

4.2 Mounted flap wheels

GRINDING AND POLISHING

(with flexible tools)

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(with flexible tools)

1–8

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

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.

Application examples:

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

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.

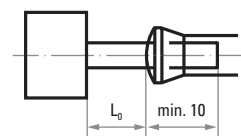
Application examples:

- Cleaning
- Derusting
- Pre-grinding
- Texturing
- Roughing

Quality	Abrasive particles	Grit	Surface
A104	Regular aluminium oxide	NK 100	medium
A106	Regular aluminium oxide	NK 180	fine
A107	Regular aluminium oxide	NK 280	very fine

SPEED

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





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
 	4-6	SFL mounted flap wheel	★★☆	■	■	■	■	■	■	■	■	■
	7	SFV mounted flap wheel	★★☆	■	■	■	■	■	■	■	■	■
	8	SFM mounted flap wheel	★★☆	■	■	■	■	■	■	■	■	■

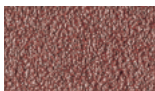
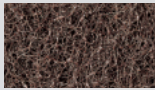
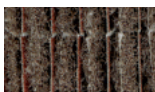
GRINDING AND POLISHING
(with flexible tools)

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.

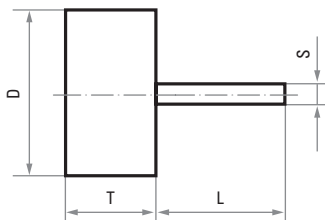
The overview below lists all abrasives for use with flexible grinding and polishing tools. Read through the properties and application areas for various workpiece materials to establish the most suitable abrasive grain type and tools to meet your requirements.

Quality		Properties	Application areas/ machining	available as	Page
	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	Mounted flap wheels	4-6
	NK Abrasive fleece Regular aluminium oxide	polishing effect with the fibre structure, consistent results thanks to continuous exposure of new abrasive particles	chrome-nickel alloys and other non-rusting steels, zinc die castings, non-ferrous metals, wood	Mounted flap wheels	7
	Combination 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	deal for surface finishing of sheet metal products made from non-rusting steel such as stainless steel sinks and containers	Mounted flap wheels	8

CERAMIC MOUNTED FLAP WHEELS FROM LUKAS FOR THE MOST PRECISE APPLICATIONS

EFFICIENT SURFACE GRINDING WITH SELF-SHARPENING EFFECT AND EXCEPTIONAL TOOL LIFE

SFL mounted flap wheel



- 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

★★☆

Product number	Description	D mm	T mm	S mm	L mm	Grit	n_{recom} rpm	n_{max} rpm	Pack contains
6FS020100308024	SFL 02010.03 P80	20	10	3	40	NK 80	20,000	28,000	10
6FS020150608024	SFL 02015.06 P80	20	15	6	40	NK 80	20,000	38,200	10
6FS02020068024	SFL 02020.06 P80	20	20	6	40	NK 80	20,000	38,200	10
6FS02020061224	SFL 02020.06 P120	20	20	6	40	NK 120	20,000	38,200	10
6FS02020062424	SFL 02020.06 P240	20	20	6	40	NK 240	20,000	38,200	10
6FS02515068024	SFL 02515.06 P80	25	15	6	40	NK 80	16,000	30,600	10
6FS025150612024	SFL 02515.06 P120	25	15	6	40	NK 120	16,000	30,600	10
6FS03005066024	SFL 03005.06 P60	30	05	6	40	NK 60	16,000	30,600	10
6FS03005068024	SFL 03005.06 P80	30	05	6	40	NK 80	16,000	25,400	10
6FS03005061224	SFL 03005.06 P120	30	05	6	40	NK 120	16,000	25,400	10
6FS03010036024	SFL 03010.03 P60	30	10	3	40	NK 60	16,000	18,000	10
6FS03010031224	SFL 03010.03 P120	30	10	3	40	NK 120	16,000	18,000	10

