Transforming surfacesand beyond



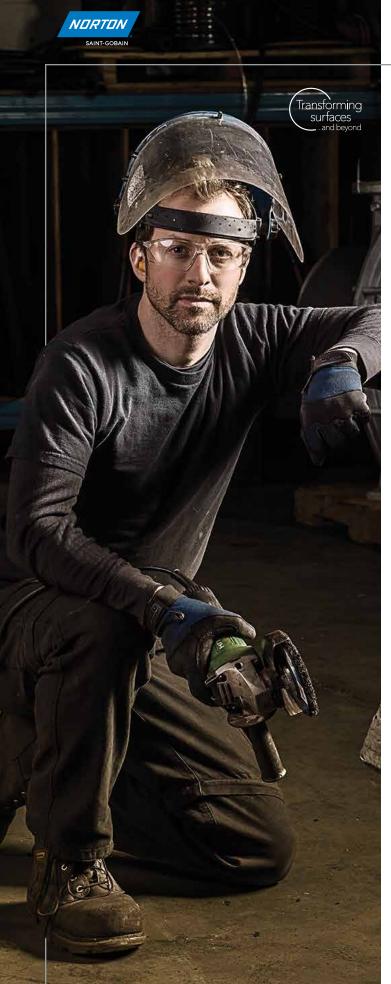
CATALOG #7362

FULL-LINE STOCK CATALOG ABRASIVE PRODUCTS FOR THE INDUSTRIAL MARKET





BECAUSE **RIGHT CHOICES** MATTER™



Our Mission

We offer powerful, precise, user-friendly solutions, which enable our customers to cut, shape and finish all materials even in the most complex and challenging applications. By working closely with end-users and our grinding expert partners, we design and provide customized solutions to secure the best option for performance, cost and safety.

Our Expertise

Norton is the leading brand of Saint-Gobain Abrasives, with more than 135 years of experience in manufacturing abrasives.

We are committed to providing access to our expert's knowledge whenever you need it. Whether it is through our <u>Process Solutions Program (PSP)</u>, ongoing training programs, or through on-line expert articles and white papers you can stay up-to-date with Norton where and when you need it.

Bring us your grinding challenges, we have solutions!

Our Commitment

You be the final judge in performance! We are so confident of the superior performance of our abrasive products, as recommended for specific applications, that we invite in-plant tests against any other brand of abrasive product on the market. Contact your Norton Representative to find out more about our No Risk test policy or visit nortonabrasives.com



Why Tiers Matter

At Norton we believe in delivering right choices that matter. Our abrasives are classified in BEST, BETTER, and GOOD performance/ price tiers to help you choose the right product for your specific application every time.

BEST

Our BEST tier products are designed for the customer who is seeking the highest productivity at the lowest total cost.

BETTER

Dur BETTER tier products provide an excellent blend of performance and price.

GOOD

And, our GOOD tier products promise the highest quality you expect from the Norton name with a low initial price.

If you need help determining the right tier for your specific needs, don't hesitate to contact us directly or reach out to your Norton sales representative.

Go Further

Visit our website at <u>nortonabrasives.com</u> for a more comprehensive outline of products, safety and application information. We continually update it with our most current information.

Connect with us:





METAL FAB CUTTING AND GRINDING

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Easy-to-Follow Page Guide

Key Questions to Simplify Product Selection

Am I in the right section?

- A Product
- **B** Category overview

NDRTDN

SAINT-GOBAIN

- **C** General attributes
- D Correct machine use

How do I narrow choices?

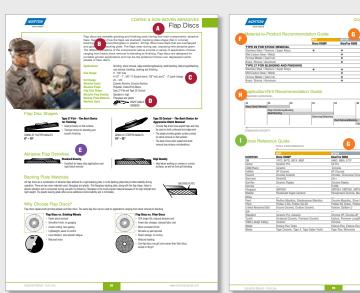
E Product design variations

How do I match my end-user needs?

- **F** Application recommendations
- G Best/Better/Good performance color coding
- H Full application / grit guide

How do I match or upgrade from a competitive product?

Cross reference guide



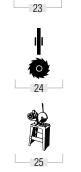
Flap Discs



GENERAL INFORMATION Machine Index and Catalog Navigation



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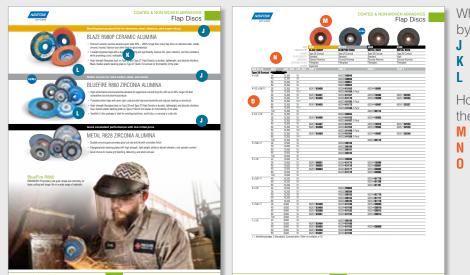




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What are the Leading Products by Tier?

- J Tiers by color-coding: Best, Better, Good K Features and benefits
- L New, improved, and/or expanded offering

How Do I Find the Right Product for the job?

- M Visual identification
- N Key product attributes
- 0 Full specification and product number





GENERAL INFORMATION Safety Basics



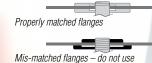
Visit our newly updated safety website for safety guides, safety data sheets, videos and lots of additional safety resources at nortonsga.us/safety

WARNING

Improper use of abrasive products might cause grinding wheel breakage and serious injury. Comply with ANSI B7.1, OSHA and Safety Guide furnished with package. Don't overspeed, abuse, or drop wheel. Always use a guard, personal protective equipment and proper mounting procedures.



Speeds Check machine spindle speed and speed listed on machine against safe maximum operating speed marked on the grinding wheel. Do not overspeed the wheel.





When mounting most grinding wheels, use flanges of equal diameter and bearing surface. For exceptions, see ANSI B7.1.



Safety Gloves Grinding applications are conducted in harsh environments. The use of proper fitting gloves is recommended.



Wheel Guard Always use the wheel guard as supplied by the machine manufacturer, in the proper position.



Do Not Use Damaged Wheel Always check each wheel for cracks or damage before use. Never use a damaged wheel.



Eye/Face Protection Always wear governmentapproved face and eye protection when using abrasive products.



Hearing Protection Use of abrasive products can create elevated sound levels. Hearing protection must be worn where required.



Safety Guides, SDS and Wheel Warning Messages Before using any abrasive materials, READ:

- The Safety Guides
- Wheel Warning Messages
- Safety Data Sheets (SDS)

All Norton products provide information pertaining to safe use. Please take the time to read it carefully. Contact suppliers of the workpiece and abrasive materials for copies of the SDS if one is not readily available. Norton abrasives SDS can be obtained on nortonsga.us/safety



Dust Protection

Exposure to dust generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury.

Use dust capture or local exhaust as stated in the SDS. Wear government-approved respiratory protection and eye and skin protection. Failure to follow this warning can result in serious lung damage and/or physical injury.

This is a general dust warning and does not cover specific situations. For more information, refer to the SDS dust warning provided with your products, and workpiece.

Please see pages 359 - 368 for additional safety information

Metal Fab Cutting and Grinding

when the going gets rough RELY ON NORTON INNOVATION

For stock removal, rough blending, cleaning castings and welds...Norton depressed center wheels are constructed to tackle the demanding work of all material types.



Depressed center wheels may also be referred to as raised hub wheels or by their shape designation of "Type", with Type 27 being the most popular. The depressed center design allows the flange/lock nut to recess within the wheel so that it can be used for various grinding and cutting applications. Depressed center wheels are designed to handle the most severe right angle grinding applications from heavy stock removal to rough blending. More recently, depressed center wheels have been designed to increase the utility of the tool for cut-off applications. While large right angle grinders (7" & 9") have been around for many years, small or mini grinders that handle 4", 4-1/2", 5", and 6" wheels have made this machine, and wheel category, the most popular in power tools.

Applications: Size Range:	Grinding, stock removal, edge chamfering, beveling, weld blending, and cutting-off 2" - 9"
	2 0
Thickness Range:	.040" - 1/4"
Grit Range:	24 – 46 grits for stock removal;
-	60, 80 grits for blending and finishing
Abrasive Grain:	Ceramic Alumina, Diamond, Zirconia Alumina, Aluminum Oxide, Silicon Carbide
Mounting Options:	Plain hole (3/8", 5/8" and 7/8") and mount (5/8"-11)
Shape:	Type 27, Type 28, Type 29
Machine Used:	
	RIGHT ANGLE GRINDER

How to Pick the Right Wheel

DEPRESSED CENTER WHEEL DESCRIPTION CODES							
BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free				
= Aluminum	= Foundry	Stainless	Steel / Metal				
DESCRIPTION CODE DEFI	NITIONS						
BLANK = All Purpose	Wh	ere an excellent blend of cu	t rate and life is needed.				
FC = Fast Cut	Wh	ere fast stock removal is ne	eded, or the application only allows for low-pressure or under-horsepowered grinders.				
HD = Heavy Duty	Trip	le reinforced for the most a	ggressive foundry applications				
INOX/SS = Contaminate	e Free Cor	ntain <0.1% iron, sulfur or c	hlorine for rust-free and corrosion-free results. Will not contaminate stainless steel.				

How to Pick the Right Mount

Most wheel sizes come with a plain hole or a discard mount option. While the plain hole has a small, initial cost advantage, the discard mount can provide a labor cost advantage with the quicker wheel change.



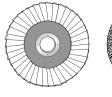
Mini-Mount Hub

Our unique mini-mount hub used on 4-1/2" and 5" depressed center wheels provides up to 30% more wheel life because the hub covers just a small surface area, providing maximum grinding area exposure and usage.

Standard throw-away hub size

Why Choose Depressed Center Wheels?





Depressed Center Wheels vs. Flap Discs or Fiber Discs

- · Up to 5X life over flap discs, less downtime and inventory
- Up to 100X life over fiber discs, less downtime and inventory
- Rigidity for severe operations and high power grinders
- 1/8" wheels can be used for cutting and grinding
- · Can be used to grind inside corners at outer edge of wheel



How To Mount a Depressed Center Wheel: Mounted Hub vs No Hub रे nortonsga.us/7hc5m



Type-To-Application Recommendation Guide

Wheel Type/Thickness Applications



		90° ANGLE	30° ANGLE	15° ANGLE
TYPE 27	Type 27 wheels are essentially straight wheels that have a "depressed center/ raised hub". Different types of fiberglass reinforcement mesh give the product stability for use on the periphery, on the face, or a combination of the two.			
.040", .045", and 1/16" Type 27/42 RightCut	Cutting only, where fast cutting and low kerf loss are desired	•		
3/32" and .125" Type 27/42	For tough cutting and notching applications where stability is important; cutting and cleaning burr-free narrow root pass welds	•		
1/8" Type 27	For multiple applications ranging from cutting-off, notching and light-duty side grinding	•	•	
1/8" Pipe Notcher Type 27	2-1/2 pieces of reinforcement; durable face grinding; root pass grinding without removing pipe material	•	•	
1/8" Type 27 Flexible	For light stock/blending/finishing/polishing		•	
.140" and 1/8" Type 27 Foundry Notchers	Triple-reinforced for grinding steel and dirty/scale-covered castings; removing and cleaning gates and risers	•	•	
1/4" Type 27	For light- to heavy-duty grinding on the bottom/face of the wheel		•	
1/4" Type 27 Foundry Snaggers	Designed for cleaning parting lines, pads and slag		•	
1/4" Type 27 Heavy-Duty Foundry	Triple-reinforced for the most aggressive foundry applications		•	
TYPE 28	Type 28 wheels are constructed with a downward angle built into the grinding section to facilitate a flatter grinding angle. These wheels can only be used on the face and never on the periphery for cutting-off.			
1/4" Type 28	Smooth, gouge-free grinding at shallow angles			٠
TYPE 29	Type 29 wheels are constructed with an upward angle built into the grinding section to provide full face contact for light stock removal and blending operations. These wheels can only be used on the face and never on the periphery for cutting-off.			
1/8" Type 29 Flexible, AVOS	Polishing and blending applications			•

Material/Application-To-Product Recommendation Guide

	BEST	BETTER		GOOD	
	Quantum3	BlueFire	Norton for Aluminum	Gemini	Metal
CUTTING					
Mild Carbon / High Tensile Steel	•	•		•	•
Stainless Steel / Alloys	•	•		•	•
Contaminate Free*		FC/INOX/SS		INOX/SS	
Cast Iron	•			•	
Aluminum / Bronze / Brass			•		
NOTCHING					
Mild Carbon / High Tensile Steel	•	•		•	•
Stainless Steel / Alloys	•	•		INOX/SS	
Contaminate Free*		FC/INOX/SS		♦ INOX/SS	
Cast Iron	•	Foundry		•	
Aluminum / Bronze / Brass			•		
GRINDING					
Mild Carbon / High Tensile Steel	•	•		•	
Stainless Steel / Alloys	•	•		•	
Contaminate Free*	•	FC/INOX/SS		INOX/SS	
Cast Iron		Foundry		•	
Gray Iron	•	Foundry		•	
Aluminum / Bronze / Brass			•		
BLENDING					
Mild Carbon / High Tensile Steel				◆ Flexible	
Stainless Steel / Alloys				◆ Flexible	
Aluminum / Bronze / Brass			•	◆ Flexible	
Fiberglass / Plastic				•	

Typical Steel, Stainless Steel, Cast Iron Products: Angle Iron, Bar Stock, Ductile Pipe, Channel Iron, Decking, Rebar, I-Beams, Rail Steel, Studs, Tubing, and Welds

* For use in nuclear and food industry applications that require contaminant free (<0.1% iron, sulfur or chlorine)



Cross Reference Guides

Type 27 and 28 – 1/8" and 1/4"

	BEST	BETTER		GOOD				BETTER	
NORTON	Quantum3	BlueFire	BlueFire FC/INOX/SS	Gemini	Gemini Fast Cut	Gemini SS	Metal	BlueFire Foundry	Norton ALU
3M	Cubitron II	Silver, High Perform., Green Corps	-	-	-	-	-	-	-
Arc	-	-	-	Predator A24R	-	-	-	-	-
Bullard	TA24S	ZA24R Competitor	ZA24R	A24R	A24N	A46Q	A24R CompetitorC24R	-	AL36N
Camel	-	_	ZA24T	A24R	Ultra A24-N-BF, A24T Super Quickie Cut	WA24S	A24N, R&T Fast CutC24R	-	A30N, Fast Cut
DeWalt	XP Ceramic	XP, HP	-	-	-	HP SS	Metal	-	-
Flexovit	Flexon ZA24P, ZA30T, Flexon ZA20Q	Metalhog, AXT24S	-	High Perform. A24/30T	High Performance A30S, Specialist A30Q & R	Free Grind A30Q	High Perform. C24/30P	Flexon ZA16U	HP Aluminum
Vletabo	M-Calibur	ZA24T	-	A24R & T	A24N	A360	C24N	-	A36M
Pearl	_	-	Z24T	Premium Metal A24S, Redline Max A/WA24S	Premium Metal A24R, Redline Max A/WA24R	WA24R, SRT24	Silver Line A24R & & Silver Line C24S	-	D.A. Series AL24M
Pferd	SG-Elastic Ceramic CO24Q	ZA SGP, ZAT SGP, SG-Elastic	ZA R SGP, Z-SG	A-PS, A-SG	-	A-SG INOX, A-PS INOX	S-SG, Masonry	-	A-SG ALU
Sait	The Ultimate Grind, Saitech Ultimate Perform, Saitech Attacker, Pipeline	Z24R Z-Tech	Stainless	A24R, A24Turbo	A24N	XA24Q	A24T, C24N	CA24R - Foundry	A46N-ALU
Tyrolit	-	ZA24P- BFX	ZA24N-BFX	A30S & Q-BFX	A30R-BFX	A30-BF INOX	A30-BF	ZZA24R-BFX	A36N-BFX WA46-BF
Walter	-	Allsteel XX, Allsteel	Double-X	HP	-	Stainless	-	-	A30 Zip ALU
Weiler	Tiger Ceramic	Tiger Zirc, Tiger LL	Tiger Inox	Wolverine A24R	-	-	Wolverine A24N	-	Tiger ALU 24F

Type 27 - Flexible 1/8"

	GOOD
NORTON	Gemini Flexible
Bullard	Flexlite AC
Camel	FGF, Special Wheel
Flexovit	Flexcel
Metabo	Z-Plus
Pearl	Flexible AC
Pferd	SG-Flex
Sait	Challenger II
Walter	Flexcut







QUANTUM3 CERAMIC ALUMINA

- 100% next-generation, uniquely-shaped, ceramic alumina abrasive grain and tough new bond system result in 5-6 times the life of aluminum oxide wheels and up to 100% increase in performance and life over competitive ceramic wheels
- Significantly increase production, for the lowest total grinding cost of any wheel in the market place today
- Better operator control, improved comfort, and exceptional finished part quality with a more robust, sharper, yet smoother cutting action; wheels don't grab or dig

Best for metal plate, pipe, tubing, cast iron, carbon and mild steel, foundry and welding applications, and ceramics

DIALAST DIAMOND WHEELS

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for
 exceptional wheel life; less blade changes reduce downtime and labor costs
- Environmentally friendly design generates minimal dust for less clean-up and safer working conditions



Better choice for stainless steel, carbon steel, alloys and gray iron

BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- A blend of the most advanced zirconia alumina and premium aluminum oxide abrasives delivers 2 to 3 times the life of aluminum oxide wheels
- · Broad utility; from light-to heavy-pressure applications
- · Engineered specifically to deliver fast cut rate; excellent blend of performance and price









Better choice for aluminum

NORTON FOR ALUMINUM

- Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- Non-loading, specially designed bond, allowing fast, free-cutting with long- lasting performance
- · Contaminant free, no need for waxes or lubricants



Good choice for steel and ferrous metals as well as specialty applications

GEMINI ALUMINUM OXIDE

- Upgraded with a new premium aluminum oxide grain for 15% faster cut rate
- High-performance bond and wheel hardness are designed for fast cut and up to 60% more life and metal removed per wheel
- Good choice for grinding 400 series stainless and hard and soft carbon steel applications including heavy stock removal, weld repairs, flashing, multi-pass welding for pipe fitting, and notching



Good choice for steel/ferrous metal applications with low initial price

METAL ALUMINUM OXIDE

- · Durable bond and wheel hardness are designed to provide an good mix of cut rate and life
- Good choice when low initial price is needed for small jobs or newer operators
- Metal (Aluminum Oxide) engineered for all steel/ferrous materials



			HORZON	
		TIER:	BEST	GOOD
		TRADENAME:		GEMINI
		SHAPE:		Type 27
		ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS
		MATLNIAL.	STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
1/8" (5/32") - Pipe Notcl	hing – Type 27	-		
4-1/2 x 1/8 (5/32) x 5/8-11	13,580	10	4	662533 70272
4-1/2 x 1/8 (5/32) x 7/8	13,580	25		662533 70271
5 x 1/8 (5/32) x 5/8-11	12,225	10		662533 70273
5 x 1/8 (5/32) x 7/8	12,225	25		662528 42038
6 x 1/8 (5/32) x 5/8-11	10,185	10		662528 41193
7 x 1/8 (5/32) x 5/8-11	8,600	10	662529 39184	662533 70274
9 x 1/8 (5/32) x 5/8-11	6,600	10	662530 49066	662533 70275
Pipe Notchers are to be used	d for cutting/not	ching only.		

See Type 27 .040" – 1/4" Foundry, Type 28, Type 27 Flexible, and Type 29 Blending Wheels at the end of this section.

				Eductive Com		
		TIER:		BETTER	GOOD	GOOD
		TRADENAME:		BLUEFIRE	GEMINI Turco 07	METAL
		SHAPE:	Туре 27	Type 27 Ziroonia Alumina /	Type 27	Type 27
		ABRASIVE:		Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS
			STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.		PART #	PART #	PART #
1/8" – Cutting / Notel	hing / Light Gri	inding – Type 27	The second construction of the second s			
4 x 1/8 x 3/8	15,280	25		662528 43178	662528 42016	•
4 x 1/8 x 5/8	15,280	25			662528 42017	662528 42014
4-1/2 x 1/8 x 5/8-11	13,580	10	662528 39423	662528 43211	662528 43590	662528 43609
	13,580	10		66252843191 FC/INOX/SS		
4-1/2 x 1/8 x 7/8	13,580	25	662528 39424	662528 43212	662528 43591	662528 43611
	13,580	25		66252843190 FC/INOX/SS		
5 x 1/8 x 5/8-11	12,225	10	662528 39425	662528 43215		662528 43615
5 x 1/8 x 7/8	12,225	25	662528 39426	662528 43216	662528 43596	662528 43616
	12,225	25		66252843194 FC/INOX/SS		
6 x 1/8 x 5/8-11	10,185	10	662528 39427	66252843199 FC/INOX/SS	662528 33965	
6 x 1/8 x 7/8	10,185	20	662528 39428	662528 43202	662528 01864	
	10,185	20		66252843198 FC/INOX/SS		
7 x 1/8 x 5/8-11	8,600	10	662528 39429	662528 43233	662529 39259	076607 02678
	8,600	10		66252843183 FC/INOX/SS		
7 x 1/8 x 7/8	8,600	20	662528 39430	662528 43234	662529 39207	
	8,600	25*				076607 75956 5-Pk
9 x 1/8 x 5/8-11	6,600	10	662528 39431	662528 43244	662530 48983	
	6,600	10		66252843187 FC/INOX/SS		
9 x 1/8 x 7/8	6,600	20	662528 39432	662528 43245	662530 48994	

* 5-wheel Job Packs; wheels are packed 5 wheels/Pack, with 5 Job Packs/carton. Order per each wheel in standard package quantities of 25. Order in multiples of 25.

DEPRESSED CENTER WHEEL DESCRIPTION CODES								
BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free					
= Aluminum	= Foundry	Stainless	Steel / Metal					



			155	aurfire	GEMINI	METAL
		TIFR	BEST	BETTER	GOOD	GOOD
	T		QUANTUM3	BLUEFIRE	GEMINI	METAL
			Type 27	Type 27	Type 27	Type 27
			Ceramic Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS
		IVIATERIAL:	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
	MAX.	STD.				ALL
SIZE (D x T x H)	RPM	PKG.	PART #	PART #	PART #	PART #
1/4" – Grinding – Type		a dia dia dia dia dia dia dia dia dia di	3			
3 x 1/4 x 3/8	18,000	25			662528 42179	
4 x 1/4 x 3/8	15,280	25	662533 71180	662528 43179	662528 42018	
4 x 1/4 x 5/8	15,280	25	662533 71181	662528 43177		662528 42011
	15,280	25			662528 42019	
4-1/2 x 1/4 x 5/8-11	13,580	10	662533 70793	662528 43213	662528 43593	662528 43605
	13,580	10		66252843193 FC/INOX/SS	662528 43585 FC	
	13,580	40				662528 19559
4-1/2 x 1/4 x 7/8	13,580	25	662533 70794	662528 43214	662528 43594	662528 43607
	13,580	25		66252843192 FC/INOX/SS	662528 43584 FC	
	13,580	25			662528 42033 INOX/SS	
	13,580	50				662528 36796
5 x 1/4 x 5/8-11	12,225	10	662533 70795	662528 43217	662528 43597	662528 43613
	12,225	10		662528 43197 FC/INOX/SS		
5 x 1/4 x 7/8	12,225	25	662533 70796	662528 43218	662528 43598	662528 43614
	12,225	25			662528 42040 INOX/SS	
6 x 1/4 x 5/8-11	10,185	10	662533 70797	662528 43224	662528 32390	
6 x 1/4 x 7/8	10,185	20	662533 70798	662528 43203	662528 01865	
7 x 1/4 x 5/8-11	8,600	10	662533 70799	662528 43235	662529 40147 FC	662529 12633
	8,600	10		662528 43185 FC/INOX/SS	662529 40148	
7 x 1/4 x 7/8	8,600	20	662533 70800	662528 43236	662529 40098	
	8,600	25*				076607 75936 5-Pk
9 x 1/4 x 5/8-11	6,600	10	662533 70801	662528 43246	662530 49105 FC	
	6,600	10			662530 49104	
	6,600	25*				076607 75938 5-Pk
9 x 1/4 x 7/8	6,600	20	662533 70802	662528 43247	662530 49077 FC	
	6,600	20		662528 43188 FC/INOX/SS	662530 48991	

* 5-wheel Job Packs; wheels are packed 5 wheels/Pack. with 5 Job Packs/carton. Order per each wheel in standard package quantities of 25. Order in multiples of 25.

See 1/4 inch thick Type 27 Foundry and Type 28 Wheels on the next page.



SIZE (D x T x H)

4-1/2 x 1/4 x 7/8

4-1/2 x 1/4 x 5/8-11

4 x 1/4 x 5/8

5 x 1/4 x 7/8

6 x 1/4 x 7/8

7 x 1/4 x 7/8

7 x 1/4 x 5/8 - 11

9 x 1/4 x 5/8-11

4-1/2 x 1/8 x 7/8

4-1/2 x 1/8 x 5/8-11



		TIER:	BEST	BEST	BEST	BETTER	GOOD
	TR	RADENAME:	QUANTUM3	DIALAST	DIALAST	BLUEFIRE	GEMINI
		SHAPE:	Type 28	Type 29	Reversible	Type 28	Type 28
		ABRASIVE:	Ceramic Alumina	Diamond	Diamond	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS	STAINLESS
			STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
1/4" – Grinding – Typ	e 28						
7 x 1/4 x 5/8-11	8,600	10	662533 70803			662528 43229	662529 40149 🗶
7 x 1/4 x 7/8	8,600	20					662529 40095
9 x 1/4 x 5/8-11	6,600	10	662533 70804			662528 43237	662530 49106
9 x 1/4 x 7/8	6,600	20	662533 70805				662530 49081
Light Grinding – Type							
4-1/2 x 5/8-11	13,600	1		662533 70009			W
5 x 5/8-11	12,225	1		662533 70010			
6 x 5/8-11	10,200	1		662533 70011			
7 x 5/8-11	8,600	1		662533 70012			
1/4" – Grinding – Rev		ding Disc					A STREET
4-1/2 x 1/4 x 5/8-11	13,600	1			662533 70019		W
7 x 1/4 x 5/8-11	8,600	1			662533 70020		

					alustics
			Think of the		
			BEST	BEST	BETTER
	1R/	ADENAME:	<u> </u>	DIALAST	BLUEFIRE
		SHAPE:	Type 27	Type 27	Type 27
	1	ABRASIVE:	Ceramic Alumina	Diamond	Zirconia Alumina/ Silicon Carbide
	1	MATERIAL:	FOUNDRY	FOUNDRY	FOUNDRY
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
.140", 1/8" - Cutting	/ Notching /	Lt. Grindi	ng – Type 27 🔜		1
4-1/2 x 1/8 x 5/8-11	13,580	10			662528 43206
4-1/2 x 1/8 x 7/8	13,580	25			662528 43204
7 x .140 x 5/8-11	8,600	1		662533 70014	
7 x 1/8 x 5/8-11	8,600	10			662528 43232
7 x 1/8 x 7/8	8,600	20			662529 15526
9 x .140 x 5/8-11	6,600	1		662533 70015	
9 x 1/8 x 5/8-11	6,600	10			662528 43240
9 x 1/8 x 7/8	6,600	20			662528 43238
1/4" - Grinding - Ty	pe 27 📖		23		17 - T
4 x 1/4 x 3/8	15,280	25			662528 43181
4 x 1/4 x 5/8	15,280	25			662528 43180
4-1/2 x 1/4 x 5/8-11	13,580	10			662528 43207
4-1/2 x 1/4 x 7/8	13,580	25			662528 43205
7 x 1/4 x 5/8-11	8,600	10			662528 43231
7 x 1/4 x 7/8	8,600	20			662528 43230
9 x 1/4 x 5/8-11	6,600	10	662533 70849 HD		
	6,600	10			662528 43261 HD
9 x 1/4 x 7/8	6,600	20	662533 70848 HD		
	6,600	20			662528 43260 HD
All Norton foundry whee	ls are designe	d and reinfo	prced to withstand the most aggre	ssive foundry applications.	

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DEPRESSED CENTER W	HEEL DESCRIPTION CODES		
BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free
= Aluminum	= Foundry	Stainless	Steel / Metal



Blending Wheels

Gemini Flexible

Type 27 wheel features a unique pattern with square grooves that prevent loading and promote cooling, this Gemini Flexible grinding wheel polishes your aluminum, hard carbon steel and soft carbon steel projects effectively and efficiently without gouging. 7/8 arbor wheels are sold with a back plate included for safety.

The Gemini Type 29 blending wheel is ideal for larger blending jobs and has a raised bump surface pattern to promote cool grinding, ideal for aluminum. The shape allows for a flatter grind and higher contact area. Can also be used to blend stainless, hard, and soft carbon steel.

				•	
				GOOD	GOOD
		TRA	DENAME:	GEMINI FLEXIBLE	GEMINI FLEXIBLE
			SHAPE:	Type 27	Type 29
		A	BRASIVE:	Aluminum Oxide	Aluminum Oxide
				ALUMINUM	ALUMINUM
		N	IATERIAL:		STAINLESS
				STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	GRIT	PART #	PART #
1/8", 1/4" – Blendir	ng – Type 27	and 29		Carena construction construction	
2 x 1/8 x 3/8	30,560	25	60	662528 35632 *	
4 x 1/8 x 5/8	15,280	20	36	662435 29721 #	
4-1/2 x 1/8 x 5/8-11	12,000	10	36		662528 42203
4-1/2 x 1/8 x 7/8	12,000	25	36	662528 30424 #	662528 42204
5 x 1/8 x 7/8	12,225	25	36		662528 42205
7 x 1/8 x 5/8-11	8,600	10	36	662529 39024	662529 17052
*Norton Motal E who	la par diaplau	nooly E dian	lau paaka r	ar standard paskaga	

*Norton Metal, 5 wheels per display pack; 5 display packs per standard package.

These wheels are packed 20 per box, and must be used with this specific back plate. Two back plates are included in each box.



Depressed Center Adapter Kit

This reusable adapter kit contains everything you need to mount depressed center wheels and saucers with 7/8" center holes on to portable right angle or vertical shaft grinders. Adapter hubs are threaded for mounting on to standard 5/8"-11 NCRH spindles.

KIT NO.	WHEEL DIAMETER	WHEEL THICKNESS	PART #	STD. PKG.	
114	7" thru 9"	1/16" thru 1/4"	076607 89275	1	

DEPRESSED CENTER W	HEEL DESCRIPTION CO	DES		
BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free	
Aluminum	= Foundry	Stainless	Steel / Metal	

Cut-off Wheels

no short cuts taken here SATISFY ALL YOUR CUT-OFF REQUIREMENTS

From small diameter portable cut-off wheels to large diameter foundry cut-off wheels; from portable high-speed gas saw wheels to precision toolroom and Metlab wheels, our Norton offering encompasses the broadest range of applications.





The Norton small diameter cut-off wheel line consists of Type 01/41 straight and Type 27/42 depressed center cut-off wheels from 1-1/2" to 9" diameters. These wheels come in ultra thin .035" for quick burn-free and burr-free cutting to .125" for more durable applications. All are reinforced for the demanding nature of portable cut-off.

Applications: Size Range: Thickness Range: Abrasive Grain:

Shape: Machine Used: Cutting sheet metal, cutting pipe, and metal fabrication 1-1/2" - 9" diameter .035", .040", .045", .050", .060", 1/16", .090", 3/32" and .125" Ceramic Alumina / Zirconia Alumina, Zirconia Alumina / Aluminum Oxide, Aluminum Oxide, Silicon Carbide, Diamond Type 01/41 Straight and Type 27/42 Depressed Center

(



PORTABLE R CUT-OFF TOOL G

RIGHT ANGLE DRILL GRINDER

How to Pick the Right Wheel Type

DEPRESSED CENTER WH	IEEL DESCRIPTION CODES			
BLANK = All Purpose	INOX/SS = Contaminant Free	LL = Long Life	1-2-3 = Cutting/Notching/Grinding	
= Aluminum	= Stainless	Steel / Metal		

DESCRIPTION CODE DEFINITIONS	
BLANK = All Purpose	Where an excellent blend of cut rate and life is needed
ALU = Aluminum	Specially formulated bond for reduced loading and surface contamination while cutting aluminum and soft materials
INOX/SS = Contaminate Free	Contain <0.1% iron, sulfur or chlorine for rust-free and corrosion-free results. Will not contaminate stainless steel
LL = Long Life	Where durability is needed due to severe application, and when horsepower of the grinder allows for heavy pressure
Right = Cutting-off Only	RightCut wheels for cutting only, provide noticeably longer life and faster cut rate versus competitive wheels, and less pressure is required for first cut
1-2-3 = Cutting/Notching/Grinding	Can be used in cutting, notching and grinding applications

Type-to-Application Recommendation Guide

Wheel Type/Thickness	Applications	
	Type 01/41 straight cut-off wheels are designed for portable cut-off tool applications. All are supplied with full fiberglass reinforcing.	Fritze
.035, .040, .060, and 1/16	Where fast cutting and low kerf loss are desired	•
125	For tough cutting and notching applications where stability is important	•
	Type 01/41 RightCut straight cut-off wheels are designed for use on right angle grinder cut-off applications. All are supplied with full fiberglass reinforcing.	90° angle
.035, 040, .045, .050, 1/16	Where fast cutting and low kerf loss are desired	•
3/32	For tough cutting and notching applications where stability is important	•
TYPE 27/42 RIGHTCUT	Type 27/42 RightCut depressed center cut-off wheels are designed for use on right angle grinder cut-off applications. Their depressed center shape provides a recess for the hub, which allows flush cutting. All are supplied with full fiberglass reinforcing.	90° angle
.040, .045, 1/16	Where fast cutting and low kerf loss are desired	•
3/32, .125	For tough cutting and notching applications where stability is important	



Material-To-Product Recommendation Guide

	BEST	BETTER	GOOD	
	Quantum3	BlueFire	Gemini	Metal
Mild Carbon / High Tensile Steel	•	•		•
Stainless Steel / Alloys	•	•	•	
Contaminate Free*			INOX/SS	
Cast Iron	•	•	•	

* For use in nuclear and food industry applications that require contaminant free (<0.1% iron, sulfur or chlorine)

Cross Reference Guides

Type 01/41 .035" - .125" Reinforced Cut-off Wheels for Portable Cut-off Tools

TOTAL PERFORMANCE

TOTAL PERFORMANCE



INITIAL PRICE

	BEST	BETTER	GOOD		
NORTON	NorZon Plus	BlueFire	Gemini Free Cut	Gemini Long Life	Metal
Bullard		ZA46T, ZA60T	TA36T	TA46T, TA60T	A36T, A60T Comp.
Camel		ZA60-TBF	A36 RBF	A60 RBF	Fast Cut RBF
DeWalt	XP extended performance	_	HP metal	_	Metal
Flexovit	Flexon Fast Cut A46, 60	_	High Perf Fast Grind A36	High Perf Fast Cut A36, 46, 60	_
Metabo		_	Original Slicer	Original Slicer LL	
Pearl		SRT, Zirconia	<u> </u>	Premium	Silver Line
Pferd		—		_	PSF-A
Sait	Saittech	—	A60S	A24R, A36T, A60T	—
Walter		_	A24 ZIP	A60 ZIP	_
Weiler	Tiger Ceramic	Tiger Zirc		Tiger	Wolverine A60T, A36T

Type 01/41 and Type 27/42 .035" - .125" Reinforced Cut-off Wheels for Right Angle Grinders



INITIAL PRICE

SPECIALTY	Y	
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	BEST		BETTER	GOOD			BETTER	GOOD
NORTON	Quantum3 .045"	Quantum3 1/16"	BlueFire	Gemini Free Cut	Gemini	Metal	Norton For Aluminum	Gemini INOX/SS
3M	_	Cubitron II .045	Silver	—	—	_	_	_
Bullard	—	—	ZA60T	SGA60U	TA46T, TA60T, TA60U	A46T, A60T Comp.	AL46N	—
Camel	—	_	ZA Quickie Cut	A36-S-BF	Super Quickie Cut	Quickie Cut	A46 Quickie Cut	A60-T-BF, WA60R, Quickie Cut
DeWalt	XP Ceramic 0.040	XP Ceramic 1/16", XP Ceramic 0.045	XP	—	HP	Metal		_
Flexovit	_	—		Razorblade A60SST	Razorblade A24T, 30V, 36T		Razorblade A30Q	_
Klingspor	—	—			A960TZ, Kronenflex edge	A46TZ	_	—
Metabo	Slicer Limited Edition .040	M-Calibur 1/16	Super Slicer	—	Slicer-Plus, Original Slicer LL	Original Slicer	—	—
Pearl	—	—	Redline Max Slimcut	—	Slimcut	Slimcut Pro-V, Silverline	—	_
Pferd	SG Elastic, SG Plus 1mm	SG Plus 1.6, SG Elastic 1.6		—	—	PS-Forte	SG-ALU	—
Sait	_	The Ultimate Ceramic Cutoff .045, Saitech	Z-tech	SAIT.M.X	Sait .045, The Ultimate Cutoff	_	A46N	XA46R
Tyrolit		Cerabond		_	_	_	_	
Walter	Zip One	—	Zip+ Xtra	A-30-ZIP	A-60-ZIP	_	A-60-ZIP-ALU	A60-SS-ZIP
Weiler	Tiger Zirc Ultra Cut 1mm, Tiger INOX UltraCut 1mm	Tiger Ceramic .045, Tiger Zirc .045, Tiger INOX .045	_	_	Tiger	Wolverine	_	_



SAFFT

Dangerous Pairing: Die Grinders and Cut-off Wheels

While die grinders and cut-off tools may look similar, they are not interchangeable. Small diameter cut-off wheels can be used only on portable cut-off tools. Several crucial differences exist between the two handheld machines.

- Small diameter cut-off wheels must be used on portable cut-off tools with guards for the safety of the operator and bystanders. Also, portable cut-off tool guards prevent use of an oversized wheel.
- flanges on portable cut-off tools as described in the national safety standard for abrasive wheels, ANSI B7.1. Die grinders make use of a collet for mounting.
- These cut-off wheels must be mounted between proper All cut-off wheels must be used at or below their maximum operating speed, marked clearly on the side of the wheel. Die grinders operate above cut-off wheel speeds. Excessive speed can result in breakage and serious personal injury.



TFCH TIP

Measure Your Wheel's Thickness

Why should you measure your wheel thickness? Many competitors market their wheels as .045", but they are truly thicker. Norton Quantum3 RightCut wheels are true to size so you can pick the right wheel for the job whether you need precision cutting or rugged durability. Compare our 1/16" Quantum3 with competitive 0.045" ceramic cut-off wheels and you will see the longest life and fastest cut on the market.



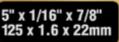
It is the user's responsibility to refer to and comply with ANSI B7.1

Norton Quantum3 RightCut Wheels

The Norton Quantum3 RightCut is our top tier cut-off wheel, available in 0.045" and 1/16" thickness. If you want speed of cut and work on thin or hollow materials, the 0.045" will get you there with comfort. If you are cutting thicker materials and life of the wheel is important, then the 1/16" is ideal. Whatever your pick is, experience the extra-smooth cutting action, thanks to our premium ceramic grain.

Norton Quantum3 RightCut: 0.045" versus 1/16"

How to match the wheel to the application



6" (1)

16" x 7/8" .6 x 22mm	5" x .045" x 7/8" 125 x 1.2 x 22mm
EST LIFE)	0.045" (FAST CUTTING)
	Ceramic

	.,	
Abrasive:	Ceramic	Ceramic
Target application:	Thick metals and/or aggressive-style cutting	Thin metals and/or light-style cutting
Strengths:	Long lasting, durable, aggressive easy feel, versatile across applications and metals	Fast cutting, smooth easy feel, precise and maneuverable, reduced burrs

PRODUCT

THE R. P. LEWIS CO., NAMES OF CO., NAMES OF











Best choice for stainless steel and carbon steel applications

QUANTUM3 CERAMIC ALUMINA

- 100% advanced ceramic alumina grain with a special shape for comfort and performance guaranteeing 7X the life of aluminum oxide wheels and 3X the life of zirconia alumina wheels
- · Unique bond system prevents premature grain release maximizing wheel life
- · Available in type 01 straight and type 27 depressed center cut-off wheels from 4-1/2 inch to 6 inch diameters

Best for metal plate, pipe, tubing, cast iron, carbon and mild steel, foundry and welding applications, and ceramics

DIALAST DIAMOND WHEELS

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for
 exceptional wheel life; less blade changes reduces downtime and labor costs
- · Environmentally-friendly grinding for minimal dust, less clean-up and safer working conditions

Better choice for stainless steel, carbon steel, alloys and gray iron

BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- A blend of the most advanced zirconia alumina and premium aluminum oxide abrasives delivers 2 to 3 times the life of aluminum oxide wheels
- Ultra-thin side reinforcing for maximum cut rate with minimum kerf loss; ideal when precise, thin cut is desired
- · Broad utility from light-to heavy-pressure applications

Better choice for aluminum

NORTON FOR ALUMINUM

- · Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- · Non-loading, specially designed bond, allowing fast, free-cutting with long- lasting performance
- · Contaminant free, no need for waxes or lubricants



Good, versatile choice for steel and ferrous metals

GEMINI ALUMINUM OXIDE

- · Quality aluminum oxide for consistent performance at an economical price
- · Designed for portable cut-off tool applications where a fast cut and minimum material loss are desired
- · Durable bond designed for fast cut while retaining excellent wheel life



Good choice for grinding alloys, metals, steels, and ferrous metals

METAL ALUMINUM OXIDE

- · Quality aluminum oxide abrasive for quick cutting action
- · Resin bond provides free cutting action with long life
- · Good choice when low initial price is needed for small jobs or newer operators



		TIER:	BEST	BETTER	GOOD	E00D
		TRADENAME:	NORZON PLUS	BLUEFIRE	GEMINI	METAL
		SHAPE:	Type 01/41	Туре 01/41	Type 01/41	Туре 01/41
		ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS
			STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
.035", .040", .060", 1			-off			P
2 x .035 x 1/8	30,560	25			662434 11392	
2 x .035 x 1/4	30,560	25			662434 11393	
2 x .035 x 3/8	30,560	25			662434 11394	
2 x 1/16 x 1/4	30,560	25			662434 11395	
2 x 1/16 x 3/8	30,560	25			662434 11396	
2 x .125 x 1/4	30,560	25			662434 11402	
2 x .125 x 3/8	30,560	25			662434 11403	
2-1/2 x 1/16 x 1/4	30,560	25			662435 10640	
2-1/2 x 1/16 x 3/8	30,560	25			662435 10641	
3 x .035 x 1/4	25,465	25	662435 10668		662435 10627	
3 x .035 x 3/8	25,465	25	662435 10669	662528 43174	662435 10628	076607 89451
3 x 1/16 x 1/4	25,465	25	662435 10670		662435 10645	
3 x 1/16 x 3/8	25,465	25	662435 10671	662528 43175	662435 10647	662528 35553
3 x .125 x 1/4	25,465	25			662435 10650	
3 x .125 x 3/8	25,465	25	662435 10673		662435 10651	
4 x .035 x 1/4	19,100	25			662435 10629	
4 x .035 x 3/8	19,100	25	662435 10675	662528 43173	662435 10630	076607 89453
4 x 1/16 x 1/4	19,100	25			662435 10654	
4 x 1/16 x 3/8	19,100	25	662435 10677	662528 43171	662435 10655	
4 x .125 x 1/4	19,100	25			662435 10658	
4 x .125 x 3/8	19,100	25	662435 10680	662528 43172	662435 10659	



	-		
VORTON		1217	
	-	-	ł
	P		
	ų		-
-	- 11		

SIZE (D x T x H)

4-1/2 x .045 x 7/8

5 x .045 x 7/8

6 x .045 x 7/8

.045" Right Angle Cut-Off Type 01/41 🚥

Drill-Mount Mandrel

MAX. RPM STD. PKG.

25

25

25

13,580

12,225

10,185

Used for mounting 2" and 3" x 3/8" hole cut-off wheels on to a drill

DESCRIPTION	STD. PKG.	PART #	
Drill-Mount Mandrel	1	076607 47769	نيا ا

CUT-OFF WHEEL DESCRIPTIO	IN CODES
BLANK = All Purpose	INOX/SS = Conta
= Stainless	= Steel / Meta

ntaminant Free	LL = Long Life
tal	= Aluminum

1-2-3 = Cutting/Notching/Grinding



						cine and	METAL
			56 O =				
		TIED.	BEST	BEST	BETTER	GOOD	GOOD
			OUANTUM3	DIALAST		GEMINI	METAL
	TE	RADENAME:	RIGHTCUT	RIGHTCUT	BLUEFIRE RIGHTCUT	RIGHTCUT	RIGHTCUT
Dialat		SHAPE:	Туре 01/41	Type 01/41	Туре 01/41	Type 01/41	Type 01/41
nic///		ABRASIVE:	Ceramic Alumina	Diamond	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS	STAINLESS
		IVIATERIAL:	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
017E (D T 11)	MAX.	STD.	DADT #	DADT #	DADT #	DADT #	PART #
SIZE (D x T x H)	RPM	PKG.	PART #	PART # ut Cut-off	PART #	PART #	PART #
.035", .040", .045", .0 4 x .040 x 5/8	ט", ו/וט , 15.280	, and 3/32 °° 25	Type 01/41 – Kighto	ut cut-ott			076607 01616
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4 x 3/32 x 5/8	15,280	25				662435 27955	
4 x 3/32 x 3/8 4-1/2 x .040 x 7/8	13,280	25				00243327933	076607 01617
4-1/2 X .040 X 7/0	13,580	250+					662528 40001
4-1/2 x .045 x 7/8	13,580	25	662528 38454				00202040001
+ 1/2 X .0+3 X 1/0	13,580	25	00202000404			662528 41997 INOX/SS	
	13,580	250+				662528 41213	
4-1/2 x .050 x 7/8	13,580	1		662533 70016		00202011210	
4-1/2 x 1/16 x 7/8	13.580	25	662528 38455	002000.0010	662528 43208		
4-1/2 x 3/32 x 7/8	13,580	25				662528 23599	
5 x .040 x 7/8	12,225	25					076607 01618
5 x .045 x 7/8	12,225	25	662528 38460			662528 23603	
	12,225	250+				662528 41214	
5 x .050 x 7/8	12,225	1		662533 70017			
5 x 1/16 x 7/8	12,225	25	662528 38462		662528 43209		
5 x 3/32 x 7/8	12,225	25				662528 23600	
6 x .040 x 7/8	10,185	25					076607 02757
6 x .045 x 7/8	10,185	25				662528 23604	
	10,185	25				662528 41999 INOX/SS	
	10,185	250+				662528 41215	
6 x .050 x 7/8	10,185	1		662533 70018			
6 x 1/16 x 7/8	10,185	25	662528 38465		662528 43210		
6 x 3/32 x 7/8	10,185	25				662528 23601	
7 x .045 x 7/8	8,600	25				662528 32323	
	8,600	20				662528 42000 INOX/SS	
7 x 1/16 x 7/8	8,600	1		701846 94055			
9 x .060 x 7/8	6,600	1		701846 94056			

RightCut wheels are to be used for cutting only

+ Bulk packed 250 Wheels/carton; 5 inner boxes of 50 wheels each. Order in multiples of 250 wheels.



