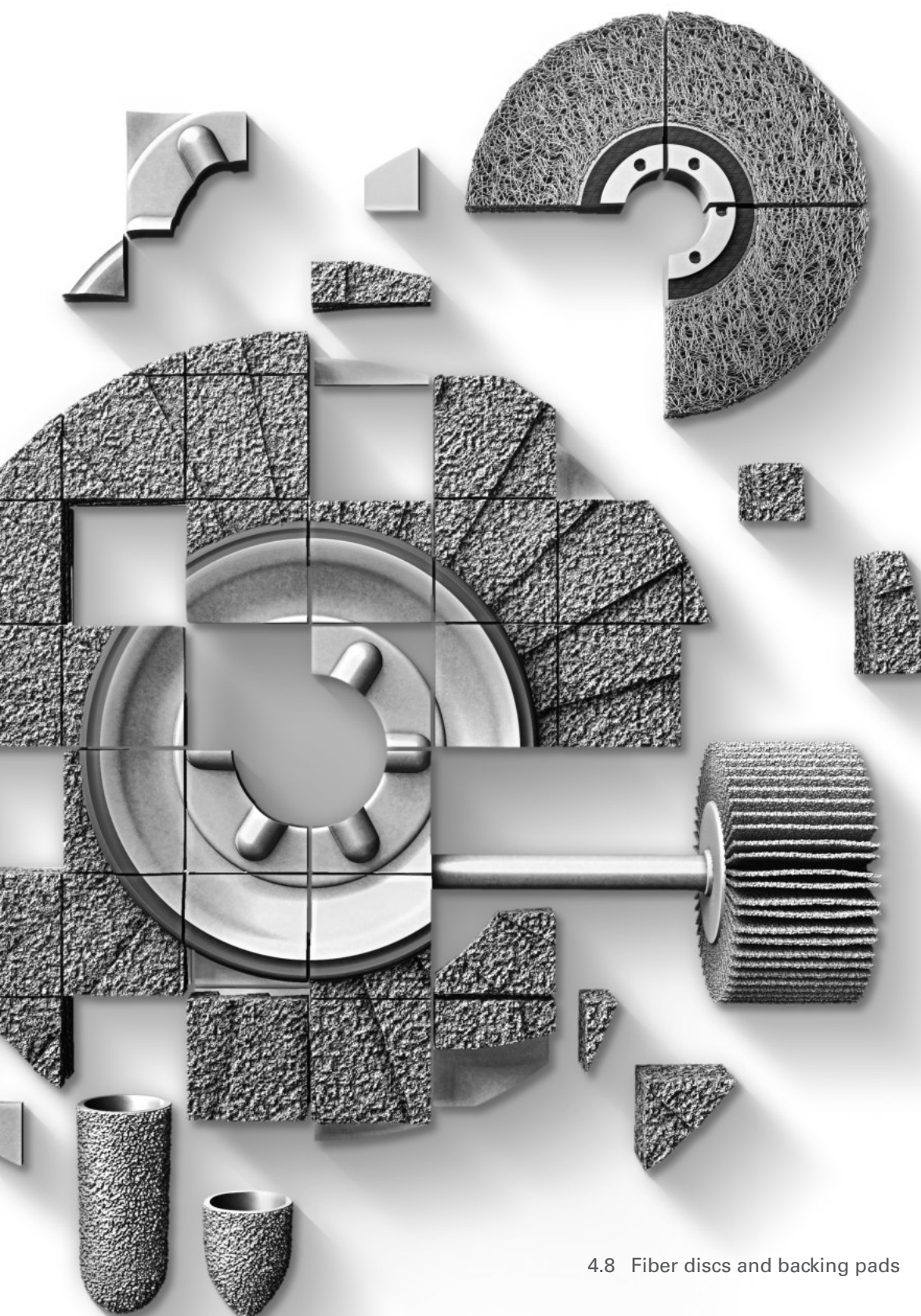


GRINDING AND POLISHING



4.8 Fiber discs and backing pads

1–11

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Fibre discs and backing pads

GENERAL

Lukas Abrasive South Africa has partnered with Hermes Schleifmittel GmbH to be the sole distributor in Southern Africa of the Hermes brand coated abrasives.