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

Product number	Description	D mm	T mm	S mm	L mm	Grit	n _{recom} rpm	n _{max} rpm	Pack con- tains
6FS03010032424	SFL 03010.03 P240	30	10	3	40	NK 240	16,000	18,000	10
6FS03010033224	SFL 03010.03 P320	30	10	3	40	NK 320	16,000	18,000	10
6FS03010066024	SFL 03010.06 P60	30	10	6	40	NK 60	16,000	25,400	10
6FS03010068024	SFL 03010.06 P80	30	10	6	40	NK 80	16,000	25,400	10
6FS030100612024	SFL 03010.06 P120	30	10	6	40	NK 120	16,000	25,400	10
6FS030100615024	SFL 03010.06 P150	30	10	6	40	NK 150	16,000	25,400	10
6FS03015066024	SFL 03015.06 P60	30	15	6	40	NK 60	16,000	25,400	10
6FS03015068024	SFL 03015.06 P80	30	15	6	40	NK 80	16,000	25,400	10
6FS03015061224	SFL 03015.06 P120	30	15	6	40	NK 120	16,000	25,400	10
6FS03020066024	SFL 03020.06 P60	30	20	6	40	NK 60	16,000	25,400	10
6FS04010068024	SFL 04010.06 P80	40	10	6	40	NK 80	12,000	19,100	10
6FS04015066024	SFL 04015.06 P60	40	15	6	40	NK 60	12,000	19,100	10
6FS04015068024	SFL 04015.06 P80	40	15	6	40	NK 80	12,000	19,100	10
6FS04015061224	SFL 04015.06 P120	40	15	6	40	NK 120	12,000	19,100	10
6FS04015061824	SFL 04015.06 P180	40	15	6	40	NK 180	12,000	19,100	10
6FS04015062424	SFL 04015.06 P240	40	15	6	40	NK 240	12,000	19,100	10
6FS04015063224	SFL 04015.06 P320	40	15	6	40	NK 320	12,000	19,100	10
6FS04015064024	SFL 04015.06 P400	40	15	6	40	NK 400	12,000	19,100	10
6FS04020066024	SFL 04020.06 P60	40	20	6	40	NK 60	12,000	19,100	10
6FS04020068024	SFL 04020.06 P80	40	20	6	40	NK 80	12,000	19,100	10
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6FS04020062424	SFL 04020.06 P240	40	20	6	40	NK 240	12,000	19,100	10
6FS04025066024	SFL 04025.06 P60	40	25	6	40	NK 60	12,000	19,100	10
6FS04025068024	SFL 04025.06 P80	40	25	6	40	NK 80	12,000	19,100	10
6FS04025061224	SFL 04025.06 P120	40	25	6	40	NK 120	12,000	19,100	10
6FS04040066024	SFL 04040.06 P60	40	40	6	40	NK 60	12,000	19,100	10
6FS04040068024	SFL 04040.06 P80	40	40	6	40	NK 80	12,000	19,100	10
6FS04040061224	SFL 04040.06 P120	40	40	6	40	NK 120	12,000	19,100	10
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6FS05010062424	SFL 05010.06 P240	50	10	6	40	NK 240	9,000	15,300	10
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6FS05015066024	SFL 05015.06 P60	50	15	6	40	NK 60	9,000	15,300	10
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6FS05015061224	SFL 05015.06 P120	50	15	6	40	NK 120	9,000	15,300	10
6FS05015061824	SFL 05015.06 P180	50	15	6	40	NK 180	9,000	15,300	10
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6FS05020068024	SFL 05020.06 P80	50	20	6	40	NK 80	9,000	15,300	10
6FS05020061224	SFL 05020.06 P120	50	20	6	40	NK 120	9,000	15,300	10
6FS05020062424	SFL 05020.06 P240	50	20	6	40	NK 240	9,000	15,300	10
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6FS05040061224	SFL 05040.06 P120	50	40	6	40	NK 120	9,000	15,300	10
6FS06015068024	SFL 06015.06 P80	60	15	6	40	NK 80	8,000	12,700	10
6FS06020066024	SFL 06020.06 P60	60	20	6	40	NK 60	8,000	12,700	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● TitaniumGRINDING AND POLISHING
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Product number	Description	D mm	T mm	S mm	L mm	Grit	n _{recom} rpm	n _{max} rpm	Pack con- tains
6FS06020068024	SFL 06020.06 P80	60	20	6	40	NK 80	8,000	12,700	10
6FS06020061224	SFL 06020.06 P120	60	20	6	40	NK 120	8,000	12,700	10
6FS06030064024	SFL 06030.06 P40	60	30	6	40	NK 40	8,000	12,700	10
6FS06030066024	SFL 06030.06 P60	60	30	6	40	NK 60	8,000	12,700	10
6FS06030068024	SFL 06030.06 P80	60	30	6	40	NK 80	8,000	12,700	10
6FS06030061224	SFL 06030.06 P120	60	30	6	40	NK 120	8,000	12,700	10
6FS06030062424	SFL 06030.06 P240	60	30	6	40	NK 240	8,000	12,700	10
6FS06040064024	SFL 06040.06 P40	60	40	6	40	NK 40	8,000	12,700	10
6FS06040066024	SFL 06040.06 P60	60	40	6	40	NK 60	8,000	12,700	10
6FS06040068024	SFL 06040.06 P80	60	40	6	40	NK 80	8,000	12,700	10
6FS06040061224	SFL 06040.06 P120	60	40	6	40	NK 120	8,000	12,700	10
6FS06040062424	SFL 06040.06 P240	60	40	6	40	NK 240	8,000	12,700	10
6FS06050066024	SFL 06050.06 P60	60	50	6	40	NK 60	8,000	8,500	10
6FS08015061224	SFL 08015.06 P120	80	15	6	40	NK 120	6,000	9,500	10
6FS08020066024	SFL 08020.06 P60	80	20	6	40	NK 60	6,000	9,500	10
6FS08020068024	SFL 08020.06 P80	80	20	6	40	NK 80	6,000	9,500	10
6FS08020061224	SFL 08020.06 P120	80	20	6	40	NK 120	6,000	9,500	10
6FS08030066024	SFL 08030.06 P60	80	30	6	40	NK 60	6,000	9,500	10
6FS08030068024	SFL 08030.06 P80	80	30	6	40	NK 80	6,000	9,500	10
6FS08030061224	SFL 08030.06 P120	80	30	6	40	NK 120	6,000	9,500	10
6FS08030062424	SFL 08030.06 P240	80	30	6	40	NK 240	6,000	9,500	10
6FS08050064024	SFL 08050.06 P40	80	50	6	40	NK 40	6,000	7,500	10
6FS08050066024	SFL 08050.06 P60	80	50	6	40	NK 60	6,000	7,500	10
6FS08050068024	SFL 08050.06 P80	80	50	6	40	NK 80	6,000	7,500	10
6FS08050061224	SFL 08050.06 P120	80	50	6	40	NK 120	6,000	7,500	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium									