How To Convert An Angle Grinder for Cut Off Wheels **youtu.be/AMue0p1Gjqo**

CUT-OFF WHEEL DESCRIPTION	CODES			
BLANK = All Purpose	INOX/SS = Contaminant Free	LL = Long Life	1-2-3 = Cutting/Notching/Grinding	
Stainless	Steel / Metal	Aluminum		



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FIRADE/MAR QUANTUMS BLUEFIRE NURTOR FOR Type 27/42 Upe 27/42 Upe 27/42 SHAPE Upe 27/42 Upe 27/42 Upe 27/42 Upe 27/42 Upe 27/42 ABRANCE Ceramic Aluminal Aluminaun Oxide Aluminaun Oxide				P. C.		ANN TO			
FIRADE/MAR QUANTUMS BLUEFIRE NURTOR FOR Type 27/42 Upe 27/42 Upe 27/42 SHAPE Upe 27/42 Upe 27/42 Upe 27/42 Upe 27/42 Upe 27/42 ABRANCE Ceramic Aluminal Aluminaun Oxide Aluminaun Oxide									Sector.
FIRADELAME QUANTUMS BLUEFIRE NURTOR FOR Type 27/42 Type 27/42 Type 27/42 SHAPE Type 27/42 Type 27/42 Type 27/42 Type 27/42 Type 27/42 ABRANCE Ceramic Aluminal Aluminum Oxide Aluminum Oxide Alumi				00				00	1
FIRADELAME QUANTUMS BLUEFIRE NURTOR FOR Type 27/42 Type 27/42 Type 27/42 SHAPE Type 27/42 Type 27/42 Type 27/42 Type 27/42 Type 27/42 ABRANCE Ceramic Aluminal Aluminum Oxide Aluminum Oxide Alumi			TIED.	PEST	DETTED		COOD	COOD	1.13
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AddBM/L Ceffante Aduminant Oxide Aduminant Oxide Aduminant Oxide Aduminant Oxide MATERIAL STAILLESS STAILESS STAILESS STAIL						Type 27/42	Type 27/42	Type 27/42	
STEEL/METAL STEEL/METAL ALUMINUM STEEL/METAL PART # 040, 045, 1/16" - RightCat Left-off - Type 27/2 PART # PA						Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	
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These wheels are to be used for cutting only.									

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These wheels are to be used for cutting only.

CUT-OFF WHEEL DESCRIPTION CODES						
BLANK = All Purpose	INOX/SS = Contaminant Free	LL = Long Life	1-2-3 = Cutting/Notching/Grinding			
Stainless	Steel / Metal	= Aluminum				



CUT-OFF WHEELS Chop Saw Reinforced Cut-off



A chop saw is a light, low-horsepower portable machine. Although very similar to a compound miter saw, it is designed for cutting denser materials, like metal bar, tubing or pipe. Chop saw cut-off wheels are designed specifically for this machine with finer grit, softer grades, and reinforcement layers that match the application.

Applications:

Size Range: Thickness Range: Abrasive Grain: Shape: Reinforcement Type: Machine Used:

Cutting small-diameter metal pieces, bar stock, metal pipe, tubing, decking, cable, drywall studs, and metal plate dimensioning 10" - 16" diameter 3/32" and 7/64" Zirconia Alumina / Aluminum Oxide Blend, Aluminum Oxide, and Diamond Type 01/41 Straight Side reinforced, centrally reinforced



Cross Reference Guide

	TOTAL PERFO	RMANCE		SPEC	SPECIALTY			
	BETTER			GOOD			GOOD	
NORTON	BlueFire Free Cut	BlueFire Rapid Cut	BlueFire Long Life	Gemini Free Cut	Gemini Rapid Cut	Gemini Long Life	Stud Cutter	Norton Aluminum
Astromax	737 FC	_	_	733,758	742, 764	733+, 744	_	_
BMC	_		_	Westside A36P	_	_	_	_
Bullard	ZA36T	_	—	TA36T A46T The Competitor	A36R The Competitor	A36R Ironmaster	A46T Studmaster	AL36R
Camel	_		ZA24-S	A36-P, WA36-P	_	A36-S	A30-R Mr. Stud	A30-N
Dewalt			ХР	GP, Stainless Fabrication		_	Stud Cutting	
Flexovit		_		A30R Fast Cut A30-Q Free Cut	_	A30S Long Life	A30T Drywall Stud	
Makita	_	_	_	_	General Purpose, A-93859-5	—	_	—
Pearl	SRT36	—	_	A36P Premium, A36S, A36T	A30P Silver Line	—	A46S Stud Cutting	—
Pferd				A 36 K SG CHOP	PSF CHOP		A 36 K SG- STUD	
Sait	Saitech Steel Worker	Z-tech		EZ-Chop	EZ-Chop Attacker	Iron Worker	Stud King	Aluminum
Walter	_	_	_	_	A-30	A-30-HC+	_	A30-ALU

Application-to-Product Recommendation Guide

Wheel Type/Reinforcement

TYPE 01/41 STRAIGHT SIDE-REINFORCED Side-reinforced wheels have two full layers of reinforcing and are designed for a fast cut and the most aggressive applications. All Purpose, Free Cut, and Long Life are side reinforced.

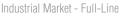


TYPE 01/41 STRAIGHT CENTRALLY-REINFORCED CUT-OFF WHEEL

Centrally-reinforced wheels have a single layer of reinforcing with exposed rough sides for free-cutting, non-binding applications where minimal burr and burn are the key requirements. Rapid Cut wheels are centrally reinforced.

How to Pick the Right Bond Type

DESCRIPTION CODE DEFINITIONS	
BLANK = All Purpose	Where an excellent blend of cut rate and life is needed
FC = Free Cut	Used when fast, burn-free cutting is desired or when cutting pieces with larger cross sections
LL = Long Life	Where durability is needed due to severe application, and when cutting parts with small cross sections
RC = Rapid Cut	Where a free cutting, non-binding wheel is needed for burn-free and burr-free cuts
STUD = High-Performance	High-performance aluminum oxide/resin bond combination designed for cleaner cuts and longer life when cutting steel studs



CUT-OFF WHEELS Chop Saw Reinforced Cut-off

Designed for cutting steel, metal studs, stainless steel, non-ferrous materials, tile, brick, plastic and much more

DIALAST DIAMOND

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for exceptional wheel life; less blade changes reduce downtime and labor costs
- · Environmentally-friendly grinding for minimal dust, less clean-up and safer working conditions

Better choice for Aluminum

NORTON FOR ALUMINUM

- Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- · Non-loading, specially designed bond, allowing fast, free-cutting with long- lasting performance
- · Contaminant free, no need for waxes or lubricants



Better choice for steel, stainless steel and all other ferrous metals

BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- Durable, latest generation zirconia alumina and premium aluminum oxide abrasive blend outperforms competitive chop saw zirconia wheels by 20 percent
- · Delivers twice the life and cut rate of aluminum oxide wheels on difficult to cut metals
- · High performance resin bond is designed for free cut and long life



Good choice for all steel and ferrous metals as well as specialty applications in aluminum

GEMINI ALUMINUM OXIDE

- Durable, versatile aluminum oxide abrasive engineered for consistent performance and economical price on chop saw cut-off machine applications
- · Abrasive and bond combination designed for smooth clean cut on low HP machines
- · Good choice for consistent performance at an economical price

MITAL CONTRACTOR

Good choice for drywall studs

METAL ALUMINUM OXIDE

- Quality aluminum oxide abrasive designed for cutting alloys, steels and ferrous metals including 400 series stainless, soft and hard carbon steels
- · Designed with finer grit and softer grades, specifically for chop saw machines that typically have lower horsepower
- · Constructed with full fiberglass reinforcing; Stud Cutter version designed specifically for cutting steel studs







CUT-OFF WHEELS Chop Saw Reinforced Cut-off

								Coming the	
								Ø	
	TI	ER: BEST	BETTER	BETTER	BETTER	GOOD	GOOD	GOOD	GOOD
	TRADENAN	ne: Dialast	BLUEFIRE	BLUEFIRE	NORTON FOR Aluminum	GEMINI	GEMINI	METAL	METAL
	SHAI	PE: Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41
	ABRASI		Zirconia Alumina/ Aluminum Oxide	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxid
	REINFORCIN	IG:	Side	Central	Side	Side	Central	Side	Central
	MATERI	STAINLESS	STAINLESS	STAINLESS		STAINLESS	STAINLESS	STAINLESS	STAINLESS
			STEEL/METAL	STEEL/METAL	ALUMINUM	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
IZE) x T x H)	MAX. STD RPM PKG		PART #	PART #	PART #	PART #	PART #	PART #	PART #
ype 01/41	Straight Cu	t-off							<u> </u>
0 x 7/64 x 1	6,110 10					662531 06109 LL			
2 x 7/64 x 1	5,095 10		662528 43250			662532 07554 LL			
	5,095 5							076607 89400	
4 x 3/32 x 1	4,365 10					662533 06627 FC	662533 13588 RC	662528 35554	
	4,365 10					662533 06626 LL		076607 89405 STUD	
	4,365 5V								076607 89399
4 x 7/64 x 1	4,365 10			662528 43254 RC	662528 49382				
	4,365 10		662528 43253 LL						
4 x .155 x 1	5,400 1	701846 94053							
6 x 7/64 x 1	3,820 10					662534 10198 LL			
	3,820 10		662528 43257 LL						

CUT-OFF WHEEL DESCRIPTION CODES					
BLANK = All Purpose	FC = Free Cut	LL = Long Life	RC = Rapid Cut	STUD = Stud Cutter	
= Stainless	Steel / Metal	= Aluminum			









Norton high-speed cut-off abrasive wheels provide the industry's leading performance in all high-speed gas and electric-powered applications.

Applications:	Metalworking: steel, stainless, ductile, cast iron, rail steel and metal decking
	Non-Metal Building Materials: concrete, brick, masonry, asphalt aggregate, stone and schedule 40 and 80 PVC pipe
	Rescue and Demolition: steel, acrylic, fiberglass, rubber, glass, wood, concrete, brick and asphalt
Size Range:	12" – 16" diameter
Thickness Range:	1/8" and 5/32"
Abrasive Grain:	Aluminum Oxide, Silicon Carbide, Silicon Carbide / Aluminum Oxide Blend
Shape:	Type 01/41 Straight
Reinforcement:	Wheels are offered in standard two-layer reinforcement as well as three-layer reinforcement for higher-speed saws and heavy-duty applications.
Arbor:	Wheels are offered with patented universal arbor that accommodates both 20mm and all other machines with 1" arbors.
Machine Used:	



OR ELECTRIC SAW

Material / Application-to-Product Recommendation Guide

lcon		Application
	Metal	High-performance aluminum oxide grain wheels designed for general purpose cutting of all steel and stainless parts including rebar, steel pipe, structural steel, sheet metal, cable and small to medium diameter solid pieces.
	Metal Decking	High-performance aluminum oxide abrasive combined with a thicker wheel (5/32") that stands up to the sharp edges of sheet metal and roof decking.
	Ductile/Cast Iron	A special blend of silicon carbide abrasive for cutting and aluminum oxide abrasive for life, designed to cut ductile and cast iron pipe, concrete-lined water pipes, sewer construction and heavy duty PVC.
	Rescue	For ventilation, forcible entry, rescue and demolition. A versatile abrasive formula that can be used on a wide range of materials including all types of metals and masonry.
	Concrete	Coarse grit silicon carbide abrasive provides a low initial cost solution for cutting brick, block, concrete or other masonry materials. For higher-production applications that require optimum speed of cut and product life, please see our complete selection of high-speed diamond wheels in our Norton Construction diamond product line.
	Asphalt	A special blend of extra coarse silicon carbide abrasive grains provides a low initial cost solution for cutting asphalt, green concrete, asphalt over concrete, a wide range of aggregates and abrasive materials. For higher-production applications that require optimum speed of cut and product life, please see our Norton Construction diamond blade product offering in the Construction Product section of this catalog -and the complete offering in our "Diamond, Abrasives and Equipment for the Construction Market Catalog" #7719 found on nortonabrasives.com

Cross Reference Guide

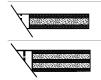
SPECIALTY

GOOD				
Gemini Metal	Gemini Metal Decking	Gemini Ductile	Gemini Concrete	Gemini Asphalt
A 24 R, Kompetitor Metal	A 24 T	AC 24 R, Kompetitor Ductile Iron	C 24 R, Kompetitor Concrete	C 16 T, Kompetitor Asphalt
A24R, ZA24Q,	TA24R	AC24R	C24R,	CC20R
The Competitor				
A24-R	A24-T	AC24-R	C24-R	C16-U
A24/30SB	A24TB	AC24SB	C30UB	C16UB
Blue XHS, Blue QMS-CM, Blue EHS	Grey QMS-CM	Green QMS-CM, Green EHS	Red XHS, Red QHS-CM, Red EHS	Black QMS-AS
SRT, Premium A36S, Silver Line A30R	_	AC30S	Premium C36S, Silver Line C24R	_
A 24 R SG	A 24 Q SG-RAIL	AC 24 Q SG	C 24 R SG	—
A24R, A30S, XFC	Brute	Ductile	C24R	Big M.A.C, XFC
A30P, A30BF	_	AC24, AC30BF	1C24, C30BF	_
Metal	—	Ductile	Concrete	Asphalt
A-24	_	_	_	_
	Gemini MetalA 24 R, Kompetitor MetalA24R, ZA24Q,The CompetitorA24-RA24/30SBBlue XHS, Blue QMS-CM, Blue EHSSRT, Premium A36S, Silver Line A30RA 24 R SGA24R, A30S, XFCA30P, A30BF Metal	Gemini MetalGemini Metal DeckingA 24 R, Kompetitor MetalA 24 TA24R, ZA24Q,TA24RThe CompetitorAA24-RA24-TA24-RA24-TA24/30SBA24TBBlue XHS, Blue QMS-CM, Blue EHSGrey QMS-CMSRT, Premium A36S, Silver Line A30R—A 24 R SGA 24 Q SG-RAILA24R, A30S, XFCBruteA30P, A30BF—Metal—	Gemini MetalGemini Metal DeckingGemini DuctileA 24 R, Kompetitor MetalA 24 TAC 24 R, Kompetitor Ductile IronA24R, ZA24Q,TA24RAC24RThe CompetitorA24-TAC24-RA24-RA24-TAC24-RA24/30SBA24TBAC24SBBlue XHS, Blue QMS-CM, Blue EHSGrey QMS-CMGreen QMS-CM, Green EHSSRT, Premium A36S, 	Gemini MetalGemini Metal DeckingGemini DuctileGemini ConcreteA 24 R, Kompetitor MetalA 24 TAC 24 R, Kompetitor Ductile IronC 24 R, Kompetitor ConcreteA 24 R, ZA24Q, The CompetitorTA24RAC24RC 24R, The CompetitorA 24-RA24-TAC24-RC 24-RA 24-RA 24-TAC24SBC 30UBBlue XHS, Blue QMS-CM, Blue EHSGrey QMS-CMGreen QMS-CM, Green EHSRed XHS, Red QHS-CM, Red EHSSRT, Premium A36S, Silver Line A30R—AC 24 Q SGC 24 R SGA 24 R SGA 24 Q SG-RAILAC 24 Q SGC 24 R SGA 24 R, A30S, XFCBruteDuctileC 24RA30P, A30BF—AC 24, AC 30BF1C 24, C 30BFMetal—DuctileC 24R



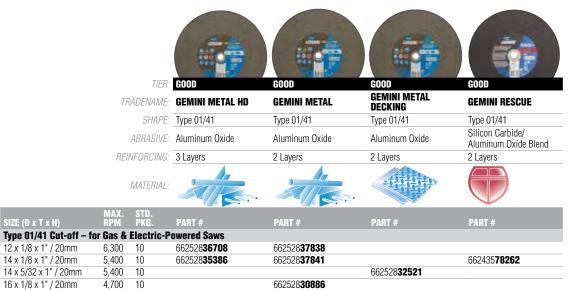
CUT-OFF WHEELS High-Speed Reinforced Cut-off

How to Pick the Right Reinforcement



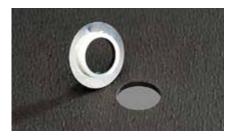
Two full layers of reinforcing are offered for lower power machines, and light-to-medium applications where speed of cut is the primary selection criterion.

Three full layers of reinforcing are recommended for high-speed, high-power machines where the application is heavy-duty, and durability is the primary selection criterion.



See addtional Rail Cut wheels on page 34 for larger-volumne jobs.

TIER		GOOD	GOOD	GOOD	GOOD
TRADENAME		GEMINI DUCTILE	GEMINI CONCRETE HD	GEMINI CONCRETE	GEMINI ASPHALT
SHAPE	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Туре 01/41
ABRASIVE	Silicon Carbide / Aluminum Oxide Blend	Silicon Carbide / Aluminum Oxide Blend	Silicon Carbide	Silicon Carbide	Silicon Carbide
REINFORCING	3 Layers	2 Layers	3 Layers	2 Layers	2 Layers
MATERIAL					
STD.					
SIZE (D x T x H) MAX. RPM PKG.	PART #	PART #	PART #	PART #	PART #
Type 01/41 Cut-off – for Gas & Electric-F	owered Saws				
12 x 1/8 x 1" / 20mm 6,300 10		662528 37840		662528 37839	
14 x 1/8 x 1" / 20mm 5,400 10	662528 35388	662528 37843	662528 35387	662528 37842	701846 72877
16 x 1/8 x 1" / 20mm 4,700 10				701846 23029	



Universal Arbor

Two Blade Sizes in One

Our Norton patented 1"/20mm knock-out arbor fits all gas and electric high-speed saws. A 20mm bushing is pre-mounted into the 1" molded arbor hole. The wheel, with the 20mm bushing, can be mounted directly on any 20mm arbor high-speed saw. With the bushing removed, exposing the 1" arbor hole, the wheel can be mounted on any 1" arbor high-speed saw. Combining this arbor, with heavy-duty triple reinforcing results in a higher performing, extra strong, longer lasting cutting wheel. Once the 20mm bushing is removed, it cannot be replaced.



CUT-OFF WHEELS Stationary Saw Reinforced Cut-off

The Norton stationary saw reinforced cut-off wheel line consists of Type 01/41 straight 10" - 24" wheels, designed to fit on fixed-base stationary saws that are free-standing or mounted on a workbench.

Applications:

Size Range: Thickness Range: Abrasive Grain: Shape: **Machine Used:**

Primary applications are cutting of all metal parts (flat stock, bars, studs, pipes, tubes, angle iron, cable), wire rope and hydraulic hose used in fabrication, construction and plant maintenance. 10" - 20" diameter 3/32", 1/8", 5/32", 3/16"

Zirconia Alumina / Aluminium Oxide Blend, Aluminum Oxide, Silicon Carbide Type 01/41 Straight



STATIONARY SAW

Cross Reference Guide

	TOTAL PERFORMANC	CE		INITIAL	PRICE SPECIALITY
	BETTER	GOOD			GOOD
NORTON	BlueFire	Gemini Free Cut	Gemini Long Life	Gemini Rapid Cut*	Foundry Cut**
Abmast	Z 24 R3	A 30 R			AC 24 R3
Bullard	<u> </u>	A30-R	A30-T	A300	
Camel	ZA24-R	A24-R, A46-T	_		WA24-S
Flexovit	_	A30RB Multi Purpose	A30SB Long Life, A24TB Long Life	—	AC24PB Heavy Duty
Vetabo		A30N, A30R	A30S, A30V	_	_
Pearl	SRT36	A30P Premium, A30Q Silver Line	A30S Premium, A36R Premium	—	_
Pferd	ZA 24 Q/R SG-HD	A 24 N/P SG-HD	A 24 Q/S SG-HD		
Sait		A24N, A36R	A24R		
Fyrolit 🛛		A30BF			_
Nalter		A-24-FC	A-24-RIP	_	

* For Burr-Free applications, please see centrally-reinforced BlueFire Rapid Cut and Gemini Rapid Cut wheels in Chop Saw cut-off wheel section or at nortonabrasives.com ** For Foundry and other cut-off wheels, please refer to that section of this Norton Full Line Catalog #7362 or at nortonabrasives.com

					any A
		TIER:	BETTER	GOOD	GOOD
		TRADENAME:	BLUEFIRE	GEMINI FREE CUT	GEMINI LONG LIFE
		SHAPE:	Type 01/41	Type 01/41	Type 01/41
		ABRASIVE:	Zirconia Alumina/	Aluminum Oxide	Aluminum Oxide
		ADNASIVE.	Aluminum Oxide		
		MATERIAL:	STAINLESS	STAINLESS	STAINLESS
			STEEL/METAL	STEEL/METAL	STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Type 01/41 Straight C	ut-Off				
10 x 3/32 x 5/8	6,110	10	662528 43248	662531 06101 FC	662531 06102 LL
	6,110	5			
12 x 1/8 x 1	5,095	10	662528 43249		662532 07548 LL
	5,095	5			
14 x 1/8 x 1	4,365	10	662528 43251	662533 06609 FC	662533 06611 LL
	4,365	5			
16 x 5/32 x 1	3,820	10	662528 43255	662534 10183 FC	662534 10184 LL
18 x 5/32 x 1	3,015	10		662534 10185 FC	
20 x 5/32 x 1	2,710	5	662528 43258 FC	690786 09031 FC	690786 09032 LL
	2,710	5	662528 43259 LL		
20 x 3/16 x 1	2,710	5		690786 09033 FC	690786 09034 LL
CUT-OFF WHEEL DESCR	RIPTION CODES				
BLANK = All Purpose		Free Cut	LL = Long Life	= Stainless	Steel / Metal



Bond: Shape:

CUT-OFF WHEELS Toolroom Cut-off

Reinforced and non-reinforced engineered cut-off wheels for cutting all types of tool steel with fixed-based cut-off machines.

Type 01/41 Straight

Applications:

Size range: Grit range: Abrasive grain: Reinforced cut-off wheels are designed to resist breakage caused by severe cross-bending and are required on any operation where the work is not securely clamped. Non-Reinforced cut-off wheels are designed for use on fixed-based machines where the work is securely clamped, guarded, and where the wheel operates on a controlled cutting plane. 6" - 12" diameter 36 – 90 grit Aluminum Oxide Resinoid, Rubber, and Shellac

Cross Reference Guide

	BETTER			TECH TIP		
NORTON	Reinforced A60-OBNA2	Reinforced 57A364-TB25N	Non-Reinforced 57A60-M8B	Smooth side pattern – Used when a precise thickness tolerance is needed		
Bates	A602-T-BF	A36-R-BF	-	 Rough (R) side pattern – Abrasive particles protrude from sides of wheel 		
Buffalo	A60-R-BF2	-	-	- Hough (h) side pattern - Abrasive particles protrude from sides of wheel		
Dia. Tool	A80-SP	A46-SP	-			
Radiac	A54-N6-B20	-	A54-N6-B20	•		
Tyrolit	A60-QBF38A2	-	-			

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Poor cut rate	Insufficient power used	Increase feed or pressure to full power
	Wheel too hard	Use softer grade, or thinner wheel
	Contact area too large	Reduce contact area
	Wheel too coarse	Use finer grit
	Wheel side out of truth	Check spindle runout
Non-square cuts	Work not clamped properly	Check clamp and clean to remove swarf
	Misaligned spindle bearings	Check for bearing truth and alignment
	Poor coolant distribution	Ensure equal volume of coolant to each wheel side
	Wheel is too hard	Use softer acting wheel: softer grade, or finer grit
Norkpiece burn	Insufficient feed rate	Work machine to maximum power available
	Poor coolant flow	Increase volume and direct at cutting point
	Wheel is too coarse	Use finer grit or more machine power
	Wheel is too hard	Use softer grade wheel
	Wheel is running out	Check spindle and flanges
	Wheel speed is too slow	Ensure tight flanges and maximum safe operating speed being used
Poor finish	Too much burr	Use finer grit, or softer grade
	Wheel too coarse	Use finer grit

TECH TIP

- Wheels with a "W" reinforcement (reinforcement around the hole) are not considered to be truly reinforced.
- Clamp or fixture the workpiece for straightest cuts.
- · Run wheels at the highest possible speed marked on the wheel and make cuts as quickly as possible. Do not overspeed wheels.
- It is recommended that a cut-off machine should have 1 horsepower for every inch of wheel diameter. For less than this, we recommend using a softer specification.
- Using a harder grade wheel increases wheel life, but it also increases burn, power required and decreases cut rate.
- · Using a coarser grit wheel increases wheel life and cut rate, but it also increases burr and power required.



CUT-OFF WHEELS Toolroom Cut-off



Better choice for cutting tool steel on fixed-based machines when work is not securely clamped

TOOLROOM REINFORCED ALUMINUM OXIDE

- Tough, versatile aluminum oxide grain for toolroom cut-off applications
- Constructed with full diameter fiberglass reinforcement on each side of wheel, to provide greatest possible resistance to side pressure and bending
- OBNA2 full side reinforced, resin bond; yields maximum cut rate and minimum kerf loss; ideal when thin cut is desired
- · B25N full side reinforced, resin bond; versatile; durable, free cutting; offer greatest stiffness

		TIER:	BETTER				TIER:	<i>TIER:</i> BETTER
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #	SIZE (D x T x H)	SIZE (D x T x H) MAX. RPM	SIZE (D x T x H) MAX. RPM STD. PKG.	SIZE (D x T x H) MAX. RPM STD. PKG. SPEC.
Type 01/41 Straig	ght Cut-off –	Reinforced			Type 01/41 Straig	Type 01/41 Straight Cut-off -	Type 01/41 Straight Cut-off - Reinforced	Type 01/41 Straight Cut-off – Reinforced
6 x .035 x 1-1/4	10,190	25	A60-0BNA2	662528 35055	8 x .035 x 1/2	8 x .035 x 1/2 7,640	8 x .035 x 1/2 7,640 25	8 x .035 x 1/2 7,640 25 A60-OBNA2
6 x .060 x 1/2	10,190	25	A60-0BNA2	662528 35164	8 x .035 x 1-1/4	8 x .035 x 1-1/4 7,640	8 x .035 x 1-1/4 7,640 25	8 x .035 x 1-1/4 7,640 25 A60-OBNA2
6 x .060 x 1/2	10,190	25	57A364-TB25N	662528 22969	8 x .060 x 1/2	8 x .060 x 1/2 7,640	8 x .060 x 1/2 7,640 25	8 x .060 x 1/2 7,640 25 A60-OBNA2
6 x .060 x 1-1/4	10,190	25	A60-0BNA2	662528 35165	8 x .060 x 1-1/4	8 x .060 x 1-1/4 7,640	8 x .060 x 1-1/4 7,640 25	8 x .060 x 1-1/4 7,640 25 A60-OBNA2
7 x .035 x 1/2	8,730	25	A60-0BNA2	662529 38786	8 x .060 x 1-1/4	8 x .060 x 1-1/4 7,640	8 x .060 x 1-1/4 7,640 25	8 x .060 x 1-1/4 7,640 25 57A364-TB25N
7 x .035 x 1-1/4	8,730	25	A60-0BNA2	662529 38788	10 x .060 x 5/8	10 x .060 x 5/8 6,110	10 x .060 x 5/8 6,110 25	10 x .060 x 5/8 6,110 25 A60-OBNA2
7 x .060 x 1/2	8,730	25	A60-0BNA2	662529 38816	10 x .060 x 1-1/4	10 x .060 x 1-1/4 6,110	10 x .060 x 1-1/4 6,110 25	10 x .060 x 1-1/4 6,110 25 A60-OBNA2
7 x .060 x 1-1/4	8,730	25	A60-0BNA2	662529 38796	12 x .060 x 1	12 x .060 x 1 5,095	12 x .060 x 1 5,095 10	12 x .060 x 1 5,095 10 A60-OBNA2
7 x .060 x 1-1/4	8,730	25	57A364-TB25N	662529 22676	12 x .075 x 1			
					12 x .075 x 1-1/4	12 x .075 x 1-1/4 5,095	12 x .075 x 1-1/4 5,095 10	12 x .075 x 1-1/4 5,095 10 A60-OBNA2

Better choice for cutting tool steel on fixed-based machines when the work is securely clamped



TOOLROOM NON-REINFORCED ALUMINUM OXIDE

- Tough, durable and versatile aluminum oxide grain for toolroom cut-off applications
- · Non-reinforced, use on fixed-based machines where the work is securely clamped
- B bond (smooth sides); a mild acting resin bond for light cut-off applications
- B25 bond (smooth sides); a versatile, free-cutting, more durable resin bond; ideal for dry cutting metal in high production runs
- E7 bond (smooth sides); a shellac bond with very mild cutting action, recommended for highly critical applications where no burr, heat checks, or discoloration is permitted
- · R30 bond (smooth sides); mild acting rubber bond primarily for wet, ultra-thin cutting

		TIER:	BETTER		
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #	
Type 01/41 Strai	ght Cut-off –	Non-Reinfo	rced		
6 x .015 x 1-1/4	6,370	25	57A90-R0R30	662528 22953	
6 x .020 x 1-1/4	6,370	25	57A90-R0R30	662528 22954	
6 x .035 x 1-1/4	6,370	25	57A60-M8B	662528 22958	
6 x .060 x 1/2	7,640	25	57A541-RB25	662528 22970	
6 x .060 x 1-1/4	7,640	25	57A60-M8B	662528 22975	
7 x .035 x 1-1/4	5,460	25	57A60-M8B	662529 22983	
	5,460	25	57A60-08B	662529 22986	
	5,460	25	57A60-Q8B	662529 22987	
7 x .035 x 1-1/4	5,460	25	57A601-PB25	662529 22988	
	5,460	25	57A601-RB25	662529 22989	
7 x .035 x 1-1/4	5,185	25	57A60-0E7	662529 22985	
7 x .035 x 1-1/4	5,460	25	23A601-PB25	662529 38701	
7 x .050 x 1-1/4	5,460	25	23A601-PB25	662529 38724 *	
7 x .060 x 1/2	6,550	25	57A60-08B	662529 22672	

		TIER:	BETTER	
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #
Type 01/41 Straight	nt Cut-off – I	Non-Reinfor	ced	
7 x .060 x 1-1/4	6,550	25	57A46-M8B	662529 22677
	6,550	25	57A60-M8B	662529 22681
	6,550	25	57A60-08B	662529 22684
	5,185	25	57A60-0E7	662529 22683
7 x .090 x 1-1/4	6,550	25	57A60-M8B	662529 22690
7 x .125 x 1-1/4	6,550	25	57A60-M8B	662529 22692
8 x .035 x 1-1/4	4,775	25	57A60-N8B	662530 22694
8 x .060 x 1/2	5,730	25	57A60-M8B	662530 22702
8 x .060 x 1-1/4	5,730	25	57A60-M8B	662530 22708
10 x .060 x 5/8	4,585	25	57A46-Q8BW	662531 22816
	4,585	25	57A60-M8BW	662531 22818
10 x .090 x 5/8	4,585	25	57A60-M8BW	662531 22824

*Exception: rough sides





CUT-OFF WHEELS Metallurgical Non-Reinforced Cut-off

The Norton metallurgical line of Type 01/41 straight cut-off wheels was developed specifically for sectioning off metal samples; burr-free cutting, minimal burn and distortion.

Applications:

Designed specifically for cutting off metal samples ranging from mild steel to super alloys on fixed-based machinery by scientists, engineers, and lab technicians. 9" – 13.75" diameter

Size range:

Cross Reference Guide

		NORTO	N	BUEHLER		LECO	LECO	STRUER	S
SIZE	MATERIAL CUT	SPEC.	PART #	METABRASE PART #	BUEHLERMET II PART #	PART #	PART #	PART #	AXITOM/-5 PART #
9 x .063 x 1-1/4	Very Hard Steels (Rc 55 - 68)	ML-109	662531 17874	10-4110-010				60A24*	
(229mm x 1.6mm x 32mm)	Medium Steels (Rc 30 - 40)	ML-309	662531 17877	10-4116-010	10-5112-010	811-043-010		40A24*	
	Soft Steels (Rc 20 - 30)	ML-409	662531 17828	10-4120-010	10-5116-010	811-049-010		30A24*	
10 x .063 x 1-1/4	Very Hard Steels (Rc 55 - 68)	ML-110	662531 17879	10-4210-010		808-673	812-231	60A25•	
(254mm x 1.6mm x 32mm)	Hard Steels (Rc 40 - 55)	ML-210	662531 17880	10-4212-010	10-5210-010	811-059-010	810-310-010	54A25•	
	Medium Steels (Rc 30 - 40)	ML-310	662531 17881	10-4216-010	10-5212-010	811-067-010	810-310-010	40A25•	
	Soft Steels (Rc 20 - 30)	ML-410	662531 17830	10-4220-010	10-5216-010	811-073-010		30A25•	
12 x .078 x 1-1/4	Very Hard Steels (Rc 55 - 68)	ML-112	662533 22151	10-4410-010		808-674	811-065-010	60A30†	
(305mm x 2.0mm x 32mm)	Hard Steels (Rc 40 - 55)	ML-212	662533 22152	10-4412-010	10-5410-010	811-081-010	810-311-010	50A30†	
13.75 x .098 x 1-1/4	Very Hard Steels (Rc 55 - 68)	ML-114	662533 22863	10-4310-010		808-675	812-232	60A350	50A35
(350mm x 2.5mm x 32mm)	Hard Steels (Rc 40 - 55)	ML-214	662533 22156	10-4312-010	10-5310-010	809-346	811-977-010	50A350	40A35
*Discotom/Labotom • Di	scotom-5/-6/Labotom-3 † Un	itom/Disco	tom-50/-60/-65	□ Exotom/Uniton	n-2/-5/-50				



Best choice for wet use when you want burn-free cuts and ultra-clean samples

METLAB 38A ALUMINUM OXIDE

- Quality aluminum oxide abrasive wheel designed specifically for burr-free cutting of soft carbon steels, tool steels, super alloys for microscopic metal analysis
- · Superior bond system generates pure cuts for sectioning off samples while minimizing wheel wear and odor
- Designed to work on Buehler®, LECO® and Struers® machinery

					TIER: BEST
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PRODUCT #	APPLICATION	PART #
Type 01/41 Straight Cut-off - No	n-Reinforced				
9 x .063 x 1-1/4	4,025	10	ML-109	Very Hard Steels (Rc 55 - 68)	662531 17874
(229mm x 1.6mm x 32mm)	4,025	10	ML-309	Medium Steels (Rc 30 - 40)	662531 17877
	5,085	10	ML-409	Soft Steels (Rc 20 - 30)	662531 17828
10 x .063 x 1-1/4	3,500	10	ML-110	Very Hard Steels (Rc 55 - 68)	662531 17879
(254mm x 1.6mm x 32mm)	3,500	10	ML-210	Hard Steels (Rc 40 - 55)	662531 17880
	3,500	10	ML-310	Medium Steels (Rc 30 - 40)	662531 17881
	4,585	10	ML-410	Soft Steels (Rc 20 - 30)	662531 17830
12 x .078 x 1-1/4	3,820	10	ML-112	Very Hard Steels (Rc 55 - 68)	662533 22151
(305mm x 2.0mm x 32mm)	3,820	10	ML-212	Hard Steels (Rc 40 - 55)	662533 22152
13.75 x .098 x 1-1/4	2,770	10	ML-114	Very Hard Steels (Rc 55 - 68)	662533 22863
(350mm x 2.5mm x 32mm)	2,770	10	ML-214	Hard Steels (Rc 40 - 55)	662533 22156
				_	
	TIER: BET	ER			

		TIER:	BETTER	
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #
Type 01/41 Straig	jht Cut-off –	Non-Reinfor	ced	
10 x 1/16 x 1-1/4	4,585	5	88A901-HB82 Metlab	662531 49449
12 x 1/16 x 1-1/4	3,820	5	88A901-HB82 Metlab	662532 62172





CUT-OFF WHEELS Rail Reinforced Cut-off

GOOD

A30X

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RailCut

RailCut

Metal

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RailCut

FastCut

NorZon III

The Norton RailCut line is designed for high-speed fixtured hydraulic or gas-powered rail saws.

Applications: Size range: Thickness range: Grit range: Abrasive grain: Shape: Reinforcement: Speed rating: Machines Used: Fixed rail track cutting 14" and 16" diameter 1/8" 14 – 16 Zirconia Alumina / Aluminum Oxide Blend, Zirconia Alumina, and Aluminum Oxide Type 01/41 Straight Side reinforced with R (rough) sides All wheels are rated for 20,000 SFPM applications

BETTER

RailCut

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NorZon III



FIXTURED HYDRAULIC OR GAS-POWERED RAIL SAW

Cross Reference Guide and Machine-to-Product Recommendation Guide

BEST	BETTER	GOOD	GOOD		BEST
RailCut X	RailCut NorZon III	RailCut A30X	RailCut Metal	NORTON	RailCut X
Trackmaster Pro ZA24 Q-BF	Pro ZA24 Q-BF	Trackmaster A30 R-BF (Red)	_	HYDRAULIC SAW	•
(Diue)	(blue)	_	RailMaster Rail Cut 27	High-Horsepower / Newer Machine	•
		A30-PB		Low-Horsepower /	•
A 24 SX Special	A 24 SX Special		<u>NR242-Q</u>	Ulder Machine	
A30 R-BF	A30 R-BF	_	_		
A24R	A24R	_	_		
	RailCut X Trackmaster Pro ZA24 Q-BF (Blue) — AM303-R A 24 SX Special A30 R-BF	RailCut XRailCut NorZon IIITrackmaster ProTrackmaster ProZA24 Q-BF (Blue)ZA24 Q-BF (Blue)——————AM303-RAM303-R A 24 SX SpecialA30 R-BFA30 R-BF	RailCut XRailCut NorZon IIIRailCut A30XTrackmaster ProTrackmaster ProTrackmaster A30 R-BFZA24 Q-BF (Blue)ZA24 Q-BF (Blue)(Red)————————A30-PBAM303-RAM303-RNR242-QA 24 SX SpecialA24 SX Special—A30 R-BFA30 R-BF—	RailCut XRailCut NorZon IIIRailCut A30XRailCut MetalTrackmasterTrackmasterTrackmasterProProA30 R-BFZA24 Q-BFZA24 Q-BF(Red)(Blue)(Blue)RailMaster Rail Cut 27A30-PBAM303-RAM303-RNR242-QA 24 SXA 24 SXSpecialSpecial	RailCut X NorZon IIIRailCut A30XRailCut MetalNORTONTrackmaster ProTrackmaster ProTrackmaster A30 R-BF——Pro (Blue)Pro (Blue)A30 R-BF—HYDRAULIC SAWC GAS SAW(Red)—GAS SAW— AM303-R——RailMaster Rail Cut 27High-Horsepower / Newer MachineAM303-R SpecialAM303-RNR242-QNR242-QA30 R-BFSpecial——

Best choice for high-performance cutting of rails on applications where the hydraulic or gas saw is fixtured and has adequate power

RAILCUT X ZIRCONIA ALUMINA / A/O BLEND

- Highest-performance zirconia alumina and engineered aluminum oxide abrasive blend expertly cuts a broad range of rail material
- Rough sides enable fastest cutting and longest lasting wheels
- · Achieve highest productivity with lowest total abrasive costs



Good choice for price-sensitive jobs with lowest initial price

RAILCUT METAL ALUMINUM OXIDE

- Quality aluminum oxide abrasive wheels designed for jobs where low initial price is a key purchasing criterion
- · Side reinforced with rough sides; rated for 20,000 SFPM applications
- Designed for multi-purpose use; great versatility on a variety of rail materials

		7150	(5	6	6	3
		TIER:	BEST	BETTER		GOOD	GOOD
	TRA	ADENAME:	RAILCUT X	RAILCUT NORZON III	RAILCUT NORZON III Fastcut	RAILCUT A30X	RAILCUT METAL
	,	ABRASIVE:	Zirconia Alumina/ Aluminum Oxide Blend	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide	Aluminum Oxide
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
Type 01/41 Cut	-Off						
14 x 1/8 x 1		10	662533 37716	662533 60493	662533 63694	662532 60462	
16 x 1/8 x 1	4,800	10	662533 35024	662534 64607	662534 64415	662532 59935	662434 82066



Foundry cut-off wheels are designed with abrasives, bonds and reinforcement types specific to foundry machine parameters and materials. Most of the specifications are non-stock. This stock listing is designed to provide popular size and starting specifications.

Reinforced: 14" - 30" diameter; Non-reinforced: 12" - 20" diameter Size Range: **Grit Range:** 24 – 46 arit **Abrasive Grain:** Ceramic Alumina (Norton Quantum; non-stock only), Zirconia Alumina, Aluminum Oxide **Reinforcement:** Reinforced: Engineered with strengthening fabric or filaments, which make wheels resistant to cross-bending breakage. All portable cut-off, swingframe, locked-head push-through and foundry chop stroke operations require reinforced cut-off wheels. B: One or more full diameter pieces of filament molded inside each wheel. This construction leaves the abrasive exposed on the side of the wheel, improving freeness of cut. Used for fixed work operations with low probability of side pressure. N: Full diameter pieces of reinforcement on the side of the wheel. Offers greatest possible resistance to side pressure and bending. Non-Reinforced: Designed for use on fixed-base types of machines where the work is securely clamped and guarded, and where the wheel operates on a controlled cutting plane. W: Reinforcement around the center hole only. These wheels are not considered to be truly reinforced. Smooth sides: Used for precision cutting applications **Side Patterns:** Rough (R) sides: Abrasive particles protrude from sides of wheel Used wet or dry on most metals

Material-to-Product Recommendation Guide

BEST	BETTER	GOOD	GOOD
Foundry X Quantum*	Foundry X BlueFire	Foundry X	Foundry Metal
		•	
•	•	•	•
•	•	•	•
•	•	•	•
		•	
•	•	•	•
•	•	•	•
•	•	•	•
•	•	•	•

*Foundry X Quantum wheels are non-stock, custom-made to your requirements

Cross Reference Guide

NDRTDN

SAINT-GOBAIN

TOTAL PERFORMANCE

INITIAL PRICE

	BEST	BETTER	GOOD	GOOD						
NORTON	Foundry X Quantum and B97 (Non-stock; custom-made to your exact requirements)	Foundry X BlueFire	Foundry X	Foundry Metal						
Allison	TA362 R6 8045HA, YW462 MR B2HA	TA302-T6-B6HA, A46-T6-BX5T6A, HF 1247 K – CHALLENGER	_	Economiser						
Avery	_	TA30-V680	A 3226 C7A, C11922 W071	92871H						
Buckeye	—	Steel Shark	_							
DiaTool	BV1734R 710	BV 1397-5284-C		_						
Flexovit	<u> </u>	ZAX30TB	A24PB, A30RB							
Klingspor	20A24-QBF	_								
NATAB	_	_	T 1584 HA							
Rappold	<u> </u>	6Z30U-B3F2								



Better choice on stainless steel, aerospace alloys, cast iron, and steel

FOUNDRY X BLUEFIRE REINFORCED

- · Next generation self-sharpening zirconia alumina abrasive provides fast cuts on foundry cut-off applications
- · Improved durability and heat resistance result in longer abrasive life
- · More aggressive; can withstand very demanding applications



FOUNDRY WHEELS Foundry Cut-Off



Good choice on general purpose applications

FOUNDRY X ALUMINUM OXIDE

- · Durable, versatile aluminum oxide abrasive engineered for consistent performance and economical price on foundry cut-off applications
- · Advanced bond technology with improved thermal stability and mechanical strength
- · Excellent value on stainless steel and exotic aerospace alloys

Good choice for price-sensitive jobs with lowest initial price



- · Great versatility from multi-purpose aluminum oxide abrasive formulated specifically for typical foundry applications
- · Bond and reinforcement engineered to foundry market machine parameters and materials
- · Good choice for small jobs and quick applications where performance is not measured

Reinforce	d							
TIER: TRADENAME: ABRASIVE:				GOOD		GOOD		
					FOUNDRY X Aluminum Oxide		FOUNDRY METAL Aluminum Oxide	
SIZE	MAX.	STD.	Zirconia Alumina		Aluminulli Oxide		Aummulii Oxide	
(D x T x H)	RPM	PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type 01/41 Strai	ght Cut	-off – Foundry	y Reinforced					
14 x 1/8 x 1	4,365	10			U57A30-TB75N	662533 45779		
	4,365	10			U57A30-VB75N	662531 79191		
16 x 5/32 x 1	3,820	10	NV24-TB75N	662533 47676	U57A30-TB75N	662533 45781	Side Reinforced	662434 85919
	3,820	10	NV24-VB75N	662531 79147	U57A30-VB75N	662531 79148		
20 x 5/32 x 1	2,710	10	NV24-TB75N	662533 47683	U57A30-TB75N	662533 47546	Side Reinforced	662434 85920
	2,710	10	NV24-VB75N	662531 79363	U57A30-VB75N	662531 79364		
	2,710	10	NV24-YB97N	662533 47694	U57A30-YB97N	662533 47701		
20 x 3/16 x 1	2,710	10	NV24-TB75B	662533 47684	U57A30-TB75B	662533 47547	Centrally Reinforced	662434 85921
	2,710	10	NV24-VB75B	662531 79366				
	2,710	10	NV24-YB97B	662533 47699	U57A30-YB97B	662533 47702		
24 x 7/32 x 1-3/4	2,260	10	NV24-TB75B	662533 47685				
	2,260	10	NV24-VB75B	662531 79374	U57A30-VB75B	662531 79375		
	2,260	10	NV24-YB97B	662533 47697				
30 x 1/4 x 1-3/4	1,810	10	NV24-TB75B	662533 47722				
	1,810	10	·		U57A30-YB97B	662533 47721		

Specifications ending in "B" are centrally reinforced; specifications ending in "N" are side reinforced.

Non-Reinforced

NOII-Reli	morce	Ask your Norton representative about our custom, made-to-order Norton Foundry X Quantum ceramic alumina wheels for high alloys, stainless steel, and					
0.55	555 1	ABRASIVE:	Aluminum Oxide		Aluminum Oxic	10	aerospace applications.
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #	SPEC	PART #	· · · ·
Type 01/41 Str	aight Cut	CUT-OFF WHEEL DESCRIPTION CODES					
12 x 3/32 x 1	5.095	10	U57A461-PB25	662532 61887			AP = All Purpose
16 x 1/8 x 1	3.820	10			AP	662534 22942	Where a good blend of cut rate and life
20 x 1/8 x 1	2,710	10	U57A304-VB25W	690786 65497			is needed



For consistent, quality performance in foundries, welding shops, fabrication facilities, steel mills and shipyards, Norton portable snagging wheels maximize your productivity. Used on horizontal/straight shaft grinders or right angle portable cup grinders.