Our Fibre discs and backing pads are available in many different qualities 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.

HANDLING AND STORAGE ADVICE

Fibre discs should be stored in dry, frost free conditions. They should be kept away from heat sources, cold, damp walls, doors or windows and should not be in direct contact with the floor. Temperatures and humidity should be between 18-22 °C and 45%-65% Relative Humidity and should not be exposed to direct sunlight.

FIBRE DISCS

Fibre discs are used together with a backing pad on angle grinders. We offer these very popular tools in the qualities Ceramic, ZK, ALO, SIC as well as in ZK, ALO and SIC in base-x quality for the price-conscious user.

SEMI-FLEXIBLE GRINDING DISCS

The semi-flexible grinding discs consist of a stable fibre backing with a structured abrasive coating of silicon carbide. This combination is particularly suitable for rough grinding work on many different materials. Typical applications include removing paint, rust and adhesives, but also machining fibre-reinforced plastics such as CFRP and GFRP, e.g. in the manufacture of swimming pools. Like fibre discs, semi-flexible grinding discs for angle grinders are only used together with a backing pad.



for an excellent finish

Hermes Schleifmittel is a multi-national company with a long series of tradition and innovation, the Hermes brand of abrasives is a market leader in the coated abrasives sector. Manufacturing sanding products that includes heavy duty belts, sanding discs, rolls and accessories.

Quality: "Outstanding".

Hermes is the first European abrasives manufacturer to be awarded certification to DIN EN ISO 9001, including its research and development work, as long ago as 1993. A group certificate was added to this award in 1996.

In 2002, the quality management was expanded to include the environmental management (incorporating occupational health and safety) to form an integrated management system which is applicable all over the world.

Controlled quality has top priority in the company, meaning that Hermes can satisfy customer requirements in every respect..



APPLICATION RECOMMENDATIONS

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

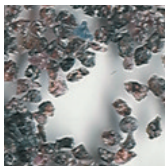
Do not apply too much pressure when using LUKAS grinding tools: excessive pressure does not improve the performance, and will instead result in premature wear. Even if the chip removal is unsatisfactory, you do not apply more pressure. Use a coarser grain instead to prevent unnecessary tool wear and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

QUALITY AND APPLICATIONS

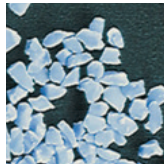
The right abrasive for every application

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.



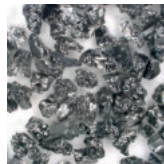
A
Semi-friable
aluminium oxide



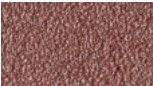
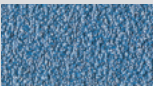

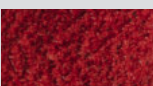
CER
Ceramic grain



ZK
Zirconia alumina



C/SIC
Silicon carbide

Quality		Properties	Application areas/ machining	Available as	Page
	A Semi-friable 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	fibre discs	7,9
	ZK 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	fibre discs	6,8
	C/SIC Silicon carbide	minimum heat generation, special quality for the aerospace industry	aluminium and alloys, titanium materials, glass, ceramic, heat-resistant steel, plastic	fibre discs semi-flexible grinding discs	10,11
	Cer Ceramic grain	excellent removal rate without grain shredding cool cutting	non-rusting steels, nickel alloys	fibre discs	5

TECHNICAL INFORMATION

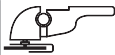



Qualities and areas of application

We have a range of abrasive rolls in proven qualities from the full spectrum of possibilities described here.