LUKAS MOUNTED FLAP WHEELS MADE OF ABRASIVE FLEECE

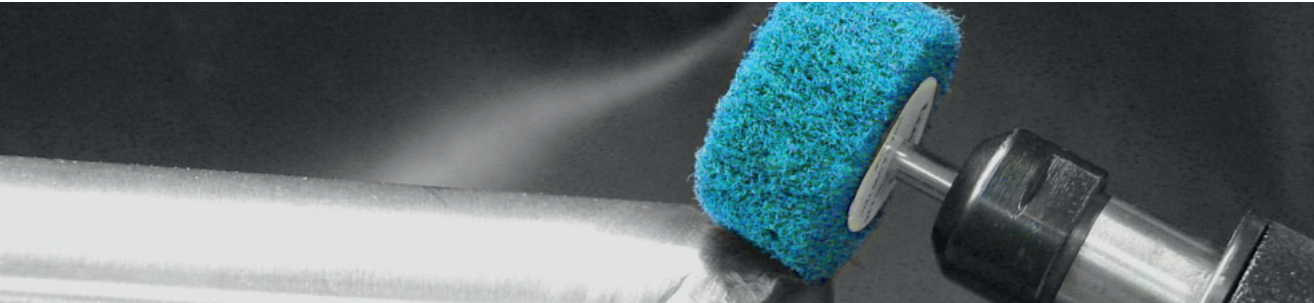
READY FOR EVERY WORK SCENARIO

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, smooth-

ening 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.