Applications: Removing flaws, cracks, gates, risers and parting lines, smoothing weld seams, cleaning castings, and rough beveling Type 01 Straight Wheels: 2-1/2" - 8" diameter **Size Range:** Type 06 and 11 Cup Wheels: 4" - 6" diameter Cones and Plugs: Type 16, 17, 17R, 18 and 18R **Grit Range:** 14 - 24 **Abrasive Types:** Zirconia Alumina NZ and NV; Zirconia Alumina / Silicon Carbide Blend NVC; Aluminum Oxide 57A and Metal; Aluminum Oxide / Silicon Carbide Blend 57AC, Silicon Carbide 37C and Masonry **Machine Used:** R PORTABLE **RIGHT ANGLE** PORTABLE

GRINDER

GRINDER

Material-To-Product Recommendation Guide

NDRTDN

SAINT-GOBAIN

	BEST	BETTER	GOOD	
	NorZon Plus	BlueFire	Gemini	Metal
IRON				
Gray	◆ NZ14-R	NV16-Q	◆ 57A16-Q	•
Ductile/Malleable	◆ NZ14-R	NV16-Q	◆ 57A16-Q	•
Dirty/Scale-covered		NVC16-Q	◆ 57AC16-Q	
STEEL				
Carbon and Low Alloy	NZ14-Q	•	◆ 57A16-Q	•
Stainless and High Alloy	NZ14-P	•	◆ 57A16-Q	•
ALUMINUM, COPPER, BRASS, & BRONZE ALLOYS		NVC16-Q	57AC16-Q	
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CUT-OFF TOOL

NOTE: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Cross Reference Guide for Type 01, 06 and 11 Wheels

TOTAL PERFORMANCE

INITIAL PRICE

	BEST	BETTER	GOOD		
NORTON	NorZon Plus	BlueFire NV	Gemini 57A/Metal	Gemini 57AC	Gemini 37C/Masonry
Bullard		ZA16PB	A16R	AC16	C16P
Camel			A	CA	С
Flexovit	ZA16PB		A16QB	AC16QB	C16PB
Gulf States	Zirconium		A16		C16
Pacific	Z, Z-GPC	_	А	CA	
Pearl	_	—	A16Q	_	C16-Q
Pferd	ZA 16 Q SG	_	A 16 Q SG	_	C 16 Q SG
Sait		Z16	A16, 20	CA16	C16
Tyrolit			A16PB		C16PB
Walter			A		С



FOUNDRY WHEELS Portable Snagging



LOW

Best choice for heavy-duty stock removal on medium- and high-horsepower grinders

NORZON PLUS ZIRCONIA ALUMINA

- Tough, durable, premium zirconia alumina grain provides 10X life and 50% faster grinding versus aluminum oxide products
- Engineered to excel on the toughest foundry snagging applications
- Best performance on a wide variety of materials; 300 and 400 series stainless, soft and hard carbon steels, tool
 steels, titanium, super alloys, soft metals, and cast, ductile and gray iron

Better choice for stock removal on high- and medium-horsepower grinders

BLUEFIRE ZIRCONIA ALUMINA

- Friable zirconia alumina grain and durable resin bond technologies deliver sharper grain longer, for extended wheel life, higher metal removal rates, and faster, freer cutting action than standard zirconia alumina blends
- Ideal for foundry snagging, tool sharpening, portable grinding and stock removal applications on high- and medium-horsepower grinders
- Strong operator preference for these smooth-acting wheels that require less pressure and exertion, while improving productivity
- NVC zirconia alumina / silicon carbide blend is highly effective on dirty, scale-covered castings
- · Available with low odor bond to help reduce odors associated with portable grinding when used in confined spaces



Good choice for steel and ferrous metals as well as specialty applications in aluminum and foundries

GEMINI ALUMINUM OXIDE

- Tough, durable aluminum oxide abrasive for heavy-duty work including foundry snagging, tool sharpening, and stock removal
- · Work well with a variety of machines, horsepowers, and operations
- · Good general-purpose choice for numerous small jobs
- · Available with low odor bond to help reduce odors associated with portable grinding when used in confined spaces



Good choice for steel/ferrous metal applications with low initial price

METAL ALUMINUM OXIDE

- Tough, durable aluminum oxide abrasive for heavy-duty work including foundry snagging, tool sharpening, and stock removal
- · Work well with a variety of machines, horsepowers, and operations
- Good general-purpose choice for numerous small jobs on 300 and 400 series stainless, soft and hard carbon steels, tool steels, titanium, super alloys, soft metals, and cast, ductile and gray iron

Good choice for masonry applications with low initial price

MASONRY ALUMINUM OXIDE

- · Sharp silicon carbide abrasive for small-volume snagging jobs
- Delivers rapid stock removal in small areas on a portable cup grinder
- Versatile; good starting specification where initial price is a primary purchasing consideration, especially nonferrous and masonry



FOUNDRY WHEELS Portable Snagging

			BEST	Lation	BETTER	fire	GOOD		GOOD	
	TRADE		NORZON PI		BLUEFIRE		GEMINI		METAL/MASON	RY
		SHAPE:	Type 01 and	11	Type 01, 06, and	d 11	Type 01 and 11	574	Type 11	
		-	Premium Zir	conia Alumina	Zirconia Alumina Zirconia Alumina Silicon Carbide I	ı/	Aluminum Oxide Silicon Carbide Aluminum Oxide Silicon Carbide 5	37C, /	Metal – Aluminu Masonry – Silico	
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #	SPEC	PART #
Type 01 Straight										
2-1/2 x 1/2 x 3/8	21,700	20					57A24-R	662435 22381		
3 x 1/4 x 3/8	20,370	25			NV20-T	662533 43872 *	57A24-T	662435 28831		
3 x 3/8 x 3/8	18,080	10				,	57A24-R	662435 22415		
3 x 1/2 x 3/8	18,080	10					57A24-P	662435 22417		
4 x 1/4 x 3/8	15,280	10			NV20-T	662533 44098	57A24-R	662435 22221		
6 x 1 x 5/8	8,000	5			NV14-R	662531 98589	57A16-QS	662528 09563		
S Webs	8,000	5			NZ III 14-Q	662528 38075				
	8,000	5			NZ III 14-R	662528 37961				
8 x 3/4 x 5/8 S Webs	6,000	10			NV14-S	662533 44347				
8 x 1 x 5/8	6,000	5	NZ IV 16-0	662530 30778	NV16-Q	662531 98590				
S Webs	6,000	5	NZ IV 16-Q	662530 44532		00050044055				
	6,000	10			NV14-R	662533 44355				
	6,000	10			NV14-T NVC16-Q	662533 44365				
	6,000	10			NVC16-Q	662531 98592				
Type 06 Straight Cup										
6 x 2 x 5/8-11 Rim 2" Back 3/4"	6,000	5			NZ III 16-R	662528 38577				
Type 11 Flaring Cup		7								
4/3 x 2 x 5/8-11 Rim 3/4" Back 3/4"	9,070	10	NZ IV 16-Q	662435 30761	NV16-Q	662531 98583	57A16-Q	662435 10512	Masonry C16-Q	076607 89431
5/3-3/4 x 2 x 5/8-11	7,260	5			NV16-Q	662531 46918	57A16-Q	662528 09598	Metal 16-Q	076607 89430
Rim 1" Back 3/4"	7,260	5			4NZ16-Q RB	690786 40233	57AC16-Q RB	690786 40234		
6/4-3/4 x 2 x 5/8-11	6,000	5			NV16-Q	662531 46925	57A16-Q	662528 25201		
Rim 1" Back 3/4"	6,000	5			NZ III 16-Q	662528 38568				
6/4-3/4 x 2 x 5/8-11	6,000	5	NZ IV 16-P	662528 30765	NV14-R	662533 44371	37C16-P	662528 09609		
Rim 1-1/2" Back 3/4"	6,000	5			NV16-Q	662531 98584	57A16-Q	662528 09618		
	6,000	5			NVC16-Q	662531 46922	57AC16-Q	662528 09608		
	6,000	5			4NZ16-Q RB	690786 40484	574040 0 00	00070040405		
							57AC16-Q RB	690786 40485		
Type 11 Flaring Cup w	ith Steel Ba	ack ,								
4/3 x 2 x 5/8-11 Rim 3/4" Back 3/4"	9,070	10			NV16-Q	662531 46917				
5/3-13/16 x 2 x 5/8-11 Rim 1" Back 3/4"	7,260	10			NV16-Q	662531 46920				
6/4-13/16 x 2 x 5/8-11	6,000	5			NV14-R	662533 44373	57A16-Q	662528 09599		
Rim 1-1/2" Back 3/4"	6,000	5			NV16-Q	662531 98586	57AC16-Q	662528 09600		
	6,000	5			NVC16-Q	662531 46929	57AC16-Q RB	690786 40486		
	6,000	5			4NZ16-Q RB	690786 40487				
* Ctd Dka EO										

* Std.Pkg. = 50

RB = Low odor bond. Note: Ti formulation optimized for grinding Titanium

TECH TIP

Norton BlueFire and Gemini Type 11 cup wheels now available in new RB low odor bond to help reduce odors associated with portable grinding when used in confined spaces.

FOUNDRY WHEELS Portable Snagging



		7/50								
			BEST		BETTER		GOOD		GOOD	
			NORZON PLUS Zirconia Alumina		BLUEFIRE Ziroonia Alumiu	oo/Aluminum Ovide	GEMINI		METAL Aluminum Oxic	
	MAX.	ASIVE: Std.	ZIICOIIIa AluIIIIIia	1	ZIICOIIIa AluIIII	na/Aluminum Oxide		5		le
SIZE (D x T x H)	RPM		SPEC	PART #	SPEC	PART #	SPEC	PART #	SPEC	PART #
Type 16 Cones 😥										
1 x 3 x 3/8-24 (ME 107019)	36,290	10			NV20-S	662533 44376	57A24-R	614636 22342	Metal 24	662533 49752
1-1/2 x 2-1/2 x 3/8-24 (ME 44436)	24,190	10					57A24-R	614636 22349	Metal 24	662533 49754
1-1/2 x 2-1/2 x 5/8-11 ME 171651	24,190	10							Metal 20	690786 40046
1-1/2 x 3 x 3/8-24 (ME 139029)	24,190	10			NV20-S	662533 44377				
1-1/2 x 3 x 3/8-24 (ME 171652)	24,190	10							Metal 20	690786 40215
1-1/2 x 3 x 5/8-11 (ME 70535)	24,190	10	NZ IV 20-R	614636 44231	NV20-S	662533 44379	57A24-R	614636 22190	Metal 24	662533 49757
1-3/4 x 3 x 3/8-24 (ME49226)	20,735	10					57A24-R	614636 14503	Metal 24	662533 49840
1-3/4 x 3 x 5/8-11 (ME 33432)	20,740	10					57A24-R	614636 22195	Metal 24	662533 49841
2 x 3 x 3/8-24 ME 157287	18,145	10			11/00 0				Metal 24	662534 76413
2 x 3 x 5/8-11 (ME 28229)	18,145	10	NZ IV 20-R	614636 44232	NV20-S	662533 44381	57A24-R	614636 22218	Metal 24	662533 49846
2-3/4 x 3-1/2 x 5/8-11 (ME 18265)	13,195	10			NV20-S	662533 44383	57A24-R	614636 22387	Metal 24	662533 49855
3 x 3 x 5/8-11 (ME70537)	12,100	10							Metal 24	662434 96885
Type 17 Cones, Squar	24,190	>> 10					57A24-R	614636 22194	Metal 24	662533 49753
1-1/2 / 1/2 x 3 x 3/8-24 1-1/2 / 1/2 x 3 x 5/8-11	24,190	10					J/A24-11	01403022194	Metal 20	690786 40224
2 / 1/2 x 3 x 5/8-11	18,145	10					57A24-R	614636 15722	Metal 24	662533 49845
Type 17R Cones, Rour	, ~						01712111	01100010122	inotal E i	002000 100 10
2 / 3/4 x 3 x 5/8-11 (ME 151373)	18,145				NV20-S	662533 44384				
Type 18 Plugs, Square	e Tip 📠	-								
1-1/2 x 2-1/2 x 3/8-24	24,190	10					57A24-R	614636 22217	Metal 24	662533 49755
1-1/2 x 2-1/2 x 5/8-11	24,190	10	NZ IV 20-R	614636 44224	NV20-S	662533 44385	57A24-R	614636 22351	Metal 20	690786 40226
1-1/2 x 3 x 5/8-11	24,190	10	1711/02 5	014000	NV20-S	662533 44386	57A24-R	614636 22191	Metal 24	662533 49838
2 x 3 x 5/8-11	18,145 18,145	10 10	NZ IV 20-R	614636 44234	NV20-S NV24-S	662533 44387 662533 44391	57A24-R	614636 22219	Metal 24	662533 49847
2 x 4 x 5/8-11	18,145	10					57A24-R	614636 22366	Metal 24	662533 49850
Type 18R Plugs, Roun		~					57404 D	60070640020	Motal 20	60070640000
1-1/2 x 2-1/2 x 3/8-24 1-1/2 x 2-1/2 x 5/8-11	24,190	10 10					57A24-R	690786 40230	Metal 20 Metal 20	690786 40229 690786 40227
1-1/2 x 2-1/2 x 5/8-11 1-1/2 x 3 x 3/8-24	24,190 24,190	10					57A24-R	614636 22192	Metal 20	662533 49756
1-1/2 x 3 x 5/8-11	24,190	10					JI 727-11	01400022132	Metal 24	662434 95628
2 x 3 x 5/8-11	18.145	10			NV20-S	662533 44389	57A24-R	614636 22220	Metal 24	66253349849
3 x 3 x 5/8-11	12,095	10					5	5	Metal 20	690786 40231

Core Files

These files consist of coarse grit silicon carbide abrasive in a hard grade, resin-bonded to a reinforcing rod. Half-round in shape, they are a frequent choice for easy cleaning of rough castings.



		TIER:	GOOD								
		ABRASIVE:	Silicon Carbi	de							
SIZE (T x W x L)	STD. PKG.		SPEC.	PART #							
Stock Resinoid Core Files – Silicon Carbide											
1/2 x 1 x 10	5		37C24-SB	614636 10314							





FOUNDRY WHEELS Floorstand and Swingframe Snagging

Norton snagging wheels maximize your productivity in foundries, welding shops, fabrication facilities, steel mills, and ship yards.

Applications:

Size Range: Abrasive Grain: Shape: Reinforcement: Removing unwanted metal on castings, removing flaws and cracks, removing gates, risers and parting lines 24" and 30" diameters in stock; other diameters available as made-to-order Zirconia Alumina, Zirconia Alumina/Silicon Carbide blend, Aluminum Oxide Type 01 Straight

Strong fiberglass webbing and steel rings for maximum strength

Floorstand Snagging Wheel Material-to-Product Recommendation Guide

	BEST		BETTER	GOOD				
	4ZF1434- R5B38S	4ZF1434- Q5B38S	4NZ1434- R5B38S	4NZ1434- Q5B38S	ZI/25-R	ZI/26-Q	Charger	Gemini All Purpose
IRON								
Gray	•				•	•	Long Life	•
Ductile/Malleable		•			•	•	Long Life	•
STEEL								
Carbon and Low Alloy			•				Free Cut	•
Stainless and High Alloy				•			Free Cut	•

Note: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Swingframe Snagging Wheel Material-to-Product Recommendation Guide

BEST			GOOD				
4ZF1234-R5B38S	4ZF1434-R5B38S	NZC142-R5B38S	ZI/25-R	ZI/26-Q	Gemini All Purpose		
•			•	•	•		
•			•	•	•		
	•				•		
					•		
		•					
		•					

Note: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION				
Poor stock removal	Insufficient pressure applied	Increase pressure to use all available power				
	Wheel too coarse or hard	Use finer grit and/or softer grade wheel				
	Inadequate abrasive	Try NorZon, 4ZF, or ZI/25 specification				
Grinding costs too high	Wheel acting too soft	Use harder and/or coarser wheel				
	Low performance specification	Try NorZon or ZI products				
Wheel loading or glazing	Grade too hard	Try softer grade				
	Grit too coarse	Try finer grit				
	Dirty, scale-covered parts	Try NZC wheels				
Wheels "dusty"	Wheel too soft	Try harder grade				
Wheel doesn't hold corner or	Wheel too coarse	Use finer grit and/or 2 grit combination				
wheel spalling	Wheel too soft	Use harder grade				
Burning the workpiece	Wheel too hard	Use softer grade				
	Wheel glazed or loaded	Dress the wheel face				
	Grinding pressure too low	Increase grinding force				
	Grinding pressure too high	Reduce grinding force				
Surface finish too rough	Wheel too coarse	Try finer grit or try ZI/26 specification				
	Wheel speed too slow	Try higher speed machine (Do not exceed maximum operating speed of wheel)				
	Worn machine bearings	Rebuild machine				
Vibration	Wheel worn out of round	Try truing the wheel				
	Faulty flanges	Check flanges for flatness and burrs (see ANSI B7.1)				
	Bent machine spindle	Check spindle run-out				
	Worn machine bearings	Rebuild machine				
Wheel stalls or slows	Grinding force too high	Reduce pressure or contact area				
	Wheel too hard	Use softer grade wheel				
	Machine power too low	Replace machine with higher power grinder				



Best choice for demanding applications

4ZF, 4NZ, ZI, AND NZC ZIRCONIA ALUMINA

- · Zirconia alumina abrasive engineered for high-pressure, heavy duty, snagging operations including foundry snagging and stock removal
- · These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- 4ZF zirconia alumina grain for exceptional wheel life; engineered for high-pressure, heavy-duty, snagging operations, particularly on iron
- 4NZ zirconia alumina grain for sharpness and an exceptionally high cut rate; developed for low- to medium-pressure operations, especially on steel and steel castings; the most operator-friendly wheels
- ZI zirconia alumina grain stays sharper, longer, making it the choice for iron castings: ZI/25 for tough metal removal, ZI/26 for finer surface finish
- NZC zirconia alumina and silicon carbide blend is ideal for dirty, scale-covered castings

Better choice for strong performance to price ratio

CHARGER ZIRCONIA ALUMINA

- · Strong, free-cutting aluminum oxide abrasive for foundry snagging and stock removal
- · These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- · Good, general-purpose choice for heavy-duty stock removal on low- to medium-horsepower machines

Good choice for numerous small jobs

5ZF ZIRCONIA ALUMINA AND GEMINI ALUMINUM OXIDE

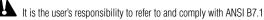
- · These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- · Ideal for lower horsepower machines or low-pressure applications
- 5ZF Versatile, good quality zirconia alumina abrasive for foundry snagging and stock removal
- · Gemini versatile aluminum oxide formulation works well with a variety of machines, horsepowers, and operations

		TIER:	BEST		BETTER		GOOD	
	7	RADENAMES:	4ZF, 4NZ, ZI, NZC		CHARGER		5ZF / GEMINI	
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type 01 Straight								
24 x 3 x 12	1,990	1	4ZF1234-R5B38S	690831 66310			5ZF14-QS	690831 66858
HS Steel Rings with Fine Centers, S Webs	1,990	1					Gemini All Purp.	690831 67173
30 x 2 x 12	1,595	1	4NZ1634-Q5B38S	692104 21412	Charger Free Cut	692104 21417	5ZF14-R	692104 67105
IS Steel Rings with	1,595	1	4ZF1434-R5B38S	692104 66458	Charger Long Life	692104 21418	Gemini All Purp.	692104 17463
ine Centers, S Webs	1,595	1	ZI/25-R	662531 19636			· · · · ·	
	1,595	1	ZI/26-Q	662531 19638				
	1,595	1	NZC142-R5B38S	692104 21414				

For your safety: all floorstand and swingframe wheels have strong fine centers, steel rings and high-strength fiberglass reinforcement construction.

TECH TIP

- Always ensure proper mounting of floorstand and swingframe wheels by mounting with arrow down as marked on wheel
- Always use safety guard
- Always run wheel for 1 minute before grinding
- For optimum performance, ensure adequate air pressure and air volume when using pneumatic machines
- · Use constant surface foot per minute machines for highest efficiency
- · Do not overdress the wheel face
- Avoid loading or glazing by changing the contact angle
- Use pressure assist whenever possible to obtain maximum cut rate



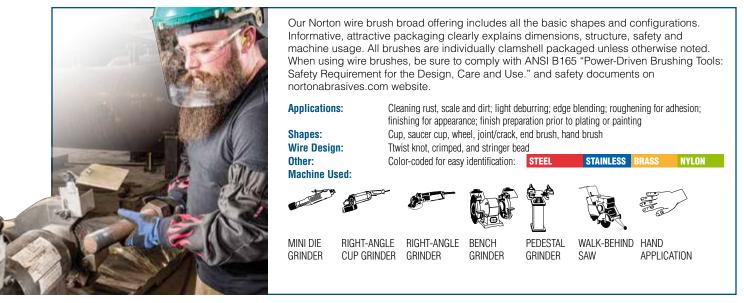
Wire Brushes

get wired FOR SUCCESS

Our broad wire brush offering includes the shapes, wire configurations and filament materials you'll need for heavy- to light-duty brushing applications.

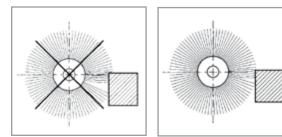


WIRE BRUSHES Wire Brush Basics



Why Use Wire Brushes vs. Other Brushes, Coated Abrasive, and Surface-Cleaning Products

Norton Wire brushes remove rust and oxidations, paint, slag, weld spatter and other unwanted surface contaminants, without removing any base material. Other products can remove base material along with the surface contaminant. Our flexible wire brushes are able to clean hard-to-reach places and conform to irregular surfaces, which more rigid products cannot do.





Crimped



Standard Twist Knot



Stringer Bead Twist Knot

Let the tip of the wire brush do the work – operate the brush with the lightest pressure. If heavy pressure is used, wires will be overstressed, resulting in a wiping action, which, if continued, creates wire fatigue and will shorten brush life. Reversing the rotation periodically sharpens the wire tips for faster cutting action and longer life. Use finest suitable wire size.



TECH TIP

When to Use Crimped Wire vs. Standard Twist Knot vs. Stringer Bead Twist Knot Brushes

Crimped Wire Brushes

Crimped wire brushes' individual filaments are supported only by each other – creating extra flexibility.

Ideal for work on irregular surfaces, finer surface finishing, and light- to medium-duty contaminant removal applications.

Standard Twist Knot Wire Brushes

Ensuring longer life, making them the choice for more aggressive applications requiring higher-impact action, and a rougher surface finish.

Standard twist knot brushes are made with straight wire filaments that are twisted together to make more rigid rope- or cable-like pieces.

Stringer Bead Twist Knot Wire Brushes

Stringer bead twist knots (vs. standard twist knots) are more tightly twisted to the end of the knot, creating a narrower face and highest-impact action.

The choice for tough weld scale cleaning, removing the bead scale that occurs at the initial joining of two sections of pipe, root and hot weld pass cleaning, and the most aggressive brushing applications.



Wire Diameter

Choose the appropriate wire brush wire diameter for the job

Very fine to fine wire for light-duty applications

voly into to into who for light duty upproducing a line into to the volume for heavy-duty approaches											
Wire	Coarse M		Medium t	Medium to Coarse		Medium		Fine		Very Fine	
DIAMETER IN INCHES	.032	.020	.020	.015	.012	.0104	.010	.008	.006	.005	
DIAMETER IN MM	.80	.50	.50	.37	.30	.26	.25	.20	.15	.13	

TECH TIP

Trim Length

Choose the appropriate trim length for the job. "Trim Length" equals the amount of usable filament:

- Longer trim lengths are more flexible, making them the choice for irregular surfaces
- Shorter trim lengths are fast acting and more rigid, so better for more severe applications

<u>TECH TIP</u>

Filament Do's and Don'ts

Excessive pressure bends and could break brush filaments. Instead of increasing the pressure applied, consider:

- A more aggressive brush:
- Increasing wire diameter
- Shorter trim length
- Different brush type, e.g. twist knot versus crimped wire

Medium to coarse wire for heavy-duty applications

· Increasing RPM without exceeding the MAX RPMs marked on the brush

Slick Packaging

A good looking product on and off the shelf. Norton BlueFire wire brushes come in a sturdy, clear clamshell package protecting the wire brush until it's ready for use. Educational information is prominently displayed for ease of selection in three languages. The new packaging will be a great addition to the merchandising POP display signage.

Instructional Videos



Wire Brushes Playlist

𝓎 nortonsga.us/wgazw

To learn which wire style is the best choice for your job and see what makes Norton Wire Brushes the ultimate power tool accessories.



Better choice for deburring, removing rust, paint, corrosion and weld spatter from metal surfaces

BLUEFIRE WIRE BRUSHES

- · Perfect for removing rust, scale, paint, and dirt from metal and other surface
- · Available in a variety of brush types and sizes for large flat areas to small, tight spaces
- · Durable design provides a uniform finish while offering the longest life



Good choice for removing rust oxidation, paint, slag and weld spatter without removing base material

GEMINI WIRE BRUSHES

- · Ideal low-impact solution for refining surfaces without removing any base material
- Flexible design for cleaning hard-to-reach places and conforming to irregular surfaces, which more rigid products cannot do

Economically priced yet solid-performing to complement your projects perfectly while bringing real savings to the bottom line



WIRE BRUSHES Wire Cup Brushes



Deburring; roughing; cleaning rust, scale, paint and oxidation; cleaning corners, recesses, and other hard-to-reach areas and removing concrete and large surfaces

WIRE CUP BRUSHES

- Used on right angle cup grinders
- Twist Knot style for heavy-duty applications
- · Crimped cup for light- to medium-duty applications

Twist Knot Wire Saucer Cup Brushes

• Saucer cup brushes are ideal for reaching into and cleaning corners and hard-to-reach areas where a standard cup brush cannot.

			TIER:	BETTER	BETTER
			TRADENAME:	BLUEFIRE	BLUEFIRE
			WIRE TYPE:	STEEL	STAINLESS
SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #
Twist Knot Wire Saucer (Cup Brushes - Single	Row - with Th	readed Nut		
4 x 0.020 x 5/8-11	7/8	15,000	5	662528 33483	
5 x 0.020 x 5/8-11	1-1/8	12,500	10	662528 35585	662528 35586

Twist Knot Wire Cup Brushes

- Their more rigid structure allows efficient, high-impact cutting and cleaning on more demanding applications.
- · Single row construction limits flaring of the brush on corners and angles

	Y							-	-
			TIER:	BETTER	BETTER	BETTER	BETTER	GOOD	GOOD
			TRADENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
			WIRE TYPE:	STEEL	STAINLESS	STEEL	STEEL	STEEL	STAINLESS
SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #					
Twist Knot Wire Cup Brushes -	Single Row - v	ith Threade	d Nut						
2-3/4 x 0.014 x 5/8-11	7/8	14,000	5						662528 38871
2-3/4 x 0.014 x 5/8-11	1	14,000	5					662528 39109	
2-3/4 x 0.020 x 5/8-11	3/4	15,000	5	699366 53336	699366 53340				
2-3/4 x 0.020 x 5/8-11	1	14,000	10					662528 39033	662528 38812
3 x 0.020 x 5/8-11	7/8	14,000	5					662528 38835	662528 39127
3 x 0.020 x M10	7/8	14,000	5					662528 39075	
3-1/2 x 0.020 x 5/8-11	7/8	13,000	5					662528 38813	
3-1/2 x 0.020 x 5/8-11	1-3/8	13,000	5					662528 38868	
4 x 0.020 x 5/8-11	1-1/8	9,000	10					662528 39103	
4 x 0.020 x 5/8-11 with bridle	1-1/16	10,200	5	699366 53345	662528 33947				
4 x 0.023 x 5/8-11	1-1/4	9,000	5					662528 39090	
6 x 0.020 x 5/8-11	1-3/8	6,000	5	699366 05965	662533 71115			662528 39104	
6 x 0.023 x 5/8-11	1-3/8	6,000	5					662528 39091	
6 x 0.035 x 5/8-11	1-3/8	6,000	5	699366 02003					
Twist Knot Wire Cup Brushes -				tective Guard					
2-3/4 x 0.020 x 5/8-11	3/4	15,000	5			662528 33492			
4 x 0.020 x 5/8-11	1-1/8	10,200	5			662528 33496			
5 x 0.020 x 5/8-11	1-1/8	6,500	5			662528 33497			
Twist Knot Wire Cup Brushes -									
6 x 0.020 x 5/8-11	1-3/8	6,000	5				699366 53346		





WIRE BRUSHES Wire Cup Brushes

Crimped Wire Cup Brushes

For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing where added flexibility is needed; fast-cutting and flexible, with heavy wire fill

- Machine for cups with threaded nuts: right angle cup grinder
- · Machine for stem mounted cups: straight in-line grinder, pencil grinder



			TIER:	BETTER
			TRADENAME:	BLUEFIRE
			WIRE TYPE:	STEEL
A	TRIM	MAX.	STD.	
SIZE	LENGTH	RPM	PKG.	PART #
High Performance Cable C - with Threaded Nut and P			hes	
3 x (12 x 0.009) x 5/8-11	7/8	15,000	5	662528 33493
4 x (12 x 0.009) x 5/8-11	1-3/16	9,000	5	662528 33494



			WIRE TYPE:	STEEL	STAINLESS	STEEL
0175	TRIM		STD.			
SIZE	LENGTH	MAX. RPM	PKG.	PART #	PART #	PART #
Crimped Wire Cup Brush	es – with Thr	eaded Nut				
2-3/4 x 0.014 x 5/8-11	1	14,000	5			662528 38856
2-3/4 x 0.020 x 3/8-24	1	14,000	5			662528 39080
3 x 0.014 x 5/8-11	13/16	14,000	5			662528 39076
3 x 0.014 x 5/8-11	7/8	15,000	5	699366 53341	662528 36362	
3 x 0.014 x 5/8-11	1	14,000	10			662528 39034
4 x 0.014 x 5/8-11	1-1/8	9,000	10			662528 39121
4 x 0.014 x 5/8-11	1-3/16	10,200	5	699366 53347		
4 x 0.020 x 5/8-11	1-3/16	10,200	1	699573 70103		
4 x 0.020 x 5/8-11	1-3/16	10,200	5		662528 43844	
5 x 0.014 x 5/8-11	1-3/8	8,000	5			662528 39105
6 x 0.014 x 5/8-11	1-1/8	6,600	5	699366 53348		
6 x 0.020 x 5/8-11	1-1/8	6,600	5	699366 53349		

TIER: BETTE TRADENAME: BLUEFIRE





* Brass-coated carbon steel filaments

4 x 0.014 x 5/8-11



				ANT THE REAL OF	AND IN COLUMN	She was
			TIER:	GOOD	GOOD	GOOD
			TRADENAME:	GEMINI	GEMINI	GEMINI
			WIRE TYPE:	STEEL	STAINLESS	BRASS
SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Crimped Wire Cup Brus	hes - with Ste	em				
5/8 x 0.005 x 1/8	1/4	37,000	100			662528 39087
1-3/4 x 0.012 x 1/4	3/4	13,000	12	662528 39028		
2 x 0.010 x 1/4	5/8	10,500	12		662528 38859	
2-1/4 x 0.014 x 1/4	5/8	4,500	10	662528 38860		



BLUEFIRE

GEMINI



WIRE BRUSHES Wire Wheel Brushes





Applications range from the toughest, more aggressive surface cleaning applications, including removing weld scale, spatter, extra-heavy rust and corrosion, cleaning pipe joints, or surface roughening to light- to medium- duty surface cleaning and contaminant removal

WIRE WHEEL BRUSHES

- · Available in Standard Twist Knot, Stringer Bead Twist Knot, and Crimped
- · See specific machines for each wire wheel below

Standard Twist Knot Wire Wheel Brushes

Our twist knot wire design provides added rigidity for extra cutting and cleaning power, and a rougher surface finish.

- Wheel brushes with threaded nuts perform well on more aggressive applications requiring high-impact action: tough
 welding and metal fabrication applications, including removing weld scale, spatter, extra-heavy rust.
- These stem-mounted wheel brushes are used for small-to medium-duty jobs requiring some flexibility and lighter brushing action for corrosion, or surface roughing applications. These brushes are used on straight shaft, die, pencil grinders, drills and right angle grinders.

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- Sandara	N/W		TRA	DENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
			Ŵ	IRE TYPE:	STEEL	STAINLESS	PIPELINE	STEEL	STAINLESS
	FACE	TRIM	MAX.	STD.					
SIZE	WIDTH	LENGTH	RPM	PKG.	PART #				
Standard Twist Knot Wire V	Wheel Brushes	– with Thre	aded Nut						
4 x 0.014 x 5/8-11	1/2	3/4	20,000	6	699573 70137				
4 x 0.014 x 5/8-11	1/2	7/8	20,000	10				662528 39052	
4 x 0.020 x 5/8-11	1/2	3/4	20,000	5	662528 38300				
4 x 0.020 x 5/8-11	1/2	3/4	20,000	6		699573 70138			
4 x 0.020 x 5/8-11	1/2	7/8	20,000	5				662528 39078	662528 39020
4 x 0.020 x 5/8-11	1/2	7/8	20,000	10				662528 39035	
4 x 0.020 x 5/8-11	9/16	7/8	20,000	10				662528 39019	
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	5	699366 06275	699366 53333			
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	6	699366 53331				
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	6			662528 40466		
5 x 0.020 x 5/8-11	1/2	1	12,500	5	662528 33487	662528 33488			
6 x 0.020 x 5/8-11	1/2	1-3/8	12,500	5	699366 53352				
6 x 0.020 x 5/8-11	5/8	1-1/4	9,000	5				662528 39107	
Standard Twist Knot Wire V	Wheel Brushes	– with Arbo	or Hole						
3 x 0.014 x 3/8	3/8	5/8	25,000	1				662528 39021	
4 x 0.014 x 5/8	5/16	7/8	20,000	5				662528 39011	
4 x 0.014 x 5/8	1/2	3/4	20,000	6	699573 70136				
6 x 0.014 x 5/8	1/2	1-1/2	9,000	5				662528 39014	
· · · ·			,						



				TIER:	GOOD
			ī	TRADENAME:	GEMINI
				WIRE TYPE:	STEEL
SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #
Standard Twist Kno	t Wire Wheel Bı	rushes - with St	em		
3 x 0.014 x 1/4	1/4	5/8	25,000	12	662528 39015
3-1/4 x 0.014 x 1/4	3/8	5/8	25,000	10	662528 39031
4 x 0.014 x 1/4	1/2	7/8	25.000	8	662528 39032



WIRE BRUSHES Wire Wheel Brushes

4224-



Stringer Bead Twist Knot Wire Wheel Brushes

The choice for toughest weld scale cleaning; removing the bead scale that occurs at the initial joining of two sections of pipe; root, and hot weld pass cleaning, and the most aggressive brushing applications. Stringer Bead Twist Knot Wire Wheel Brushes are best used on right angle grinders for difficult jobs.

			e P F							EOE	TOF
75	200	0.0		TIER:	BETTER	BETTER	BETTER	BETTER	BETTER	GOOD	GOOD
90	ALL ALL ALL	ALC:	трлг	ENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
		Van		RE TYPE:	STEEL	STEEL	STEEL	STAINLESS	STAINLESS	STEEL	STAINLESS
	and while done		V V 11	OTHER:	UILLE	Pipeline	Heavy-Duty	OTAINEE00	Pipeline	UTLL	OTAINEESS
	FACE	TRIM	MAX.	STD.		ripelille	Heavy-Duly		ripenne		
SIZE	WIDTH	LENGTH		PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #
Stringer Bead Knot Wi	ire Wheel	Brushes -	– with Th	readed	Nut						
4 x 0.020 x 5/8-11	3/16	7/8	20.000	5	699366 06277			699366 06278			
4 x 0.020 x 5/8-11	3/16	7/8	20,000	6		662528 40467 *			66252842233*		
4 x 0.020 x 5/8-11	3/16	7/8	20.000	10	66253370022*					662528 39036	662528 39039
4 x 0.020 x 5/8-11	1/4	7/8	20,000	5						662528 38997	
4 x 0.020 x 5/8-11	1/4	7/8	20,000	10							
4 x 0.020 x 5/8-11	1/2	7/8	20,000	10						662528 39130	
4 x 0.020 x 5/8-11	1/2	1	20,000	10						662528 39106	
4 x 0.020 x M10	3/16	7/8	20,000	6				699573 70144			
4 x 0.020 x M10	3/16	7/8	20,000	10							
4-1/2 x 0.020 x 5/8-11	3/16	3/16	15,000	5						662528 39111	
4-1/2 x 0.020 x 5/8-11	3/16	1-1/8	12,500	6		662528 42299 *	662528 44886				
5 x 0.020 x 5/8-11	3/16	7/8	12,500	10	662528 33490 *			662528 33491 *			
5 x 0.020 x 5/8-11	1/2	7/8	12,500	5						662528 39133	
6 x 0.020 x 5/8-11	3/16	1-3/8	12,500	10		662528 40469 *		699366 53351			
6-7/8 x 0.020 x 5/8-11	3/16	1-1/8	9,000	10		662528 40468 *	662528 43919 *				
9 x 0.020 x 5/8-11	3/16	2-1/8	6,000	6	662528 37993						
Joint Crack Cleaning											
12 x 0.035 x 1-DP	3/8	3-1/4	4,500	2	699366 06280						
*Dully Dealand Hom											

*Bulk Packed Item



Radial Wheel

Nylon Radial Wheel Brushes are best used for deburring, surface and light cleaning, adding an edge radius on ferrous and non-ferrous parts. The long trim length is ideal when used on intricate or irregular parts.

• Machine: Bench and Pedestal, Automated CNC, Inline Grinders

				TIER:	GOOD
			ī	RADENAME:	GEMINI
				WIRE TYPE:	NYLON
SIZE	FACE Width	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #
Radial Wheel with Arbor Hole					
8 x 3/8 x 5/8	3/8	15/16	15,000	12	662528 38842

Crimped Wire Wheel Brushes

Stem-mounted wheel brushes are used on straight shaft, die, and pencil grinders, and drills. Wheel brushes with arbor holes are used on bench and pedestal grinders. Their extra flexibility and lower impact makes these brushes an excellent choice for cleaning irregular surfaces and finer surface finishing, and light to medium duty surface contaminant removal applications. May be used individually or stacked on a shaft.

· Narrow-faced brushes are ideal for general-purpose brushing of uneven or difficult-to-reach surfaces.

R 3

· Medium-faced brushes clean larger surface areas and have longer life



Crimped Wire with Threaded Nut – Narrow Face – Steel

ionger me.						0	0
					TIER:	BETTER	GOOD
					TRADENAME:	BLUEFIRE	GEMINI
					WIRE TYPE:	STEEL	STEEL
SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.		PART #	PART #
						FANI #	FANT #
Crimped Wire Wheels E		with Inrea		Narrow Fa	ce		
4 x 0.014 x 5/8-11	7/16	7/8	15,000	10			662528 39001
Crimped Wire Wheels E	Brushes	with Threa	ded Nut –	Medium Fa	ace		
4-1/2 x 0.014 x 5/8-11		1	13,000	6		662533 70278	



WIRE BRUSHES Wire Wheel Brushes

				TIER:	BETTER	GOOD	GOOD
			111111	DENAME:	BLUEFIRE	GEMINI	GEMINI
				RE TYPE:	STEEL	STEEL	STAINLESS
SIZE	FACE Width	TRIM Length	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Crimped Wire Wheels	Brushes	with Arbo	r Hole – N	arrow Fa	ce		
2 x 0.014 x 1/2	3/8	1/2	20,000	12		662528 39023	
3 x 0.005 x 1/2	1/4	1	20,000	20			662528 38960
3 x 0.014 x 1/2	5/8	1	20,000	10		662528 39024	
6 x 0.014 x 1/2-2	3/4	1-1/8	6,500	5	699366 53306		
8 x 0.014 x 5/8	3/4	1-9/16	4,500	5		662528 39099	
8 x 0.014 x 5/8	3/4	1-5/8	4,000	1	699573 70117		
8 x 0.014 x 5/8	3/4	2-1/16	6,000	5		662528 39089	
8 x 0.014 x 1-1/4	5/8	1-1/2	4,000	5		662528 38978	
Crimped Wire Wheels	Brushes						
6 x 0.014 x 1/2-2	1	1-1/8	6,500	5	699366 53324		
8 x 0.014 x 1/2-2	1-1/16	1-5/8	4,500	5	699366 53326		
8 x 0.014 x 5/8	1	1-9/16	4,000	5		662528 39100	
8 x 0.014 x 2	1	1-3/8	4,500	5		662528 39025	
10 x 0.014 x 3/4	1-9/16	2-1/2	3,600	1		662528 39102	
<u>12 x 0.012 x 2</u>	2	2	3,600	1	699573 70135		
12 x 0.012 x 2	2	3-1/4	3,600	1		662528 39006	



Crimped Wire with Arbor hole - Narrow Face - Steel



				HER:	BEITER	BEITEK	GUUD	GUUD	GUUD
			TRADE	NAME:	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI	GEMINI
			WIRE	TYPE:	STEEL	STAINLESS	STEEL	STAINLESS	BRASS
\$17E		TRIM	MAX.	STD.	DADT #	DADT #	DADT #	DADT #	PART #
						FANT T	ΓANT π	ΓANT π	
					i lii əleili				
1 x 0.005 x 1/8	1/8	5/16	37,000	100					662528 39085
1-1/2 x 0.008 x 1/4	1/4	1/4	25,000	20			662528 38962		
1-1/2 x 0.014 x 1/4	1/4	1/4	25,000	20			662528 38963		
2 x 0.006 x 1/4	3/8	1/2	20,000	20			662528 39029		
2 x 0.008 x 1/4	3/8	7/16	25,000	20			662528 38964		
2 x 0.0118 x 1/4	3/8	1/2	20,000	20			662528 39030		
2 x 0.014 x 1/4	3/8	7/16	25,000	12	699573 70123				
2-1/2 x 0.008 x 1/4	7/16	11/16	25,000	10			662528 38967		
2-1/2 x 0.014 x 1/4	5/8	5/8	25,000	12	699573 70126				
3 x 0.008 x 1/4	7/16	3/4	25,000	10			662528 38969		
3 x 0.008 x 1/4	7/16	3/4	25,000	12				662528 38972	
3 x 0.0118 x 1/4	5/8	5/8	25,000	12	699573 70132				
3 x 0.014 x 1/4	7/16	3/4	25,000	12				662528 38973	
3 x 0.014 x 1/4	1/2	1	20,000	20				662528 39048	
3 x 0.014 x 1/4	5/8	5/8	25,000	12	699573 70130	699573 70131			
3 x 0.020 x 1/4	3/8	1	20,000	12			662528 39096		
4 x 0.014 x 1/4	1/2	1	25,000	12			662528 38974		
	$\begin{array}{c} 1 \times 0.005 \times 1/8 \\ 1-1/2 \times 0.008 \times 1/4 \\ 1-1/2 \times 0.014 \times 1/4 \\ 2 \times 0.006 \times 1/4 \\ 2 \times 0.006 \times 1/4 \\ 2 \times 0.008 \times 1/4 \\ 2 \times 0.0118 \times 1/4 \\ 2 \times 0.014 \times 1/4 \\ 2 -1/2 \times 0.008 \times 1/4 \\ 3 \times 0.014 \times 1/4 \\ 3 \times 0.020 \times 1/4 \end{array}$	SIZE WIDTH Crimped Wire Wheels Brus 1/8 1-1/2 x 0.005 x 1/8 1/8 1-1/2 x 0.008 x 1/4 1/4 1-1/2 x 0.014 x 1/4 1/4 2 x 0.006 x 1/4 3/8 2 x 0.008 x 1/4 3/8 2 x 0.018 x 1/4 3/8 2 x 0.018 x 1/4 3/8 2 x 0.014 x 1/4 5/8 3 x 0.008 x 1/4 7/16 3 x 0.018 x 1/4 7/16 3 x 0.014 x 1/4 5/8 3 x 0.014 x 1/4 1/2 3 x 0.014 x 1/4 5/8 3 x 0.014 x 1/4 5/8 3 x 0.014 x 1/4 5/8 3 x 0.020 x 1/4 3/8	SIZE WIDTH LENGTH Crimped Wire Wheels Brushes with I 1 x 0.005 x 1/8 1/8 5/16 1-1/2 x 0.008 x 1/4 1/4 1/4 1/4 1-1/2 x 0.008 x 1/4 1/4 1/4 1/4 1-1/2 x 0.006 x 1/4 3/8 1/2 2 x 0.006 x 1/4 3/8 1/2 2 x 0.006 x 1/4 3/8 1/2 2 x 0.014 x 1/4 3/8 1/16 2 x 0.014 x 1/4 3/8 1/2 2 x 0.014 x 1/4 3/8 1/16 2 - 1/2 x 0.008 x 1/4 7/16 11/16 2-1/2 x 0.008 x 1/4 7/16 3/4 3 x 0.008 x 1/4 7/16 3/4 3/4 3/4 3/4 3/4 3 x 0.008 x 1/4 7/16 3/4	FACE VIIDTH TRIM LENGTH MAX. RPM SIZE FACE WIDTH TRIM LENGTH MAX. RPM Crimped Wire Wheels Brushes with Narrow F. 1 x 0.005 x 1/8 1/8 5/16 37,000 1-1/2 x 0.008 x 1/4 1/4 1/4 25,000 1-1/2 x 0.014 x 1/4 1/4 1/4 25,000 2 x 0.006 x 1/4 3/8 1/2 20,000 2 x 0.006 x 1/4 3/8 1/2 20,000 2 x 0.014 x 1/4 3/8 1/2 20,000 2 x 0.014 x 1/4 3/8 7/16 25,000 2 x 0.014 x 1/4 3/8 7/16 25,000 2 x 0.014 x 1/4 7/16 11/16 25,000 2 x 0.014 x 1/4 7/16 3/4 25,000 3 x 0.008 x 1/4 7/16 3/4 25,000 3 x 0.0118 x 1/4 5/8 5/8 25,000 3 x 0.014 x 1/4 1/2 1 20,000 3 x 0.014 x 1/4 1/2 1 20,000 3 x 0.014 x 1/4 5/8 5/8 25,000	$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$	TRADENAME: BLUEFIRE WIRE TYPE: STEEL SIZE FACE WIDTH TRIM LENGTH MAX. PPM STD. PKG. PART # Crimped Wire Wheels Brushes with Narrow Face - with Stem 1 x 0.005 x 1/8 1/8 5/16 37,000 100 1-1/2 x 0.008 x 1/4 1/4 1/4 25,000 20 1-1/2 x 0.004 x 1/4 1/4 1/4 25,000 20 2 x 0.006 x 1/4 3/8 7/16 25,000 20 2 x 0.006 x 1/4 3/8 1/2 20,000 20 2 x 0.014 x 1/4 3/8 1/2 20,000 20 2 x 0.014 x 1/4 3/8 1/12 20,000 20 2 x 0.014 x 1/4 3/8 7/16 25,000 12 2 x 0.014 x 1/4 3/8 5/8 25,000 12 3 x 0.008 x 1/4 7/16 3/4 25,000 12 3 x 0.014 x 1/4 5/8 5/8 25,000 12 3 x 0.014 x 1/4 1/2 1 20,000 20 3 x 0.014 x 1/4 5/8 </td <td>TRADENAME: BLUEFIRE WIRE TYPE: BLUEFIRE STEEL BLUEFIRE STAINLESS SIZE FACE WIDTH TRIM LENGTH MAX. RPM STD. PKG. PART # Crimped Wire Wheels Brushes with Narrow Face - with Stem 1 x 0.005 x 1/8 1/8 5/16 37,000 100 1-1/2 x 0.008 x 1/4 1/4 5/16 37,000 100 1 1-1/2 x 0.004 x 1/4 1/4 1/4 25,000 20 1 1 2 x 0.006 x 1/4 3/8 7/16 25,000 20 2 2 1 2 1 2 1 2 2 0 2 2 1 3 1 2 0 20 2 2 1 1 1 4 2 2 0 2 2 2 1 3 7 1 2 0 2 2 1 1 1 2 2 0 2 2 1 2 1 2 1 2 2 1 2</td> <td>TRADENAME: BLUEFIRE BLUEFIRE GEMINI WIRE TYPE: STEEL STAINLESS STEEL STEEL</td> <td>TRADENAME: BLUEFIRE BLUEFIRE GEMINI GEMINI SIZE FACE TRIM MAX. STD. PART # PART #</td>	TRADENAME: BLUEFIRE WIRE TYPE: BLUEFIRE STEEL BLUEFIRE STAINLESS SIZE FACE WIDTH TRIM LENGTH MAX. RPM STD. PKG. PART # Crimped Wire Wheels Brushes with Narrow Face - with Stem 1 x 0.005 x 1/8 1/8 5/16 37,000 100 1-1/2 x 0.008 x 1/4 1/4 5/16 37,000 100 1 1-1/2 x 0.004 x 1/4 1/4 1/4 25,000 20 1 1 2 x 0.006 x 1/4 3/8 7/16 25,000 20 2 2 1 2 1 2 1 2 2 0 2 2 1 3 1 2 0 20 2 2 1 1 1 4 2 2 0 2 2 2 1 3 7 1 2 0 2 2 1 1 1 2 2 0 2 2 1 2 1 2 1 2 2 1 2	TRADENAME: BLUEFIRE BLUEFIRE GEMINI WIRE TYPE: STEEL STAINLESS STEEL STEEL	TRADENAME: BLUEFIRE BLUEFIRE GEMINI GEMINI SIZE FACE TRIM MAX. STD. PART # PART #



Crimped WIre with Stem





Clean and deburr recessed areas or inside diameters of tubes and pipes to proper surface finish; rubber and plastic flash removal; paint and rust removal, and mold and tool polishing

END BRUSHES

- Used on CNC, Robotic, die grinders, and drill presses
- Twist knot wire end brushes for more aggressive cutting
- · Crimped wire end brushes for lighter brushing action and contoured surfaces



Twist Knot Wire End Brush

Their added wire rigidity makes these brushes the choice for more aggressive cutting.