Quality recommendations apply for ideal operating conditions.

best suitable

suitable

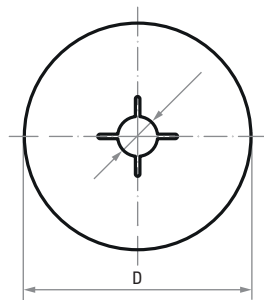
Type	Page	Reference/ Description	Product line	Quality	Materials								
					<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
					Inox/Stain- less steel	General purpose Steel	Tool steels	Cast Iron	Aluminium, magnesium and copper alloys	Construction materials/ Plaster/ plasterboard walls	Titanium and nickel alloys	Plastic/ wood/ rubber	Glass/Stone
	5	Ceramic fibre disc	★★★										
	6	RB 414 X ZK fibre disc	★★☆										
	7	RB 314 X ALO fibre disc	★★☆										
	8	ZK fibre disc	★★☆										
	9	ALO fibre disc	★★☆										
	10	SIC fibre disc	★★☆										
	11	Semi-flexible grinding disc	★★☆										

FINE AND CONSISTENT SURFACE FINISH

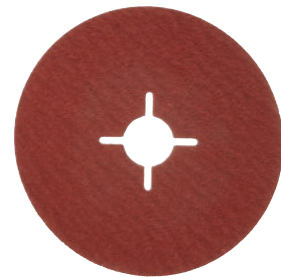
LUKAS FIBRE DISCS FOR YOUR REQUIRED SURFACE RESULTS



- single layer of abrasive with ceramic grain for the toughest applications
- 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.
- used together with a backing pad on angle grinders