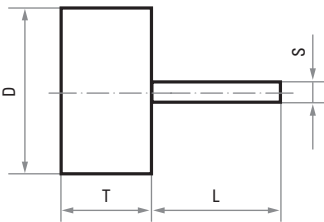


GRINDING AND POLISHING
(with flexible tools)



SFV mounted flap wheel, regular aluminium oxide

- 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

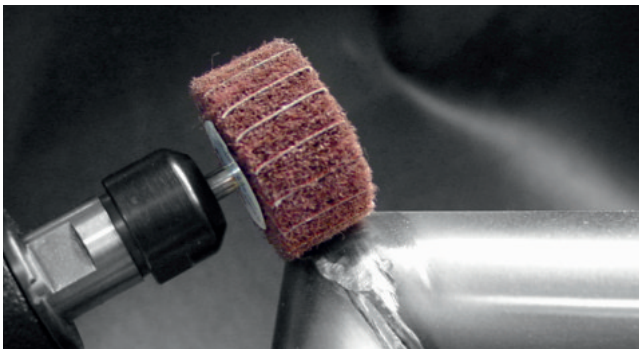


★★☆

Product number	Description	Quality	D mm	T mm	S mm	L mm	Grit	n _{recom} rpm	n _{max} rpm	Pack contains
6FN040200610424	SFV 04020.06 P100	A104	40	20	6	40	NK 100	7,500	14,000	10
6FN040200610624	SFV 04020.06 P180	A106	40	20	6	40	NK 180	7,500	14,000	10
6FN040300610724	SFV 04030.06 P280	A107	40	30	6	40	NK 280	7,500	14,000	10
6FN050300610624	SFV 05030.06 P180	A106	50	30	6	40	NK 180	6,000	11,000	10
6FN080500610424	SFV 08050.06 P100	A104	80	50	6	40	NK 100	4,000	7,000	10
6FN080500610624	SFV 08050.06 P180	A106	80	50	6	40	NK 180	4,000	7,000	10
6FN080500610724	SFV 08050.06 P280	A107	80	50	6	40	NK 280	4,000	7,000	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium										

COMBINATION OF ABRASIVE FLEECE AND ABRASIVE CLOTH

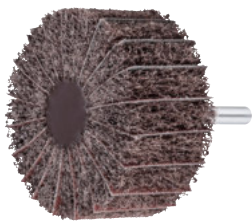
GREATER STABILITY FOR SUSTAINED USAGE



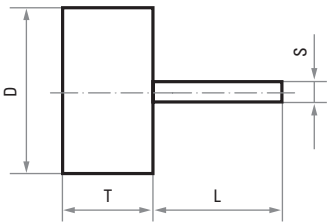
These LUKAS grinding tools feature a combination of abrasive fleece and abrasive cloth. During the production, the fleece and cloth flaps are fastened alternately and radially to the tool axis.

The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate than can be achieved compared to mounted flap wheels without the cloth. These optimised mounted flap wheels are mainly used on handheld power tools and, thanks to their stability, are ideally suited for cleaning, derusting, surface preparation, texturing and rough grinding.

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	Quality	D mm	T mm	S mm	L mm	Grit	n _{recom} rpm	n _{max} rpm	Pack contains
6FN080500680024	SFM 08050.06 Combi	A104/80	80	50	6	40	NK 100/80	4,000	7,000	10
Recommended for: Inox/Steel Steel Aluminium Cast material Plastic/Wood Titanium										