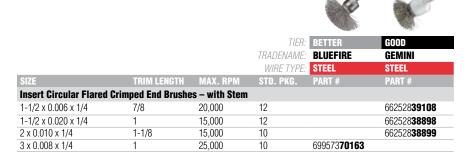
			TIER:	BETTER	BETTER	GOOD	GOOD
. Allas	A Land		TRADENAME:	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
			WIRE TYPE:	STEEL	STAINLESS	STEEL	STAINLESS
IZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
wist Knot Wire End Br	rushes – with Stem						
/2 x 0.006 x 1/4	1-1/8	22,000	20			662528 38876	
/2 x 0.014 x 1/4	1-1/8	22,000	20			662528 38877	
/4 x 0.014 x 1/8	7/8	22,000	20			662528 39056	
/4 x 0.014 x 1/4	7/8	25,000	10		699573 70165		
/4 x 0.014 x 1/4	7/8	22,000	20			662528 38879	
/4 x 0.020 x 1/4	7/8	25,000	10	699366 53316 *			
/4 x 0.020 x 1/4	7/8	22,000	20			662528 39057	
/4 x 0.020 x 1/4	1	22,000	20			662528 39116	662528 39118
/4 x 0.020 x 1/4	1-1/8	22,000	20			662528 38878	
x 0.006 x 1/4	1-1/8	22,000	20				662528 38885
x 0.010 x 1/4	1-1/8	22,000	25				662528 38886
x 0.014 x 1/4	7/8	25,000	10	699366 06279 *	699573 70167		
x 0.014 x 1/4	1	22,000	20			662528 38882	662528 38887
x 0.020 x 1/4	7/8	25,000	10	699366 53310 *			
x 0.020 x 1/4	1	22,000	20				662528 39119
x 0.020 x 1/4	1	22,000	25			662528 39117	

* Bulk Packed Item



Insert Circular Flared Crimped Wire End Brush

The flared end configuration facilitates interior side cleaning and will not harm the bottom of the hole.





WIRE BRUSHES End Brushes



Crimped Wire End Brushes

Designed to generate lighter brushing action and reach into contoured surfaces.

all the second and				C.		C.T.
		TIER	BETTER	BETTER	GOOD	GOOD
		TRADENAME		BLUEFIRE	GEMINI	GEMINI
		WIRE TYPE.	STEEL	STAINLESS	STEEL	STAINLESS
TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
s – with Stem						
	37 000	12				662528 39086
1						662528 38902
3/8	25,000	20			662528 39040	
1	25,000	20			662528 38889	662528 39043
1	25,000	20			662528 38890	
1	25,000					662528 38888
1	25,000				662528 38891	
1	25,000	10		699366 06145 *		
3/8	22,000				662528 39053	
1	25,000	10	699366 53317 *			
7/8	22,000	20			662528 39112	
1	25,000	10	699573 70152			
1	22,000				662528 38892	
1						662528 38896
1	22,000				662528 39045	662528 38838
1-3/16	25,000		699573 70154	699573 70155		
1	22,000					662528 38897
1						662528 39055
1-3/16				699573 70157		
3/4					662528 39094	
1	22,000				662528 39046	
1-3/16	25,000		699573 70158			
7/8	22,000				662528 39095	
1-3/16	25,000	10	699366 53309 *			
	s – with Stem 7/16 1 3/8 1 1 1 1 1 1 3/8 1 1 7/8 1 1 1 1 1 1 1 1 1 1 1 1 1	s – with Stem 7/16 37,000 1 25,000 3/8 25,000 1 25,000 1 25,000 1 25,000 1 25,000 1 25,000 1 25,000 1 25,000 3/8 22,000 1 25,000 1 25,000 1 25,000 1 22,000 1 3/4 20,000 1 3/4 20,000 1 3/4 20,000 1 3/4 22,000 1 3/4 22,000	TRIM LENGTH MAX. RPM STD. PKG. s - with Stem 7/16 37,000 12 1 25,000 20 3/8 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 10 3/8 22,000 20 1 25,000 10 7/8 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20	TRIM LENGTH MAX. RPM STD. PKG. PART # s - with Stem 7/16 37,000 12 1 25,000 20 3/8 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 10 69936653317* 7/8 7/8 22,000 20 1 25,000 10 1 22,000 20 1 22,000 20 1 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20	TRADENAME: BLUEFIRE BLUEFIRE STAINLESS TRIM LENGTH MAX. RPM STD. PKG. PART # PART # s - with Stem 7/16 37,000 12 1 25,000 20 3/8 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 25,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1 22,000 20 1	TRADENAME: BLUEFIRE BLUEFIRE GEMINI WIRE TYPE STELL STAINLESS STEEL STAINLESS STEEL TRIM LENGTH MAX. RPM STD. PKG. PART # PART # PART # PART # 7/16 37,000 12 -





WIRE BRUSHES Tube Brushes



Cleaning, polishing, reaming, finishing and removing debris, burrs, rust, residues, and surface contaminants inside cylindrical items, including tubes, pipes, bottles, smooth-sided and threaded holes, and other industrial components

TUBE BRUSHES

- Use manually or fastened to portable or fixed machines (including drills, drill presses, and CNC machines)
- Available in single and double stem providing firm support when working internally
- A wide selection of shapes and filament variations to achieve the best results on many different applications



Single Stem, Single Spiral Tube Brush – with Eye Loop

These spiral brushes have a single layer of filament twisted around a stem wire to create additional strength and higher density fill brushes. This spiral configuration ensures consistent and constant abrasive contact with the tube. Formed eye loop at the end of the stem for convenient hand use.

		TIER:	GOOD	GOOD	GOOD
	TRA	DENAME:	GEMINI	GEMINI	GEMINI
	Ŵ	IRE TYPE:	STEEL	STAINLESS	BRASS
SIZE	TRIM LENGTH	STD. PKG.	PART #	PART #	PART #
Single Stem, Single Sp	oiral Tube Bru	sh – with	1 Eye Loop		
3/16 x 0.004 x 0.094	5/64	12	662528 38913		
3/16 x 0.003 x 0.094	1-1/2	12	662528 38822		
1/4 x 0.004 x 0.115	5/64	12	662528 38914		
3/8 x 0.004 x 0.125	2	12			662528 38826
3/8 x 0.004 x 0.132	1/8	12	662528 38916		
3/8 x 0.006 x 0.168	1-1/2	12		662528 38946	



Double Stem, Single Spiral Tube Brush – with Stem

These brushes have two stem wires. This results in a brush with high strength and one with consistent and constant abrasive contact with the tube.

			MIC MONTH
		TIER:	GOOD
	TR	ADENAME:	GEMINI
	ļ	VIRE TYPE:	NYLON
SIZE	TRIM LENGTH	STD. PKG.	PART #
Double Stem, Single Sp	iral Tube Br	ush – with	Stem
3/4 x 0.040 x 0.238	3/8	12	662528 38850



WIRE BRUSHES Tube Brushes



Power Burr, Single Spiral Tube Brush – with Stem

Power burr brushes are used to remove burrs resulting from previous operations. They are designed to remove burrs without creating secondary burrs or leaving sharp edges.



Double Stem, Double Spiral Tube Brush – with Stem

Brush filaments are twisted between two stem wires with two layers of filament bristles. Each layer is perpendicular to the other with a single stem wire in each of the brush's four sections. This configuration ensures consistent and constant abrasive contact with the tube.



C

Single Spiral Nylon Hand Tube Brush – with Eye Loop

These brushes are made with larger stem wires to give them the strength and rigidity needed for manual cleaning applications.

			- Adde	144
		TIEI	R: GOOD	GOOD
		TRADENAM	E: GEMINI	GEMINI
		WIRE TYP	E: STEEL	STAINLESS
SIZE	TRIM LENGTH	STD. PKG.	PART #	PART #
Power Burr Single Spiral	Tube Brushes – with Stem			
1/4 x 0.004 x 0.125	1	12	662528 39061	662528 39081
3/8 x 0.004 x 0.125	1	12	662528 39062	662528 39050
3/8 x 0.005 x 0.125	9/64	12	662528 38910	
1/2 x 0.005 x 0.188	1	12	662528 39063	662528 39051
5/8 x 0.005 x 0.188	1	12	662528 39064	
3/4 x 0.006 x 0.219	1	12	662528 39065	
1 x 0.005 x 0.125	15/32	12	662528 38912	
1 x 0.005 x 0.250	1	12	662528 39066	662528 39083

			internet.
			TIER: GOOD
		TRADEI	VAME: GEMINI
		WIRE	TYPE: BRASS
SIZE	BRUSH LENGTH	STD. PKG.	PART #
Double Stem, Double Spin	al Tube Brush – with Stem		
3/4 x 0.006 x 0.250	2-1/2	12	662528 38832

			Hanna and a second seco
			TIER: GOOD
		TRADEI	VAME: GEMINI
		WIRE	TYPE: NYLON
SIZE	TRIM LENGTH	STD. PKG.	PART #
Single Spiral Nylon Hand Tu	ıbe Brush – with Eye Loop		
1/2 x 0.008 x 0.094	3	12	662528 38939
1/2 x 0.010 x 0.125	3	12	662528 38820
1 x 0.010 x 0.156	25/64	12	662528 38941
1 x 0.022 x 0.156	2-1/2	12	662528 38817
1-1/4 x 0.010 x 0.219	1/2	12	662528 38943
2 x 0.010 x 0.219	1/2	12	662528 38944



WIRE BRUSHES Tube and Hand Brushes



Flue Double Spiral Tube Brushes – with 1/4" x 2" NPT Pipe Nipple with Stem

These aggressive brushes are designed specifically for efficient pipe and boiler cleaning.

			TIER: GOOD
		TRADEI	IAME: GEMINI
		WIRE	TYPE: STEEL
SIZE	TRIM LENGTH	STD. PKG.	PART #
Flue Double Spiral Tube Br	ushes – with 1/4" x 2" NP	T Pipe Nipple – with	Stem
1 x 0.010 x 0.313	25/64	12	662528 38932
1-3/4 x 0.012 x 0.313	1/2	12	662528 38934



Side-Action Tube Crimped Wire Tube Brushes – with Stem

Their dense side filament configuration creates increased bristle rigidity with minimal flexing, to aggressively clean the tube without changing its geometry or surface finish.

			TIER: GOOD
		TRADEI	NAME: GEMINI
		WIRE	TYPE: STEEL
SIZE	TRIM ENGTH	STD. PKG.	PART #
Side-Action (Burrite) Cri	mped Wire Tube Brush – v	vith Stem	
1/4 x 0.003 x 0.094	5/64	12	662528 38908

Hand Brushes

Hand brushes come in a variety of handle and filament shapes and styles for most hand scratching applications. They are favored by many in removing scale, surface coatings, or removing weld debris.



For steel/stainless

HAND BRUSHES

- Long handle and shoe handle brushes are made with a high-carbon, brass-coated steel; stainless steel is made with a 302 stainless.
- Plastic ergonomic handle scratch brush with curved face to access hard-to-reach places. Crimped wire for longer life. Wires are wrapped up and around the metal post so they never come out.
- · Narrow brush allows access into tight areas and slots.

				IIIIII MARTINA	and the second	and the second		Challes
			TIER:	BETTER	BETTER	BETTER	BETTER	BETTER
			TRADENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE
			WIRE TYPE:	STAINLESS	STEEL	STAINLESS	STEEL	STAINLESS
SIZE	HANDLE Type	TRIM Length	STD. PKG.	PART #				
Hand Scra	tch Brushes – With Handle)						
3 x 19	Long Handle	1-3/16	12	662528 33950				
4 x 16	Shoe Handle	1-3/16	12		662528 33949	662528 33951		
5 x 10	Plastic Handle	1-1/8	24				662528 33954	
3 x 7	Inspection Brush	1/2	36					662528 33952



NYLON BRUSHES Nylon Brushes



When maximum conformability is needed, tough, Norton nylon brushes' flexible nylon filaments embedded with abrasive grain provide exceptional finishing and polishing and eliminate the need for costly and inconsistent hand deburring applications.

Norton nylon brushes are precision-engineered with the highest quality abrasive grains for those markets with the strictest requirements – for easy integration into today's automated machinery, CNC machining centers, transfer lines, robotic cells, and other highly-specialized machinery, as well as hand tools.

Applications:	Deburring, cleaning, finishing, and polishing
Brush Configurations:	Radial wheel brushes, narrow face wheel brushes, disc brushes, end brushes, and twisted brushes
Markets:	Aerospace/aircraft, automotive, construction/utility products, medical, metal finishing, woodworking
Abrasive Grain:	Ceramic Alumina, Silicon Carbide

Why Choose Nylon Abrasive Brushes?

- Abrasive grain cutting points are increased as the grain is exposed and cut equally when pressure is applied to the side or tip of the filament
- Uniform distribution of grain throughout the filaments allows cutting and finishing performance levels to remain consistent throughout the life of the brush – making Norton abrasive brushes ideal for automated applications
- Heat- and stress-resistant filaments prolong brush life and allow for superior conformability to irregular surface shapes
- The grain impregnated filaments act as a flexible file to deburr and radius edge profiles with precision, without gouging or affecting the overall geometry of a part
- The filaments bend at various angles to fit contours, creating a less prominent, more uniform surface finish in comparison to wire wheels or coated abrasive products
- Brush conformability allows usage on variety of complex part shapes without the need for ultra-precise programming and fixturing that is required with other deburring and finishing tools

Currently, all Norton Blaze ceramic alumina nylon abrasive brushes are custom-made to your exact requirements. Your Norton representative would be pleased to review availability, quotations, and lead-times with you.



Coated & Non-Woven Abrasives

the brightest product solutions from **A TOTAL SPECTRUM OF INNOVATION**

For everything from heavy-to-medium stock removal, to fine finishing, to light blending and polishing, abrasive products are available in many shapes, abrasive grains, specialty coatings and backing configurations to meet many application needs.



COATED & NON-WOVEN ABRASIVES Coated Abrasive Basics

Coated Abrasives

A coated abrasive product is made up of three basic raw materials: an abrasive grain, the backing onto which the abrasive is applied, and an adhesive bond.

Abrasive Types

Emery (6)

Emery is a dark gray, round-shaped grain which tends to polish rather than abrade a work surface.

For polishing and cleaning metal only

Garnet (5)

Garnet is reddish brown in color. This natural abrasive is medium hard and relatively sharp, but not as durable as synthetic abrasives.

- For use on wood only
- Particularly good for soft woods such as pine
- · Produces an excellent finish

Silicon Carbide (4)

Silicon carbide is the hardest and sharpest of the manufactured abrasives. Because of its extreme sharpness, this bluish-black abrasive grain permits fast stock removal and cool cut.

- Cast iron
- Non-ferrous metals, i.e. brass, aluminum and bronze
- Non-metallics, i.e. glass, rubber, plastic and stone
- Final finish on wood and stainless steel
- · Abrasive planing particleboard

Light Brown Aluminum Oxide (2)

Light brown aluminum oxide is a tough, yet sharp synthetic abrasive characterized by cool cut, long life and the ability to break down under pressure, producing new cutting edges.

- Production wood sanding
- Non-ferrous metal finishing









Brown Aluminum Oxide (2, 7)

Brown aluminum oxide is a tough, durable, synthetic abrasive characterized by the long life and wear resistance of its cutting edges. It offers enormous penetrating strength, even at high speeds.

- Ferrous metals
- Aluminum
- Hardwood

Heat-treated Aluminum Oxide (2)

Heat-treated aluminum oxide is a tough but cool cutting abrasive which gives both long life and freeness of cut on a wide range of materials.

- Ferrous metals
- Wood sanding

Zirconia Alumina (8)

Zirconia alumina is an ultra-tough, synthetic abrasive which provides a free, cool cut for high stock removal applications. It is tougher and sharper than aluminum oxide. It has a micro-crystalline structure which allows for controlled breakdown and self-sharpening.

- Heavy-duty snagging and grinding of all ferrous and non-ferrous metals
- · Abrasive planing of wood, plywood and particleboard
- Grinding fiberglass, rubber and plastics

Ceramic Alumina (9)

The sub-micron structure of ceramic alumina allows each grain to continually expose sharp cutting points, resulting in a cooler cutting action and an extended life.

· All ferrous/non-ferrous metals, carbon steel and exotic alloys













Backing Types

Backings are the base for the abrasive minerals and, combined with the adhesive bond, support and anchor the abrasive mineral. The backings used in the manufacture of coated abrasives are:

Paper

Due to the fine surface of paper, a consistent finish is produced. Paper weights include *A*, *B*, *C*, *D*, *E* and *F* weights with *A* being the lightest and most flexible and *F* being the heaviest and least flexible. *A*, *B*, *C* and *D* weight papers are used for hand sanding and light mechanical operations in the form of sheets, PSA (pressure sensitive adhesive) and hook and loop discs and sheet rolls. *E* and *F* weight papers are primarily used for more aggressive mechanical operations in the form of belts and discs.

Cloth

Cloth backings used for coated abrasives are identified by weight. Cloth backings are filled or "finished" with a variety of materials (glues or resins) to create various backing characteristics, most notably flexibility. Several cloth types are used: cotton, polyester, polyester/nylon and polyester/cotton blends, and rayon.

There are three basic weights of cloth: J-weight or "jeans" is the lightest and most flexible. X-weight or "drills" is a heavier cloth that ranges in flexibility, strength and durability and is used on the broadest range of applications. Y-weight is a heavyweight drills cloth used on heavy-duty, high stock removal operations.

Fiber

Vulcanized fiber (cotton fibers which are chemically treated and then pressed under temperature and pressure to form a very durable backing) is used exclusively as the backing for resin fiber discs.

Film

Polyester film backing comes in 3 mil. and 5 mil. thicknesses, which have high strength and surface smoothness. They are used primarily in disc and roll applications requiring consistent surface finish, including powertrain applications.

Foam

Primarily used as backing for sponges, finer grit finishing discs, and buffing and polishing pads for cleaning and moist finishing applications.

Mesh

Mesh matrix backing comprised of thousands of tiny holes allowing for maximum dust extraction.

COATED & NON-WOVEN ABRASIVES Coated Abrasive Basics

Bond Types

An adhesive bond system is required to secure the abrasive mineral to the backing. All coated abrasive products are made with a two stage bonding process, the *make coat* and the *size coat*.

The *make coat* is the first layer of bond applied to the backing. The make coat provides the adhesive base between the abrasive mineral and the backing.

The *size coat* is the second coat, which is applied over the abrasive mineral and make coat to anchor the abrasive mineral and provide the desired physical strength of the finished product.

Glue, urea resin, and *phenolic resin* are the three basic bonding agents most commonly used. There are many size coat and make coat combinations, such as *glue over glue*, *urea over glue*, and *resin over resin*. *Glue over glue* is the most flexible bond while *resin over resin* bond is moisture-resistant, harder, less flexible, heat-resistant and has superior grain retention.

Coating Types

There are two types of abrasive coatings used in the manufacturing of coated abrasives: *open coat* and *closed coat*.

Closed Coat

longest product life.

With a closed coat, the entire surface

most typical coating, permitting the

greatest degree of stock removal and

CLOSED COAT

is covered with abrasive grain, with no voids between the particles. This is the

Open Coat

With an open coat, 50% to 75% of the surface is covered by abrasive grain. There are evenly spaced voids between the particles of grain, helping reduce the effect of loading caused by wood dust or metal particles.



(1/3 LESS GRAIN THAN CLOSED)

Super Size Coating

The Super Size coat is an optional final coat and grinding aid applied over the size coat to help maintain low grinding temperatures and prevent loading.

How to Read a Coated Abrasive Specification

The Norton coated abrasive marking system includes both a generic and a technical marking, which identifies the actual components which make up the product. The markings identify the tradename, abrasive type, bond, backing, and any special features. An example would be: Norton Blaze R980P.

	R 9	8 0 P		
Backing / Bond	Principal Abrasive	Coating	Random	Modifier
A = Lightweight Paper (A-D wts.)	1 = Aluminum Oxide	Odd = Open Coat	Designates different	Additional description, often
excluding Waterproof F = Fiber H = Heavy Paper / Resin Bond (E and F wts.) K = Cloth / Glue Bond (J and X wts.) M = Mesh PB = B-wt. Paper with Resin Bond and Latex Q = Various (e.g. Screen-Bak, Film, and Foam) R = Cloth / Resin Bond (H, J, X and Y wts.) T = Waterproof Paper (A, C wts.) U = Lightweight Waterproof Paper/ NORaX Engineered Abrasive Resin Bond	 2 = Aluminum Oxide 3 = Layered Aluminum Oxide 4 = Silicon Carbide 5 = Garnet 6 = Crocus & Emery 7 = Aluminum Oxide 8 = Zirconia Alumina 9 = Norton SG Ceramic Alumina 	Even = Close Coat	products within the same product group.	indicative of a product upgrade i.e. "P" = Plus



Coated Abrasive Grit Comparison Chart

AVERAGE Particle size	GRADING SYST	EMS (OTHER THAN	I EMERY)	EMERY
IN MICRONS	ANSI	FEPA	JIS	PRODUCTS
5.0	-	-	-	-
6.0	-	-	3000	-
6.5	1200	-	2500	4/0
8.4 8.5	_	P2500	2000	
9.2	1000	_	-	3/0
10.3	_	P2000	_	-
10.5	_	-	1500	_
12.2	800	_	1200	-
12.6	-	P1500	-	-
15.0	-	-	-	-
15.3	-	P1200	1000	-
16.0	600	-	-	2/0
18.3	-	P1000	800	-
19.7 20.0	500	_	-	0
20.0	_	 P800	_	_
23.6	400	-	600	_
25.0	-	_	_	_
25.75	_	P600	_	_
28.8	360	-	500	-
30.0	-	P500	-	-
35.0	-	P400	400	-
36.0	320	-	-	-
40.0	-	-	360	_
40.5	-	P360	_	-
44.0	280	_	-	1
45.0	_	– P320	320	
50.0	_	-	-	_
52.5	_	P280	280	_
53.5	240	-	_	_
55.0	-	_	_	_
58.5	-	P240	-	-
60.0	_	-	240	-
64.0	-	-		2
65.0	-	P220	220	-
66.0	220	-	-	
78.0	180	P180	180	-
79.0 93.0	150	-	 150	3
95.0	-	_	-	FINE
97.0	_	 P150	_	
116.0	120	_	120	_
127.0	-	P120	100	-
136.0	-	-	-	MEDIUM
141.0	100	-		-
156.0	-	P100	-	_
189.0	-	-	-	COARSE
192.0	80	-	80	_
197.0	_	P80	-	
260.0 268.0	-	P60 -	- 60	_
326.0	60		50	
341.0	-	-	-	EX. COARSE
351.0	50	_	_	-
412.0	_	P40	40	_
428.0	40	-	-	-
524.0	-	P36	-	-
535.0	36	-	36	-
622.0	_	P30	_	_
638.0	30	-	30	-
715.0	24	-	-	-
740.0	-	P24	24	_
905.0	20	- D20	- 20	
984.0 1320.0	- 16	P20	20 16	_
1320.0	-	– P16	-	_
1764.0	_	P12	_	_
1842.0	12	-	_	_
.012.0				

Coated Abrasive Storage

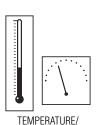
Stored under proper conditions, coated abrasives will retain their efficiency and usefulness over long periods. Improper or inadequate storage can introduce problems of weakened bond, curl, brittleness, and breakage.

Temperature and humidity are the two most important climatic factors influencing coated abrasive performance. Backings and adhesives are sensitive to climatic changes and will gain or lose moisture according to the relative humidity of their surroundings.

Excessive humidity may cause a softening of some types of adhesive bonds so that the product quickly fills and clogs, or loses its grain during use. Excessive dryness may cause brittleness, reduced flexibility, and distortion of product shapes.

As moisture in the coated abrasive product increases or decreases, dimensional changes can occur. When the backing changes more than the adhesive bond, it causes cupping. High and low humidity can cause concave and convex cupping respectively.

The newer synthetic-backed belts are not affected by moisture. Broad temperature swings will not permanently harm these products either, but cold temperatures will cause a "cold set" condition. Consequently, these products should be allowed to come to room temperature before use.



HUMIDITY





STORE BELTS PROPERLY

STORE BULK ROLLS FLAT



KEEP AWAY FROM HEAT/COLD SOURCES

Storage Facilities

The ideal storage (stock) room for coated abrasives would be one in which all the walls are inside partitions, rather than the outside walls of the building.

PRECONDITION

BEFORE USE

- Constant levels of humidity and temperature should be maintained. Stockroom temperature should be 60-degrees to 80-degrees F and relative humidity between 35 and 50%.
- Cartons should be kept away from damp or cold walls and floors, where they might absorb moisture.
- Store coated abrasives away from heat sources steam heated radiators, steam pipes, hot air inlets, heat ducts, or rooms near furnaces or ovens.
- Keep products in original packages. These packages facilitate handling and can be stacked in the most practical and convenient manner.
- Bulk rolls should not be allowed to stand on edge after they have been unpacked. Store flat on shelves or pallets.
- Narrow belts which have been removed from the carton should be rolled up and stored on edge on a clean shelf. Belts may be draped over a large cylinder, such as a gallon can, brake drum, or flanged hanger of the type used for a garden hose. Never hang a belt from a nail – the backing will crease and the abrasive belt might crack.
 Wide belts should be hung over a tube of at least 4" diameter. Center the belt joint over the tube and add a light weight (such as old packaging tubes) to the bottom loop of the belt to aid in removing set. Condition for 24 hours prior to use.
- For maximum product efficiency, precondition coated abrasive products in a chamber of controlled temperature and humidity before use.



Introduction

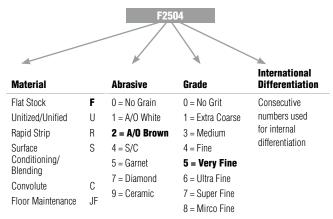
Most Norton Bear-Tex products consist of a non-woven web of nylon fibers impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting. The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Norton Bear-Tex products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic and non-rusting. Non-woven wheels are easily pre-formed to conform to special-shaped work pieces.

Since non-woven products are designed for use where stock removal is not required, they begin where other abrasives leave off. The relatively non-aggressive nature of nylon and grit inherent in the material makes it ideal as a finishing tool. While 60 to 80 grits are considered intermediate sizes in other products, they are considered coarse for non-woven items.

Used wet or dry, Norton Bear-Tex non-woven products offer the following advantages: controlled cut (with little or no stock removal) allows for increased productivity, consistent, uniform finish, ability to automate operations, minimized smearing and reduced operator training. These advantages make our non-woven products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds and steel wool.

Product Identification System



COATED & NON-WOVEN ABRASIVES Non-Woven Basics

Abrasives

Ceramic alumina, silicon carbide and aluminum oxide abrasives are offered. Ceramic alumina cuts the fastest and is the most cost effective on large-volume applications. Silicon carbide is sharper, cuts faster than aluminum oxide, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer. It causes less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Norton Bear-Tex hand pads are also available in a non-abrasive material.

Grits

Grit refers to the size of the abrasive grain impregnated into the nylon web. The coarser the grit, the more aggressive the cut, the rougher the finish. The finer the grit, the less aggressive the cut and the resulting surface finish will be finer, if all other conditions are equal.

GRIT DESIGNATIONS	GRIT SIZE
Extra Coarse (XC)	50
Coarse (C)	60 - 80
Medium (M)	100 – 150
Fine (F)	180 - 220
Very Fine (VF)	240 - 360
Super Fine (SF)	400
Ultra Fine (UF)	600
Micro Fine (MF)	800 - 1200

Densities

The product "density" refers to the number of fibers which have been compressed into the nylon web material. Under identical conditions, harder density wheels cut faster, last longer and produce finer finishes than softer density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the work piece.

Fiber Sizing

Several nylon fiber sizes are used in the manufacture of Norton Bear-Tex and Merit web material because the fiber size is a significant factor in the coating process, as each produces distinct cutting characteristics.

Bonding Agents

Waterproof resins are used in the manufacture of Norton Bear-Tex and Merit web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web.





Getting the Most Out of Norton Bear-Tex Wheels

Maximum wheel life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

1) Wheel Direction

Convolute, interleaf flap wheels, and conventional flap wheels must always run in the direction indicated by the arrow printed on the side of each wheel. Unified wheels can be run in either direction.

2) Wheel Speed

Wheel speed is an important factor in that it affects product finish, rate of cut, and wheel life. In general, fast wheel speeds give harder action and a finer finish; whereas, slower speeds give a softer action and a coarser finish for the same wheel density.

The following are recommended operating speeds for the most common applications.

APPLICATION	RECOMMENDED SPEED
Cleaning and upgrading of surface conditions	2200 to 6000 SFPM
Cut-buffing on metal surfaces	6500 to 8000 SFPM
Deburring	5500 to 8000 SFPM
Decorative finishing	500 to 3000 SFPM
Imparting decorative finishes	900 to 3000 SFPM
Oxide removal	3500 to 6500 SEPM

Testing might show that a slower or faster speed is desirable for specific operations. Never exceed the maximum RPM rating of the wheel.

3) Pressure

Light to medium pressure is recommended for most operations. Flap wheels require much lighter pressure to perform properly than other non-woven wheels; unified wheels can withstand much higher pressures in order to perform deburring jobs. In all cases, avoid excessive pressure which might result in wheel deformation and damage to the work surface.

4) Feed Speed

Low feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.

5) Oscillation

Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut might be experienced.

A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

6) Lubricants

Lubricants, such as water, water soluble oil, and straight oil, will decrease the heat generated while running, improve the luster, and reduce the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

Factors in Wheel Choice

This chart provides a relative comparison of other Norton Bear-Tex wheel variables. It can serve as a useful guide in choosing the most suitable product for a given application. However, as many other factors affect wheel performance, this chart can only be general in nature. The most cost-effective results can always be obtained by wheel testing on the application.

1	1 Wheel Conformability	MOST CONFORMABLE (SOFT) LEAST CONFORMABLE (HAP							
		Flap Wheels	Clean & Finish	Metal Finishing	Rapid Finish GP 7 Density	Rapid Finish GP 8 & 9 Density	Series 4000		
2	Wheel Openness	OPEN MESH					CLOSED MESH		
			Clean & Finish	Metal Finishing	Rapid Finish GP 7 Density	Rapid Finish GP 8 & 9 Density	Series 4000		
3	Wheel	MOST AGRES	SIVE				LEAST AGGRESSIVE		
	Aggressiveness		Metal Finishing		Clean & Finish	Rapid Finish GP	Flap Wheels		
4	Finishing Action	COARSER					FINER		
			Metal Finishing	Clean & Finish	Series 4000	Rapid Finish GP Series 4000	Flap Wheels		
5	Pressure for	LIGHTER					HIGHER		
	Best Results		Flap Wheels	Clean & Finish	Metal Finishing Rapid Finish GP 7 Density	Rapid Finish GP 8 & 9 Density	Series 4000		

* On steel surfaces, silicon carbide wheels will produce a brighter finish than aluminum oxide wheels.

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the work piece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1 Grit Size	Coarse <	► Very Fine
2 Wheel Grade	Soft <	► Hard
3 Wheel Speed	Slow \prec	► Fast
4 Feed Speed	Faster (Long Scratch) <	Slower (Short Scratch)
5 Oscillation	No Oscillation \prec	► Oscillation
6 Lubricants	Dry 🗸 🔶 Water \prec	Soluble Oil Straight Oil
and Compounds		Compounds





Conventional Finishing Methods Versus Norton Bear-Tex Non-Woven Products

The following chart outlines the advantages achievable when using our products as alternatives to other cleaning, blending, deburring and finishing methods. These products are listed in the sequence of normal preference for the application stated. However, because of the numerous variables, only testing can ensure selection of the most cost-effective product.

CONVENTIONAL FINISHING METHOD Bristle Brushes	KEY APPLICATION Cleaning	NORTON PRODUCT ALTERNATIVES Rapid Strip Convolute Wheels Rapid Prep Discs Rapid Prep Flap Discs	ADVANTAGES OF NORTON/MERIT PRODUCT VERSUS ALTERNATE FINISHING METHODS Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminate compound dust	
Greaseless Compounds	Finishing	Flap Wheels Convolute Wheels Unified Wheels Rapid Prep Discs Rapid Prep Flap Discs	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate	
Set-up Wheels			No break-in time required More consistent cut More uniform finish Maintain geometry Safer, no flying wheel pieces	
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters	

Conventional Finishing Method



Norton Bear-Tex Non-Woven Finishing Method









The strongest of coated abrasive discs with resin-over-resin construction on heavy-duty fiber backing. Designed for applications ranging from heavy stock removal to surface blending. Used with back-up pads on portable angle grinders.

4" x 5/8" hole, 4-1/2" - 9-1/8" x 7/8" and 5/8"-11 hole

Ceramic Alumina, Zirconia Alumina Blend, and Aluminum Oxide

Conventional, Speed-Change hubs (5/8"-11), and AVOS technology

Stock removal, edge chamfering, weld blending, deburring/deflashing, rust removal,

Applications:

Size Range: Grit Range: Abrasive Grain: **Product Options:** Accessories: **Machines Used:**



RIGHT ANGLE GRINDER

cleaning and finishing

16 - 120





How To Select The Correct Abrasive To Blend a Weld 📎 nortonsga.us/5sdjv

Material-to-Product Recommendation Guide

	BEST			BETTER	GOOD
	BlazeX F970	BlazeX F980	Blaze F980	BlueFire F826P	Metal F240
Stainless Steel / Titanium / Super Alloys*		•	•	•	•
Mild Carbon Steel / Welds	•			•	•
Ferrous Metals / Cast Iron	•			•	•
Brass / Bronze / Aluminum					•
*Nickel/Cobalt Based – Hastelloy, Inconel, Waspalloy					

Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)

16	24	30	36	40	50	60	80	100	120
Stock Removal									
		Edge Chamf	ering						
			Weld Blendin	g					
				Deburring/	Deflashing				
						Rust Removal			
							Cleaning and Fin	ishing	

Cross Reference Guide

	TOTAL PERFORMANCE			
	BEST		BETTER	GOOD
NORTON	BlazeX F970	BlazeX F980, Blaze F980	BlueFire F826P	Metal F240
3M	782C, 982C, 988C	785C, 787C, 985C, 987C	501C	_
Camel	· · · · · ·	Ceramic	Zirconia	
Flexovit	CG	CG+	ZA	
GemTex	PMD, Gem Supreme	PMD Supreme, PMD Supreme Plus	Zee-Type, Zee Supreme, Gem Supreme	А-Туре
Hermes		CR456	RB414X, RB414X Procut	RB314
Klingspor	FS964 ACT	FS966	CS565, CS570	CS561
Metabo	CER	CER	ZA	A/0
Mirka		<u> </u>	Blue, Gold	Red
Pearl	Red Line	_	FZ	Silver Line
Pferd	CO-PMD	CO Cool	Z, Z Cool	А
United Abrasives/Sait	7S, 7A-S, 7-11	9S, 9-11	3Z, Z, AZX	A/0, 2A
SIA	4515, 4580	4515, 4560,	4815, 4819	4919, 4961
Standard	Ceramic	Ceramic Pro	Zirconia	A/0
VSM	XF760	AF890, AF799, XF885, XF870, XF850	ZF713, ZF714, ZF844	KF708
Walter	Walter Coolcut XX	Walter Coolcut XX	Walter Topcut	
Weiler	_	Tiger Ceramic	Tiger Zirc, Wolverine Zirc	Wolverine A/O





Best choice for carbon steel and other soft-to-grind materials

BLAZEX F970 CERAMIC ALUMINA

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- · Heavier fiber backing for additional strength and tear resistance
- · Non-supersized design for cool cutting and long life on carbon steel and other soft-to-grind materials



Best choice for coarse grit beveling, blending, deburring, and stock removal

BLAZEX F980 CERAMIC ALUMINA

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Strong fiber backing for strength and tear resistance
- · Supersized design for stainless steel and hard-to-grind materials



Best choice for stainless steel, titanium, and super alloys

BLAZE F980 CERAMIC ALUMINA

- 100% ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Self-lubricating grinding aid treatment delivers the coolest cut on stainless steel, high alloy steels, super alloys, titanium, and other difficult-to-grind materials
- · Heavier fiber backing for additional strength and tear resistance



Better choice for stainless, super alloys, steel, cast iron and high-pressure applications

BLUEFIRE F826P ZIRCONIA ALUMINA

- High-performance zirconia alumina abrasive blend provides 15% faster cut and longer life with less power draw than conventional zirconia discs
- · Advanced resin bond technology with enhanced grain adhesion for extended life
- · Heavier fiber backing for additional strength and tear resistance



Good choice for small jobs, applications where performance is not measured, and price-sensitive operations

METAL F240 ALUMINUM OXIDE

- Versatile, multi-purpose aluminum oxide abrasive provides consistent performance on numerous materials and small jobs
- Full resin bond for strength and durability
- · Heavier fiber backing for additional strength and tear resistance; low initial price

NORTON	
SAINT-GOBAIN	

SIZE (D x H) GRIT S 4-1/2 x 7/8 24 2 36 2 36 5 50 2 60 2 100 2 120 2 5 x 7/8 16 2 36 5 50 2 60 2 100 2 120 2 36 5 50 2 60 2 120 2 36 5 50 2 100 2 36 5 50 2 100 2 36 5 50 2 100 2 36 5 50 2 100 2 36 5 50 2 100		BLAZEX F970 Ceramic Alumina	BEST BLAZEX F980 Ceramic Alumina Supersize PART # 78072743400	BEST BLAZE F980 Ceramic Alumina Supersize PART # 69957398002 69957398002 69957398003 69957398004 66254425332 69957398005	BETTER BLUEFIRE F826P Zirconia Alumina Blend PART # 66261138457 66261138456 66623377276 66261138454 66261138453 66261138452	COOD METAL F240 Aluminum Oxide PART # 66623353309 66623353310 66623353311 66623353312 66623353313 66623353314 66623353314 66623353314 66623553317
IZE (D x H) GRIT S -1/2 x 7/8 24 2 36 2 36 5 50 2 60 2 120 2 x 7/8 16 2 36 5 24 2 36 5 50 2 60 2 120 2 x 7/8 16 2 36 5 50 2 60 2 120 2 36 5 120 2 36 5 120 2 36 5 120 2 36 5 120 2 36 5 120 2 120 2 36 5 120 2 36 5 120 2 120 2 36 5 120 2 36 5 2 36 5 2 100 2 36 5 2 36 5 2 100 2 2 36 5 2 100 2 2 36 5 100 2 100 2	RADENAME: ABRASIVE: OTHER: STD. PKG. 25 25 25 25 25 25 25 25 25 25	BLAZEX F970 Ceramic Alumina PART # 69957370193 69957370194 69957370195 69957370196	BLAZEX F980 Ceramic Alumina Supersize PART # 780727 43400	BLAZE F980 Ceramic Alumina Supersize PART # 69957398000 69957398002 69957398003 69957398004 66254425332	BLUEFIRE F826P Zirconia Alumina Blend PART # 66261138457 66261138456 66623377276 66261138454 66261138453 66261138452	METAL F240 Aluminum Oxide PART # 66623353309 66623353306 66623353310 66623353311 66623353312 66623353312 66623353314 05539510684
ZE (D x H) GRIT S 1/2 x 7/8 24 2 36 2 36 5 50 2 60 2 100 2 120 2 x 7/8 16 2 36 5 50 2 60 2 120 2 36 5 50 2 60 2 120 2 36 5 50 2 60 2 120 2 120 2 36 5 50 2 100 2	RADENAME: ABRASIVE: OTHER: STD. PKG. 25 25 25 25 25 25 25 25 25 25	BLAZEX F970 Ceramic Alumina PART # 69957370193 69957370194 69957370195 69957370196	BLAZEX F980 Ceramic Alumina Supersize PART # 780727 43400	BLAZE F980 Ceramic Alumina Supersize PART # 69957398000 69957398002 69957398003 69957398004 66254425332	BLUEFIRE F826P Zirconia Alumina Blend PART # 66261138457 66261138456 66623377276 66261138454 66261138453 66261138452	METAL F240 Aluminum Oxide PART # 66623353309 66623353306 66623353310 66623353311 66623353312 66623353312 66623353314 05539510684
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x 7/8 120 2 24 22 36 22 36 5 50 22 60 22 80 22 100 2	25 25 25	600679 70407			662611 38563	666233 53314 055395 10684
x 7/8 16 2 24 2 36 2 36 5 50 2 80 2 100 2	25 25	600579 70107			662611 38563	05539510684
24 2 36 2 36 5 50 2 60 2 80 2 100 2	25	600572 70107		699573 98005	662611 38563	
36 2 36 5 50 2 60 2 80 2 100 2		60057270107		699573 98005	662611 38563	66602257976
36 5 50 2 60 2 80 2 100 2	25	60057270107				00023331210
50 2 60 2 80 2 100 2		0990/3/013/	780727 43401		662611 38562	666233 57277
60 2 80 2 100 2	50 V				666233 77283	
80 2 100 2	25	699573 70198		699573 98007	662611 38561	666233 57278
80 2 100 2	25	699573 70199		699573 98008	662611 38601	666233 57279
100 2	25	699573 70200		699573 98009	662611 38600	666233 57280
100	25					666233 57281
120 2	25			662544 09084		666233 57282
x 7/8 24 2	25			662611 60033		
	25					055395 10693
	25			699573 98010	662611 38594	66623357283
	25	699573 70201	780727 43402	,	662611 38593	666233 57284
	25	699573 70202		699573 98012	662611 38592	666233 57285
	25	699573 70203		699573 98013	662611 38591	666233 57286
	25	699573 70204		699573 98014	662611 38590	666233 57287
	25			,		666233 57288
	25			662544 11528		666233 57289
	25			69957398015	662611 38584	05539510702
	25		699573 98016		662611 38583	05539510701
	25		30001000010	699573 98017	662611 38582	
60 2				33301000011	USEO TOUVUL	055395 10699

Note: Fiber discs must be used with back-up pads shown on the last page of this section. V = Vendible Package. Ideal for vending machines and small jobs. 10 discs/package, 5 packages per standard carton. Order in multiples of 50.

B = Bulk & Baled. Baling Units also available on Page 68.

AVOS Fiber Discs

- · Patented, see-through design allows interrupted cut which reduces heat up to 30% over standard discs
- The scooped holes create air flow to pull swarf away from grinding zone; cool cutting and extended product life
- 15° back-up pad for full utilization of discs no gouging
- Quick, tool-free, twist-on and -off Speed-Lok fasteners





		TIER:	BEST	BEST	BETTER
		TRADENAME:	BLAZEX F980	BLAZE F980	BLUEFIRE F826P
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina Blend
SIZE	GRIT	STD. PKG.	PART #	PART #	PART #
4-1/2 Speed-Lok	24	10		662544 68389	662611 29718
(3 hole)	36	10	662544 68390		662611 29719
	50	10		662544 68391	662611 29720
	60	10		662544 68392	662611 29721
	80	10		662544 68393	662611 29722
5 Speed-Lok	24	10		662544 68385	662611 26556
(3 hole)	36	10	662544 68386		662611 26557
	50	10		662544 68387	662611 26558
	60	10		662544 68388	662611 26559
	80	10			662611 26560
7 Speed-Lok	24	10		662544 68381	662611 37454
(6 hole)	36	10	662544 68382		662611 37455
	50	10		662544 68383	662611 37456
	60	10		662544 68384	
	80	10			662611 37458

ed with AVUS Speed-Lok back-up pads, see acc



Speed-Change Fiber Discs

These fiber discs feature Norton quick, tool-free, twist-on and -off Speed-Change fasteners. Discs lock to standard back-up pads with a unique nut design and are easily removed, increasing your productivity with more time to grind.

			٢	0		
		TIER:	BEST	BEST	BEST	BETTER
		TRADENAME:	BLAZEX F970	BLAZEX F980	BLAZE F980	BLUEFIRE F826P
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina Blend
		OTHER:		Supersize	Supersize	
SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #
4-1/2 x 5/8-11	24	25			662610 23269	
	36	25	699573 70205	780727 43403		
	50	25	699573 70206			
	60	25	699573 70207		662610 42247	
	80	25	699573 70208		666233 28529	
5 x 5/8-11	24	25			662544 25336	662611 38797
	36	25	699573 70209	780727 43404		662611 38796
	50	25	699573 70210			
	60	25	699573 70211		662611 85803	
	80	25	699573 70212		666233 16697	
7 x 5/8-11	24	25			699573 49782	662611 38819
	36	25	699573 70213	780727 43405		662611 38818
	50	25	699573 70214			662611 38817
	60	25	699573 70215		662610 42249	662611 38816
	80	25	699573 70216		662544 74373	

Note: Speed Change fiber discs must always be used with smooth face back-up pads, see next page for details.



Better Choice for grinding concrete, marble, granite and other natural stone with ease

FASTCUT SILICON CARBIDE

- · Sharp, fast-cutting silicon carbide abrasive quickly penetrates and removes any coatings
- · Engineered specifically with cooling ridges to remain free-cutting, minimize loading, and maximize life
- Rigid fiber backing helps to aggressively grind concrete, marble, granite and other stone works
- · Ideal for demanding right angle grinding at comfortable lower angles

			*	
		TIER:	BETTER	BETTER
		TRADENAME:	FASTCUT	FASTCUT
		ABRASIVE:	Silicone Carbide	Silicone Carbide
		TYPE:	27	29
SIZE	GRIT	STD. PKG.	PART #	
4-1/2 x 7/8	16	25	662611 99054	
7 x 7/8	16	25	662544 37691	662611 99052
Note: Lles with M	auton Ain	Cooled book .		

Note: Use with Norton Air-Cooled back-up pad for best performance.

Efficiently Grind Softer Materials Where Loading is a Problem

Extra coarse, sharp, silicon carbide abrasive and cooling ridges make fast work of all your masonry, concrete, marble, and granite surface preparation and stock removal jobs – without loading. Quickly penetrates and removes any coating, such as adhesive, paint, acrylic, mastic, etc.



COATED & NON-WOVEN ABRASIVES Fiber Disc Accessories

Fiber Disc Accessories



- Fiber Disc Baling Unit
- Places 100 discs on a spindle between two plates
- Locks down with a pinch screw
- Maintains the shape of the discs by maintaining pressure to minimize curl
- User-friendly and reusable



Air-Cooled Standard Back-up Pad Slotted hub design and curved ribs draw heat away from the grinding zone, reducing disc loading and increasing life. All pads have a 5/8"-11 threaded

female hub for mounting. We also offer

a no-nose pad for shorter-shafted right

angle grinders.



Smooth Face Speed-Change Back-up Pad Molded rubber back-up pads with a smooth face.

- Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications



AVOS Fiber Disc Back-up Pad

- Patented, see-through design allows interrupted cut which reduces heat up to 30% over standard discs
- The scooped holes create air flow to pull swarf away from grinding zone
- 15° back-up pad for full utilization of discs – no gouging
- Quick, tool-free, twist-on and -off
 Speed-Lok fasteners

Fiber Bisc Baling Unit — 1 7769601066 T' or below — 1 7769601066 Rubber Back-up Pads — 1 77696011066 Air-Cocled Standard for 7/8 Hole Fiber and Non-Woven Discs — 63642502122 4 Medium 11,000 5 63642504212 5 ' Medium 10,000 5 63642543425 7 ' Hard 8,600 5 63642543426 9' Hard 6,600 5 6364254302 7/ Medium 11,000 5 6364254323 Altr-Cocled No-Nose — — 41/2' Medium 10,000 5 6364254323 5' Medium 12,000 5 6364254324 1 1 7' Mardi 8,600 5 6384254324 1 1	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Number Back-up Pads Air-Cooled Standard for 7/8 Hole Fiber and Non-Woven Discs 5 63842504918 4 'Medium 11,000 5 638425042122 5' Medium 10,000 5 63842504212 7' Martium 8,600 5 63842543425 7' Medium 8,600 5 63842543422 9' Hard 6,600 5 63842543422 9' Hard 6,600 5 63642543423 9' Hard 6,600 5 6364254323 9' Medium 10,000 5 6364250367 5' Medium 12,000 5 63642543240 7' Hard 8,600 5 63642543240 7' Medium 12,000 5 63642543240 7' Medium 7,000 5 <t></t>				
Air Coloid Standard for 7/8 Hole Fiber and Non-Wover Viscol 63642504918 4' Medium 1,000 5 63642504122 5' Medium 10,000 5 63642543421 7' Hard 8,600 5 63642543425 7' Medium 8,600 5 63642543426 9' Hard 6,600 5 63642543426 9' Hard 6,600 5 63642543426 9' Medium 6,600 5 63642543426 9' Medium 6,600 5 63642543426 9' Medium 6,000 5 63642543426 9' Medium 10,000 5 63642504872 5' Medium 10,000 5 63642504872 5' Medium 10,000 5 63642543245 7' Mard 8,600 5 63642543245 7' Medium 2,000 5 63642543245 7' Medium 8,600 5 63642543245 7' Medium 8,600 5 63642543245 7' Medium 2,000 5 63642543245 7' Medium 10,00	7" or below	_	1	776960 01066
4* Medium 12,000 5 63842504918 4-1/2* Medium 11,000 5 63842502122 5* Medium 10,000 5 63842543421 7* Hard 8,600 5 63842543425 7* Medium 8,600 5 63842543422 9* Hard 6,600 5 63842543422 9* Hard 6,600 5 63842543423 9* Medium 6,600 5 63842543423 9* Medium 6,600 5 63842543423 9* Medium 10,000 5 63842504872 5* Medium 10,000 5 63842504872 5* Medium 10,000 5 63842543240 5* Medium 10,000 5 63842543240 5* Medium 10,000 5 63842543240 7* Madium 12,000 5 63842543240 7* Medium 12,000 5 63842543240 7* Medium 7,000 5 63842543240 7* Medium 7,000 5 63842543250 9* Medium 7,000 <t< td=""><td>Rubber Back-up Pads</td><td></td><td></td><td></td></t<>	Rubber Back-up Pads			
4-1/2' Medium 11,000 5 63642502122 5' Medium 10,000 5 63642543421 7' Hard 8,600 5 63642543425 7' Medium 8,600 5 63642543422 9' Hard 6,600 5 63642543426 9' Medium 6,600 5 63642543423 Note: Retainer nuts are not included with back-up pads. These must be ordered separately. A A A1-Cooled No-Nose	Air-Cooled Standard for 7/8 Hole Fibe	r and Non-Woven Discs		
5* Medium 10,000 5 63642543421 7* Hard 8,600 5 63642543425 9* Hard 6,600 5 63642543422 9* Hard 6,600 5 63642543426 9* Hard 6,600 5 63642543423 9* Medium 6,600 5 63642543423 Note: Retainer nuts are not included with back-up pads: These must be ordered separately: - - AirCooled No-Nose - - 63642504872 5* Medium 10,000 5 63642503000 Smooth Face for Fiber and Non-Woven Speed-Change Discs - - 4-1/2* Medium 20,000 5 63642543235 7* Hard 8,600 5 63642543245 7* Medium 9,000 5 63642543240 7* Medium 8,600 5 63642543245 7* Madium 8,600 5 63642543245 7* Soft 8,600 5 63642543245 7* Soft 8,600 5 63642503029 9* Medium 7,000 5 63642503029	4" Medium	12,000	5	636425 04918
7" Hard 8,600 5 63642543425 7" Medium 6,600 5 63642543422 9" Mard 6,600 5 63642543423 9" Medium 6,600 5 63642543423 Note: Retainer nuts are not included with back-up pads. These must be ordered separately. - - Air-Cooled Mon-Nose - - 6642543423 4-1/2" Medium 11,000 5 63642504872 5" Medium 10,000 5 63642503000 Smooth Face for Fiber and Non-Woven Speed-Change Discs - - 4-1/2" Medium 12,000 5 63642543235 7" Hard 8,600 5 63642543240 7" Medium 12,000 5 63642543240 7" Medium 8,600 5 63642543240 7" Medium 8,600 5 63642543245 7" Medium 8,600 5 63642543250 9" Medium 7,000 5 63642543250 9" Medium 13,000 5 63642543250 5" x 3/8-24 Pistol Grip" 20,000 5 63642503	4-1/2" Medium	11,000	5	636425 02122
7* Medium 8,600 5 63642543422 9' Hard 6,600 5 63642543426 9' Medium 6,600 5 63642543423 Note: Retainer nuts are not included with back-up pads. These must be ordered separately. Air-Cooled No-Nose Air-Cooled No-Nose 4 -1/2' Medium 10,000 5 63642504872 5' 5' Medium 10,000 5 636425043000 5 63642503000 Store for Fiber and Non-Woven Speed-Change Dises 4 -1/2' Medium 20,000 5 63642543235 5' 5' Medium 12,000 5 63642543236 5' 63642543235 7' Hard 8,600 5 63642543240 5' 63642543240 5' 5' 63642543240 5' 5' 63642543240 5' 5' 63642543240 5' 5' 63642543240 5' 5' 63642543240 5' 5' 5' 63642543240 5' 5' 5' 5' 5' 5' 5' 5' 5' 5' 5'	5" Medium	10,000	5	636425 43421
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9" Medium 6,600 5 63642543423 Note: Relativer nuts are not included with back-up pads. These must be ordered separately.		8,600	5	636425 43422
Note: Retainer nuts are not included with back-up pads. These must be ordered separately. Air-Cooled No-Nose 4-1/2* Medium 11,000 5 63642504872 5* 5* Medium 10,000 5 63642504872 5* 5* Medium 10,000 5 63642504872 5* 4-1/2* Medium 20,000 5 66254492277 5* 5* Medium 12,000 5 63642543235 7* 4-1/2* Medium 8,600 5 63642543240 7* 7* Medium 8,600 5 63642543240 7* 7* Medium 7,000 5 63642543250 9* 9* Medium 7,000 5 63642543250 9* 9* Medium 7,000 5 63642543250 9* 9* Medium 7,000 5 63642543270 AVOS speed-Lok Back-up Pads 4-1/2* x 5/8-11 13,000 5 6364250329 5* x 3/8-24 Pistol Grip* 20,000 5 6364250329 5* x 5/8-11 5* x 5/8-11 13,000 5	9" Hard		5	636425 43426
Air2 Medium 11,000 5 63642504872 4'1/2' Medium 10,000 5 63642503000 S'mooth Face for Fiber and Non-Woven Speed-Change Discs			5	636425 43423
4-1/2' Medium 11,00 5 63642504872 5' Medium 10,000 5 63642503000 Smooth Face for Fiber and Non-Woven Speed-Change Discs - - 4-1/2' Medium 20,000 5 66254492277 5' Medium 12,000 5 63642543235 7' Hard 8,600 5 63642543240 7' Medium 8,600 5 63642543240 7' Medium 8,600 5 63642543245 7' Medium 7,000 5 63642543250 9' Medium 7,000 5 63642543250 9' Medium 7,000 5 63642543250 4-1/2' x 5/8-11 13,000 5 63642502365 5' x 3/8-24 Pistol Grip* 20,000 5 63642503029 5' x 5/8-11 13,000 5 63642503663 5'' x 5/8-11 13,000 5 63642503663 <tr< td=""><td>Note: Retainer nuts are not included with ba</td><td>ck-up pads. These must be ordered separately.</td><td></td><td></td></tr<>	Note: Retainer nuts are not included with ba	ck-up pads. These must be ordered separately.		
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AVOS Speed-Lok Back-up Pads AVOS Triangular Speed-Lok Back-up Pads 4-1/2" x 5/8-11 13,000 5 63642502985 5" x 3/8-24 Pistol Grip* 20,000 5 63642503029 5" x 5/8-11 13,000 5 63642503029 5" x 5/8-11 13,000 5 63642503663 5" x 5/8-11 Thicker 13,000 5 63642503663 5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 *Use on air pneumatic and high-speed pistol grip sanders - - - AVOS Round Speed-Lok Back-up Pads - - - - #103 Retainer Nut 10 63642543463 - Spanner Wrench 5 63642543405 -		8,600		636425 43250
AVOS Triangular Speed-Lok Back-up Pads 4-1/2" x 5/8-11 13,000 5 63642503029 5" x 3/8-24 Pistol Grip* 20,000 5 63642503029 5" x 5/8-11 13,000 5 63642503029 5" x 5/8-11 13,000 5 63642503663 5" x 5/8-11 Thicker 13,000 5 63642503663 5" x 5/8-10 Crip* 20,000 5 63642503030 5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 * Vos on air pneumatic and high-speed pistol grip sanders * VSe on air pneumatic and high-speed pistol grip sanders * XS/8-11 Hard 8,600 5 63642504873 Tools * #103 Retainer Nut — 10 63642543463 Spanner Wrench — 5 63642543405	9" Medium	7,000	5	636425 43270
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5" x 3/8-24 Pistol Grip* 20,000 5 63642503029 5" x 5/8-11 13,000 5 63642502517 5" x 5/8-11 Thicker 13,000 5 63642503663 5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 *'Use on air pneumatic and high-speed pistol grip sanders - - - AVOS Round Speed-Lok Back-up Pads - - 63642504873 Tools - 10 63642543463 #103 Retainer Nut 5 63642543005	AVOS Triangular Speed-Lok Back-up P	Pads		
5" x 5/8-11 13,000 5 63642502517 5" x 5/8-11 Thicker 13,000 5 63642503663 5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 *Use on air pneumatic and high-speed pistol grip sanders *Use on air pneumatic and high-speed pistol grip sanders *VSR Round Speed-Lok Back-up Pads T' x 5/8-11 Hard 8,600 5 63642504873 Tools #103 Retainer Nut — 10 63642543463 Spanner Wrench — 5 63642543005	4-1/2" x 5/8-11	13,000		636425 02985
5" x 5/8-11 Thicker 13,000 5 63642503663 5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 *Use on air pneumatic and high-speed pistol grip sanders * * AVOS Round Speed-Lok Back-up Pads * * 7" x 5/8-11 Hard 8,600 5 63642504873 Tools #103 Retainer Nut 10 63642543463 Spanner Wrench 5 63642543005	5" x 3/8-24 Pistol Grip*	20,000	5	636425 03029
5" x 7/16-20 Pistol Grip* 20,000 5 63642503030 *'Use on air pneumatic and high-speed pistol grip sanders * AVOS Round Speed-Lok Back-up Pads 5 63642504873 7" x 5/8-11 Hard 8,600 5 63642504873 Tools #103 Retainer Nut 10 63642543463 Spanner Wrench 5 63642543005				636425 02517
*Use on air pneumatic and high-speed pistol grip sanders AVOS Round Speed-Lok Back-up Pads 7" x 5/8-11 Hard 8,600 5 63642504873 Tools #103 Retainer Nut — 10 63642543463 Spanner Wrench — 5 63642543005		13,000		636425 03663
AVOS Round Speed-Lok Back-up Pads 5 63642504873 7" x 5/8-11 Hard 8,600 5 63642504873 Tools #103 Retainer Nut — 10 63642543463 Spanner Wrench — 5 63642543405	5" x 7/16-20 Pistol Grip*	20,000	5	636425 03030
7" x 5/8-11 Hard 8,600 5 63642504873 Tools ************************************	*Use on air pneumatic and high-speed pisto	l grip sanders		
Tools #103 Retainer Nut — 10 63642543463				
#103 Retainer Nut — 10 63642543463 Spanner Wrench — 5 63642543005	7" x 5/8-11 Hard	8,600	5	636425 04873
Spanner Wrench — 5 636425 43005	Tools			
	#103 Retainer Nut		10	636425 43463
66NS Short Retainer Nut 10 636425 43461	Spanner Wrench	_	5	636425 43005
	66NS Short Retainer Nut		10	636425 43461

All fiber disc back-up pads are packed in individual boxes within the shipping carton. Each box can be used in a vending machine.





Flap discs are versatile grinding and finishing tools having four main components: abrasive flaps, flap density (how the flaps are stacked), backing plate shape (flat or conical), backing plate material (fiberglass or plastic). All flap discs have flaps that are overlapped and glued to the backing plate. The flaps wear during use, exposing new abrasive grain. The different variations of the components above provide a variety of application choices ranging from heavy stock removal to blending to finishing. Flap discs are designed for portable grinder applications and can be the preferred choice over depressed center wheels or fiber discs.

Applications:

Size Range:

Grit Range: Abrasive Grain: Abrasive Flaps: Flap Disc Shape: Abrasive Flap Density: Backing Plate Material: Machine Used: Grinding, stock removal, edge chamfering/beveling, weld blending, deburring/deflashing, rust removal, blending, cleaning and finishing 4" : 5/8" hole 4-1/2" - 7" : 5/8"-11 discard mount, 7/8" hole, and 2" - 3" quick-change 24 - 120 Ceramic Alumina, Zirconia Alumina Polyester, Cotton/Poly Blend Type 27 Flat and Type 29 Conical Standard or high Fiberglass and plastic

GRINDER

Flap Disc Shapes



GRIND AT FLATTER ANGLES: **0° – 15°**

Type 27 Flat – The Best Choice for Finishing • Used primarily on flat surfaces

Excellent for heavy-duty applications and

The best choice for blending and smooth finishing

Standard Density

rapid stock removal



GRIND AT STEEPER ANGLES: 15° – 25°

Type 29 Conical – *The Best Choice for Aggressive Stock Removal*

- Conical flap discs have angled flaps and may be used on both contoured and edge work
- The angle provides greater surface contact for stock removal on flat surfaces
- The best choice when speed and stock removal are primary considerations

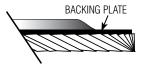
High Density

 Ideal when working on uneven or curved surfaces, as well as finer grit blending

Backing Plate Materials

Abrasive Flap Densities

All flap discs are a combination of abrasive flaps adhered to a rigid backing plate. It is the backing plate that provides stability during operation. There are two main materials used: fiberglass and plastic. The fiberglass backing plate, along with the flap shape, helps to absorb vibration and is consumed during use with no smearing. Fiberglass is the most popular material because of its high strength and light weight. The plastic backing plate offers some additional conformability and is trimmable.



Why Choose Flap Discs?

Flap discs replace both grinding wheels and fiber discs. The same flap disc can be used for applications ranging from stock removal to blending.



Flap Discs vs. Grinding Wheels Faster stock removal

- Smoother finish, no gouging
- Cooler cutting, less glazing
- Lightweight, easier to control
- Less vibration, less operator fatigue
- Reduced noise





Flap Discs vs. Fiber Discs

- · 20X longer life, reduced abrasive cost
- · Fewer disc changes, reduced labor cost
- More consistent finish
- · No back-up pad required
- · Easier storage, no curling
- Reduced loading
 - Use flap discs one grit size coarser than fiber discs, except in 36 grit



Material-to-Product Recommendation Guide

	BEST	BETTER	GOOD	
	Blaze R980P	BlueFire R860	Metal R828	Gemini R766
TYPE 29 FOR STOCK REMOVAL				
Stainless Steel / Titanium / Super Alloys	•	•	•	•
Mild Carbon Steel / Welds		•	•	•
Ferrous Metals / Cast Iron		•	•	•
Brass / Bronze / Aluminum		•		
TYPE 27 FOR BLENDING AND FINISHING				
Stainless Steel / Titanium / Super Alloys	•	•	•	•
Mild Carbon Steel / Welds		•	•	•
Ferrous Metals / Cast Iron		•	•	•
Brass / Bronze / Aluminum		•	•	•

Application/Grit Recommendation Guide

COARSER ((GRINDING)						FINER (FINISHING)
24	36	40	50	60	80	100	120
Heavy Stock I	Removal						
	Edge Chamfer	ring/Beveling					
	Weld Blending	g					
			Deburring/Deflashing				
				Rust Removal/Blendin	ng		
					Cleaning and Finishin	g	
	,						

STANDARD DENSITY

Cross Reference Guide

TOTAL PERFORMANCE

	BEST	BETTER	GOOD			
NORTON	Blaze R980P	BlueFire R860	Metal R828	Gemini R766		
3M	747D, 947D, 967A, 969F	546D, 566A, 577F	_	_		
Camel	Ceramic Pro	ZA Pro	ZA	A Pro		
CGW/Pasco	Ceramic	Zirconia		A/0		
DeWalt	XP Ceramic	HP Zirconia	FlexVolt	Zirconia		
Flexovit	Zircotex Ceramic	Zircotex, Zirocomax,Tornado				
Garryson	CeramIQ	Zirc+	A/0	Zirconium		
GemTex	Ceramic Flaptec	Zirconia Flaptec		A/O Flaptec		
Hermes	_	FL390	Webrax-AN 701	RB48024YX, RB48624YX		
Klingspor	SMT656	SMT624, SMT626, SMT627, SMT630		SMT627		
Metabo	Flexiamant Super Ceramic	Flexianmant Zirconia, Novoflex		_		
Mirka				Blue		
Pearl	Redline Maxidics, Stainlessmax Maxidics	Zirconia Maxidisc, Silver Line Zirconia	Silver Line A/O	A/O Maxidisc		
Pferd	Polifan Z-SG, Polifan SG-CO	Polifan SG Zirkon, Polifan SG ZA, SGP, PSF Zirc	Polifan PSF A/O	Polifan SG A, A-Cool		
United Abrasives/Sait	Encore Ceramic, Ovation Ceramic	Ovation, Saitlam U	Encore	Ovation Attacker		
SIA		_		2824 SIAFlap		
Standard	Ceramic Pro, Ceramic	Zirconia HP, Zirconia AP		Zirconia GP		
Tyrolit	Cerabond Ceramic, Premium Ceramic	Fastcut, Premium Longlife	Basic, Standard	Premium A/O		
VSM (Lehigh Valley)	Ceramic	Zirconia	_	A/0		
Walter	Enduro-Flex Turbo	Enduro-Flex, Enduro-Flex Stainless	Flexsteel	Enduro-Flex Alu.		
Weiler	Tiger Ceramic, Tiger X, Tiger Saber Tooth	Tiger Paw, Wolverine	Tiger	Tiger Premium		

INITIAL PRICE

HIGH DENSITY





/ENDIRI F

Best/highest productivity for stainless steel, titanium, and super alloys

BLAZE R980P CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain lasts 50% 200% longer than many flap discs on stainless steel, cobalt, chrome, inconel, titanium and other hard-to-grind materials
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably fast cut rate
- High-strength fiberglass back on Type 29 and Type 27 High Density is durable, lightweight, and absorbs vibration; flexible plastic backing plate on Type 27 Quick Trim allows for trimmability of the plate

Better choice for mild carbon steel, and welds

BLUEFIRE R860 ZIRCONIA ALUMINA

- High performance zirconia alumina abrasive for aggressive cut and long life, with up to 30% longer life than
 competitive zirconia alumina products
- · Polyester/cotton flaps with semi-open coat provide improved durability and reduces loading on aluminum
- High-strength fiberglass back on Type 29 and Type 27 High Density is durable, lightweight, and absorbs vibration; flexible plastic backing plate on Type 27 Quick Trim allows for trimmability of the plate
- · Vendible 2-disc package is ideal for vending machines, small jobs, or carrying to a job site

Good consistent performance with low initial price

METAL R828 ZIRCONIA ALUMINA

- Durable zirconia grain provides good cut rate and life with consistent finish
- · Fiberglass/resin backing plates with high strength, light weight, ability to absorb vibration, and operator comfort
- · Good choice for coarse grit blending, deburring, and stock removal

Good choice for carbon steel and aluminum applications

GEMINI R766 ALUMINUM OXIDE

- Alternating zirconia alumina and aluminum oxide flaps provide higher performance than aluminum oxide while retaining an economical price
- Polyester/cotton flaps are the best choice when speed of job completion and stock removal are primary considerations
- Type 27 Flat with quick trim, flexible plastic backing plate or high-density fiberglass back



Proprietary new grain shape and chemistry for faster cutting and longer life on a wide range of materials.





				6	VENDIBLE		
			TIER:	BEST	BETTER	GOOD	GOOD
				BLAZE R980P	BLUEFIRE R860	METAL R828	METAL R828
			SHAPE:	Type 29 Conical	Type 29 Conical	Type 29 Conical	Type 29 Conical
			FLAP DENSITY:	Standard	Standard	Standard	High
				Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
		Bi	ACKING PLATE:		Fiberglass	Fiberglass	Fiberglass
	0015		OTHER:	1			
SIZE (D x H)	GRIT		M STD. PKG.	PART #	PART #	PART #	PART #
ype 29 Conical			10		00000000000		
1 x 5/8	36	15,300	10		666233 99049		
	40	15,300	10		66623399050		
	60 80	15,300	10 10		666233 99051		
		15,300		00001100100	666233 99052	00054440004	
4-1/2 x 5/8-11	36	13,300	10	662611 83490	662544 61165	662544 19991	
	36 40	13,300 13,300	10 V 10	66061102401	666233 41104 2-Pack	66054410004	660611 90505
	40 60	13,300	10	662611 83491	662544 61167 662544 61170	662544 19994	662611 32535
	60	13,300	10 V	662611 83492	666233 41105 2-Pack	662544 19996	662611 32536
	80	13,300	10 V	662611 83493	66254461173	662544 19997	662611 32537
	80	13,300	10 V	00201103493	666233 41106 2-Pack	00204419997	00201132337
	120	13,300	10 V		000233 41100 2-Pack	666233 99174	
4-1/2 x 7/8	24	13,300	10		666233 99204	000233 33174	
+-1/2 X 7/0	36	13,300	10	662611 83486	662544 61155	662544 19963	
	36	13,300	10 V	00201103400	666233 41107 2-Pack	00204419903	
	40	13,300	10 0	662611 83487	662544 61161	662544 19978	662611 32538
	60	13,300	10	662611 83488	662544 61163	662544 19984	662611 32539
	60	13,300	10 V	00201103400	666233 41108 2-Pack	00234413304	00201132335
	80	13,300	10 10	662611 83489	662544 61164	662544 19987	662611 32540
	80	13,300	10 V	00201103403	666233 41109 2-Pack	00234413307	00201132340
	120	13,300	10 10		00023341109 2-rack	666233 99175	
5 x 5/8-11	36	12.000	10		666233 99189	00020033113	
J X 3/0 11	40	12,000	10		66623399190		
	60	12,000	10		66623399191		
	80	12,000	10		666233 99192		
	120	12,000	10				
5 x 7/8	24	12,000	10		666233 99206		
0 / 170	36	12,000	10	662611 90001	662544 61174	662544 19998	
	40	12,000	10	662611 90002	662544 61176	662544 20001	
	60	12,000	10	662611 90003	662544 61177	662544 20002	
	80	12,000	10		662544 61178	662544 20003	
	120	12,000	10				
6 x 5/8-11	40	10,200	10			662544 91779	
	60	10,200	10			662544 91780	
	80	10,200	10			662544 91781	
6 x 7/8	24	10,200	10		666233 99066		
	36	10,200	10		666233 99298		
	40	10,200	10		666233 99193	662544 91776	
	60	10,200	10		666233 99194	662544 91777	
	80	10,200	10		666233 99195	662544 91778	
′ x 5/8-11	36	8,600	10	662611 83498	662544 61188	662544 20009	
	40	8,600	10	662611 83499	662544 61190	662544 20010	
	60	8,600	10	662611 83500	662544 61192	662544 20012	
	80	8,600	10	662611 83501	662544 61193	662544 20013	
	120	8,600	10				
7 x 7/8	24	8,600	10		666233 99196		
	36	8,600	10	662611 83494	662544 61180		
	40	8,600	10	662611 83495	662544 61183	662544 20006	
	60	8,600	10	662611 83496	662544 61185		
	80	8,600	10	662611 83497	662544 61186		

V = Vendible package. 2 discs/pack; 5 packs/carton. Order in multiples of 10.



NORTON	
SAINT-GOBAIN	

					0		0		
									Non the second
				BEST	BEST	BETTER	BETTER	GOOD	GOOD
		TRAE	DENAME:		BLAZE R980P	BLUEFIRE R860	BLUEFIRE R860	GEMINI R766	GEMINI R766
				Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat
			DENSITY		High	Standard	High	Standard	High
			BRASIVE:		Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
		BACKIN	G PLATE:		Fiberglass	Quick Trim Plastic	Fiberglass	Quick Trim Plastic	Fiberglass
			OTHER:		Supersize				
IZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
pe 27 Flat			T Ku.						
-1/2 x 5/8-11	36	13,300	10		662544 99894	666233 99136		666233 99125	
1/2 / 0/0 11	36	13,300	10 V		00207733034	666233 41086 2-Pk			
	40	13,300	10	662544 00257	662610 98290	666233 99137	776960 90086	666233 99000	
	60	13,300	10	662544 00258	662610 96435	66623399138	776960 90087	66623399001	666233 99060
	60	13,300	10 V		5020.030.00	666233 41087 2-Pk			3002000000
	80	13,300	10	662544 00259	662610 96436	666233 99139	77696090088	666233 99002	
	120	13,300	10	662544 00261				66623399003	
-1/2 x 7/8	36	13,300	10	636425 01865	662610 97678	666233 99140	77696090081		
	40	13,300	10	662544 00253	662610 20628	666233 99141	77696090082		
	60	13,300	10	662544 00254	662610 20633	666233 99142	77696090083		
	80	13,300	10	662544 00255	662610 20634	666233 99143	77696090084		
	120	13,300	10	662544 00256			77696090085		
x 5/8-11	36	12,000	10			666233 99144		666233 99127	
	40	12,000	10	776960 90141		666233 99145		666233 99128	
	60	12,000	10	776960 90142		666233 99146		666233 99130	
	80	12,000	10	776960 90143		666233 99147		666233 99131	
	120	12,000	10					666233 99132	
x 7/8	36	12,000	10			666233 99148			
	40	12,000	10	662544 00262		666233 99149			666233 99212
	60	12,000	10	662544 00264		666233 99150			666233 99213
	80	12,000	10	662544 00265		666233 99151			
	120	12,000	10	662544 00519					
x 5/8-11	40	10,200	10	662611 32128	662611 32145				666233 99219
	60	10,200	10	662611 32129	662611 32146				666233 99220
7/0	80	10,200	10	662611 32130	662611 32147	0000000150			666233 99221
x 7/8	40	10,200	10	662611 32123	66061100400	666233 99152			666233 99216
	60	10,200	10	662611 32124	662611 32136	666233 99153			666233 99217
	80 120	10,200	10 10	662611 32125		666233 99154			
x 5/8-11	36	8,600	10			666233 99155			
∧ J/0-11	40	8,600	10	662544 61066	662611 32148	666233 99156	776960 90092		
	60	8,600	10	662544 61067	662611 32168	666233 99157	77696090092	666233 99017	
	80	8,600	10	662544 61067	00201132100	666233 99158	77696090093	666233 99018	
	120	8,600	10	662544 61069		000200 JJIJU	11000 JUU34	666233 99019	
x 7/8	36	8,600	10	636425 01866		666233 99159		00020033013	
	40	8,600	10	662544 61059		666233 99160	77696090089		
	60	8,600	10	662544 61060		66623399161	77696090090		
	80	8,600	10	662544 61061		666233 99162			





Packaged for retail / walk-in selling / small jobs

BLUEFIRE R860 ZIRCONIA ALUMINA

- · Zirconia alumina abrasive for aggressive cut and long life
- · Individual hang cards provides product selling points; ships in merchandise display case of small quantities
- Available wire rack (with header card) allows merchandising of 4-1/2" product three ways: hung on pegboard, mounted on an upright, or placed on a shelf/counter

TIER: BETTER TRADENAME: BLUEFIRE R860 SHAPE: Type 29 FLAP DENSITY: Standard ABRASIVE: Zirconia Alumina BACKING PLATE: Fiberglass SIZE (D x H) PART # 40 13,300 4-1/2 x 5/8-11 07660703211 5 60 13,300 07660703212 5 13.300 80 5 07660703213 7 x 5/8-11 07660703206 60 8,600 5 Wire Rack 07660704157 1

WIRE RACK (WITH HEADER CARD) ALLOWS MERCHANDISING OF 4-1/2" PRODUCT THREE WAYS: HUNG ON PEGBOARD, MOUNTED ON AN UPRIGHT, OR PLACED ON A SHELF/COUNTER



See Portable Tools and Specialties section for mini flap discs.



COATED & NON-WOVEN ABRASIVES Non-Woven Discs



Non-woven discs have three components: strong synthetic fiber mesh and quality abrasives, bonded together by a smear-resistant adhesive. Rapid Strip discs have an open web construction that enables aggressive cutting action while maintaining a cool, non-loading surface. Rapid Blend discs have a unitized construction with varying weave – from open to tighter – for deburring and finishing. Rapid Prep discs have a more open weave that excels in surface preparation and cleaning. Each product provides excellent cutting action while improving surface finish.

Applications:

Size Range: Grit Range: Abrasive Grain: Machine Used: Medium-to-light material removal, deburring, blending, cleaning, finishing, and polishing 4^{*} - 7^{*}

Extra Coarse, Coarse, Medium, Fine, Very Fine Ceramic Alumina, Silicon Carbide, Engineered Aluminum Oxide, Aluminum Oxide





RIGHT ANGLE GRINDER

VERTICAL SHAFT PORTABLE GRINDER

DIE Er grinder

Material/Application-To-Product Recommendation Guide

Stripping Discs	BEST	BETTER	Deburring, Blending,	BEST		BETTER		
	Blaze Rapid Strip Ceramic	Rapid Strip Silicon Carbide	Finishing Discs	Vortex Rapid Blend	Vortex Rapid Prep	Rapid Blend	Rapid Prep	
Removing scale and coarse welding marks	◆ XC	◆ XC	Removing weld marks and weld spatter	◆ C		◆ C		
Removing coatings, epoxy/glue, paint and	◆ XC	◆ XC	Stainless steel deburring and cleaning	◆ C		◆ C		
other clogging material			Removing small flashings and	◆ C		◆ C		
Removing rust, oxidation, corrosion and residue	◆ XC ◆ XC		Curtooo proparation batara					◆ C
Removing parting	◆ XC	XC XC	Light cleaning		◆ F		♦ F	
lines and seams on	▼ X0		Cleaning and prepping welds		◆ M		• M	
fiberglass parts			Removing blemishes after welding stainless		◆ M		◆ M	
Removing paint/graffiti from concrete/stone	◆ XC	◆ XC	Blending and finishing all metal parts			◆ VF		
			Creating decorative finishes on stainless steel	◆ VF		◆ VF		
			Final finishing and polishing	VF		VF		
			Final finishing/polishing where				VF	

high conformability is needed XC - Extra Coarse, C - Coarse, M - Medium, F - Fine, VF - Very Fine

Application/Product Recommendation Guide

MOST AGGRESSIVE / LEAST CONFORMABLE

LEAST AGGRESSIVE / MOST CONFORMABLE

Depressed Center Discs	Blaze Rapid Strip	Vortex Rapid Blend A/O Med. Rapid Blend A/O Coarse	Rapid Blend A/O Medium	Rapid Blend S/C Fine	
Discs With Back-Up Pad		Vortex Rapid Prep Rapid Prep A/O Coarse	Rapid Prep A/O Medium	Rapid Prep A/O Fine	Rapid Prep Very Fine
Scale Removal	First Choice				
Stock Removal	First Choice	Second Choice			
Heavy Deburring	Second Choice	First Choice			
Light Deburring		First Choice	Second Choice		
Light Finishing		Second Choice	First Choice		
Blending			First Choice	Second Choice	
Finishing			Second Choice	First Choice	
Polishing				First Choice	Second Choice





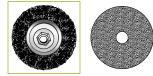
COATED & NON-WOVEN ABRASIVES Non-Woven Discs

Cross Reference Guide - For All Discs Used on Right Angle Grinders

STRIPPING (EXTRA COARSE) SURFACE FINISHING (COARSE – MEDIUM – FINE) SURFACE PREP (VERY FINE)

						,
	BEST	BETTER	BEST	BETTER	BEST	BETTER
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend	Vortex Rapid Prep	Rapid Prep
3M	Clean & Strip XT PRO, Clean & Strip XT PRO Extra Cut	Clean & Strip X	Debur and Finish PRO, Cut and Polish	EXL	SE, Duraflex	SC, PD, AI, LS
Bibielle	_	SDR Strip-It/Red	_	BUR Unitized	SCHD	SCLS, SCD, SCSB
Camel	—	EZ Strip Black/Red	—	—		—
Flexovit	_	Clean & Strip	—	—		—
Hermes	Strip Discs	Webrax	—	—		—
Pearl	_	S/C Stripping	—	—		Surface Preparation
Pferd	—	Policlean	—	Poliflex PUR		—
Sait	—	Sait-Strip	—	Unitized	7S, 8S	3Z
SIA	SiaStrip	_	_	—	6260	6250
Standard	_	Cleaning	700/800/900 Series	700/800/900 Series	FE, GP	FE, GP, RC
Superior	_	Stripping		XL Unitized		FD, GD, CC
Walter	—	FX Cleaning	_	—	—	Blendex Surface Conditioning

Why Choose Non-Woven Depressed Center Discs?



Non-Woven Right Angle Discs vs. Fiber Discs, Wire Wheels, and Depressed Center Wheels

- Deburring, blending and finishing done with one product to reduce the number of steps
- To provide a controlled, sustained finish
- To prevent undercutting and gouging
- To provide a cooler grinding action to lessen the chance of warping or discoloration

For stripping coatings and paint off of hard materials like concrete, cement and stone



Less vibration and quieter for high operator acceptance

· When loading is an issue with fiberglass, adhesives and soft metals

• To provide an alternative to wire brushes





RAPID, DURABLE BLENDING AND FINISHING

Reduce Steps and Increase Productivity Choose a Vortex Rapid Prep Flap Disc

Norton Vortex Rapid Prep flap discs, featuring layers of non-woven surface conditioning material, offer a longer life over traditional single layer products. Featuring high performance Vortex grain technology that cuts coarser and finishes finer with a smear free resin system.

The Type 27 shape provides forgiveness when going over uneven surfaces and reduces vibration to improve the ergonomics of any operation.

- Product finer finish faster, reduce steps
- Improve life and reduce disc changes, reduce vibration
- Faster cut rate, longer life and less disc changes

Recommended Starting Grits for Applications

			<u> </u>										
	AVERAGE			EDGE		PAINT	PARTING		RUST				SURFACE
GRIT	RA (µIN)	BLENDING	DEBURRING	BREAK	FINISHING	REMOVAL	LINE REMOVAL	POLISHING	REMOVAL	SANDING	SMOOTHING	STRIPPING	PREP
COARSE	40	•	•	•		•	•		•	•	•	•	•
MEDIUM	20	•	•	•	•	•	•	•		•	•	•	•
FINE	10	•			•			•		•	•		•
VERY FINE	5	•			•			•		•			•



Rapid Strip



Best choice for quick and easy rough cleaning and stripping of all materials

BLAZE RAPID STRIP CERAMIC ALUMINA

- Blaze ceramic grain provides 2X plus faster, consistent rate and life than silicon carbide discs, leaves a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as painting and soldering
- Open web construction for minimal loading; does not shed or snag on rusty pieces; prevents gouging and rework
- · Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish

Better choice for use on a variety of materials, including metal, fiberglass and stone



- · Sharp silicon carbide abrasive provides fast aggressive cutting action
- · Advanced resin bond prevents shedding, snagging, gouging, and rework
- · Open web construction for minimal loading; great alternative to wire brushes



ABRASIVE:

		TYPE/BACKING:	Type 27/Fiberglass	Type 27/Fiberglass
SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #
4-1/2 x 5/8-11	12,000	10	662544 98101	662610 09585
4-1/2 x 7/8	12,000	10	666233 03783	662610 09649
5 x 5/8-11	11,000	10	666233 03915	
5 x 7/8	11,000	10	666233 03916	
7 x 5/8-11	8,000	10	666233 03919	662610 09650
7 x 7/8	8,000	10	666233 03920	662610 09586





Rapid Blend / High Strength



Best choice with revolutionary technology for heavy deburring and finishing

VORTEX RAPID BLEND ALUMINUM OXIDE

- Proprietary engineered Vortex aluminum oxide agglomerated grain performs the medium to fine grit steps of traditional aluminum oxide discs
- Thick nylon web for 2X longer life and faster finishing vs. traditional aluminum oxide discs, with minimal shedding
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing



Best Choice for tough and conformable, resists tearing on burrs and sharp edges

HIGH-STRENGTH ALUMINUM OXIDE

- · Premium aluminum oxide grain; engineered for more demanding applications
- Uniform construction maintains part tolerance; prevents cutting and gouging
- · Smear-free bond excels at producing light satin finishes



Better choice for surface prep, deburring, blending and removing parting lines, rust, and coatings

RAPID BLEND NEX A/O / S/C

- · Premium aluminum oxide or silicon carbide grain for consistent performance
- Uniform construction extends life and maintains part tolerance; prevents cutting and gouging
- Resin formula produces consistent, smear-free finishes

MOST AGGRESSIVE / LEAST CONFORMABLE

LEAST AGGRESSIVE / MOST CONFORMABLE

	0	0	0	0	0	0	0	0
TIER.	BEST	BEST	BEST	BEST	BETTER	BETTER	BETTER	BEST
TRADENAME.	VORTEX Rapid Blend	VORTEX Rapid Blend	VORTEX Rapid Blend	HIGH- Strength	RAPID BLEND Nex	RAPID BLEND Nex	RAPID BLEND Nex	HIGH- Strength
ABRASIVE.	Engineered A/O	Engineered A/O	Engineered A/O	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
GRIT SIZE.	Coarse	Coarse	Medium	Coarse	Medium	Fine	Fine	Medium
SPECIFICATION:	Vortex 5AC	Vortex 8AC	Vortex 5AM	High Strength	NEX-2AM	NEX-2AF	NEX-2SF	High Strength
TYPE/BACKING.	Type 27/ Fiberglass							
SIZE MAX. STD.		D107 //	D107 //		B497 //	D. D. //	D. D. //	D4D7 //
(D x H) RPM PKG	. PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #
4-1/2 x 5/8-11 12,000 10	662611 32881	662611 32929	662544 29243	776960 00144	662610 23947	662610 23946	662610 23943	662610 23949
4-1/2 x 7/8 12,000 10	662611 32880	662611 32928	662544 29268	776960 00145	662610 20548	662610 20547	662610 20546	662610 20549





Vortex Rapid Prep Flap Discs



Best choice for cleaning, light deburring and processing TIG welded seams on stainless steel

VORTEX RAPID PREP FLAP DISCS

- High-performing, patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit
 with the finish of a finer grit
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals
- Multiple layers of surface conditioning material provide added life, fewer disc changes, and reduced vibration





Reduce Grits & Steps with Norton Vortex Rapid Prep Flaps Discs!



ANDIAD.



Rapid Polish

Better choice for finishing to a mirror like shine

RAPID POLISH

- Type 27 disc with premium quality pressed hardened felt for polishing to a mirror like finish
- Use with our without polishing compound
- Soft padding is Ideal for final finishing with no vibration



TILLMAN'



COATED & NON-WOVEN ABRASIVES Non-Woven Arbor Hole Discs

Rapid Strip Arbor Hole Discs



Best choice for removing rust, scale and paint/coatings on a variety of substrates, such as wood, metal and plastics

BLAZE RAPID STRIP CERAMIC ALUMINA

- · Norton Blaze ceramic alumina grain provides 2X cut rate, 2X life over silicon carbide products
- · Advanced resin bond does not shed on rust-encrusted pieces, and prevents gouging and rework; does not snag when used for deburring
- · Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering

Better choice for removing coatings on a variety of substrates such as wood metal and plastics

RAPID STRIP SILICON CARBIDE

- · Faster cutting, sharp, extra coarse silicon carbide abrasive provides a unique combination of aggressive performance, long life, and improved finish
- · Advanced resin bond prevents shedding on rust-encrusted pieces and gouging and rework; does not snag when used for deburring
- Leaves a thoroughly clean surface that ensures excellent adhesion in subsequent processes such as coating, painting and soldering



	MAX. RPM	STD. PKG.		PART #
Arbor Hole				
4 x 1/4	8,000	25	662610 09324	662610 08008
4 x 1/2	8,000	25	666233 04856	662610 07916
6 x 1/4	4,000	15	666233 40171	662610 07988 NS
6 x 1/2	4,000	15	662610 99378	662610 08051



FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK Diameter	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	PART #
Mandrel	Assemblies						
1/4"	1/2" (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	662610 09502



Industrial Market - Full-Line



COATED & NON-WOVEN ABRASIVES Non-Woven Arbor Hole Discs

High-Strength Arbor Hole Discs

Applications include rust/oxide or coating removal, pipe ID and OD polishing, casting cleaning, highlighting (antiquing), contaminant removal, removal of handling marks, gasket removal, cleaning and blending of surface imperfections, prepping prior to soldering, removal of filling materials, cleaning angles and odd shapes. Will not stretch or shed. Ganging increases versatility. For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.



Best choice for removing rust, scale and paint/coatings on a variety of substrates, such as wood, metal and plastics

HIGH-STRENGTH ALUMINUM OXIDE DISCS

- Strongest non-woven buffing and polishing disc
- · Premium aluminium oxide grain; engineered for more demanding applications
- Tough but flexible web resists tearing on burrs and sharp edges; and conforms to intricate shapes and contours
 without changing the workpiece dimension; can be ganged together and used as a wheel
- Smear-free bond excels at producing light satin finishes



			TIER:	BEST
			TRADENAME:	HIGH STRENGTH
			ABRASIVE:	Aluminum Oxide
SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #
6 x 1/4	VF	4,000	70	662610 07628
6 x 1/2	С	4,000	70	776960 00146
	М	4,000	70	662610 05073
	VF	4,000	70	662610 04980
8 x 1/2	С	3,000	50	776960 00147
	М	3,000	50	662610 05491
	VF	3,000	50	662610 04506
12 x 1-1/4	С	1,900	25	776960 00148
	VF	1,900	25	662610 08723

See page 169 for High Strength quick-change discs.



FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK Diameter	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	PART #
Mandre	l Assemblies For	Using Discs On	Edge				
1/4"	1/2" (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	662610 09502
1/2"	1/2" (Standard)	Up to 8"	1/4"	3-1/8"	2-1/4"	1	662610 59420



Rapid Prep 7/8" Center Hole

COATED & NON-WOVEN ABRASIVES Non-Woven Standard Back-up Pad Discs



Best choice for aggressive stock removal and blending in one step

RAPID PREP XHD

- Coarse and Medium discs solve your most aggressive stock removal and blending challenges; remove weld lines, weld spatter, weld discoloration and blend surfaces in a single step
- Improve cut control and surface blending over traditional coated flap discs and fiber discs from our unique combination of a conformable fiber matrix and premium ceramic grain
- XHD Coarse discs for aggressive weld removal and surface blending on steels and Medium discs on softer metals/alloys



		TIER: BEST
		TRADENAME: RAPID PREP XHD
		ABRASIVE: Ceramic Alumina
SIZE (D x H)	STD. PKG.	PART #
Coarse		
4-1/2 x 7/8	40	662611 70275
5 x 7/8	40	662611 70279
7 x 7/8	25	662611 70280
Medium		
4-1/2 x 7/8	40	662611 70282
5 x 7/8	40	662611 70283
7 x 7/8	25	662611 70284
NULL NAME DOMAIN A		

Note: Max RPM is determined by corresponding back up pad.



Norton Rapid Prep Surface Conditioning Products

The Perfect Abrasive, Coating, and Bond Built into Every Disc and Belt

- Available in premium Vortex aluminum oxide aggregate grain and Norton aluminum oxide grain; ideal for many aerospace, metal and stainless steel fabrication, and MRO applications
- Our proprietary coating method extends life and delivers consistent finishes by creating a thick layer of grain throughout the product; grain does not sit on top of fibers as other competitive products can
- Our new Clean Bond resin system guarantees smear-free finishes, even on high nickel content alloys; will not load on
 aluminum and soft metals, as competitive products can





Rapid Prep 7/8" Center Hole

COATED & NON-WOVEN ABRASIVES Non-Woven Standard Back-up Pad Discs



Best choice for finishing and blending applications

VORTEX RAPID PREP ALUMINUM OXIDE DISCS

- High-performing, patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit
 with the finish of finer grits
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life and provides added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

Better choice for high nickel content alloys, aluminum and other soft metals



RAPID PREP ALUMINUM OXIDE

- Quality aluminum oxide abrasive grain coating provides up to 20% higher cut rate and 50% better performance than competitive products
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life, added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals



	TIER:	BEST	BETTER
	TRADENAME:	VORTEX RAPID PREP	RAPID PREP
	ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide
SIZE (D x H)	STD. PKG.	PART #	PART #
Extra Coarse			
4-1/2 x 7/8	25		666233 26070
5 x 7/8	25	666233 34975	
7 x 7/8	25	666233 41360	
Coarse			
4-1/2 x 7/8	25	666233 34944	662544 73868
5 x 7/8	25	666233 34946	662610 08293
7 x 7/8	25	666233 41362	666233 25138
Medium			
4-1/2 x 7/8	25	666233 33612	666233 25915
5 x 7/8	25	666233 34963	662610 17124
7 x 7/8	25	666233 41364	666233 25919
Fine			
4-1/2 x 7/8	25	666233 33608	666233 25153
5 x 7/8	25	666233 34954 NS	662544 69132
7 x 7/8	25	666233 41366 NS	
Very Fine			
4-1/2 x 7/8	25	666233 33616	
5 x 7/8	25		666233 25943
7 x 7/8	25	666233 41368 NS	666233 25959

Additional sizes are available made-to-order, contact your Norton representative for current order quantities and lead times. NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Note: Max RPM is determined by corresponding back-up pad.

See page 68 for 7/8" Hole Air Cooled Back-up Pads



Industrial Market - Full-Line



Rapid Prep

- Speed Change 5/8"-11
- These discs feature Norton quick, tool-free, twist-on and -off Speed-Change fasteners. Discs lock to standard back-up pads with a unique nut design and are easily removed, increasing your productivity with more time to grind.
- Rapid Prep XHD are the best choice for aggressive stock removal and blending in one step.