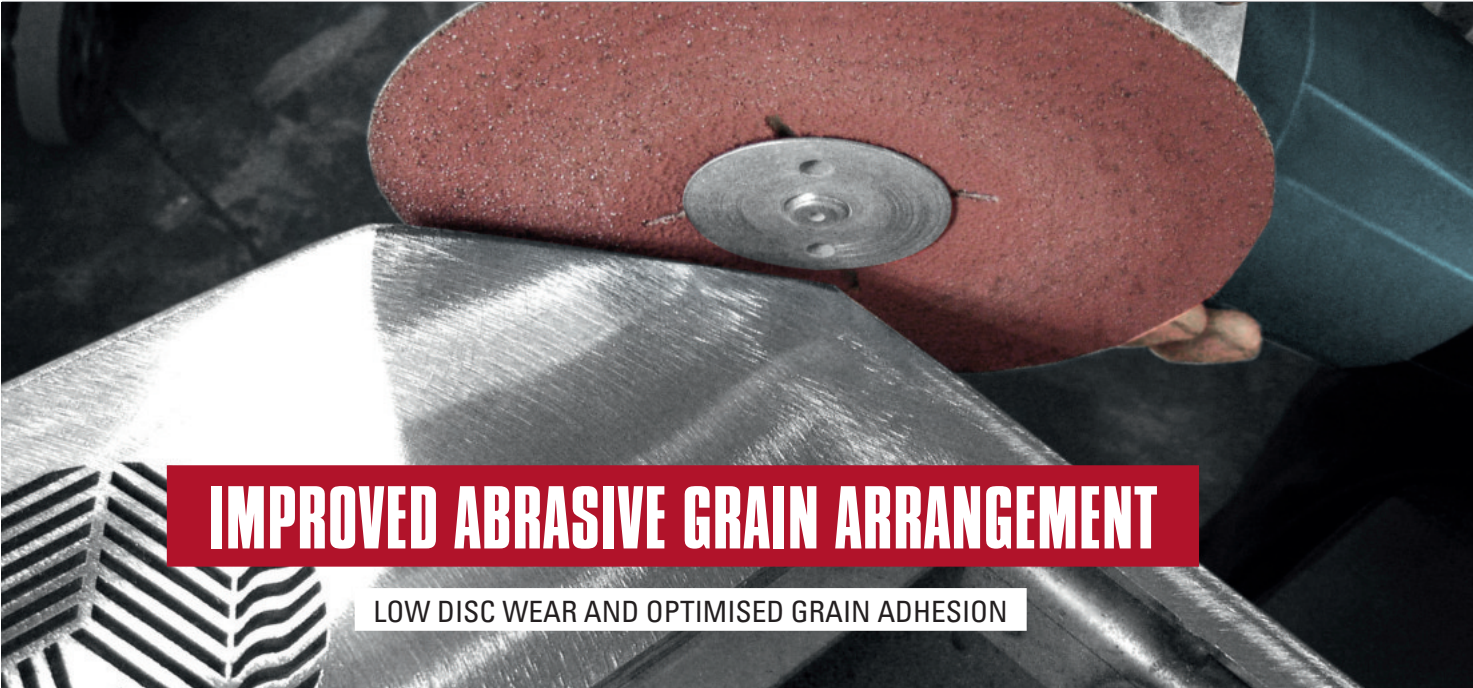


Ceramic fibre disc with cross slot



★★★

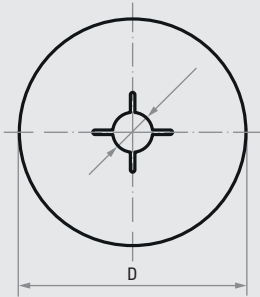
Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n_{max} rpm	Pack contains
6DC115220368899	115 rsn fbr Ceramic P36	115	22	36	Ceramic	cross slot	13,300	25
6DC115220608899	115 rsn fbr Ceramic P60	115	22	60	Ceramic	cross slot	13,300	25
6DC115220808899	115 rsn fbr Ceramic P80	115	22	80	Ceramic	cross slot	13,300	25
6DC125220608899	125 rsn fbr Ceramic P60	125	22	60	Ceramic	cross slot	12,200	25
6DC180220368899	180 rsn fbr Ceramic P36	180	22	36	Ceramic	cross slot	8,500	25
6DC180220508899	180 rsn fbr Ceramic P50	180	22	50	Ceramic	cross slot	8,500	25
6DC180220608899	180 rsn fbr Ceramic P60	180	22	60	Ceramic	cross slot	8,500	25
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium								



RB 414 X Zirconia alumina fibre disc



★★☆



- 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.

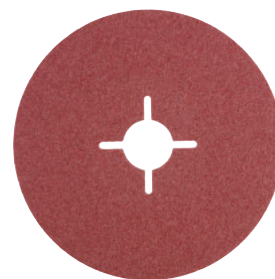
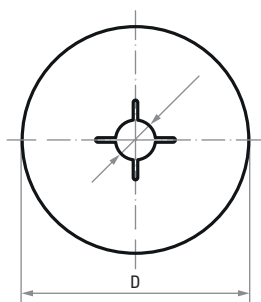
Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n _{max} rpm	Pack contains
6DD115220243127	115 RB 414 X rsn fbr ZK24	115	22	24	ZK	cross slot	13,300	25
6DD115220363127	115 RB 414 X rsn fbr ZK36	115	22	36	ZK	cross slot	13,300	25
6DD115220603127	115 RB 414 X rsn fbr ZK60	115	22	60	ZK	cross slot	13,300	25
6DD115221203127	115 RB 414 X rsn fbr ZK120	115	22	120	ZK	cross slot	13,300	25
6DD180220363127	180 RB 414 X rsn fbr ZK36	180	22	36	ZK	cross slot	8,500	25
6DD180220603127	180 RB 414 X rsn fbr ZK60	180	22	60	ZK	cross slot	8,500	25

Recommended for: Inox/Steel Steel Cast material Titanium



RB 314 X aluminium oxide fibre disc

- single layer of abrasive for tough applications
- regular aluminium oxide for cost-effective working
- used together with a backing pad on angle grinders