	Th	ER: BEST
	TRADENAN	ME: RAPID PREP XHD
	ABRASI	VE: Ceramic Alumina
SIZE (D x H)	STD. PKG.	PART #
Coarse		
4-1/2 x 5/8-11	25	662611 70060
5 x 5/8-11	25	662611 70061
7 x 5/8-11	25	662611 70288
Medium		
4-1/2 x 5/8-11	25	662611 70062
5 x 5/8-11	25	662611 70063
7 x 5/8-11	25	662611 70289
Max RPM is deter	mined by correspon	ding hack up nad

Max RPM is determined by corresponding back up pad.

			690	
		TIER:	BEST	BETTER
		TRADENAME:	VORTEX RAPID PREP	RAPID PREP
		ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide
SIZE (D x H)	STD. PKG.		PART #	PART #
Extra Coarse				
1-1/2 x 5/8-11	25		666233 73667 NS	666233 73690 NS
5 x 5/8-11	25		666233 73669 NS	
7 x 5/8-11	25		666233 73670	
Coarse				
1-1/2 x 5/8-11	25		666233 73671	666233 73693 NS
5 x 5/8-11	25		666233 73674 NS	662544 98516
7 x 5/8-11	25		666233 73675 NS	662611 92908
Nedium				
4-1/2 x 5/8-11	25		666233 73678	666233 08157
5 x 5/8-11	25		666233 73679 NS	666233 73694 NS
7 x 5/8-11	25		666233 73680 NS	662611 92913 NS
Fine				
1-1/2 x 5/8-11	25		666233 73681	
5 x 5/8-11	25		666233 73682 NS	666233 73695 NS
7 x 5/8-11	25		666233 73684 NS	
/ery Fine				
5 x 5/8-11	25		666233 73686 NS	666233 73699 NS
7 x 5/8-11	25		666233 73687	666233 73700 NS
Note: Sneed Channe di	isos must always he us	ed with smooth fa	ice hack-un nads	

Note: Speed Change discs must always be used with smooth face back-up pads.

Max RPM is determined by corresponding back-up pad.

7

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

AVOS Non-Woven Speed-Lok

- Patented hole design allows for interrupted cut, reducing heat up to 30% over standard surface preparation discs for cooler cutting and longer life
- With complete vision into the grinding zone, operators can grind more accurately with less re-work; scooped holes create air glow to pull loose abrasive and swarf away from work surface grinding zone – resulting in extended disc life
- The 15° angle back-up pad lets you grind at 5° 15° angle allowing for greater utilization of disc surface and eliminates gouging of workpiece

See page 68 for Speed Change and AVOS Back-up Pads



	TIER:	BEITER
	TRADENAME:	RAPID PREP AVOS
	ABRASIVE:	Aluminum Oxide
SIZE (DIAMETER)	STD. PKG.	PART #
Coarse		
4-1/2	10	662610 10447
5	10	666233 74818
Medium		
4-1/2	10	662610 10448
5	10	666233 74819
Very Fine		
4-1/2	10	666233 74823
5	10	666233 74824
Noto: AV/OC diago m	wat ha wood with MVOC	Chood Lak back up pada

Note: AVOS discs must be used with AVOS Speed-Lok back-up pads. Max RPM is determined by corresponding back up pad.



COATED & NON-WOVEN ABRASIVES Non-Woven Speed-Change Discs



COATED & NON-WOVEN ABRASIVES Non-Woven Hook and Loop Discs

Rapid Prep

Non-Woven Hook and Loop Discs

 Rapid Prep XHD are the best choice for aggressive stock removal and blending in one step.

ssive	ant			
			1	
		1		

	1	TIER: BEST
	TRADENA	ME: RAPID PREP XHD
	ABRAS	SIVE: Ceramic Alumina
SIZE (DIAMETER)	STD. PKG.	PART #
Coarse		
4-1/2	40	662611 70179
5	40	662611 70181
7	25	662611 70182
Medium		
4-1/2	40	662611 70183
5	40	662611 70185
7	25	662611 70186
May DDM in datarmin	d by corresponding by	al up pad

Max RPM is determined by corresponding back-up pad.

* Standard Package = 80

Back-up Pads

Hook & Loop Back-up Pads

PAD	SPINDLE OR	MAX.	3M	STD.	D4D7 #		
DIAMETER	HOLE SIZE	RPM	EQUIVALENT	PKG.	PART #		
Back-up Pads for Non-Woven Hook and Loop Discs							
2	1/4 Steel Shank	23,000	922	5	662610 59352		
3	1/4 Steel Shank	20,000	923	5	662610 59354		
4	1/4 Steel Shank	18,000	924	5	662610 59356		
	5/8-11	13,000	914	5	662610 59304		
4-1/2	5/8-11	10,000	9145	5	662610 06948		
5	5/16-24 Male	10,000	905	5	662610 59360		
	5/8-11	10,000	915	5	662610 59310		
6	5/8-11	8,000	916	5	662610 59312		
7	5/8-11	6,000	917	5	662610 59368		
8	5/8-11	4,500	918	5	662610 59372		

		A TO	
	TIER:	BEST	BETTER
	TRADENAME:	VORTEX RAPID PREP	RAPID PREP
	ABRASIVE:	Engineered Aluminum Oxide	Aluminum Oxide
SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
2	50		662610 17900 NS
4-1/2	25	666233 34972	662610 17906
5	25	666233 34974	662610 17215
7	25	666233 34976	662611 92846
Coarse			
2	50	666233 34882	662610 04431 *
3	25	666233 34883	662610 55015
4-1/2	25	666233 34943	662610 17806
5	25	666233 34945	662610 04435
7	25	666233 34951	662610 55027
Medium			
2	50	666233 34958	662610 04441
3	25	666233 34956	662610 04442
4-1/2	25	666233 34961	662610 04444
5	25	666233 34962	662610 55022
7	25	666233 34965	662610 17813
Fine			
2	50		666233 25141
3	25	666233 33605	666233 25143 NS
4-1/2	25	666233 33607	666233 25147
5	25	666233 33609	666233 25154
7	25	666233 34955	662611 99465
Very Fine			
2	50		666233 25926
3	25	666233 33614	666233 25934
4-1/2	25	666233 33615	666233 25936
5	25	666233 33617	666233 25941
7	25	666233 34969	662610 19990



Max RPM is determined by corresponding back-up pad.

* Standard Package = 80

NS Non-Stock, contact your Norton representative for current order quantities and lead times.







COATED & NON-WOVEN ABRASIVES Cloth PSA Discs and Accessories

Norton PSA (pressure sensitive adhesive) individual cloth discs are used on four different types of machines and the application changes depending on which machine they are used on.

Applications:

Pneumatic and Electric Dual-Action (DA) and Electric Random Orbital Sanders – for use on contours or flat surfaces for light- to medium-pressure grinding, blending, leveling, and finishing applications.

Stationary Disc Sanders – used in woodworking and metalworking for stock removal, sanding/grinding flat surfaces, dimensioning and finishing. 5" - 24" diameter

Size Range: Grit Range: Abrasive Grain: Back-up Pads:

Machine Used:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide Rubber, with hardness variations for different applications, for portable machines. Steel for stationary disc sanders.





Best choice for all hard-to-grind high alloy steels

24 - 180

BLAZE R980P CERAMIC ALUMINA

- 100% ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to provide fastest cut rate and longest life over competitive blended/low-ratio ceramic alumina discs
- Strong resin bond and heavy-duty Y-weight polyester backing for consistent cut, better grain adhesion, edge-tear
 resistance, and durability
- Self-lubricating grinding aid treatment delivers the coolest cut on stainless steel, high alloy steels, super alloys, titanium, and other difficult to grind materials



Better choice for grinding and deburring stainless steel

BLUEFIRE R821P ZIRCONIA ALUMINA

- Latest generation of self-sharpening, zirconia alumina abrasive for cooler cut and extended life over aluminum oxide discs
- · Heavy-duty Y-weight cotton backing for edge-tear resistance and durability
- · Pressure sensitive adhesive makes for easy application and removal



Good choice for general-purpose metalworking

GEMINI R228 ALUMINUM OXIDE

- · Premium aluminum oxide abrasive gives an excellent initial cut rate
- Durable X-weight cotton backing makes these discs a good blend of flexibility and life
- · The cotton backing provides good resistance to heat



Good option for light- to medium-pressure grinding, blending, leveling and finishing applications

METAL R243 ALUMINUM OXIDE

- · Aluminum Oxide grain provides consistent cut for general purpose use
- Improved resin bond system provides longer life
- · Flexible J-weight cotton backing for added conformability, tabs allow for easy liner removal



COATED & NON-WOVEN ABRASIVES Cloth PSA Discs and Accessories

Cloth PSA Discs for Dual-Action and Random Orbital Sanders

			BEST	BETTER	GOOD	GOOD
		TRADENAME:	BLAZE R980P	BLUEFIRE R821P	GEMINI R228	METAL R243
		ABRASIVE:	• • • • • • • • • • • • • • • • • • • •	Zirconia Alumina	Aluminum Oxide	Aluminum Oxide
			PSA Discs	PSA Discs	PSA Discs	PSA Discs
		OTHER:	Supersize	Tabbed		Tabbed
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #
5	36	50/250	662544 61506 *	662611 32579	662611 36589	
	40	50/250	662544 61507		662611 36588	
	50	50/250	662544 61508	699573 49352	662611 36587	
	60	50/250	662544 61509	699573 49353	662611 36586	
	80	50/250	662544 61510	662611 35091	662611 36585	699573 39967
	100	50/250			662611 36584	
	120	50/250	662544 61512		662611 36583	699573 39969
	150	50/250			662611 36582	
	180	50/250			662611 36581	
6	60	50/250			662611 36596	
	80	50/250			662611 36595	699573 39973
	100	50/250			662611 36594	
	120	50/250			662611 36593	699573 39978
	150	50/250				
	180	50/250			662611 36592	
8	36	50/250			662611 36350	
	40	50/250			662611 36351	
	50	50/250			662611 36352	
	60	50/250			662611 36576	
	80	50/250			662611 36354	
	120	50/250			662611 36355	

*Pkg./Case: Blaze R980P 5" 36 grit discs = 50/200



Back-up Pads for Cloth PSA Discs

DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Back-up Pads for Cloth PSA Discs			
5" Diameter – Low Profile – Soft	12,000	5	636425 06126
5" Diameter – Low Profile – Medium	12,000	5	636425 06131
5" Diameter – Tapered – Medium	12,000	5	636425 06139
6" Diameter – Low Profile – Soft	10,000	5	636425 06127
6" Diameter – Low Profile – Med	10,000	5	636425 06133
6" Diameter – Tapered – Medium	10,000	5	636425 06141
8" Diameter – Tapered – Medium	6,000	5	636425 43112



COATED & NON-WOVEN ABRASIVES Cloth PSA Discs and Accessories

Large Diameter Cloth PSA Discs

Used on stationary disc machines for dimensioning and finishing metal workpieces and woodworking. Pressure sensitive adhesive offers fast, convenient mounting. Made without center holes for full-face usage.

				a series we	
		TIER:	BEST	BETTER	GOOD
		TRADENAME:	BLAZE R980P	BLUEFIRE R821P	GEMINI R228
		ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide
		ATTACHMENT:		PSA	PSA
		OTHER:	Supersize		
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #
0	36	25/50			662611 36606
	40	25/50		662611 38314	662611 36604
	50	25/50			662611 36607
	60	25/50		662611 38316	662611 36602
	80	25/50		662611 38317	662611 36601
	100	25/50			662611 36600
2	24	25/50		662611 38318	
	36	25/50	662544 16171	662611 38319	662611 36635
	40	25/50	662544 16172	662611 38320	662611 36630
	50	25/50	662544 16173	662611 38321	662611 36625
	60	25/50	662544 16174	662611 38322	662611 36620
	80	25/50	662544 16175	662611 38323	662611 36615
	100	25/50			662611 36614
	120	25/50	662544 16176		662611 36613
5	36	25/50			662611 36666
	60	25/50			662611 36663
	80	25/50			662611 36662
6	36	25/50			662611 36700
	40	25/50			662611 36685
	50	25/50			662611 36684
	60	25/50		662611 38334	662611 36683
	80	25/50		00201100001	662611 36701
8	36	25/50			662611 36720
	60	25/50			662611 36696
	80	25/50			662611 36723
20	36	25/50	662544 16165	662611 38343	662611 36710
	40	25/50		662611 38344	662611 36709
	50	25/50	662544 16167	30201100011	662611 36711
	60	25/50	662544 16168	662611 38346	662611 36712
	80	25/50	662544 16169		662611 36706
	120	25/50	662544 16170		00201100100
4	36	10/10	00201110110		662611 36718
. 1	40	10/10			662611 36717
	50	10/10			662611 36725
	60	10/10			662611 36726
	80	10/10			662611 36727
	00	10/10			JUZUTIJUIZI



NDRTDN

SAINT-GOBAIN

For use on dual action and random orbital sanders. The industry's highest performing and broadest selection of paper discs in PSA (pressure sensitive adhesive) disc rolls and individual discs, and hook and loop discs.

Applications:

Size Range: Grit Range: Abrasive Grain: Attachment Systems: Paper Weights: Vacuum Holes: Machine Used:

Stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass and composites, bare wood sanding, light weld blending, preparing and finishing metal, and sanding of all gel coat and body filler compounds. 3" – 8"

36 - 1500

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide PSA (pressure-sensitive adhesive), hook and loop Heavyweight – E and F; Lightweight – B, C, and D See product availability charts



ORBITAL VE SANDER PC

VERTICAL SHAFT PORTABLE GRINDER

Material/Application-to-Product Recommendation Guide

	BEST			BETTER		GOOD		
	Heavy-Medium Stock Removal		Light Stock Removal Finishing		dium Ioval	Light Stock Removal Finishing	Light Stock Removal Finishing	
	SG H920	Blaze A995	Dry Ice A975	BlueFire H875P	BlueFire H822	A2750P	Gold Reserve A296	
Primed, Painted Surfaces		•	•	•		•	•	
Fiberglass / Composites / Gel Coats		•	•	•		•	•	
Wood		•	•	•		•	•	
Metal	•	•	•		•	•	•	
Body Fillers / Compounds / Plastics		•	•	•		•	•	

Application/Grit Recommendation Guide

COARSER (GRINDING)

36	40	60	80	100	120	150	180	220	240	280	320	360	400	500	600	800	1000	1200	1500
Rough	ing to Int	ermediat	е																
			Interm	ediate to	Finishing														
									Fine Fir	nishing									
																Ultra Fir	ne Finishi	ng	

Cross Reference Guide

TOTAL PERFORMANCE

INITIAL PRICE

FINER (FINISHING)

	DEOT			DETTED				0000
NORTON	BEST F-Weight SG H920	D-Weight Blaze A995	B- & C-Weight Dry Ice A975	BETTER F-Weight BlueFire H822	E-Weight BlueFire H875P	B-Weight A275 OP	B-Weight Durite A475	GOOD C-Weight Gold Reserve A296
3M	763U	732U, 737U, 755L 775L	334U, 734U, 735U		7401, 7451, 750U, 751U, 7511	216U, 255L, 236U, 260L, 334U	405N, 414N, 415U, 426U, 435U	236U, 316U, NX, 216U, 236U
Hermes	BW114, CR116	CR116	_	BW115, BW184	BW110, VC153	VC154-LL	SF168	VC151-LL, VC152, WA flex 28
Indasa		HT Line	HT Line, RedLine		HeavyLine	PlusLine	_	WhiteLine, YellowLine
Klingspor	PS61	_	PS36	PS21	PS36	PS33, PS73W	PL35, PS14	PS33, PL36
Mirka	—	—	_		Royal CRS. Cut	Q-Silver, Royal Micro	CaratFlex, PolarStar	Bulldog Gold, Basecut
SIA		_	Siaprime 5550, 1958	1820	1820, 1919, 1948	1940, 1944,1950	1748	1947, 1960
VSM	_	_	_	_	KP510E, KP709		CP131A	KP911



Heavyweight Paper Discs



Best choice for most demanding stock removal applications

SG H920 CERAMIC ALUMINA

- Durable and friable Norton seeded gel ceramic alumina abrasive ensures fast, aggressive, yet cool cutting action and maximum life
- Strong F-weight paper, synthetically-coated, provides maximum durability and resistance to edge chipping and shedding
- Closed coat and sharp grain make this a premiere product for metal fabricating and blending; ideal for soldered and welded areas

Better choice for aggressive metalworking applications

BLUEFIRE H822 ZIRCONIA ALUMINA

- · Patented zirconia alumina abrasive provides 2X-3X life over aluminum oxide products
- Strong F-weight paper, synthetically-coated for excellent durability and chip resistance; pressure sensitive adhesive
 and linked disc roll format allow easy application, removal, and dispensing
- Non-stearated (no anti-loading agents) for non-contaminating; often required for prime auto and aerospace paint applications

Better choice for soft material and wood applications

BLUEFIRE H875P ZIRCONIA ALUMINA

- Next-generation, self-sharpening zirconia alumina abrasive provides 2-3 times the life of aluminum oxide discs, longer life versus original zirconia alumina discs, improved cut rate, and minimal heat
- Strong E-weight latex/paper backing resists tearing while staying conformable and flexible
- · Open coat contributes to minimized loading

Stick & Sand (PSA) Heavyweight Disc Rolls Non-Vacuum

				4		
			TIER:	BEST	BETTER	BETTER
			TRADENAME:	SG H920	BLUEFIRE H822	BLUEFIRE H875P
			ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina
		PAP	ER BACKING WEIGHT:	F-Weight	F-Weight	E-Weight
			FASTENING:	PSA	PSA	PSA
SIZE (D)	GRIT	ROLLS/STD. PKG.	DISCS/ ROLL	PART #	PART #	PART #
5	60	4	100	662611 49873	662611 37310	
	80	4	100	662611 49872	662611 37309	662611 24977
	100	4	100		662611 37308	
	120	4	100	662611 49870		
6	60	4	100		662611 37323	
	80	4	100	662611 49876	662611 37322	662611 25573
	120	4	100	662611 49874		

Refer to the Sanding Accessories section for back-up pads and accessories.

•	•		
	~	-	
		-/	



Heavyweight Paper Discs

пеачуже	ауш на	iper Discs		
Stick & Sar Individual I Non-Vacuu	Discs			
NOII-VACUL	in and v			
			BETTER	BETTER
		TRADENAME:		BLUEFIRE H875P
			Zirconia Alumina	Zirconia Alumina
		PAPER BACKING WEIGHT:		E-Weight
		FASTENING:		PSA Vacuum
SIZE (D)	GRIT	PKG./CASE	PART #	PART #
5	36	50/200	662611 25436	
	40	50/200	662611 25307	
	80	50/200	662611 25244	
				6" x 6 Hole Die #3371
6	36	50/200	662611 23575	
	40	50/200	662611 23574	662611 23580
	80	50/200	662611 23573	
				8" x 8 Hole Die #3370
8	36	25/100	662611 23578	662611 23584
	40	25/100	662611 23577	
	80	25/100	662611 23576	662611 23582

Hook & Loop Individual Discs

Non-Vac	uum and	/accum			• •
			ALL STREET		•
		TIER:	BEST	BETTER	• BETTER
		TRADENAME:	SG H920	BLUEFIRE H875P	BLUEFIRE H875P
		ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina
		PAPER BACKING WEIGHT:	F-Weight	E-Weight	E-Weight
			Hook & Loop	Hook & Loop	Hook & Loop
		OTHER:	· · · ·	· · · · · ·	Vacuum
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #
5	40	25/100		662611 25684	
	60	50/250	662611 49864		
	80	50/250	662611 49865	662611 25444 *	
6	36	25/100		662611 23590	
	40	25/100		662611 23589	
	80	25/100		662611 23588	
					° ° °
					8" x 8 Hole Die #3370

				Die #3370
8	36	25/100	662611 23593	662611 23598
	40	25/100	662611 23592	
	80	25/100	662611 23591	662611 23596
Dookoging Standard	de Min / Std Dka	* LIO7ED 0E/100		

Packaging Standards: Min. / Std. Pkg. * H875P = 25/100



Lightweight Paper Discs



ess dust; more productivity

MULTI-AIR CYCLONIC HOOK & LOOP VACUUM

- Multi-Air Cyclonic precision laser-cut, spiral vacuum hole design maximizes dust extraction for cleanest work
 environment and less potential for contamination, while delivering coolest, fastest, most consistent cut rate, and
 longest life of any paper disc
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work
- Exceptional choice for the most demanding paper disc sanding applications; hook and loop back for easy disc
 mounting and changing

				and the			
				ALCORDER STOR	2		NORTON
					1		SAINT-GOBAIN MULTI AR
					2		
				CORRECT OF CORRECT		O	CYCLONIC
			Construction of the	ALC: CONTRACTOR	25		
		TIER:	BEST	BEST		BEST	
	TF	RADENAME:	BLAZE A995 No-Fil	DRY ICE A975 No-Fil		A2750P No-Fil	
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina		Aluminum Oxide	
PA	PFR RACKII	VG WEIGHT:	D-Weight	B- & C-Weight		B-Weight	
		ASTENING:		Hook & Loop		Hook & Loop	and the second sec
			P-Graded	P-Graded		P-Graded	
		PKG/ CASE			PKG/ Case		Constant of the state of the second sec
SIZE (D)	GRIT		PART #	PART #	CASE	PART #	" and a state of the second state of the secon
3 x 0	80	50/200		776960 95005			A COLORADO COLORADO
	120	50/200		776960 95006			
	150	50/200		776960 95007			
	180	50/200		776960 95008			
	220 240	50/200 50/200		776960 95009 776960 95010			
	240	50/200		776960 95011			
	400	50/200		776960 95012			
	500	50/200		776960 95012			
	600	50/200		776960 95014			and the set of the set
	800	50/200		776960 95015			a set at a set
	1000	50/200		776960 95016			Constant and
5 x 11/16	80	50/200	636425 97500	776960 07745	100	666233 90524	a share a shar
(125mm x 18m					100	666233 90525	
	120	50/200	636425 97501	776960 07753	100	666233 90526	
	150	50/200	636425 97502	77696007755	100	666233 90527	
	180	50/200	636425 97503	776960 07756	100	666233 90528	Die punched holes cause deformation.
	220	50/200	636425 97504	776960 07757	100	666233 90529	
	240	50/200		776960 07760	100	666233 90530 <i>NS</i>	
	280	50/200		776960 07762			
	320	50/200		776960 07763	100	666233 90531	- SUBFACE AREA
	400	50/200		776960 07765	100	666233 90532	CARLES CONTRACTOR CONT
	500	50/200		77696007768	100	666233 90534	Multi-Air Cyclonic laser-cut discs are flat and true.
	600 800	50/200 50/200		776960 07791 776960 07793	100	666233 90534	d
	1000	50/200		776960 07795	100	666233 90536	
6 x 11/16	40	25/200	636425 97515	11030001133	100	000200 30300	SURFACE AREA
(150mm x 18m		50/200	636425 97519				
	80	50/200	636425 97505	776960 07770	100	666233 90503	Improved Dust
	120	50/200	636425 97506	776960 07773	100	666233 90504	
	150	50/200	636425 97507	776960 07774	100	666233 90505	 Extraction / Increased Productivity
	180	50/200	636425 97508	776960 07775	100	666233 90506	The upgrade to precise, flat, laser-cut holes instead
	220	50/200	636425 97509	776960 07776	100	666233 90507	 of die-punched holes, dramatically increases surface
	240	50/200		776960 07777	100	666233 90508	area contact allowing Norton Multi-Air Cyclonic
	280	50/200		776960 07778			discs to improve productivity by 32% versus
	320	50/200	636425 97516	776960 07781	100	666233 90509	conventional multi-hole sanding and by 60% versus
	400	50/200	636425 97517	776960 07784	100	666233 90510	non-vacuum sanding.
	500	50/200		776960 07785	100	666233 90511	The end result is more holes for dust extraction, more
	600	50/200		776960 07786	100	666233 90512	abrasive coverage for a better cut and no deformation –
	800	50/200		776960 07787	100	666233 90513	for full surface contact utilizing all the cutting power of the
	1000	50/200		776960 07788	100	666233 90514	premium ceramic grain.

Refer to the Sanding Accessories section for back-up pads and accessories.



Lightweight Paper Discs



Best choice for the most demanding coarse grit stripping, blending, and sanding applications

BLAZE A995 NO-FIL CERAMIC ALUMINA

- P-graded, next-generation sharper-edged ceramic aluminum oxide abrasive ensures fastest cut rate and longest life of any paper disc
- Unique polyester-reinforced, D-weight latex saturated backing provides maximum tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work

Best choice for the most demanding sanding applications

DRYICE A975 NO-FIL CERAMIC ALUMINA

- · P-graded seeded-gel ceramic alumina abrasive for fastest cut rate and longest life of any paper disc
- Unique fiber reinforced, flexible B or C-weight latex saturated backing delivers 50% 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work

Better choice for high-performance dry finishing on all materials

A2750P NO-FIL ALUMINUM OXIDE

- Premium P-graded, heat treated, toughened aluminum oxide abrasive delivers superior life, fast cut rate, consistent finish
- Unique fiber reinforced, flexible B-weight latex saturated backing provides 50% 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work
- 5" and 6" individual PSA discs in fine grits have a tabbed, white translucent liner to protect the PSA adhesive from airborne contaminants; the tab allows easier removal of the paper liner



Better choice for hard-to-sand surfaces and wood applications

DURITE A475 NO-FIL SILICON CARBIDE

- Sharp and hard, P-graded, silicon carbide abrasive easily penetrates the hardest material and veneers to create finer finishes where finish is critical
- · Flexible, B-weight fiber reinforced, latex paper backing provides flexibility and resistance to tearing
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work



Good choice for sanding a broad range of substrates including primed or painted surfaces, wood, composites, aluminum, and ferrous metals

GOLD RESERVE A296 NO-FIL ALUMINUM OXIDE

- · P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent surface finish
- · Strong C-weight high latex/paper backing resists tearing while staying conformable and flexible
- · Water-based, non-loading (No-Fil) stearate coating minimizes clogging and increases disc life





Lightweight Paper Discs

		d (PSA)	-				
lgntw Jon-Va		Disc Roll n	S	61	61	61	
			TIER:	BEST	BETTER	BETTER	GOOD
		TF	RADENAME:	DRYICE A975 No-Fil	A2750P No-Fil	DURITE A475 No-Fil	GOLD RESERVE A296 NO-FIL
			ABRASIVE:	Ceramic Alumina	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
		PAPER BACKII	VG WEIGHT:	B- & C-Weight	B-Weight	B-Weight	C-Weight
		ŀ	FASTENING:	PSA	PSA	PSA	PSA
			-	P-Graded	P-Graded	P-Graded	P-Graded
SIZE (D)	GRIT	ROLLS/ STD. PKG.	DISCS/ Roll	PART #	PART #	PART #	PART #
312E (D) 3-1/2	80	4	100	PANI #	662611 36376	FANI#	FANI #
3-1/2	120	4	100		662611 36375		
	180	4	100		662611 36373		
	220	4	100		662611 36372		
	280	4	100		662611 36370		
	320	4	100		662611 36369		
	400	4	100		662611 36368		
5	60	4	100		00201100000		780727 48552
0	80	4	100	662611 40502	662611 31464 *	662544 87415	662611 83806
	100	4	100	662611 40501	662611 31463 *	662544 87417	662611 83807
	120	4	100	662611 40500	662611 31462 *	662544 87418	66261183808
	150	4	100	662611 40499	662611 31461 *	662544 87440	662611 83809
	180	4	100	662611 40498	662611 31460 *	662544 87441	662611 83810
	220	4	100	662611 42474	662611 31459 *	662544 87442	662611 83811
	240	4	100	662611 55380	662611 31458 *	662544 87443	780727 48551
	280	4	100		662611 31457 *		
	320	4	100	662611 55378	662611 31456 *	662544 87444	662611 83813
	400	4	100	662611 55377	662611 31454 *	662610 65293	662611 83814
	500	4	100		662611 31453 *		
	600	4	100	666233 05608	662611 31452 *	662544 21217	662544 92263
	800	4	100	662544 80230	662611 31451 *		776960 69730
6	60	4	100				780727 48553
	80	4	100	662611 40512	662611 31481 *	662544 87446	662611 83815
	100	4	100	662611 40511	662611 31480 *		662611 83816
	120	4	100	662611 40510	662611 31479 *	662544 87447	662611 83817
	150	4	100	662611 40509	662611 31478 *		662611 83818
	180	4	100	662611 40508	662611 31477 *	662544 87448	662611 83819
	220	4	100	662611 48340	662611 31476 *	662544 87449	662611 83820
	240	4	100	662611 55376	662611 31475 *		662611 83821
	280	4	100		662611 31474 *		
	320	4	100	662611 55374	662611 31473 *	662544 87450	662611 83822
	400	4	100	662611 55373	662611 31471 *		662611 83823
	500	4	100	636425 06198	662611 31470 *		636425 06165
	600	4	100	636425 06199	662611 31469 *		662610 40261
	800	4	100	636425 06200	662611 31468 *		636425 06164
В	80	4	100		662611 31617		
	120	4	100		662611 31615		
	150	4	100		662611 31614		
	180	4	100		662611 31613		
	220	4	100		662611 31612		
	320	4	100		662611 31609		

Refer to the Sanding Accessories section for back-up pads and accessories.



Lightweight Paper Discs

	tweigł	nd (PSA) nt Disc Ro	olls	01.			Indi	k & Sar ividual [1-Vacuu			
			TIER:			GOOD			TIER:		BETTER
		TRADI	ENAME:	A2750P No-Fil		GOLD RESERVE A296 NO-FIL			TRADENAME:	A2750P No-Fil	GOLD RESERVE A296 NO-FIL
		ABI	RASIVE:	Aluminum Oxide		Aluminum Oxide			ABRASIVE:	Aluminum Oxide	Aluminum Oxide
	PA	PER BACKING V				C-Weight		PAPER BAC	CKING WEIGHT:	B-Weight	C-Weight
		FAST	TENING:			PSA	_		FASTENING:	PSA Tabbed	PSA Tabbed
			OTHER:	P-Graded		P-Graded			OTHER:	P-Graded	P-Graded
SIZE (I) GRIT		DISCS/ Roll	PART #	ROLLS/ STD. PKG	. PART #	SIZE	(D) GRIT	MIN./ STD PKG.		PART #
				0		\bigcirc	5	60	100/400		780727 45905 <i>NS</i>
				((• • •)		80	100/400		662610 38758
				$\langle \circ \circ \rangle$		$\langle \circ \circ \rangle$		100	100/400		780727 42907
				5" x 5 Hole		5" x 5 Hole		120	100/400		662610 38759
				Die #3329		Die #3329		150	100/400		662610 38760
5	60				4	780727 48543		180	100/400		780727 42909
	80		100	662611 31498	4	662544 77327		220	100/400		780727 42910
	100		100	662611 31497	4	662611 30264	_	240	100/400		780727 42911
	120		100	662611 31496	4	666233 07048	_	320	100/400		780727 42912
	150		100	662611 31495	4	666233 05824	_	400 600	100/400 100/400		780727 42913 780727 53545
	180		100	662611 31494	4	662610 21898	_	800	100/400		780727 53468
	220		100	662611 31493	4	662544 77328	_	1000	100/400	662611 31450	780727 12632
	240		100	662611 31492	4	00001000707	_	1200	100/400	662611 31449	10012112002
	320 400		100 100	662611 31490 662611 31488	4	662610 23787 662611 30257	6	60	100/400	00201101440	780727 53831 NS
	400	0	100	00201131400	4	00201130257	_ 0	80	100/400		662611 83824
				$\langle \circ \circ \rangle$		$\langle \circ \circ \rangle$		100	100/400		662611 83825
				()				120	100/400		662611 83826
				$\langle \circ \circ \rangle$		$\langle \circ \circ \rangle$		150	100/400		662611 83827
				6" x 6 Hole		6" x 6 Hole		180	100/400		662611 83828
				Die #3333		Die #3333		220	100/400		662611 83829
6	80	6	100	662611 31515	4	780727 48550	_	240	100/400		662611 83830
-	100		100	662611 31514	4	780727 48549	_	320	100/400		662611 83831
	120		100	662611 31513	4	780727 48547	_	400	100/400		662611 83832
	150	6	100	662611 31512	4	780727 48546		600	100/400		780727 53546
	180		100	662611 31511	4	780727 48545		800	100/400	00001106 107	780727 53469
	220		100	662611 31510	4	780727 02746		1000	100/400	662611 31467	780727 12633
	240		100	662611 31509			_	1200 1500	100/400	662611 31466 662611 31465	
	280		100	662611 31508				1000	100/400	00201131403	
	320		100	662611 31507	4	780727 48787			o O o o ol' s		and the state
	400		100	662611 31505						g Accessories	s section for
	600	6	100	662611 31503			bac	:k-up pa	ads and a	ccessories.	



PSA Disc Roll Dispenser

- Norton disc roll dispensers feature heavy-duty construction and a rubberized finish to protect your product, as well as the finish on your workpiece
- These versatile dispensers are designed to accommodate any 5" or 6" disc roll or sheet roll
- They can be attached to a wall or stacked for multi-grit or multi-diameter operations
- · Discs are individually dispensed and removed from the roll by a cutter bar

DESCRIPTION	STD. PKG.	PART #
PSA Disc Roll Dispenser		
Single Disc Roll Dispenser	1	636425 42772
Double Disc Roll Dispenser (shown)	1	636425 02981



Lightweight Paper Discs

	/idual		A					
on	-Vacui	um				-11 -24- (12)		
							-	
			BEST BLAZE A995	BEST DRY ICE A975		BETTER A2750P	BETTER DURITE A475	GOOD Gold Reserve
		CAP CODE:	NO-FIL	NO-FIL		NO-FIL	NO-FIL	A296 NO-FIL
			Ceramic Alumina	Ceramic Alumina		Aluminum Oxide	Silicon Carbide	Aluminum Oxide
PA	APER BAC	KING WEIGHT:		B- & C-Weight		B-Weight	B-Weight	C-Weight
			Hook & Loop	Hook & Loop		Hook & Loop	Hook & Loop	Hook & Loop
E (D) GRIT	PKG/CASE	P-Graded	P-Graded PART #	PKG/CASE	P-Graded	P-Graded PART #	P-Graded PART #
E ((80	FRU/GAGE	FANI #	FANI#	50/200	662611 31532	FANI #	FANI#
	100				50/200	662611 44926		
	120				50/200	662611 28688		
	150				50/200	662611 40385		
	180				50/200	662611 31528		
	220				50/200	662611 31527		
	240				50/200	662611 31526		
	320				50/200	662611 31524		
	400				50/200	662611 36995		
	500				50/200	662611 31521		
	600				50/200	662611 36996		
	800				50/200	662611 31519		
	1000				50/200 50/200	662611 35900 662611 47434		
	60				100/400	00201141434		780727 48477
	80	50/200		662611 40522	100/400	662611 31549		666233 77539
	100	50/200		662611 40521	100/400	662611 31548		666233 77540
	120	50/200		662611 40520	100/400	662611 31547		666233 77541
	150	50/200		662611 40519	100/400	662611 31546		666233 77542
	180	50/200		662611 40518	100/400	662611 31545		666233 77543
	220	50/200		662611 49541	100/400	662611 31544		666233 05637
	240	50/200		662611 49540	100/400	662611 31543		662544 57751
	280				100/400	662611 31542		
	320	50/200		662611 49538	100/400	662611 31541		666233 05638
	400	50/200		662611 49537	100/400	662611 31539	662610 52270	666233 05639
	500	50/200		662544 80233	100/400	662611 31538		
	600	50/000		00054400000	100/400	662611 31537	0000108008	662611 05390
	800	50/200		662544 80232	100/400	662611 31536 662611 31535	662610 52267	666233 77544
	1000 1200				100/400 100/400	662611 31535	662610 52254	699573 50989
	1200				100/400	662611 31533		
	80	50/200	636425 97510	662611 40532	100/400	662611 31566		636425 06236 *
	100	50/200		662611 40531	100/400	662611 31565		636425 06235 *
	120	50/200	636425 97511	662611 40530	100/400	662611 31564		636425 06234 *
	150	50/200	636425 97512	662611 40529	100/400	662611 31563		636425 06233 *
	180	50/200	636425 97513	662611 40528	100/400	662611 31562		636425 06232 *
	220	50/200	636425 97514	662611 49546	100/400	662611 31561		636425 06231 *
	240				100/400	662611 31560		636425 06225 *
	280				100/400	662611 31559		
	320	50/200		662611 49543	100/400	662611 31558		636425 06230 *
	400	50/200		662611 49542	100/400	662611 31556		636425 06229 *
	500	50/200		636425 06202	100/400	662611 31555		636425 06228 *
	600	50/200		636425 06203	100/400	662611 31554		636425 06227 *
	800	50/200		636425 06204	100/400	662611 31553	00001050055	636425 06226 *
	1000	50/200		636425 06375	100/400	662611 31552	662610 52255	699573 50990 *
	1200	50/200		636425 06377	100/400	662611 31551		
	1500 120	50/200		030423 003//	100/400	662611 31550 662611 31662		
	120				100/400	662611 31661		

Packaging Standards: PKG/CASE A296 = 50/250

Refer to the Sanding Accessories section for back-up pads and accessories.



Lightweight Paper Discs

	& Loop dual Di Im	SCS	•••		
		TIER:	BETTER	GOOD	GOOD
		CAP CODE:	A2750P No-Fil	GOLD RESERVE A296 NO-FIL	GOLD RESERVE A296 NO-FIL
		ARRASIVE.	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
	PAPER R	ACKING WEIGHT:		C-Weight	C-Weight
	I I II LI I DI		Hook & Loop	Hook & Loop	Hook & Loop
		OTHER:		P-Graded	P-Graded
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #
			○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○ ○		(°°°) 5" x 8 Hole Die #3392
5	60	100/400	DIC #3320	780727 48541 *	780727 48542 *
J	80	100/400	662611 31583	666233 07110 *	662611 83916 *
	100	100/400	662611 31582	666233 12914 *	662611 83917 *
	120	100/400	662611 31581	666233 07111 *	66261183918*
	150	100/400	662611 31580	666233 12917 *	662611 83920 *
	180	100/400	662611 31579	666233 07112 *	662611 83921 *
	220	100/400	662611 31578	666233 07113 *	662611 83934 *
	320	100/400	662611 31575	666233 07114 *	662611 83977 *
	400	100/400	662611 31573	666233 07115 *	
	600	100/400	662611 31571		
			0 0 0 0 0 0 6" x 6 Hole Die #3371	(
6	80	100/400	662611 31600	666233 34786 *	
	100	100/400	662611 31599	666233 34787 *	
	120	100/400	662611 31598	666233 34788 *	
	150	100/400	662611 31597	666233 34789 * <i>NS</i>	
	180	100/400	662611 31596	666233 34790 *	
	220	100/400	662611 31595	666233 34791 *	
	240	100/400	662611 31594	00000000000	
	320	100/400	662611 31592	666233 34793 *	
	400	100/400	662611 31590	666233 34794 *	
	500	100/400	662611 31589	CCC0000 470C*	
	600	100/400	662611 31588	666233 34796 *	
	800	100/400	662611 31587	666233 34797 *	
	1000	100/400	662611 31586		
	1200	100/400	662611 31585		
Dealearin	1500 a Standard	100/400	662611 31584		

Packaging Standards: * A975 Vacuum, A296 Vacuum = 50/200

Refer to the Sanding Accessories section for back-up pads and accessories.



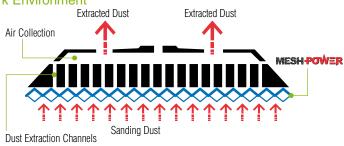
An alternative to traditional perforated paper discs, mesh discs are a multi-functional abrasive, designed with thousands of holes, created by the unique mesh matrix structure. For use with random orbital and rotary sanders, superior performing mesh discs are engineered for maximum dust extraction on composite, automotive, and other fine finishing applications. Norton mesh discs produce superior finishes with virtually dust free sanding.

Applications: Size Range: Grit Range: Machine Used: Surface preparation, Sanding, Finishing 5", 6" 80-400



Powerful Dust Extraction Means A Cleaner, Safer Work Environment

We've answered the demands for a cleaner and safer working environment with Norton MeshPower discs. The open construction of the mesh backing allows dust particles to flow freely through the thousands of tiny holes, creating a virtually dust free sanding environment. Better for your health, better for your application and better for your business!





Good choice for sharp cutting along with powerful dust extraction

MESHPOWER ALUMINUM OXIDE

- Mesh matrix backing with thousands of tiny holes offers powerful dust extraction for a cleaner, healthier working environment
- Norton No-Fil technology prevents clogging and creates a consistent cut throughout the product life
- Self-grip backing with no designated hole pattern is quick and easy to align to any backing pad just apply and go!

		TIER:	GOOD
		TRADENAME:	MESHPOWER
		ABRASIVE:	Aluminum Oxide
SIZE (D)	GRIT	PKG./CASE	PART #
5	80	50/200	636425 06451
	120	50/200	636425 06452
	180	50/200	636425 06453
	220	50/200	636425 06454
	240	50/200	636425 06455
	320	50/200	636425 06456
	400	50/200	636425 06457
6	80	50/200	636425 06458
	120	50/200	636425 06459
	180	50/200	636425 06460
	220	50/200	636425 06461
	240	50/200	636425 06462
	320	50/200	636425 06463
	400	50/200	636425 06464

Contact your Norton representative for more information on additional grit sizes.



Increase performance even further by using the Norton MeshPower discs with the Norton Multi-Air back-up pads - it's the ultimate dust extraction experience!



COATED & NON-WOVEN ABRASIVES Film and Foam Finishing Discs

For use on random orbital and rotary sanders. The industry's highest performing film and foam finishing discs are engineered for composite, automotive, and other fine finishing applications. Norton microfinishing film discs produce superior finishes dry without sacrificing cut rate while Norton foam finishing discs are used moist to produce a semi-polished surface to reduce buffing time.

> Film discs: final dry finishing of primed and painted surfaces, varnishes, composites, and gel coats before buffing Foam finishing discs: final moist finishing of clear coat, varnishes, composites, and gel coats before buffing

Compounds and buffing pads: removes swirl marks and sand scratches 3", 5" and 6" Film Discs: P80-P3000

Foam Discs: P1500, P2000, P3000

Machine Used:

Size Range:

Grit Range:

Applications:

ORBITAL SANDER VERTICAL SHAFT PORTABLE GRINDER

MINI ANGLE SANDER





Best choice for final dry finishing of primed and painted surfaces, varnishes, composites, and gel coats

PURE ICE Q175 A/O FINISHING FILM

- White aluminum oxide grain and patented resin system for better life, cut rate, and finish
- 3 mil polyester film backing for better flexibility and flatness of discs; hook and loop attachment for easy mounting and removal
- Color-coded backprint by grit size



Best choice for moist finishing of clear coats, varnishes, composites, and gel coats

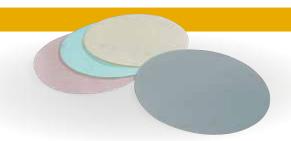
ICE Q255 A/O FINISHING FOAM

- Premium, P-graded fine grit aluminum oxide grain
- Conformable, integrated foam backing eliminates pigtails and costly rework; produces a semi-polished finished that can be quickly buffed out; hook and loop attachment
- Open mesh design distributes pressure evenly for quicker sanding and uniform scratch patterns
- · Color coded abrasive face by grit size for easy grit identification

Best choice for easy sanding of hard-to-reach areas

NORTON SUPERFLEXIBLE FILM

- Durable yet flexible film backing conforms better to surfaces and contours, preventing "over sanding" or "burn through"
- Anti-loading stearate for optimum performance and long life
- · Consistent scratch pattern and even finish





COATED & NON-WOVEN ABRASIVES Film and Foam Finishing Discs

		TIER:	BEST	ar ar		BEST)	BEST	
		TRADENAME:		0175	•	SuperFlexible		_	ICE Q255	
		ABRASIVE:		•	_	Aluminum Oxid	е		Aluminum O	xide
	BAC	KING WEIGHT:				3 mil Polyester			Foam	
		ATTACHMENT:				Hook and Loop			Hook and Loop	
		OTHER:		!	_	P-Graded			P-Graded	
SIZE (D)	GRIT	PKG./CASE	COLOR	PART #	PKG./CASE	COLOR	PART #	PKG./CASE	COLOR	PART #
3	P800	50/200	Black	776960 88701						
	P1000	50/200	Red	776960 88702						
	P1200	50/200	Green	776960 88703						
	P1500	50/200	Blue	776960 88704	25/100	Rose	666233 90561	6/24	Blue	636425 06022
	P2000				25/100	Jade	666233 90562	6/24	Magenta	636425 06021
	P2500				25/100	Aquamarine	666233 90563			
	P3000				25/100	Meteorite	666233 90564	6/24	Green	636425 06020
6	P800	50/200	Black	776960 88713						
	P1000	50/200	Red	776960 88714						
	P1200	50/200	Green	776960 88715						
	P1500	50/200	Blue	77696088716	25/100	Rose	666233 90556	15/60	Blue	636425 06015
	P2000				25/100	Jade	666233 90557	15/60	Magenta	636425 06014
	P2500				25/100	Aquamarine	666233 90558			
	P3000				25/100	Meteorite	666233 90559	15/60	Green	636425 06013

Refer to the Sanding Accessories section for back-up pads and accessories.





COATED & NON-WOVEN ABRASIVES Flexible Diamond-Coated Discs

Grinding ceramic, glass, composites, carbide and ceramic coatings, fiberglass, and reinforced plastics; removing rust and scale on other materials; producing

Ap Siz Gri Ab Ba Ma

Norton flexible diamond coated discs combine the durability and aggressiveness of diamond, on a flexible backing.

Applications:

Size Range:

Grit Range: Abrasive Types: Backing Color: Machine Used:



metallurgical stamps and coupons

PSA (Pressure Sensitive Adhesive) Discs: 2" - 6"

Quick-Change TR (Type III) Discs: 2" and 3"

ORBITAL SANDER

60 - 1500

Diamond

PORTABLE GRINDER

VERTICAL SHAFT



Better choice for grinding glass, ceramics and composites, removing rust and scale, and producing metallurgical stamps and coupons

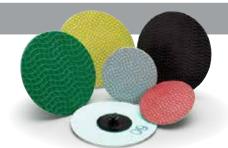
D71S PSA DISCS

- Combines the durability and aggressiveness of a unique diamond abrasive face pattern with a flexible backing, to significantly increase life and lower costs versus standard coated and diamond discs
- · Cloth backing provides strength, tear resistance, and flexibility
- · Color-coded, PSA backing for quick, easy mounting and removal and identification of coarse grit sizes/applications

			TIEI	R: BETTER
SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Dia	mond Coate	d PSA Discs		
2	Green	60	1	662603 08159
	Black	120	1	662603 07722
	Red	200	1	662603 07723
	Yellow	400	1	662603 08160
	White	800	1	662603 07012
5	Green	60	1	662603 07839
	Black	120	1	662603 07838
	Red	200	1	662603 07019
	Yellow	400	1	662603 07960

			TIEF	R: BETTER
SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Dia	amond Coated	PSA Discs		
6	Green	60	1	662603 06381
	Black	120	1	662603 06382

See Page 88 – Coated Abrasive Cloth PSA Disc section for back-up pads.



Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings

D7210 QUICK-CHANGE TR (TYPE III) DISCS

- Unique, durable diamond abrasive pattern increases life and lowers costs versus standard coated and diamond discs; color-coded backing for easy grit/application identification
- Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings
- Removes rust and scale on other material; producing metallurgical stamps and coupons

			TIE	R: BETTER		
SIZE (D)	COLOR	MESH	STD. PKG.	PART #	SIZE (D)	CO
Flexible Di	iamond Coated	l Quick-Change	e TR (Type III) Dis	SCS	Flexible Di	amond
2	Green	60	12	662603 11778	3	Gre
	Black	120	12	662603 11779		Bla
	Red	200	12	662603 11780		Yell
	Yellow	400	12	662603 11781	See Page 17	70 – Quic
	White	800	12	662603 11782		

			TIE	R: BETTER		
SIZE (D)	COLOR	MESH	STD. PKG.	PART #		
Flexible Diamond Coated Quick-Change TR (Type III) Discs						
3	Green	60	12	662603 11783		
	Black	120	12	662603 11784		
	Yellow	400	12	662603 11786		
See Page 170 – Quick-Change Disc Accessories section for back-up pads.						



Multi-Air Foam Interface Pads

- · Designed for use with fine grit Multi-Air Cyclonic hook and loop sanding discs to improve both surface finish and cut rate
- Use with Multi-Air hook and loop disc back-up pads
- · Align the interface pad with the Multi-Air back up pad then simply attach the disc to the interface pad because the holes do not have to be lined up
- · Ideal for use with new Mesh discs

IZE (D x T) DESCRIPTION

MUITI-AIL	roam interface Pads with vacuum hol	es	
5 x 1/2	Multi-Air Hook & Loop Interface Pad	8	636425 85864
6 x 1/2	Multi-Air Hook & Loop Interface Pad	12	076607 19359

COATED & NON-WOVEN ABRASIVES Sanding Accessories

Multi-Air Hook & Loop Back-up Pads with Vacuum Holes

- · Innovative design optimized for maximum air flow and powerful dust extraction
- · Pads are engineered with a durable urethane foam, heat-resistant plastic, a molded-in 5/16"-24 spindle, and hooked face
- Holes in the disc do not have to be matched up with the holes in the pad, so changeover is fast and easy



Ideal for use with new Mesh discs

SIZE (D)	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Multi-Air Hook	& Loop Back-up Pads with Va	cuum Hol	es	
5" (125mm) with 5/16"-24 Shank	Medium-Density Urethane Pad	15,000	5	666233 76000
6" (150mm) with 5/16"-24 Shank	Medium-Density Urethane Pad	15,000	5	636425 06160

Low-Profile Pads for **Dual Action / Random Orbital Sanders**

- Soft density low-profile pads utilize 1/2" thick foam for fine finish sanding and offer moderate conformability
- Medium low-profile pads have 1/2" thick urethane foam for intermediate and finish sanding
- Available with PSA (pressure sensitive) adhesive) or hook and loop faces; both designs are shock resistant and have a fiberglass backing plate with a riveted 5/16"-24 threaded shank for added strength and increased heat resistance



STD. PKG. PART #

· Available with standard hole patterns for vacuum-assist sanding

		MAX.	STD.				
SIZE (D)	DESCRIPTION	RPM	PKG.	PART #			
Low Profile Pads for DA/Random Orbital Sanders							
3	Hook & Loop Soft Low-Profile	12,000	10	636425 06128			
3-1/4	Hook & Loop Buffing Pad		5	662610 85302			
5	PSA Soft Low-Profile	12,000	5	636425 06126			
5	PSA Medium Low-Profile	15,000	5	636425 06131			
5 x 5 holes	PSA Medium Low-Profile	15,000	5	636425 06132			
5	Hook & Loop Soft Low-Profile	12,000	5	636425 06129			
5	Hook & Loop Medium Low-Profile	15,000	5	636425 06135			
5 x 5 holes	Hook & Loop Medium Low-Profile	15,000	5	636425 06136			
6	PSA Soft Low-Profile	12,000	5	636425 06127			
6	PSA Medium Low-Profile	15,000	5	636425 06133			
6	Hook & Loop Soft Low-Profile	12,000	5	636425 06130			
6	Hook & Loop Medium Low-Profile	15,000	5	636425 06137			
6 x 6 holes	Hook & Loop Medium Low-Profile	15,000	5	636425 06138			
8 x 8 holes, 5 screws	Hook & Loop Medium Low-Profile	1,500	5	636425 43712			
8 x 8 holes, 6 screws	Hook & Loop Medium Low-Profile	1,500	5	636425 43714			
Packed in ind	lividual clamshell						

Packed in individual clamshell

Tapered Pads for Dual Action / Random Orbital Sanders

- Designed with medium density polyurethane foam and a tapered edge for conformability, these pads are firm enough for flat surfaces, yet soft enough for severe curves and contours
- · Available with either PSA (vinyl, pressure sensitive adhesive) or hook and loop faces in vacuum or non-vacuum
- The 5" and 6" pads are shock resistant and have a fiberglass backing plate with a riveted 5/16"-24 threaded shank for use on random orbital or dual action sanders

female hub





SIZE (D)	DESCRIPTION	RPM	PKG.	PART #		
Tapered Pads for DA/Random Orbital Sanders						
5	PSA Medium Tapered	15,000	5	636425 06139		
5 x 5 holes	PSA Medium Tapered	15,000	5	636425 06140		
5	Hook & Loop Medium Tapered	15,000	5	636425 06143		
5 x 5 holes	Hook & Loop Medium Tapered	15,000	5	636425 06144		
6	PSA Medium Tapered	15,000	5	636425 06141		
6 x 6 holes	PSA Medium Tapered	15,000	5	636425 06142		
6	Hook & Loop Medium Tapered	15,000	5	636425 06145		
6 x 6 holes	Hook & Loop Medium Tapered	15,000	5	636425 06146		
8	PSA Medium Tapered	6,000	5	636425 43112		
8	Hook & Loop Medium Tapered	3,200	5	636425 43704		
8	PSA Medium Tapered	6,000	5	636425 43112		

Packed in individual clamshell



COATED & NON-WOVEN ABRASIVES Sanding Accessories

Hook & Loop Foam Interface Pads

- Designed for use with our fine grit hook and loop sanding discs
- Improve both surface finish and cut rate
- Use with hook and loop back-up pads



SIZE (D x T)	DESCRIPTION	STD. PKG.	PART #
Foam Hool	k & Loop Interface Pads		
3 x 1/2	Interface Pad	10	636425 05457
6 x 1/2	Interface Pad	5	636425 42089
5 x 3/4	Interface Pad	2	636425 02161
6 x 3/4	Interface Pad	2	636425 02162

Half Moon Hand Pad

- The unique half moon pad takes a standard 5" hook and loop disc folded in half, which adheres to the hooks on the pad face
- The straight edge of the pad allows the operator to sand corners, contours, narrow crevices and minute imperfections without over-sanding



SIZE (D)	DESCRIPTION	STD. PKG.	PART #
Half Moon	Hand Pad		
5	Hook & Loop	10	636425 02768

Polishing	Adapter	Pad
-----------	---------	-----

- Converts your standard hook and loop
 pad into a soft polishing pad
- The foam adapter is 3/8" thick and is excellent for fine grits where minimal removal is required

DESCRIPTION

Hook & Loop Adapter Pad

 It is ideal for either flat or contour surfaces

Polishing Adapter Pad

5

MAX. RPM	STD. PKG.	PART #
	MAX. RPM	MAX. RPM STD. PKG.

10

636425**03121**

Ergonomic Hand Sanders

- The ergonomic palm sander is uniquely designed to be user-friendly, with finger indentations for the operator
- It quickly converts standard 5" and 6" hook and loop discs into hand sanders for finishing flat surfaces



Ergonomic Hand Sander 5 Hook & Loop 5	
E Haak & Loop E	
5 HUUK & LUUP 5	636425 03147
6 Hook & Loop 5	636425 03726

<u>a</u>

Disc Hand Pads

- Hand pads eliminate finger sanding
- The ultra-thin 3/16" thick pad is composed of a single layer of neoprene foam and is designed for maximum flexibility – producing excellent finishes

3,786

- The 1" thick pad is composed of two layers, neoprene and polyester foam, for excellent conformability and softness, resulting in fine finishes
- Each pad has an elastic hand strap to hold it firmly in place
- Available with either PSA (vinyl, pressure sensitive adhesive) faces or hook and loop face



SIZE (D x T) DESCRIPTION STD. PKG. PART # Disc Hand Pads 5 x 3/16 Soft Foam PSA 10 63642503111 5 x 1 Soft Foam PSA 10 63642502842 5 x 1 Soft Foam Hook & Loop 10 63642503117

Panel and Adhesive Cleaner

- Removes adhesives, tar, grease, wax, body sealers, undercoating sprays, and silicone from most surfaces
- Aggressive cleaner is safe to use on most paint applications
- Packaged with squirt dispenser
- Use as directed

SIZE/DESCRIPTION	STD. PKG.	PART #
Panel and Adhesive Cleaner		
Quart Can	12	076607 82780



Liquid Ice Extra-Cut Compound

- · Water soluble; easy to use and easy to clean up
- Engineered to be used with a selection of 3 pads, depending on the finish required



DESCRIPTION Liquid Ice Extra-Cut Compound Quart

4

63642597116

COATED & NON-WOVEN ABRASIVES Sanding Accessories

Liquid Ice Clean-up / Detailer Spray

- The spray detailer easily cleans up excess buffing residue and produces paint protection
- Spray it on and wipe off with a Norton Microfiber cloth ("Masking Products" section)

SIZE	DESCRIPTION	STD. PKG.	STD. CASE	PART #	
32 oz.	Spray Bottle Clean-up Detailer	1	4	636425 42082	

1

 These pads can be used with Norton Liquid Ice Extra-Cut Compound



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
8	Orange Waffle Foam pad - Step 1	1	6	636425 06379
8	Blue Waffle Foam Pad - Step 2	1	6	636425 06380
8	White Waffle Foam Pad - Step 3	1	6	636425 06381

3" Hook & Loop Buffing/Polishing Pads

· For small spot repair



SIZE (D)	DESCRIPTION	STD. PKG.	STD. Case	PART #
3	Super Cut Wool Pad - Step 1	10	40	636425 43832
3	Blue Cutting Foam Pad - Step 2	10	40	636425 05459
3	White Finishing Foam Pad - Step 3	10	40	636425 05460

8" Hook & Loop Buffing/Polishing Waffle Pads 8" and 9" Hook & Loop Buffing/Polishing Pads

 These pads can be used with Norton Liquid Ice Extra-Cut Compound following the step numbers



SIZE (D)	DESCRIPTION	STD. PKG.	STD. Case	PART #
8	Super Cut Wool Pad - Step 1	1	6	636425 42077
9	Blue Cutting Foam Pad - Step 2	1	6	636425 42078
9	White Finishing Foam Pad - Step 3	1	6	636425 42079

Hook & Loop Back-up Pads for 8" and 9" **Buffing Pads**

 Black plastic back-up plate with hook and loop face. Molded-in 5/8"-11 threaded female hub



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
8 and 9	Hook & Look Back-up Pad	1	3	636425 42080

Black Lambswool Hook & Loop **Polishing Pads**

 Distributing and applying material evenly and consistently, these dense, durable, lambswool pads are designed to repair clearcoat finishes



SIZE	DESCRIPTION	STD. CASE	PART #
3	Pad with Loop – 3/4" nap	40	636425 03670
4	Pad with Loop – 3/4" nap	250	636425 03671

Please pages 350 - 356 for additional finishing products



COATED & NON-WOVEN ABRASIVES Non-Woven Convolute Wheels



Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

Non-Woven Convolute wheels are formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core.

Applications:

- Burr and flashing removal
 Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

Aluminum Oxide, Silicon Carbide

Abrasive Grain: Grit Range: Machine Used:



Application/Grit Recommendation Guide

NORTON	Rapid Finish GP Convolute Wheels	Metal Finishing Convolute Wheels	Clean & Finish Convolute Wheels	Light Finishing Convolute Wheels
Scale Removal				
Stock Removal	Second Choice			
Heavy Deburring	Second Choice			
Decorative Finishing		First Choice	Second Choice	
Blending	First Choice	Second Choice		
Cleaning		Second Choice	First Choice	
Light Deburring	Second Choice			First Choice
Light Finishing	Second Choice			First Choice
Polishing				First Choice
Buffing				

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1. Wheel Speed	Slow <	► Fast
2. Feed Speed	Faster (Long Scratch)	Slower (Short Scratch)
3. Oscillation	No Oscillation	Oscillation
4. Lubricants	Dry	Soluble Oil Straight Oil
		Compounds

Non-Woven Marking System

ABRASIVE	SILICON CARBIDE			ALUMINUM OXIDE
	SHARPER, FINER/BRIG	HTER SCRATCH PATTERN	MORE DURABLE, LONGER LA	STING, POLISHED FINISH
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)
	FASTER, AGGRESSIVE	CUT, ROUGHER FINISH	REDUCED	CUT RATE, FINER FINISH
DENSITY	2			9
	SOFT, OPEN, CONFORM	ABLE, LESS BURNING/LOADING	HARDER, MORE DURABLE, FASTER (CUTTING, BETTER FINISH

Cross Reference Guide

	BEST	BETTER	GOOD	GOOD	GOOD
NORTON	Rapid Finish	Metal Finishing	Series 4000	Light Finishing	Clean & Finish
3M	3M EXL, General Purpose	Metal Finishing	EX2 & EX3	Light Deburring	Multi Finishing
Standard	General Purpose Plus, Light Deburring	Metal Finishing	GP Plus	LDW	Multi Finishing





Convolute Wheels For Cylindrical & Centerless Grinding! youtu.be/fLqwBlq6xO8



COATED & NON-WOVEN ABRASIVES Non-Woven Convolute Wheels

Aggressive Deburring

Good choice for heavy deburring applications



SERIES 4000 ALUMINUM OXIDE & SILICON CARBIDE

- High-quality synthetic web provides long life for heavy deburring, edge-breaking, and parting line removal on exotic metals
- · Advanced resin bond system ensures free cutting action
- · Use both wet and dry

				Th	ER: GOOD	
				TRADENAN	<i>NE:</i> SERIES 4000	
SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	4		662610 04021
6 x 1 x 1	A/0	М	6,000	3	662610 04208	
	S/C	F	6,000	3	662610 04142	662610 04141
8 x 1 x 3	A/0	М	4,500	3	662610 04165	
	S/C	F	4,500	3	662610 04123	662610 04135
12 x 1 x 5	S/C	F	3,000	2	662610 04284	662610 04148
12 x 2 x 5	S/C	F	3,000	1		662610 04011

General Duty



Best choice for broad range of applications: general deburring, blending, and finishing on all materials including metals, wood, glass

RAPID FINISH GENERAL PURPOSE A/O & S/C

- Eliminate smearing and loading on a wide range of workpieces (from high-nickel-content alloys to aluminum and other soft metals with patent-pending Norton Clean Bond resin technology
- Increase throughput with a 30% faster finish through new Norton grain/bond configuration, decrease wheel changes with a 10-30% longer life, provided by a new fiber and the high-temperature resin bond
- Ease wheel selection with color-coding wheel to match the primary use (maroon for General Purpose), and fiberglass core to match the abrasive (black for silicon carbide and white for aluminum oxide)

					TIER:	BEST			
					TRADENAME:	RAPID FINISH GENE	ERAL PURPOSE		
SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	PRODUCT CODE	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	A/0	М	6,000	4	C2315		662611 34177	662611 34178	662611 34179
	S/C	М	6,000	4	C4315				662611 08076
	S/C	F	6,000	4	C4415		662611 33213	662611 06732	662611 12985
6 x 1 x 1	A/0	М	6,000	3	C2315	662611 34180	662611 34181	662611 34182	662611 34183
	A/0	F	6,000	3	C2408	662611 32100		662611 32324	
	S/C	М	6,000	3	C4315		662611 08074	662611 33215	662611 08075
	S/C	F	6,000	3	C4415	662611 14475	662611 19988	636425 77269	636425 81587
	S/C	VF	6,000	3	C4515	662611 31970			
6 x 2 x 1	A/0	М	6,000	2	C2315		662611 34184		
	S/C	М	6,000	2	C4315		662611 14471		
	S/C	F	6,000	2	C4415		662611 32325		
8 x 1 x 3	S/C	М	4,500	3	C4315		662611 08066	662611 08069	
	S/C	F	4,500	3	C4415	662611 08064	662611 08065	636425 53754	636425 76004
	S/C	VF	4,500	3	C4515				662611 33209
8 x 2 x 3	S/C	М	4,500	2	C4315		662611 14473		
	S/C	F	4,500	2	C4415		662611 14480	662611 14483	662611 14486
	S/C	VF	4,500	2	C4515				662611 33210
10 x 1 x 5	A/0	М	3,600	3	C2315		662611 34185		
	S/C	F	3,600	3	C4415			662611 06554	662611 14488
10 x 2 x 5	S/C	F	3,600	1	C4415			636425 81044	
12 x 1 x 5	A/0	М	3,000	2	C2315				662611 34186
	S/C	F	3,000	2	C4415	662611 08053	662611 14481	662611 14484	662611 14074
	S/C	VF	3,000	2	C4515				
12 x 2 x 5	S/C	F	3,000	1	C4415		662611 14482	662611 12766	662611 14490



Aesthetic Finishing





Better choice for decorative finishing, blending, and final finishing

METAL FINISHING ALUMINUM OXIDE

- · Premium, medium grit aluminum oxide grain generates uniform distinct satin and antique finishes
- Dense, very durable web allows these wheels to be used for blending applications; strong resin binder provides
 resiliency and long life
- Uniform grain dispersion and coating clean and condition without gouging or changing dimensions of workpiece

					TIER:	BETTER						TIER:	BETTER
				TRAL	DENAME:	METAL FINISHING					TRAL	DENAME:	METAL FINISHING
			DEN-	MAX.	STD.					DEN-	MAX.	STD.	
SIZE (D x T x H)	ABRASIVE	GRIT	SITY	RPM	PKG.	PART #	SIZE (D x T x H)	ABRASIVE	GRIT	SITY	RPM	PKG.	PART #
6 x 1 x 1	A/0	М	5	6,000	3	662610 07936	12 x 1 x 5	A/0	Μ	5	3,000	2	662610 07434
	A/0	М	6	6,000	3	662610 10148		A/0	М	6	3,000	2	662610 09481
6 x 2 x 1	A/0	М	5	6,000	2	662610 07957	12 x 2 x 5	A/0	Μ	5	3,000	1	662610 07212
	A/0	М	6	6,000	2	662610 09635	14 x 2 x 8	A/0	Μ	5	2,550	1	662610 07817
8 x 1 x 3	A/0	М	5	4,500	3	662610 07831							
8 x 2 x 3	A/0	М	5	4,500	2	662610 07904							
	A/0	М	6	4,500	2	662610 12971							



Good choice for light deburring, polishing, and fine finishing applications

LIGHT FINISHING SILICON CARBIDE

- Advanced manufacturing process produces a consistent web and grain distribution for a consistent finish on intricate polishing applications
- Superior form holding for consistent, reliable edge breaking and finishing with minimal wheel dressing and reshaping; less dust and shedding with more uniform wear
- · Controlled cut rate prevents "over benching", deburrs and polishes without altering geometry

			7	TIER: GOOD		
			TRADENA	ME: LIGHT FINISHING		
SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	662610 92322	662610 92324	662544 21572
6 x 1 x 1	S/C	F	6,000	662544 03708	662544 03709	662544 21573
8 x 1/2 x 3	S/C	F	4,500	662544 03707	662544 09698	662544 21575
8 x 1 x 3	S/C	F	4,500	662610 95702	662544 09924	662544 21577

All Light Finishing convolute wheels are non-stock. Ask your Norton representative for current lead-times and order quantities.



Good choice for fine finishing with light pressure

CLEAN & FINISH SILICON CARBIDE

- · Sharp, more aggressive silicon carbide abrasive leaves a fine/brighter scratch pattern
- · Conformable to intricate shapes and contours without changing the workpiece dimension
- · Open web construction makes these ideal for low-to moderate-pressure, low speed applications

			TIER: GOOD				
			TRAD	ENAME:	CLEAN & FINISH		
ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #		
S/C	М	4	4,000	10	662610 58502		
	F	4	4,000	10	662610 58501		
S/C	М	4	3,000	4	662610 58507		
	F	4	3,000	4	662610 58506		
S/C	М	4	3,000	2	662610 58510		
	F	4	3,000	2	662610 58509		
S/C	М	4	3,000	1	662610 58512		
S/C	М	4	3,000	1	662610 58514		
	S/C S/C S/C S/C	F S/C M F S/C M F S/C M	S/C M 4 F 4 S/C M 4	ABRASIVE GRIT DENSITY MAX. S/C M 4 4,000 F 4 4,000 S/C M 4 3,000 F 4 3,000 S/C M 4 3,000 S/C M 4 3,000 F 4 3,000 F 4 3,000 S/C M 4 3,000	TRADENAME: ABRASIVE GRIT DENSITY MAX. STD. S/C M 4 4,000 10 F 4 4,000 10 S/C M 4 3,000 4 F 4 3,000 4 S/C M 4 3,000 2 F 4 3,000 2 F 4 3,000 2 F 4 3,000 1		

				TRAD		GOOD Clean & Finish
SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
8 x 1 x 3	S/C	М	4	2,500	3	662610 58518
8 x 2 x 3	S/C	М	4	2,500	2	662610 58521
8 x 3 x 3	S/C	М	4	2,500	1	662610 58524
8 x 4 x 3	S/C	М	4	2,500	1	662610 58526



COATED & NON-WOVEN ABRASIVES Non-Woven Convolute Wheels

Aluminum Reducing Bushings for Flap and Convolute Wheels



- Durable, aluminum one-piece-design flanges with integrated contact washer
- Snug fit; extended usable life
- · Available in stock and non-stock sizes in many combinations of ID hole reduction

WHEEL CENTER HOLE	BUSHING REDUCES HOLE SIZE TO	FOR WHEEL DIAMETER	STD. PKG.	PART #
1	3/8	4 - 6	1 Pair	662610 80522 NS
	1/2	4 - 6	1 Pair	662610 80523
	5/8	4 - 6	1 Pair	662610 80524
	3/4	4 - 6	1 Pair	662610 80525 NS
	7/8	4 - 6	1 Pair	662610 80526 NS
2	1/2	6	1 Pair	662610 80527 NS
	5/8	6	1 Pair	662610 80528 NS
	1	6	1 Pair	662610 80529 NS
3	1	8	1 Pair	662610 80531
	1-1/4	8	1 Pair	662610 80532
5	1	10 and 12	1 Pair	662610 80533
	1-1/4	10 and 12	1 Pair	662610 80534
	3	10 and 12	1 Pair	662610 80535 NS
8	1-1/4	14	1 Pair	662610 80536 NS

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

TECH TIP

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.
- · Light to medium pressure is recommended. Excessive pressure may result in part damage.
- · Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.

It is the user's responsibility to refer to and comply with ANSI B7.1





COATED & NON-WOVEN ABRASIVES Non-Woven Unified Wheels

Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. The industry's broadest offering is available for light stock removal, deburring, blending, finishing and polishing. Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

Applications:

Abrasive Grain: Grit Range: **Machine Used:**

Cleaning and removing imperfections on metal surfaces, cleaning built-up residue, deburring or finishing a variety of surfaces, blending weld seams or creating decorative finishes. Non-woven surface finishing products have excellent versatility. Engineered Aluminum Oxide, Aluminum Oxide, Silicon Carbide Extra Coarse (XC), Coarse (C), Medium (M), Fine (F)

BENCH

GRINDER



GRINDER



DIE GRINDER

GRINDER

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1. Wheel Speed	Slow <	► Fast
2. Feed Speed	Faster (Long Scratch) 🔍	Slower (Short Scratch)
3. Oscillation	No Oscillation <	Oscillation
4. Lubricants	Dry Kater	Soluble Oil Straight Oil
		Compounds

Non-Woven Marking System

ABRASIVE	SILICON CARBIDE			
	SHARPER, FINER/BR	IGHTER SCRATCH PATTERN	MORE DURABLE, LONGER LA	STING, POLISHED FINISH
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)
	FASTER, AGGRESSIV	E CUT, ROUGHER FINISH	REDUCED	CUT RATE, FINER FINISH
DENSITY	2			9
	SOFT, OPEN, CONFO	RMABLE, LESS BURNING/LOADING	HARDER, MORE DURABLE, FASTER	CUTTING, BETTER FINISH

Cross Reference Guide

	BEST	BETTER	
NORTON	Vortex Rapid Blend	Rapid Blend NEX	
3M	Cut & Polish Unitized, Deburr and Finish PRO	EXL Unitized	
Standard	800 & 900 Series	500 - 700 Series	





COATED & NON-WOVEN ABRASIVES Non-Woven Unified Wheels

Rapid Blend Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing metals and composites. Easily preformed for use on a wide variety of shapes/contours. Hold shape well; less wheel dressing. Non-metallic so no contamination of workpiece. Uniform construction maintains part tolerance; prevents cutting or gouging.



Best choice for light weld bead and weld spatter removal, heavy deburring and finishing applications

VORTEX RAPID BLEND ALUMINUM OXIDE

- Proprietary engineered Vortex aluminum oxide aggregate grain stays sharper longer for increased cut rate while still
 offering a fine finish
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing
- 3D wheel construction enables multi-dimensional grinding which saves time on multiple wheel changes
- · Aggressive, fast stock removal cut rate while providing a fine finish

				GRIT	SE					CO
			TIER:	BEST	BEST				TIER:	BEST
			GRIT:	Coarse	Medium				GRIT:	Coarse
		ABI	RASIVE:	Engineered A/O	Engineered A/O			AB	RASIVE:	Engineered A/O
SIZE (D x T)	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #	SIZE (D x T)	DENSITY	MAX. RPM	STD. PKG.	PART #
1" x 1" x 3/16"	5	35,000	50	662611 32922	_		3	12,000	40	-
	8	35,000	50	662611 32923	-		5	18,000	40	662611 32906
2" x 1/8" x 1/8"	5	22.000	60	662611 32896	662544 25657 NS		7	18,000	40	-
	7	22.000	60	-	662544 10849 NS		8	18,000	40	662611 32907
	8	22,000	60	662611 32897	_	3" x 1/4" x 3/8"	3	12,000	40	-
2" x 1/8" x 1/4"	5	22,000	60	662611 32898	662544 06346 NS		5	18,000	40	662611 32908
1	7	22,000	60	-	662611 91446		7	18,000	40	-
	8	22,000	60	662611 32899	_		8	18,000	40	662611 32909
2" x 1/4" x 1/4"	3	18,000	60	-	662544 28456 NS	3" x 1/2" x 1/4"	5	18,000	20	662611 32912
	5	22,000	60	662611 32900	662544 33504		7	18,000	20	-
	7	22,000	60	-	662610 80270		8	18,000	20	662611 32913
	8	22,000	60	662611 32901	-		9	18,000	20	-
2" x 1/2" x 1/4"	5	22,000	30	662611 32914	_	3" x 1/2" x 3/8"	5	18.000	20	662611 32910
	8	22,000	30	662611 32915	-	,, -	7	18.000	20	-
2" x 1" x 1/4"	5	22,000	15	662611 32916	-		8	18.000	20	662611 32911
	7	22,000	15	-	662610 80269 NS		9	18,000	20	-
	8	22,000	15	662611 32917	-	3" x 1" x 1/4"	5	18,000	10	662611 32918
3" x 1/8" x 1/4"	5	18,000	40	662611 32902	-	-	8	18,000	10	662611 32919
	5	18,000	40		662610 93448	4" x 1" x 1/4"	5	16,000	5	662611 32920
	7	18,000	40	-	662611 91445		8	16,000	5	662611 32921
	8	18,000	40	662611 32903	-	6" x 1/2" x 1"	5	12,000	4	662611 32924
3" x 1/8" x 3/8"	5	18,000	40	662611 32904	662544 33503 NS	·	8	12,000	4	662611 32925
	7	18,000	40	-	662544 01131 NS	6" x 1" x 1"	5	12,000	2	662611 32926
	8	18,000	40	662611 32905	-		8	12,000	2	662611 32927

NEW

NS = Non-Stock items.

NS = Non-Stock items.

For Rapid Blend Unified Quick-Change discs please see Quick-Change disc section.



How to Grind & Blend in One Step! Non-Woven Discs Vs Grinding Wheels! ft. Vortex Rapid Blend Coarse **youtube.com/watch?v=FgSLez3MKj8**



Medium

Engineered A/O PART # 662544**28454** NS

662544**14832** 662611**99696**

662544**33505 NS**

662544**33506** NS 662611**99697**

66254432925

66261080267

662544**33508** 662610**80266**

662544**33507 NS**

662544**20696 NS**

699573**18950**

78072767709

776960**93919** 780727**13652**





Better choice for light deburring and blending

RAPID BLEND NEX ALUMINUM OXIDE AND SILICON CARBIDE

- Uniform construction provides extra-long life and holds shape well for less wheel dressing
- Smear free resin binder formula provides smear-free finishes
- A great option for light deburring and blending applications

				TIER:	BETTER				
				TRADENAME:	RAPID BLEND NEX	(
SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	2 DENSITY Part #	3 DENSITY PART #	4 DENSITY PART #	6 DENSITY PART #	8 DENSITY PART #
1 x 1 x 3/16	A/0	С	30,000	50					662610 14915
	A/0	М	18,000	50	662610 14891				
	A/0	М	30,000	50				662610 14908	662610 14924
	S/C	F	18,000	50	662610 14883				
	S/C	F	30,000	50				662610 14904	662610 14923
2 x 1/8 x 1/4	A/0	М	22,000	60					662610 14927
2 x 1/4 x 1/4	A/0	М	18,000	60	662610 14892				
	A/0	М	22,000	60					662610 14926
	A/0	F	22,000	60				662610 14901	
	S/C	F	18,000	60	662610 14884				
2 x 1/2 x 1/4	A/0	М	22,000	30					662610 14925
3 x 1/4 x 1/4	A/0	С	18,000	40					662610 14919
	A/0	М	18,000	40				662610 14909	662610 14930
	A/0	F	18,000	40			662610 15565	662610 14902	662610 14902
	S/C	F	12,000	40	662610 14886				
3 x 1/4 x 3/8	A/0	С	18,000	40					662610 14920
	A/0	М	12,000	40	662610 14895				
	A/0	M	18,000	40				662610 14910	662610 14933
	A/0	F	12,000	40			662610 14899		
	S/C	F	12,000	40	662610 14887	662610 16006			
3 x 1/2 x 1/4	A/0	M	12,000	20	662610 14893			00001011000	
	A/0	M	18,000	20				662610 14928	
0 1/0 0/0	S/C	F	12,000	20	662610 14885				0000101 1000
3 x 1/2 x 3/8	A/0	M	18,000	20				0000101.001.0	662610 14929
3 x 1 x 3/8	S/C	XC	18,000	10				662610 14914	000010110001
6 x 1/2 x 1	A/0	M	7,500	4	00001010000				662610 14931
6 x 1 x 1	S/C	F	6,000	2	662610 14888				

For Rapid Blend Unified Quick Change discs please see Quick Change disc section.

Assemblies and Mandrels for Unified Wheels

FITS WHEEL Center Hole	FOR WHEEL WIDTH	FOR WHEEL Diameter	SHANK Diameter	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	PART #
Mandrel Assem	blies for Unified V	heels and Discs O	n Edge					
3/16	1/8 – 1/2	1-2	1/4	2	7/16	994	1	662610 09852
1/4 - 5/16	Up to 1/2	Up to 2	1/4	2	5/8	932	1	662610 15146
1/4 – 5/16	Up to 1	Up to 2	1/4	2-1/2	5/8	932	1	662610 59422
	Up to 1	2-3	1/4	2-1/2	1	933	1	662610 59421
3/8	Up to 1/2	2-4	1/4	2-1/2	1	990	1	662610 09851
1/2	Up to 1	3-6	1/4	3-1/8	1-5/8	934	1	662610 09850
FOR CENTER	USE WITH	SHANK	SHANK			3M	STD.	
HOLE	UNIFIED WHEEL	DIAMETER	LENGTH			EQUIVALENT	PKG.	PART #
	Irel for Unified Wh							
3/16	1 x 1 x 3/16	1/4"	1-3/4"			948	5	662610 47584



MANDREL ASSEMBLY 66261059421



THREADED MANDREL 66261047584



MANDREL ASSEMBLY 66261059422



COATED & NON-WOVEN ABRASIVES File Belts

Portable file belt sanders have replaced tedious hand filing and sanding. First introduced in pneumatic, they are now also available in electric. Increasingly, tool manufacturers are introducing additional fixtures for additional applications. The belts listed are popular stock sizes, but additional sizes, specifications, backing materials, and edge scallops are available made-to-order.

Applications:

Size Range: Grit Range: Abrasive Grain: Machine Used: Light weld removal and blending, shape and contour sanding, surface preparation prior to coating and plating, removing cutting tool marks from molds and dies, general clean-up and finishing 1/8" to 1" wide, 12" to 30" long 40 - 120Ceramic Alumina, Zirconia Alumina, Aluminum Oxide



Cross Reference Guide

VDRTDN

SAINT-GOBAIN

	BEST	BEST	BETTER	GOOD	GOOD
NORTON	Blaze R980P	RedHeat R983	BlueFire R887D/R823P	Gemini R766	Gemini R283
3M	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	747D, 777F, 778F, 784F, 987F, 977F	577F, 551E	361F, 363F	241E, 244E, 251E, 261E
Hermes	CR456	—	RB48624YX, RB48644Z	RB377XY, SB378	RB530J, RB304J, RB306J
Klingspor	CS610	CS912	CS411X, CS416, CS409	CS412, CS413	CS412
SIA	2515, 2503	—	2800,2803, 2815, 2829, 2824	_	_
VSM	XK875X, XK885Y, XK880Y	XK870X, XK870X	ZK713X, ZK713T, KK715X	LK719X, KK711X	KK711E
Sait	—	—	AZ-X	1AX, 2AX	LA-X
Sunmight	—	—	—	P656W	_

Material-to-Product Recommendation Guide

	BEST	BEST BETTER				GOOD		
	Blaze R980P	RedHeat R983	BlueFire R887D	BlueFire R823P	Gemini R766	Gemini R283		
Carbon Steel	•	•	•	•	•	•		
Stainless Steel / Alloys	•	•	•	•	•			
Cast Iron	•	•	•	•	•			
Brass / Bronze			•	•	•			
Aluminum			•	•	•			



Best for stainless, cobalt, chrome, inconel, titanium, mild and carbon steel

BLAZE R980P CERAMIC ALUMINA

- Next-generation cooler cutting Norton SG ceramic alumina grain lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, inconel and titanium with better metal integrity
- Durable Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray, and better body retention, resulting in longer life and product consistency
- Lubricating grinding aid coating means cooler cut, burn-free grinding of heat-sensitive materials, minimized loading, and improved part finish and integrity



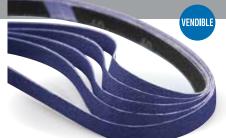
Exceptional performance, especially on hard-to-grind alloys

REDHEAT R983 CERAMIC ALUMINA

- · Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body
 retention, resulting in longer life and product consistency



COATED & NON-WOVEN ABRASIVES File Belts



Better choice for stainless and carbon steel

BLUEFIRE R887D/R823P ZIRCONIA ALUMINA

- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive
 zirconia belts
- Durable resin bond for excellent grain retention and product life
- Strong Y-weight polyester backing R887D for heavy-duty stock removal applications; flexible X-weight polyester backing - R823P for moderate- to light-pressure applications

Good choice for difficult-to-grind materials (aluminum, brass, bronze, stainless, carbon steel, titanium, etc.)

GEMINI R766 ALUMINUM OXIDE

- Premium aluminum oxide abrasive blend is ideal when primary purchasing criteria is a good-performing, economically-priced, general-purpose belt
- Y-weight waterproof polyester backing withstands light- to moderately-demanding applications and provides extended life on dry grinding applications
- · Resin bond system provides improved edge retention and 30% plus improvement in life versus key competitors



Good choice for stainless and carbon steel applications when initial price is the primary purchasing factor

GEMINI R283 ALUMINUM OXIDE

- · P-graded premium aluminum oxide abrasive for consistent, cool cut
- Strong, semi-flexible, smooth X-weight rayon waterproof backing is designed for light- to moderate- pressure applications
- · Durable resin coating provides excellent grain retention and product life

					VENDIBLE		
		TIER:	BEST	BEST	BETTER	GOOD	GOOD
		TRADENAME:	BLAZE R980P	REDHEAT R983	BLUEFIRE R887D/R823P	GEMINI R766	GEMINI R283
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
		BACKING:	Y-Weight Polyester	Y-Weight Polyester	Y- or X-Weight Polyester	Y-Weight Polyester	X-Weight Rayon
		OTHER:	Supersize	Supersize			
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
10" Dolto							

12" Belts							
1/8 x 12	40	50				666233 90000 NS	
	60	50	662544 05345 NS		662610 93029 NS		
	80	50		662544 91523 NS			
	120	50		662544 91524 NS			
1/4 x 12	40	50	662544 91520 NS				
	60	50	662611 96480 NS		780727 58896		
	80	50		662544 91526 NS	780727 82621		780727 66143
	120	50	662610 63632 NS		780727 82622		780727 63175
1/2 x 12	40	50	699573 98018	662544 91528 NS	662544 92522	666233 90006	780727 27557
	50	50	662610 43759	780727 18700			
	60	50	699573 98019	780727 18701	780727 28745	666233 90008 NS	780727 27555
	60	25 V			666233 73753		
	80	50	699573 98020	780727 18702	780727 28744	666233 90009	780727 27554
	80	25 V			666233 73754		
	100	50	662610 81180		662544 91534		780727 27553
	120	50	662610 42909	780727 00518 NS	780727 28742		780727 27552
1 x 12	60	50	662610 63641 NS		780727 53073		780727 73813

Additional sizes, grits and scalloped edge belts are available MTO (made-to-order). Contact your Norton representative for availability, order quantities and lead-times. 40 and 50 grit BlueFire belts are furnished in BlueFire R887D (Y-weight Polyester); 60-120 grits are supplied in BlueFire R823P (X-weight Polyester). Joints – All belts are PG jointed; a butt joint joined with flexible tape for contour grinding.

V = Vendible package. Ideal for vending machines and small jobs. 5 belts per pack / 5 packs per carton. Order in multiples of 25.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

continued

COATED & NON-WOVEN ABRASIVES File Belts



					VENDIBLE		
		TIER: TRADENAME:	BEST BLAZE R980P	BEST REDHEAT R983	BETTER BLUEFIRE R887D/R823P	GOOD Gemini R766	GOOD Gemini R283
			Ceramic Alumina Y-Weight Polyester	Ceramic Alumina Y-Weight Polyester	Zirconia Alumina Y- or X-Weight Polyester	Aluminum Oxide Blend Y-Weight Polyester	Aluminum Oxide X-Weight Rayon
IZE (W x L)	GRIT	OTHER: STD. PKG.	Supersize PART #	Supersize PART #	PART #	PART #	PART #
3" Belts	unn	51D.1 Ku.					
/8 x 13	60	50	699573 45359	780727 45459	780727 40295	666233 90011	780727 32112
	80	50	699573 92150	780727 74916	780727 36062	666233 90012	780727 71323
8" Belts							
/8 x 18	60	50	662610 80010			666233 90014 NS	
	80	50	66261089120	780727 89083	780727 60595 NS	666233 90015 NS	
	120	50	662544 75215	780727 89084			
/4 x 18	40	50	662610 27923	662611 98953	662544 92525	666233 90016 NS	662544 91543
	60	50	699573 47249	780727 74684	780727 43583		780727 71000
	80	50	699573 46155	780727 03284	780727 53075		780727 73921
	80	25 V			666233 73748		
	120	50	662610 85071	780727 85655	780727 73764		
/2 x 18	40	50	699573 98021	780727 66018	662544 44193	666233 90019	780727 27561
	60	50	699573 98022	780727 18704	780727 28569	666233 90020	780727 27560
	60	25 V			666233 73756		
	80	50	699573 98023	780727 18705	780727 28568	666233 90021 NS	780727 27559
	80	25 V			666233 73757		
	120	50	662610 41384	780727 18706	780727 28567		780727 27558
	120	25 V			666233 73758		
/4 x 18	40	50	699573 98027	780727 62476	662544 92526	666233 90022	780727 81797
	60	50	699573 98028	780727 45691	780727 09590	666233 90023	780727 39966
	60	25 V			666233 73762		
	80	50	699573 98029		780727 58953	666233 90024	780727 32289
	80	25 V			666233 73763		
	120	25 V			666233 73764		
20-1/2" Belts							
8/4 x 20-1/2	40	50	699573 98030	780727 14398	662544 57869	666233 90025	780727 27573
	50	50	699573 44982	780727 18714	662544 92527		
	60	50	699573 98031	780727 18715	780727 28560	666233 90027 NS	780727 27571
	60	25 V			666233 73765		
	80	50	699573 98032	780727 18716	780727 28559	666233 90028 NS	780727 27570
	80	25 V			666233 73766		
	100	50	662610 55516	7007070707000010	662610 38911		780727 27569
	120	50	662610 44755	780727 27380 NS	780727 28557		780727 27575
4" Belts	10	50	00001100001	700707 48000			
/4 x 24	40	50	662611 98631	780727 47823	662544 73499 NS		70070707070
	60	50	699573 45451	780727 56534	780727 28552		780727 27548
	60	25 V	00040500040	70070740040	666233 73750		
	80	50	636425 96940	780727 18340	78072767713		
10 0 4	120	50	662610 80367	780727 70718	780727 28550	00000000000	70070767500
/2 x 24	40	50	699573 98024	78072760092	662544 92528	666233 90032	780727 27568
	50	50	662610 43757	780727 18707	662544 52237	666233 46910 NS	70070707070707
	60	50	699573 98025	780727 18708	780727 28564	666233 90033	780727 27566
	60	25 V	CODE 7000000	70070740700	666233 73759	66600000004	700707 07FCF
	80	50	699573 98026	780727 18709	780727 28566	666233 90034	780727 27565
	80	25 V	66061040000	70070745004	666233 73760		
	100	50	662610 42203	780727 45021	780727 53076		662544 91545
v 04	120	50	662610 42565	780727 18710	780727 28565		780727 27564
x 24	40	50	699573 50019	662544 91531 NS			
	50	50 50	699573 44889 NS	780727 10374 NS			
	60	50	699573 53375 NS	70070770000	70070776400 10	000000000000000000000000000000000000000	00001005000 10
	80	50	699573 45419 NS	780727 72209	780727 76498 NS	666233 34206 NS	662610 85068 NS
	120	50	662610 85067	662544 91532 NS	780727 30029 NS		662610 85069 NS
O" Belts	10	50	00001080155			00000000000	00001150000
x 30	40	50	662610 53470		70070700000	666233 90038	662611 89958 NS
	60	50	699573 45985	7007070	780727 28583	666233 90039	662544 91549
	80	50	699573 46105	780727 64439	780727 28582	666233 90040 NS	780727 27579
	120	50	662611 93676	780727 81197	780727 66992		780727 27577

Additional sizes, grits and scalloped edge belts are available MTO (made-to-order). Contact your Norton representative for availability, order quantities and lead-times. 40 and 50 grit BlueFire belts are furnished in BlueFire R887D (Y-weight Polyester); 60-120 grits are supplied in BlueFire R823P (X-weight Polyester). Joints – All belts are PG jointed; a butt joint joined with flexible tape for contour grinding. V = Vendible package. Ideal for vending machines and small jobs. 5 belts per pack / 5 packs per carton. Order in multiples of 25.

COATED & NON-WOVEN ABRASIVES Portable Belts





Portable belts are ideal for all your metal and woodworking applications. Choose 36 - 50 grits for rough/heavy-duty applications, 60 - 100 for intermediate, and 100 - 220 for finishing/polishing applications.

The belts listed are popular stock sizes, but additional sizes, specifications, and backing materials, are available made-to-order.

Applications:

Size Range: Grit Range: Abrasive Grain: Machine Used: Grinding and finishing all metals, blending welds, sanding and finishing wood, glass seaming, and polishing 3" to 4" wide, 15-1/2" to 24" long 36-220

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide



BELT IN-LINE DRUM SANDER SANDER

Cross Reference Guide

	BEST	BETTER	GOOD
NORTON	RedHeat R983	BlueFire R831	Gemini R215/ Metalite R255
3M	747D, 777F, 778F, 784F, 987F, 977F	577F	240DZ, 340A, 340D
Hermes	—	RB480	RB320
Klingspor	CS912	CS411	LS309XH
Sait	—	Z-H	1A-X, 2A-X, AO-X, LA-X
SIA	—	2800, 2829, 2925	2920, 2928, 2921, 2951, 2925
VSM	XK870X, XK870X	ZK713X	KK504X, KP510E

Material-to-Product Recommendation Guide

	BEST	BETTER	GOOD	
	RedHeat R983	Bluefire R831	Gemini R215	Metalite R255
Wood		•	♦	•
Carbon Steel / Stainless Steel	•	•		
Brass / Bronze / Aluminum		•	•	•



Exceptional performance, especially on hard-to-grind alloys

REDHEAT R983 CERAMIC ALUMINA

- · Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency



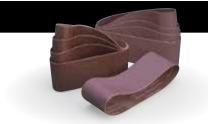
Better choice for stainless steel and wood

BLUEFIRE R831 ZIRCONIA ALUMINA

- Premium, self-sharpening zirconia alumina abrasive provides superior cut on all surfaces, lasts substantially longer, and cuts faster than the next leading competitor in side-by-side comparisons
- Proprietary patented grain technology produces one of the finest scratch patterns in the industry for finer looking finish; open-coat design and strong Y-weight cotton backing for reduced loading and extended life
- · Reversible butt splice allows belt to be used in either direction for longer life



COATED & NON-WOVEN ABRASIVES Portable Belts



Good choice to minimize loading on wood and soft metals - where initial price is the main concern

GEMINI R215 / METALITE R255 ALUMINUM OXIDE

- Premium aluminum oxide abrasive for fast initial cut rate
- Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction

Portable Belts for Belt Sanders

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					8		
			JOBPACK	JOBPACK			
		TIER:	BETTER	GOOD		GOOD	GOOD
		TRADENAME:	BLUEFIRE R831	GEMINI R215		GEMINI R215	METALITE R255
		ABRASIVE:	Zirconia Alumina	Aluminum Oxide		Aluminum Oxide	Aluminum Oxide
		BACKING:	Y-Weight Cotton	X-Weight Cotton		X-Weight Cotton	X-Weight Cotton
		JOINT:	Plyweld	Plyweld		Plyweld	Plyweld
		GRAIN COATING:	Open Coat	Open Coat		Open Coat	Open Coat
		OTHER:		·			UPC Bar Coded
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	STD. PKG.	PART #	PART #
3 x 18	36				5		780727 80447
	50	5/25*	07660749259	076607 00964	10		780727 27994
	80	5/25*	07660749258	076607 00968	10		780727 27993
	120	5/25*	076607 49256		10		780727 27992
3 x 21	36	5/25*	076607 49266	076607 01741			
	40				10		780727 27927
	50	5/25*	076607 49265	076607 01740	10		780727 27926
	60				10	780727 27925	
	80	5/25*	076607 49264	076607 02064	10		780727 27924
	100	5/25*	07660749263		10		780727 27923
	120	5/25*	07660749262	076607 02062	10		780727 27922
	220	5/25*		076607 05287			
3 x 24	36	5/25*	07660749272	076607 01743	5		780727 81847
	40				10		780727 27937
	50	5/25*	07660749271	076607 01742	10		780727 27936
	60				10	780727 27935	
	80	5/25*		076607 02067	10		780727 27934
	100	5/25*		076607 02066	10		780727 27933
	120	5/25*	076607 49268	076607 02065	10		780727 27932
x 24	36	5/25*	07660749278	076607 01745	5		780727 80438
	40				10		780727 27947
	50	5/25*	076607 49277	076607 01744	10		780727 27946
	60				10	780727 27945	
	80	5/25*	076607 49276	076607 02069	10		780727 27944
	100	5/25*			10		780727 27943
	120	5/25*	076607 49274	076607 02068	10		780727 27942
	180	5/25*		076607 05285			

*Job Pack packing standards: 5 belts/Job Pack; 5 Job Packs per case. Order by number of packs, in multiples of 5 packs.