★★☆

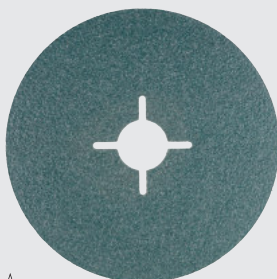
Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n _{max} rpm	Pack contains
6DD100160162027	100 RB 314 X rsn fbr P16	100	16	16	ALO	cross slot	15,300	25
6DD100160242027	100 RB 314 X rsn fbr P24	100	16	24	ALO	cross slot	15,300	25
6DD100160602027	100 RB 314 X rsn fbr P60	100	16	60	ALO	cross slot	15,300	25
6DD100160802027	100 RB 314 X rsn fbr P80	100	16	80	ALO	cross slot	15,300	25
6DD100161005127	100 RB 314 X rsn fbr P100	100	16	100	ALO	cross slot	15,300	25
6DD100161202027	100 RB 314 X rsn fbr P120	100	16	120	ALO	cross slot	15,300	25
6DD115220245127	115 RB 314 X rsn fbr P24	115	22	24	ALO	cross slot	13,300	25
6DD115220365127	115 RB 314 X rsn fbr P36	115	22	36	ALO	cross slot	13,300	25
6DD115220605127	115 RB 314 X rsn fbr P60	115	22	60	ALO	cross slot	13,300	25
6DD115220805127	115 RB 314 X rsn fbr P80	115	22	80	ALO	cross slot	13,300	25
6DD115221005127	115 RB 314 X rsn fbr P100	115	22	100	ALO	cross slot	13,300	25
6DD115221205127	115 RB 314 X rsn fbr P120	115	22	120	ALO	cross slot	13,300	25
6DD125220165127	125 RB 314 X rsn fbr P16	125	22	16	ALO	cross slot	12,200	25
6DD125220245127	125 RB 314 X rsn fbr P24	125	22	24	ALO	cross slot	12,200	25
6DD125220365127	125 RB 314 X rsn fbr P36	125	22	36	ALO	cross slot	12,200	25
6DD125220605127	125 RB 314 X rsn fbr P60	125	22	60	ALO	cross slot	12,200	25
6DD125220805127	125 RB 314 X rsn fbr P80	125	22	80	ALO	cross slot	12,200	25
6DD125221002027	125 RB 314 X rsn fbr P100	125	22	100	ALO	cross slot	12,200	25
6DD180220165127	180 RB 314 X rsn fbr P16	180	22	16	ALO	cross slot	8,500	25
6DD180220245127	180 RB 314 X rsn fbr P24	180	22	24	ALO	cross slot	8,500	25
6DD180220365127	180 RB 314 X rsn fbr P36	180	22	36	ALO	cross slot	8,500	25
6DD180220605127	180 RB 314 X rsn fbr P60	180	22	60	ALO	cross slot	8,500	25
6DD180220805127	180 RB 314 X rsn fbr P80	180	22	80	ALO	cross slot	8,500	25
6DD180221005127	180 RB 314 X rsn fbr P100	180	22	100	ALO	cross slot	8,500	25
6DD180221205127	180 RB 314 X rsn fbr P120	180	22	120	ALO	cross slot	8,500	25

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

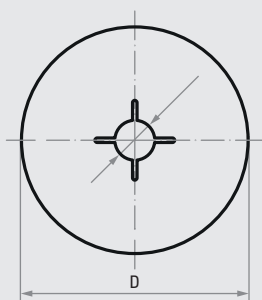
COST-EFFECTIVE GRINDING

EXCELLENT PRICE-PERFORMANCE RATIO WITH LUKAS BASE-X

Zirconia alumina fibre disc



★☆☆



- single layer of abrasive for the toughest applications
- made of exceptionally tough zirconia alumina with high resilience to pressure
- economically priced

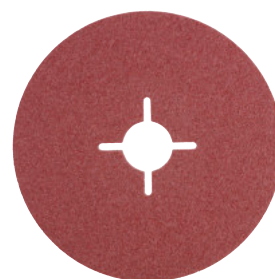
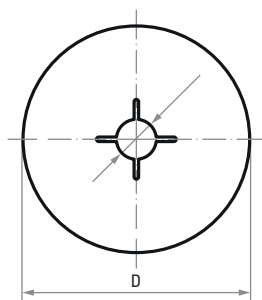
Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n _{max} rpm	Pack contains
6DD115220247153	115 base - x rsn fbr ZK24	115	22	24	ZK	cross slot	13,300	25
6DD115220367153	115 base - x rsn fbr ZK36	115	22	36	ZK	cross slot	13,300	25
6DD115220607153	115 base - x rsn fbr ZK60	115	22	60	ZK	cross slot	13,300	25
6DD115220807153	115 base - x rsn fbr ZK80	115	22	80	ZK	cross slot	13,300	25
6DD115221007153	115 base - x rsn fbr ZK100	115	22	100	ZK	cross slot	13,300	25
6DD115221207153	115 base - x rsn fbr ZK120	115	22	120	ZK	cross slot	13,300	25
6DD180220247153	180 base - x rsn fbr ZK24	180	22	24	ZK	cross slot	8,500	25
6DD180220367153	180 base - x rsn fbr ZK36	180	22	36	ZK	cross slot	8,500	25
6DD180220607153	180 base - x rsn fbr ZK60	180	22	60	ZK	cross slot	8,500	25
6DD180220807153	180 base - x rsn fbr ZK80	180	22	80	ZK	cross slot	8,500	25
6DD180221007153	180 base - x rsn fbr ZK100	180	22	100	ZK	cross slot	8,500	25
6DD180221207153	180 base - x rsn fbr ZK120	180	22	120	ZK	cross slot	8,500	25

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



Aluminium oxide fibre disc

- single layer of abrasive for tough applications
- regular aluminium oxide for cost-effective working
- used together with a backing pad on angle grinders



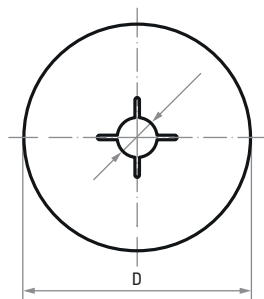
★☆☆

Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n_{max} rpm	Pack contains
6DD100160162053	100 base - x rsn fbr P16	100	16	16	ALO	no slot	15,300	25
6DD100160242053	100 base - x rsn fbr P24	100	16	24	ALO	no slot	15,300	25
6DD100160362053	100 base - x rsn fbr P36	100	16	36	ALO	no slot	15,300	25
6DD100160602053	100 base - x rsn fbr P60	100	16	60	ALO	no slot	15,300	25
6DD100160802053	100 base - x rsn fbr P80	100	16	80	ALO	no slot	15,300	25
6DD115220162053	115 base - x rsn fbr P16	115	22	16	ALO	no slot	13,300	25
6DD115220242053	115 base - x rsn fbr P24	115	22	24	ALO	no slot	13,300	25
6DD115220362053	115 base - x rsn fbr P36	115	22	36	ALO	no slot	13,300	25
6DD115220602053	115 base - x rsn fbr P60	115	22	60	ALO	no slot	13,300	25
6DD115220802053	115 base - x rsn fbr P80	115	22	80	ALO	no slot	13,300	25
6DD115221002053	115 base - x rsn fbr P100	115	22	100	ALO	no slot	13,300	25
6DD115221202053	115 base - x rsn fbr P120	115	22	120	ALO	no slot	13,300	25
6DD125220162053	125 base - x rsn fbr P16	125	22	16	ALO	no slot	12,200	25
6DD125220242053	125 base - x rsn fbr P24	125	22	24	ALO	no slot	12,200	25
6DD125220362053	125 base - x rsn fbr P36	125	22	36	ALO	no slot	12,200	25
6DD125220602053	125 base - x rsn fbr P60	125	22	60	ALO	no slot	12,200	25
6DD125220802053	125 base - x rsn fbr P80	125	22	80	ALO	no slot	12,200	25
6DD125221002053	125 base - x rsn fbr P100	125	22	100	ALO	no slot	12,200	25
6DD180220162053	180 base - x rsn fbr P16	180	22	16	ALO	no slot	8,500	25
6DD180220242053	180 base - x rsn fbr P24	180	22	24	ALO	no slot	8,500	25
6DD180220362053	180 base - x rsn fbr P36	180	22	36	ALO	no slot	8,500	25
6DD180220502053	180 base - x rsn fbr P50	180	22	50	ALO	no slot	8,500	25
6DD180220602053	180 base - x rsn fbr P60	180	22	60	ALO	no slot	8,500	25
6DD180220802053	180 base - x rsn fbr P80	180	22	80	ALO	no slot	8,500	25
6DD180221002053	180 base - x rsn fbr P100	180	22	100	ALO	no slot	8,500	25
Recommended for: ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Inox/Steel ● Titanium								

Silicone Carbide fibre disc



★☆☆



- single layer of abrasive for tough applications
- for the price-conscious user
- used together with a backing pad on angle grinders

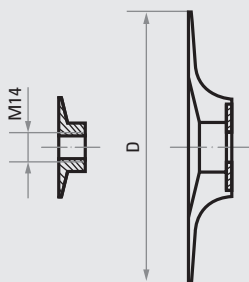
Product number	Description	D mm	Bore mm	Grit	Abrasive	Configuration	n_{max} rpm	Pack contains
6DC115220243053	115 base - x rsn fbr SIC24	115	22	24	SIC	no slot	13,300	25
6DC115220363053	115 base - x rsn fbr SIC36	115	22	36	SIC	no slot	13,300	25
6DC115220603053	115 base - x rsn fbr SIC60	115	22	60	SIC	no slot	13,300	25
6DC115220803053	125 base - x rsn fbr SIC80	125	22	80	SIC	no slot	12,200	25
6DC180220163053	180 base - x rsn fbr SIC16	180	22	16	SIC	no slot	8,500	25
6DC180220243053	180 base - x rsn fbr SIC24	180	22	24	SIC	no slot	8,500	25
6DC180220363053	180 base - x rsn fbr SIC36	180	22	36	SIC	no slot	8,500	25
6DC180220603053	180 base - x rsn fbr SIC60	180	22	60	SIC	no slot	8,500	25
6DC180220803053	180 base - x rsn fbr SIC80	180	22	80	SIC	no slot	8,500	25

Recommended for: ● Steel ● Aluminium ● Stone/Construction material ● Cast material ● Plastic/Wood

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.

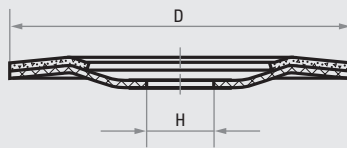
- nuts included

Product number	Description	D mm	Thread	Flex	n_{max} rpm	Pack contains
6DB115142099	115 backing pad white M14	115	M14	Soft flex	13,300	1
6DB115146099	115 backing pad black M14	115	M14	Medium flex	13,300	1
6DB178146095	178 backing pad white M14	178	M14	Soft flex	8,500	1
6DB178146099	178 backing pad black M14	178	M14	Medium flex	8,500	1



Semi-flexible grinding disc

- consists of a stable fibre backing with a structured abrasive coating of silicon carbide
- for removing paint, rust and adhesives, but also for machining fibre-reinforced plastics such as CFRP and GFRP (e.g. for swimming pools)
- also very suitable for animal hooves
- may only be used with backing pads



Product number	Description	D mm	H mm	Grit	Abrasive	Configuration	n_{max} rpm	Pack contains
6DC11522160093	115 semi-flex SIC16	115	22	16	SIC	3 cross slot	13,300	25
6DC11522360093	115 semi-flex SIC36	115	22	36	SIC	3 cross slot	13,300	25
6DC18022160093	180 semi-flex SIC16	180	22	16	SIC	3 cross slot	8,500	25
6DC18022360093	180 semi-flex SIC36	180	22	36	SIC	3 cross slot	8,500	25
Recommended for: ● Steel ● Aluminium ● Stone/Construction material ● Cast material ● Plastic/Wood								