Portable Belts for Pneumatic In-Line Drum Sanders

		TIER:	BEST	BETTER	GOOD
		TRADENAME:	REDHEAT R983	BLUEFIRE R823P	GEMINI R215
		ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide
		BACKING:	Y-Weight Polyester	X-Weight Polyester	X-Weight Cotton
		JOINT:	Plyweld	Plyweld	Plyweld
		GRAIN COATING:	Closed Coat/Supersize	Closed Coat	Open Coat
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #
3-1/2 x 15-1/2	36	10	780727 00783		780727 21997
	60	10	780727 18750		780727 22000
	80	10	780727 18751	780727 53074	780727 21995
	120	10	780727 18753		





A broad selection of sizes and grits for most dimensioning, intermediate grinding and polishing applications.

The belts listed are popular stock sizes, but additional sizes, specifications, and backing materials, are available made-to-order.

> Benchstand and Backstand Belts: grinding and deburring of all metals, heavy stock removal, blending, dimensioning and shaping, polishing. Centerless, Conveyor and Platen Belts: intermediate grinding stainless and carbon, moderate-pressure applications, dimensioning and finishing. 1" to 10" wide, 36" to 132" long

Size Range: Grit Range: Abrasive Grain: Machine Used:

Applications:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide



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BACKSTAND BELT GRINDER

BENCHSTAND GRINDER

Cross Reference Guide

	BEST	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
NORTON	Blaze R980P	RedHeat R983	BlueFire R821P	BlueFire R823P	BlueFire R884P	Gemini R766	Gemini R228
3M	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	747D, 777F, 778F, 784F, 987F, 977F	_	551E	561D	361F, 363F	241D, 251D, 341D
Hermes	CR454, CR456	CN464	—	RB486 X, RB346, RB486	RB48024YX, RB48444Z, RB485Z	RB377XY, SB378, RB34MJ	RB320X, HSB
Klingspor	CS610	CS912	CS411X	CS411X, CS416	CS411	CS412, CS413	CS310
SIA	2515, 2503	_	—	_	2820	—	2918, 2928
VSM	XK875X, XK885Y, XK880Y	XK870X, XK870X	—	ZK713X, KK715X	KK716, ZK713T	LK719X, KK711X	KK511X, KK711

Material-to-Product Recommendation Guide

	BEST	BETTER			GOOD	
	Blaze R980P	BlueFire R884P	BlueFire R823P	BlueFire 821P	Gemini R766	Gemini R228
Aluminum		•	•		•	
Cast Iron	•		•		•	
Brass / Bronze		•	•		•	
Die Castings	•		•		•	
Carbon Steel	•		•		•	•
Glass / Ceramics	•			•	•	
Stainless Steel and Alloys	•	•	•		•	
Wood		•			•	

Grit Selection Recommendation Guide

STOCK REMOVAL	INTERMEDIATE	FINISHING
24 – 50 grit	60 – 100 grit	120 – 320 grit

TECH TIP

Troubleshooting Guide

Problem	Correction	Problem	Correction
Loading	Decrease infeed pressure or belt speed	Belt breakage	Reduce belt tension
Shedding	Reduce applied pressure		Use less aggressive contact wheel
Ū.	Use a less aggressive contact wheel		Check tracking mechanism for belts tracking erratically
	Dress contact wheel if worn or damaged		
	Use entire surface of belt		





Best for mild and carbon steel, stainless, cobalt, chrome, inconel, titanium

BLAZE R980P CERAMIC ALUMINA

- Next-generation cooler cutting Norton SG ceramic alumina grain lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, inconel and titanium with better metal integrity
- Durable Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray, and better body retention, resulting in longer life and product consistency
- Lubricating grinding aid coating means cooler cut, burn-free grinding of heat-sensitive materials, minimized loading, and improved part finish and integrity

Exceptional performance, especially on hard-to-grind alloys

REDHEAT R983 CERAMIC ALUMINA

- Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body
 retention, resulting in longer life and product consistency



Better choice for heaviest-pressure applications

BLUEFIRE R821P/R823P/R884P ZIRCONIA ALUMINA

- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive zirconia belts
- Durable resin bond for excellent grain retention and product life
- R821P Y-weight cotton backing provides durability and even wear on coarser grit stock removal applications;
- R823 has flexible X-weight polyester waterproof backing to excel on light- to moderate-pressure, applications
- R884P has a durable Y-weight polyester waterproof cloth backing that excels on medium- to high pressure applications



Good choice for difficult-to-grind materials (aluminum, brass, bronze, stainless, carbon steel, titanium, etc.)

GEMINI R766 ALUMINUM OXIDE

- Premium aluminum oxide abrasive blend is ideal when primary purchasing criteria is a good-performing, economically-priced, general-purpose belt
- Y-weight waterproof polyester backing withstands light- to moderately-demanding applications and provides extended life on dry grinding applications
- · Resin bond system provides improved edge retention and 30% plus improvement in life versus key competitors



Good choice for fine grit metalworking blending and polishing where initial price is the main concern

GEMINI R228 ALUMINUM OXIDE

- Premium aluminum oxide abrasive delivers fast initial cut rate
- · Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction



1" to 6" wide, 36" to 72" long

				A star to	the second second		
		TIFR.	BEST	BETTER	BETTER	GOOD	GOOD
			BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	GEMINI R766	GEMINI R228
		ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
			Y-Weight Polyester	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
	0.01	OTHER:	Supersize				
E (W x L)	GRIT		PART #	PART #	PART #	PART #	PART #
42	36 40	50 50	662544 76825	780727 26905			780727 91710 780727 20910
	50	50	662544 76826 NS	780727 26904		666233 90042	780727 20905
	60	50	699573 45486	780727 26903	780727 28596	666233 34502 NS	780727 20900
	80	50	662610 41539	780727 26902	780727 28594		780727 20895
	100	50	662610 43462		780727 28592		780727 20890
	120	50	662610 38660		780727 28590		780727 20885
	150 180	50 50			780727 28588 780727 28586		780727 20880 780727 20875
	220	50			780727 00001		780727 20875
	240	50			10012100001		780727 20870
	320	50					780727 20865
/2 x 60	36	10	699573 45578				780727 21060
	40	10	636425 95003				
	50	10	00057045004			000000045	780727 87807
	60 80	10 10	699573 45631 699573 45579			666233 90045 666233 90046 NS	
	100	10	09907040079		780727 65077	000233 30040 N3	
	120	10	662610 56493 NS		780727 26984		
48	24	10					780727 26130
	36	10	636425 92057	780727 27103		666233 90047	780727 21255
	40	10	699573 45193	780727 27102		666233 90048 NS	780727 21250
	50	10	699573 46716	780727 27101			780727 21245
	60 80	10 10	699573 44423 699573 45100	780727 27100	780727 28621 780727 28619	666233 90050	780727 21240 780727 21235
	100	10	662610 52522	780727 27099	780727 28619	666233 90051	780727 21235
	120	10	662610 52520		780727 28615		780727 21225
	150	10	00201002020		780727 28613		780727 23246
	180	10			780727 28611		780727 21223
	220	10			780727 28609		780727 63677
00	320	10					780727 46387
60	24 36	10 10	CO0E724E10C			666000 0060	662610 54787 NS
	40	10	699573 45196 699573 94425	780727 27124		666233 90052	780727 21300
	50	10	03307334423	10012121124			780727 62537
	60	10	699573 44901	780727 27122		666233 90055 NS	780727 21290
	80	10	636425 92574	780727 27121			780727 21285
	100	10					780727 21280
	120	10	662610 42738		780727 61958		70070744040
	150 180	10 10			780727 02695		780727 44018 780727 20441
	220	10			780727 02095		780727 44020
	240	10					780727 61862
	320	10					780727 02825
72	24	10	662544 33969				
	36	10	699573 45460	780727 27147		666233 90057	780727 21335
	40	10	699573 46729	780727 27146		666233 90058 NS	7007070 -00 -
	50	10	699573 44966	780727 27145	700707 000 45	66600000000 NO	78072784894
	60 80	10 10	699573 45157 699573 44961	780727 27144 780727 27142	780727 28645 780727 28643	666233 90060 NS	780727 21325
	100	10	662610 41897	10012121142	662610 25537 NS		780727 21320 780727 23235
	120	10	662610 44095		780727 28639		780727 21318
	150	10			780727 61770 NS		78072761973
	180	10			78072763853		780727 18488
	220	10			780727 28633		780727 65601
	320	10					780727 21308

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts

Continued



1" to 6" wide, 36" to 72" long continued

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		TIFR	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
			BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	BLUEFIRE R884P	GEMINI R766	GEMINI R228
			Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	
		BACKING: OTHER:	Y-Weight Polyester Supersize	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
ZE (W x L)	GRIT			PART #	PART #	PART #	PART #	PART #
1/2 x 48	36	10					666233 90061	780727 21540
	50	10		780727 27213				
	60	10					666233 90064	780727 21525
1/2 x 60	80 24	10 10				780727 37759 NS	666233 90065 NS	780727 21520
1/2 X 00	36	10	699573 44963	780727 27235		100121 31139 NS	666233 90066 NS	780727 21610
	40	10	699573 46523	780727 27234			666233 90067 NS	780727 21605
	50	10	699573 45300	78072727233			666233 90068	780727 21600
	60	10	699573 45002	780727 27232	780727 28692	780727 21383 NS		780727 21595
	80	10	699573 46095	780727 27231	780727 28690		666233 90070	780727 21590
	100	10	662610 41380		780727 68991			780727 21585
	120	10			780727 28686			780727 21580
	180 220	10 10			780727 28682 780727 78217 NS			780727 21570 780727 21565
x 36	36	10			10012110211 113			780727 22110
X 00	40	10						780727 22105
	50	10		780727 27475			666233 90073	780727 22100
	60	10			780727 28827		666233 90074	780727 22095
	80	10		780727 27473	780727 28825		666233 90075	780727 22090
	100	10			780727 28823			780727 22085
	120	10			780727 28821			780727 22080
	150	10						780727 22079
	180 240	10 10						780727 22075 780727 22926
	320	10						780727 22920
x 54	36	10						780727 22185
	40	10						780727 22180
	50	10					666233 90078 NS	780727 22175
	60	10	662610 63419 NS	780727 27518	780727 25116 NS			780727 22170
	80	10	699573 45139 NS		780727 82996			780727 22165
	100	10						780727 22160
	120	10			780727 28847			780727 22155
x 60	24	10	662544 61488			700707 070FF		780727 72342 NS
	36 40	10 10	699573 45298 699573 91732			780727 37955		780727 44693
	40 50	10	699573 46715					780727 61630
	60	10	636425 94485		780727 74790			780727 62861
	80	10	699573 45099		780727 65086			780727 84685
	100	10						78072763161
	120	10	662544 16188		780727 66229			780727 87840
x 72	36	10				780727 25984 NS		
k 48	36	10	699573 45143	780727 27698			666233 90081	780727 22590
	40	10		780727 27697			666233 90082	
	50	10	CODE 70 44 400	780727 27696	7007070007*		666233 90083 NS	780727 22580
	60 80	10	699573 44422	780727 27695 *	780727 28937 *		666233 90084	70070799570
	100	10 10		780727 27694 *	780727 28935 * 780727 28933 *		666233 90085	780727 22570 780727 22565
	120	10			780727 28931 *			780727 22560
	150	10			780727 70042			780727 22555
	180	10						780727 22550
	220	10						780727 22546
	240	10						780727 22545
	320	10						780727 22543

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts

Continued



1" to 6" wide, 36" to 72" long continued

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		TIER:	BEST	BETTER	BETTER	BETTER	GOOD
		TRADENAME:	BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	BLUEFIRE R884P	GEMINI R228
		ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide
		BACKING:	Y-Weight Polyester	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
		OTHER:	Supersize				
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
6 x 54	60	10				780727 46982 NS	
6 x 60	36	10					780727 22680
	40	10		780727 27762			780727 22679 NS
	60	10	699573 45149	780727 28957 *			780727 22665 *
	80	10			780727 28955		780727 22660 *
	100	10	662544 77452 NS				
	120	10					780727 63882

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts

Belt Cleaning Stick



- This solid, rubber cleaning stick is designed to remove wood and other non-metallic materials that build up on belt surface during use
- Apply it to the face of the belt, while running, to remove unwanted materials and prolong the overall life of the belt up to 10 times

DESCRIPTION	STD. PKG.	PART #
1-3/8 x 1-3/8 x 6	10	076607 01717

TECH TIP

A light-bodied grease applied to a benchstand belt surface will reduce loading and greatly enhance the belt life and performance when grinding soft, malleable nonferrous materials such as aluminum, brass, bronze and copper.



Take Advantage of FastTrack Service!

For non-stock belts, FastTrack Service offers all the benefits of an ISO 9001 quality manufacturer and the advantages of a coated abrasives express belt service. As the industry's leading producer of abrasive material and backings, our FastTrack service offers an extensive range of Norton made-to-order belts including Blaze ceramic alumina, BlueFire zirconia alumina, and versatile aluminum oxide and silicon carbide belts.

Manufacturing Lead-times:

- Narrow belts: (1/2" 12" wide) two days
- Wide belts (14" 52" wide) three days
- Size Availability:
- · Maximum width: 52"
- 1/2" and greater widths; 25" and greater lengths

Please see the FastTrack Service Made-to-Order Belts section of this catalog for complete details.



2" to 10" wide, over 70" long

						- Do	· * ***	
					C. T. T			
			BEST	BEST	BETTER	BETTER	GOOD	GOOD
		TRADENAME:		REDHEAT R983	BLUEFIRE R884P	BLUEFIRE R823P	GEMINI R766	GEMINI R228
			Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	
			Y-Weight Polyester	Y-Weight Polyester	Y-Weight Polyester	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
		OTHER:	Supersize	Supersize				
IZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
x 132	36	10		780727 53086	780727 50016		666233 47337	
	40	10			780727 50015		666233 90089 NS	
	50	10		780727 40771	780727 50013			
	60	10		70070704050	780727 50011		666233 90091 NS	780727 21445 NS
	80	10		780727 01958	780727 50008	70070700000		780727 21440
70	120	10	00001000000			780727 28662		
3 x 79	50	10	662610 90276		70070740000			
3 x 90	60 36	10 10	CODE 704C210		780727 48280			70070705034
			699573 46319		70070750440			780727 85831
3 x 132	24 36	10 10	CO057044710	700707 59007 NC	780727 50140		666233 90093	70070701000
	30	10	699573 44710	780727 53087 NS	780727 50138 780727 50139		00023390093	780727 21900
	40	10	699573 44964	780727 01614 NS	10012130139			
	40 50	10	699573 44964	780727 01614 NS	780727 50135			780727 21890
	60	10	699573 44763 NS	10012103109	10012130133	780727 28794	666233 90096 NS	780727 21885
	80	10	699573 44764			780727 28792	000233 30030 N3	780727 21880
	100	10	09907344704			780727 28792		10012121000
	120	10				780727 28789		780727 21870
	180	10				780727 28785		78072721860
x 79	36	10		662610 22622		10012120105		10012121000
×1J	40	10		00201022022	780727 74955			
x 100	36	10			78072768679			
x 132	24	10			780727 50289 NS			
r x 102	36	10	699573 43852	780727 39662	780727 50287		666233 26093	
	40	10					666233 90098 NS	
	60	10			780727 50281			
	80	10			780727 50279			780727 22385
	120	10						780727 22375
6 x 78-3/4	40	10			780727 25150			
6 x 79	36	10			780727 38105			
	80	10			780727 79322			
x 107	36	10						780727 22795
-	50	10						780727 49887
	60	10						780727 22780 *
	80	10						780727 22775 *
0 x 70-1/2	36	10						780727 22840
	50	10						780727 22830 NS
	60	10					666233 47345 NS	780727 22825
	80	10						780727 22820

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts





COATED & NON-WOVEN ABRASIVES Wide Belts

A small selection of stock products in popular sizes are available for wide belt woodworking and metalworking applications.

Applications: Metalworking

Metalworking wide belts are used for plate dimensioning, slag grinding, machining, deburring, and other general metalworking applications. They are usually cloth and are closed coat.

Woodworking

Cloth woodworking wide belts are used for rough stock removal and dimensioning Paper woodworking belts are used to upgrade the finish on furniture and other wood components. Stock: 25" - 52" wide, 48" to 103" long Stock: 36 - 220Zirconia Alumina, Aluminum Oxide

Metalworking Cloth Belt Recommendation Guide/Cross Reference

Size Range:

Grit Range: Abrasive Grain:

	TOTAL PERFOR	MANCE						INITIAL PR
	BEST		BETTER			GOOD		
NORTON	H-wt. Polyester Blaze R940P	Y-wt. Polyester Blaze R980P	H-wt. Polyester BlueFire R840P	Y-wt. Polyester BlueFire R887D/R884P	X-wt. Polyester BlueFire R823P	Y-wt. Polyester Gemini R766	X-wt. Polyester Gemini R766X	X-wt. Cotton Gemini R228
3M	966F, 984F, 994F, 997F	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	561F	577F, 561D	551E	361F, 363F	353F, 384F	241D, 251D, 341D
Ekamant/ Uneeda	_	PS991, PS992	PZ628	PZ528, PZ633	XZ677	PA631, PG730, PG830	XA911	XA167
Hermes	CB441Z	CR456	SB488YR	RB48624YX, RB48644Z, RB48024YX, RB48444Z, RB485Z	RB486	RB377XY, SB378	RB377XY	RB320X, HSB
Klingspor		CS610	CS811	CS409, CS411	CS411X, CS416	CS412, CS413	CS341, CS710	CS310
SIA	_	2515, 2503	C888DP	2803, 2815, 2829, 2824, 2820	_	_	2820	2918, 2928
VSM	XK888Z, XK877Z	XK875X, XK885Y, XK880Y	KK717	KK716	ZK713X, ZK713T, KK715X	LK719X, KK711X	LK719X, KK711X	KK511X

Woodworking Cloth and Paper Belt Recommendation Guide/Cross Reference

TOTAL PERFORMANCE

INITIAL PRICE

	BEST		BETTER	GOOD			
	Y-wt. Cotton	F-wt. Paper	Y-wt. Cotton	X-wt. Cotton	F-wt. Paper	F-wt. Paper	
	Dust-Less	Dust-Less			Dust-Less	Dust-Less	
NORTON	R963	H975	BlueFire R831	Gemini R215	H295	H275	
3M	960G, 970DZ, 990FZ, 991FZ	966UZ	_	240DZ, 340A, 340D	260UZ	364UZ	
Ekamant/ Jneeda	_	—	XZ677	RKX, RKXO		ARKFO, EKA1000, EKABlack	
Hermes		CB115	RB480	RB320	BW114	BW110, BW114, CB115	
Klingspor	—		C409, CS411	LS309XH	PS22	PS29	
SIA	_	—	2803, 2820, 2829	2920, 2928, 2921, 2951	1919	1909,1918,1919 CRS,1993	
/SM	XK760X, XK760Y	XP760	KK713X, KK715X	KK504X, KP510E	KK508E	KP709, KP520, KP508E, KP510E	



COATED & NON-WOVEN ABRASIVES Wide Belts



Better choice for all metal and wood applications due to the cut rate and life of the proprietary Norton BlueFire grain

BLUEFIRE R884P/R823P ZIRCONIA ALUMINA CLOTH

- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive zirconia belts
- Durable resin bond for excellent grain retention and product life
- R884P has a durable Y-weight polyester waterproof cloth backing that excels on medium- to high pressure metal applications
- R823 has flexible X-weight polyester waterproof backing to excel on light- to moderate-pressure metal applications

Good choice for abrasive planing and dimensioning of glued-up stock and banded particleboard $% \left({\left({n_{\rm s}} \right)^2 } \right)$

GEMINI R215 ALUMINUM OXIDE CLOTH

- Premium aluminum oxide abrasive for fast initial cut rate
- · Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction

		TIER:		BETTER	GOOD
		TRADENAME::		BLUEFIRE R823P	GEMINI R215
		ABRASIVE:		Zirconia Alumina	Aluminum Oxide
		BACKING:	Y-Weight Polyester Cloth	X-Weight Polyester Cloth	X-Weight Cotton Cloth
		JOINT/FLEX:	Plyweld, RR	Plyweld, RR	Plyweld, RR
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #
25 x 48	80	3		699573 44781	
25 x 60	80	3		699573 28117	
	120	5		699573 28115	
36 x 75	36	2	699573 50934		
	60	3	699573 50931		
	120	5		699573 29014	
	180	5		699573 44869	
37 x 60	50	3	699573 06219		
	80	3		699573 29019	699573 25709
	100	5		699573 28103	699573 25708
	120	5		699573 29018	699573 25707
	150	5		699573 28102	699573 02955
	180	5		699573 28101	
	220	5		699573 28100	
37 x 75	36	2	699573 50959		
	50	3	699573 05107		
	80	3	699573 50955		699573 25957
	100	5			699573 23880
	120	5		699573 07358	699573 25760
	150	5			699573 05737
	180	5		699573 06734	
52 x 75	120	5		699573 13510	

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Due to the wide varieties of machines and applications, the majority of wide belts are non-stock. Our FastTrack belt service is available on the majority of products with 3-day lead-time on orders up to two cases quantity.

TECH TIP

6" wide belts can be used on machines that normally use 37" wide belts.



COATED & NON-WOVEN ABRASIVES FastTrack Service Made-to-Order Belts

For many non-stock belts, our FastTrack belt service offers all the benefits of an ISO 9001 quality manufacturer and the advantages of a coated abrasives express belt service. As the industry leader of abrasive belts, our FastTrack belt service has an extensive range of Norton made-to-order belts including Blaze ceramic alumina, BlueFire zirconia alumina, versatile aluminum oxide, and silicon carbide belts.

Manufacturing lead-time is two days for narrow belts (1/2" - 12" wide) and three days for wide belts (14" - 52" wide). Please see the FastTrack belt service chart below for complete details on availability and lead-time.

FastTrack Ordering Quantities and Lead-times

WIDTH*	GRIT SIZE	MINIMUM ORDER QUANTITY	CASE QUANTITY	MAXIMUM ORDER QUANTITY (EQUALS 2 CASES)	CONVERSION Lead-times
Narrow Belts					
1/2" through 1"	All	50	200	400	2
Over 1" through 5"	All	10	50	100	2
Over 5" through 9"	All	10	20	40	2
Over 9" through 14"	All	10	10	20	2
Wide Belts					
Over 14" through 20"	All	5	10	20	3
Over 20" through 52"	36 & coarser	2	2	4	3
Over 20" through 52"	40-80	3	3	6	3
Over 20" through 52"	100 & finer	5	5	10	3

How to Place a FastTrack Belt Order

- Check the FastTrack product availability
- Include a full description of belt: quantity, size, Norton CAP code, and grit size. (FastTrack Service is limited to standard joints and flexes.)
- Send order electronically, fax, or phone to customer service
- When ordering a belt that does not have an existing part number, please call Customer Service to expedite part number creation

* FastTrack belt service applies to belts 25" and greater in length. Maximum length for FastTrack belts is 350".

TIER	PRODUCT CAP CODE	SHAPE Availability	GRIT SIZE	ABRASIVE Grain	BACKING	APPLICATIONS
Metal	working					
Best	R980P	Narrow, Wide	24 - 120	Norton Blaze Ceramic Alumina	Y-wt. Polyester	Latest-generation Norton SG grain, supersized and designed for high-performance grinding on stainless and other alloys
Best	R984-NA	Narrow, Wide	36 - 120	Norton SG Ceramic Alumina	Y-wt. Polyester	Norton SG grain for medium-pressure grinding and finishing heat-sensitive alloys
Best	R983	Narrow, Wide	36 - 120	Norton Red Heat Ceramic Alumina	Y-wt. Polyester	High performance grain chemistry, enhanced backing and supersize provide longer life and faster cut for stainless and tough-to-grind alloys.
Better	R884P	Narrow, Wide	24, 36 - 80	Norton BlueFire Zirconia Alumina	Y-wt. Polyester	High-performance zirconia alumina grain designed for medium- to high-pressure grinding
Better	R887D	Narrow, Wide	24, 36 - 120	Norton BlueFire Zirconia Alumina	Y-wt. Polyester	New, significantly improved-performance zirconia alumina grain, supersized and designed for medium- to high-pressure grinding of heat-sensitive alloys
Better	R823P	Narrow, Wide	60 - 220	Norton BlueFire Zirconia Alumina	X-wt. Polyester	High-performance zirconia alumina grain on lighter backing designed for light to medium grinding
Good	R766	Narrow, Wide	P24 - 80	Aluminum Oxide Blend	Y-wt. Polyester	Premium aluminum oxide blend product designed for a variety of applications including soft metals to hard-to-grind stainless and carbon steel
Good	R766X	Narrow, Wide	P60 - P400	Norton Gemini Aluminum Oxide	X-wt. Polyester	Quality, P-graded aluminum oxide and broad grit range for stock removal to finer finishing
Good	MX240	Narrow, Wide	P80 - P150	Aluminum Oxide	X-wt. Poly/Cotton	P-graded, heat-treated aluminum oxide X-weight cloth with strong, but flexible, cotton/polyester backing making it an ideal multi-purpose product
Good	R245	Narrow	P80 – P240, P320, P400	Aluminum Oxide	J-wt. Polyester	Aluminum oxide on flexible, lightweight polyester backing for moderate- to light- pressure applications on mild steel
Good	KF376	Narrow	P80 – P320, P400, P600	Aluminum Oxide	J-wt. Cotton	P-graded, heat-treated aluminum oxide with ceramic coating on a very flexible backing for use wherever flexibility and conformability are needed
Good	R445	Narrow	60 - 220	Silicon Carbide	X-wt. Polyester	Sharp, silicon carbide grain on medium polyester backing for grinding very hard materials – glass, stone, solid surface
Good	U243	Narrow, Wide to 12"	X80, X65, X45, X30, X22, X16	Aluminum Oxide	J-wt. Cotton	High-performance, multi-layered NORaX grain on very flexible backing for dry polishing applications
Wood	working					
Best	R963	Narrow, Wide	24 – 60, P80 100 – 150	Norton SG Ceramic Alumina	Y-wt. Polyester	Norton SG ceramic alumina grain with anti-static coating for forest product applications (MDF, particleboard, plywood)
Best	R955P	Narrow	P24 - P120	Norton Red Heat Ceramic Alumina	Y-wt. Cotton	100% ceramic alumina abrasive with Y-weight cloth backing for dimensioning, intermediate sanding of wood
Better	R831	Narrow, Wide	24, 36 - 120	Norton BlueFire Zirconia Alumina	Y-wt. Cotton	Norton BlueFire open-coat product recommended for dry low-pressure applications or where loading is a problem
Good	R215	Narrow, Wide	50 - 180	Aluminum Oxide	X-wt. Cotton	Initial starting specification for all woodworking applications where loading is a problem
Good	R464P	Narrow, Wide	P36 - P180	Silicon Carbide	Y-wt. Polyester	Anti-static product for forest product applications (MDF, particle board, plywood) where loading is an issue
Good	R422	Narrow	50 - 120	Silicon Carbide	X-wt. Cotton	Initial starting specification for all woodworking applications where loading is not an issue
Best	H975	Narrow, Wide	60 - 220	Norton Red Heat Ceramic Alumina	F-wt. Paper	Ceramic alumina grain, antistatic coating, and open coat; the best choice for applications where loading is a problem (soft woods, etc.)
Better	H831	Wide	24, 36 - 120	Norton BlueFire Zirconia Alumina	F-wt. Paper	Durable zirconia alumina grain, antistatic coating, and open coat: the better choice for applications where loading is a problem (soft woods, etc.)
Good	H275B	Narrow, Wide	P60 - P220	Norton Adalox Aluminum Oxide	F-wt. Paper	Quality aluminum oxide grain, antistatic coating, and open coat make these an economical choice for all heavy-weight paper belt jobs
Better	H475	Narrow, Wide	P120 - P400	Norton Onyx Silicon Carbide	F-wt. Paper	Sharp silicon carbide and antistatic coating create finer finishes on hard materials and veneers where finish is critical



COATED & NON-WOVEN ABRASIVES Non-Woven Belts

Norton non-woven belts are a combination of strong synthetic mesh and quality abrasive, bonded together by a smear-resistant adhesive. The open construction of non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

Watch for new and improved narrow belt and file belt joints.

Applications:

Abrasive Grain: Grit Range: Machine Used: Removing surface defects, light edge burrs, parting lines, flashing, rust, oxides, corrosion, paints, and scale; blending mill marks, tool marks, uneven edges, and applying decorative finishes.

Engineered Aluminum Oxide, Aluminum Oxide

Extra Coarse (Black), Coarse (Brown), Medium (Maroon), Fine (Green), Very Fine (Blue)

IN-LINE DRUM

SANDER

PORTABLE FILE BELT BELT SANDER SANDER





Application/Grit Recommendation Guide

	849 C . A. Y		S. Martin Ba	
EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
•				
	•			
	•			
		•		
		•		
			•	
				•
	EXTRA COARSE		BEST Choice - Vortex Rapid P	EXTRA COARSE COARSE MEDIUM FINE BEST Choice - Vortex Rapid Prep BETTER Choice - Rapid Prep

Flex Key

LF: Low Flex; Highest Density; Stiffest

RF: Regular Flex; Low Stretch

XF: Extra Flexible; Low Stretch; Exceptional Conformability



Best choice for finishing and blending applications

VORTEX RAPID PREP ALUMINUM OXIDE

- Patented Vortex grain produces the most consistent cutting and finishing action combining the cutting power of a coarser grit with the finish of finer grits
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a uniformly thick layer of resin bond and grain for extended life, durability, and stiffness
- Proprietary Clean Bond resin technology and open coat guarantee smear-free finishes even on high nickel content alloys and minimize loading on aluminum and other soft metals

Better choice for finishing and blending applications

RAPID PREP ALUMINUM OXIDE

- Premium aluminum oxide abrasive grain coating provides up to 20% higher cut rate versus other surface conditioning belts
- Durable nylon fiber bonded to a strong Y-weight polyester backing with extremely low stretch is ideal for applications where low-stretch and durability are necessary
- Proprietary Clean Bond resin technology and open coat guarantee smear-free finishes even on high nickel content
 alloys and minimize loading on aluminum and other soft metals









COATED & NON-WOVEN ABRASIVES Non-Woven Belts

File Belts

					1. 1		Circle Circle Circle
			GRIT/COLOR:	COARSE	MEDIUM	FINE	VERY FINE
			TIER:	BEST	BEST	BEST	BEST
			TRADENAME:	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP
			ABRASIVE:	Engineered A/O	Engineered A/O	Engineered A/O	Engineered A/O
NIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #
1/4"	18"	XF	24	662611 58548	662611 58558	662611 58578	662611 58583 NS
1/2"	12"	XF	24	662611 58547	662611 58555	662611 58577 NS	662611 58582 NS
	18"	XF	24	662611 58549	662611 58561	662611 58579	662611 58584 NS
	24"	XF	24	662611 58550	662611 58565	662611 58580	662611 58585
3/4"	18"	XF	12	662611 58552	662611 58576	662611 58581	662611 58586
			TIER:	BETTER	BETTER	BETTER	BETTER
			TRADENAME:	RAPID PREP	RAPID PREP	RAPID PREP	RAPID PREP
			ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #
1/4	18	XF	24	662610 11420	662610 12524	666233 33424	666233 33511
	24	XF	24	699573 92606	662610 97565	666233 33425	666233 33512
1/2	12	XF	24	662610 03177	662610 06465	666233 18175	662544 99884
	18	XF	24	662610 55309	662610 55310	666233 33426	662610 55311
	24	XF	24	662610 55312	662610 08972	662544 90859	662610 19876
3/4	18	XF	12	662610 02111	662610 15808	662544 90858	662610 03622
	20-1/2	XF	12	662610 83899	662610 03260		666233 33515 NS
1	18	XF	12	662610 07023	662610 17898 NS	666233 33429	666233 33518
	21	XF	12	666233 33412 NS	666233 36005 NS	666233 33430 NS	666233 33519

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Pump Sleeve Belts

			GRIT/COLOR:	EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
			TIER:	BEST	BEST	BEST	BEST	BEST
			TRADENAME:	VORTEX RAPID PREP				
			ABRASIVE:	Engineered A/O				
WIDTH	LENGTH	FLEX	STD. PKG.	PART #				
3-1/2	15-1/2	LF	8	666233 33725	666233 35042	666233 35118	666233 33665	666233 35139
3-1/2	15-1/2	RF	8		636425 75499	776960 45732	662611 02432	662611 02436
			TIER:	BETTER	BETTER	BETTER	BETTER	BETTER
			TRADENAME:	RAPID PREP				
			ABRASIVE:	Aluminum Oxide				
WIDTH	LENGTH	FLEX	STD. PKG.	PART #				
3-1/2	15-1/2	LF	8	666233 33595	662610 55324	662544 44576	666233 33452	662610 55326





COATED & NON-WOVEN ABRASIVES Non-Woven Belts

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Narrow Belts

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			GRIT/COLOR:	COARSE	MEDIUM	FINE	VERY FINE
			TIER:	BEST	BEST	BEST	BEST
				VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP
			ABRASIVE:	-	Engineered A/O	Engineered A/O	Engineered A/O
IDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #
	132	RF	8	666233 35032	666233 35100	666233 35080	662611 06894
	48	RF	10	776960 67453	666233 35103	662611 13853	662611 09542
	60	RF	8	666233 33627	636425 54551		666233 33691
	72	RF	8	666233 35036	666233 35105	666233 33653	666233 35134
	132	RF	6	77696006299	77696006300	776960 24093	666233 33692
	132	RF	4	77696006233	776960 06234	666233 33664	666233 33699
	36	RF	6	11030000200	11030000204	0002000004	666233 33701
	72	RF	4	699573 70664	699573 09696	780727 43985	0002000000
	132	RF	2	03337370004	0000100000	666233 33669	
	48	RF	4	662611 02442	666233 35123	000233333003	662611 02435
	40	TH I	TIER:	BETTER	BETTER	BETTER	BETTER
				RAPID PREP	RAPID PREP	RAPID PREP	RAPID PREP
				Aluminum Oxide			
VIDTH	LENGTH	FLEX	STD. PKG.	PART #	Aluminum Oxide PART #	Aluminum Oxide PART #	Aluminum Oxide PART #
חועות							
	30	RF	12	662610 19801 NS	666233 36006 NS	666233 33431 NS	662610 01972 NS
	42	RF	12		662544 41289 NS	666233 33432 NS	666233 33521 NS
	60	RF	12				662610 55412
	64	RF	12	00001101010	666233 01513 NS	0005 4 400000 110	662610 55413 NS
	72	RF	12	662611 94240	662610 06378 NS	662544 93830 NS	662610 05583
	132	RF	8	666233 14981 NS	0000104444	00054400000	
1 10	132	RF	10		662610 11414	662544 36886	666233 33525 NS
-1/2	60	RF	8	666233 33415 NS	662610 07644 NS		666233 03624 NS
	34	RF	12	662610 63309 NS		666233 33437 NS	666233 33529 NS
	48	RF	10	662610 06504	662610 06648	666233 33438	666233 33531 NS
	60	RF	8	666233 33416	662611 89669	666233 33439 NS	666233 33532
	72	RF	8	662610 02571 NS	662610 07757 NS	666233 33440	662610 02307
	132	RF	6			662610 69525 NS	666233 33533
-1/2	60	RF	6	662544 29365	662544 41491	666233 33441 NS	666233 33534
-3/4	15-1/2	LF	10	666233 33417 NS	666233 33508 NS		666233 33535 NS
	10-11/16	LF	12	662610 18076 NS	662610 67469 NS	666233 33443 NS	666233 33536 NS
	18	RF	10	662544 96043 NS	662544 28776 NS		662610 19836 NS
	21	RF	10	666233 33418 NS	662610 10870 NS	666233 33445 NS	666233 33537 NS
	24	RF	10	666233 14158 NS		666233 33446 NS	
	72	RF	6	666233 33419 NS	699573 96833	666233 33447	
	80	RF	4	666233 33420 NS	662610 07149 NS		666233 33542 NS
	90	RF	4	666233 33421 NS		666233 33449 NS	666233 33541 NS
	118	RF	4	666233 33422 NS	666233 33510 NS	666233 33450 NS	
	132	RF	4	662544 90470	662610 55322	666233 33451	666233 33543 NS
	24	RF	8	662544 95931 NS	662610 31667 NS		
	36	RF	6		662610 02321 NS	666233 33454 NS	666233 33546 NS
	132	RF	2	662610 09056	662610 06898	666233 33455 NS	666233 33547
	168	RF	2		662610 09174 NS		666233 33548 NS
	48	RF	4	662610 55330 NS	662610 55331	666233 33457	662610 55332 NS

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

If you do not see the Rapid Prep belts you need in our stock offering contact your Norton Representative for made-to-order availability.





COATED & NON-WOVEN ABRASIVES Cloth Rolls and Sheets

Scouring and light deburring, scale and rust removal, blending and fine sanding, polishing



Engineered for flexibility and fast cutting, cloth sheets and rolls have a longer life than paper. They tear cleanly and straight without shedding and are packed in a protective dispenser to eliminate waste and damage.

Rolls: 1" x 10 yds., 1-1/2" - 2" x 25 yds., 1" - 4" x 50 yds.

lathe turnings, rolls and cylinders, and blending machine tool marks

All purpose, fine finishing, and screen-back

JITTERBUG

SANDER

Categories: Applications:

Size Range:

Grit Range: Abrasive Grain: Machine Used:

Aluminum Oxide, Silicon Carbide

40-600, coarse, medium, fine

hand Sanding

Sheets: 9" x 11"

Cross Reference Guide

	GOOD		
NORTON	Gemini K225	Metal R243	Screen-Bak Q421
3M	011K	211K, 314D	481W, 483W
Hermes	RB317	RB232J	GS91350, GS92400
Klingspor	LS309	KL361, LS309	
Sait/United Abrasives	DA-F	EA-F	Sait-Screen
SIA	2915	2601, 2915, 2936	SIA-Screen
VSM	KK114F	KK505J, KK504X	_

Application/Starting Recommendation Guide

Durability/Stock Removal	Conformability	Waterproof
Fast Cut	Excellent Finish	Load Resistant
Gemini K225	Metal R243	Screen-Bak Durite Q421



Good choice for general-purpose metal and woodworking applications

GEMINI K225 ALUMINUM OXIDE

- · Premium P-graded aluminum oxide abrasive for greater cut rate on general purpose metalworking application
- Flexible J-weight backing for superior conformability to complex surfaces and better finishes
- · Advanced full resin bond system for exceptional grain adhesion for longer life



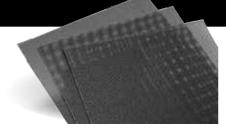
Good choice for small-volume metal and woodworking applications at a low initial price

METAL R243 ALUMINUM OXIDE

- Quality P-graded aluminum oxide abrasive grain delivers fast cut rate and consistent finish on metals
- Smooth, flexible J-weight cotton backing provides superior conformability to complex surfaces and better finishes
- Advanced full resin bond system provides exceptional grain adhesion for longer life on aluminum, fiberglass, composites, hard woods and soft woods



COATED & NON-WOVEN ABRASIVES Cloth Rolls and Sheets



Good choice for sanding softer materials where loading is a major problem such as plastic, copper, brass, plaster, wood, and drywall

SCREEN-BAK Q421 SILICON CARBIDE

- · P-graded silicon carbide for excellent cutting and non-loading properties
- · Open weave screen for extreme resistance to loading when removing scale, rust and corrosion
- Open mesh design is waterproof and washable, allowing you to rinse and reuse

Cloth and Screen Rolls

	TIER: TRADENAME	GOOD Gemini K225	GOOD Gemini K225	GOOD Gemini K225	GOOD Gemini K225	GOOD Gemini K225
	110 12 210 10121		Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
	BACKING:		J-Weight Cotton	J-Weight Cotton	J-Weight Cotton	J-Weight Cotton
		1" x 10 yds	1" x 50 yds	1-1/2" x 50 yds	2" x 50 yds	0
CDIT		,	PART #	PART #	2 X 50 yus PART #	4" x 50 yds
GRIT 40	STD. PKG.	PART #	662610 58716 +	662610 58715 +	662610 58714 +	PART #
50	1		662611 27728 +	662611 27730 +	662611 27732 +	
60	1		662611 27729 +	662611 27731 +	662611 27733 +	
80	1	662611 34298	662611 26276	662611 26288	662611 26299	
	1					
100	1	662611 34299	662611 26275	662611 26287	662611 26298	00001407005*
120	1	662611 34300	662611 26274	662611 26286	662611 26297	662611 27285 *
150	1	662611 34301	662611 26273	662611 26285	662611 26296	
180	1	662611 34302	662611 26272	662611 26284	662611 26295	
220	1		662611 26271	662611 26283	662611 26294	
240	1	662611 34303	662611 26270	662611 26282	662611 26293	
280	1		662611 26269	662611 26281	662611 26292	
320	1	662611 34304	662611 26268	662611 26280	662611 26291	
400	1		662611 26267	662611 26279	662611 26290	
600	1		662611 26266	662611 26278	662611 26289	
10 6	arit are supplied in a	durable, but flavible V waight	aattan baaking			

+ 40 - 60 grit, are supplied in durable, but flexible X-weight cotton backing

* Packaging Standards: 4" Roll Std. Pkg.: 6 rolls

		a stat			*	()
	TIER:	GOOD	GOOD	GOOD	GOOD	GOOD
	TRADENAME:	METAL R243	METAL R243	METAL R243	SCREEN-BAK Q421	SCREEN-BAK Q421
	ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide	Silicon Carbide
	BACKING:	J-Weight Cotton	J-Weight Cotton	J-Weight Cotton	Mesh	Mesh
	SIZE:	1" x 50 yds	1-1/2" x 50 yds	2" x 50 yds	1-1/2" x 25 yds	2" x 25 yds
	OTHER:			· · ·	Waterproof	Waterproof
GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
60	1	662611 36178	662611 36190	662611 36203		
80	1	662611 36179	662611 36192	662611 36204	662611 07275 *	
100	1	662611 36180	662611 36194	662611 36205		
120	1	662611 36181	662611 36195	662611 36206	662611 07270 *	662611 49811 *
150	1	662611 36182	662611 36196	662611 36207		
180	1	662611 36186	662611 36199	662611 36208	662611 07265 *	
240	1	662611 36187	662611 36200	662611 36209		
320	1	662611 36188	662611 36201	662611 36210		
400	1	662611 36189	662611 36202	662611 36211		

* Packaging Standards: Screen-Bak Q421 Std. Pkg.: 10 rolls



COATED & NON-WOVEN ABRASIVES Cloth Rolls and Sheets

Cloth SI	neets	TIER: TRADENAME:	GOOD GEMINI K225	GOOD METAL R243		GOOD SCREEN-BAK Q421
		ABRASIVE:	Aluminum Oxide	Aluminum Oxide		Silicon Carbide
		BACKING:	J-Weight Cotton	J-Weight Cotton		Mesh
		OTHER:				Waterproof
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PKG./CASE	PART #
9 x 11	40	25/125	662610 58713 +			
	50	25/125	662611 01862 +			
	60	25/125	662611 01861 +			
	80	25/125	662611 26340	662611 79998	25/125	662611 00960
	100	50/250	662611 26339	662611 81503	25/125	662611 00955
	120	50/250	662611 26338	662611 81504	25/125	662611 00950
	150	50/250	662611 26337	662611 81505	25/125	662611 00945
	180	50/250	662611 26336	662611 80005	25/125	662611 00940
	220	50/250	662611 26335		25/125	662611 00935
	240	50/250	662611 26334	662611 81507		
	280	50/250	662611 26333			
	320	50/250	662611 26332	662611 80006	25/125	662611 00920
	400	50/250	662611 26331	662611 81509	25/125	662611 00915
	600	50/250	662611 26330			
	Coarse	25/125				
	Medium	50/250				
	Fine	50/250				

 Fine
 50/250

 + 40 - 60 grit are supplied in durable, but flexible X-weight cotton backing





Paper sheets and rolls are engineered for optimum performance when sanding metal, wood, composites and painted surfaces. The sheets are packed in protective packaging to eliminate waste and permit easy, neat storage.

Categories: Applications:

Size Range: Grit Range: Abrasive Grain: Paper Weights: Machine Used: All purpose, wood sanding, stearated (non-loading), waterproof, and heavyweight Light-duty metal sanding, primer sanding, defect removal from painted surfaces, filler sanding, sanding and finishing of composites and fiberglass, bare wood sanding, sanding between sealer coats

Full Sheets, Cut Sheets, File Strips and Rolls 36 – 2500

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide, and Garnet Heavyweight – E; Lightweight – A through D

HAND JITTERBUG SANDING SANDER



SANDING SAND

SANDING BOARD

Material-to-Product Recommendation Guide

	BEST						BETTER		GOOD			
	Blaze A995	Dry Ice A975	A2750P	Black Ice T214	Black Ice T401	A259PS	Durite A475	Blue-Bak T414	Gold Reserve A296	Garnet	TufBak T461	Other
Unfinished Metal	•	•	•						•			
Primed / Painted Surfaces / Between Coats	•	•	•				•		•			
Fiberglass / Composites	•	•	•				•		•			
Bare Wood	•	•	♦							◆ A511, A513, A514		
Clear Coat Sanding				•	•						•	
Sealer Sanding	•	•	•				•		•			
Lacquer Sanding				•	•			•			•	
Wet Sanding				•	•			•			•	
Paint Stripping	•	•	•			•	•					
All Purpose	•	•	•			•						A212 A213 A211

Cross Reference Guide

NORTON	3M	Hermes	Klingspor	Mirka	SIA	VSM
STEARATED (NON-LOAD	DING)					
Blaze A995	732U, 737U, 755L, 775L	CR116			_	
Dry Ice A975	334U	_	PS36	_	Siaprime 5550	_
A2750P	216U, 255L, 236U, 260L, 334U	VC154-LL	PS33, PS73W	Q-Silver, Royal Micro	1940, 1944,1950	
A259PS	216U, 255L, 236U, 260L, 334U		_	_		
Durite A475	405N, 414N, 415U, 426U, 435U	SF168	PL35, PS14	CaratFlex, PolarStar	1748	CP131A
Gold Reserve A296	216U, 236U, 316U, 315U, NX	VC154-LL	PS33, PS73W	Q-Silver, Royal Micro, Bulldog Gold	19,401,950	MP10
WATERPROOF						
Blue Ice T214	213Q	WAFlex28	_	_	1913, 1951, 1600	
Blue Ice T401	401Q, 414Q, 486Q	WSFlex16	PL35	Waterproof (A)	_	CP918A
Blue-Bak T414	413Q	WSFlex 16	PS14	Waterproof (A)		CP918A/C
TufBak T461	431Q	WSFlex 18	PS14		1727	CP918A/C
ALL PURPOSE/WOOD						
A211	230U, 240N, 346U	_	_	_	_	
A212	210N	_	PL31	_	_	
A213	230N		PL31			
Garnet A511	110N		PS10		1400	
Garnet A513	130N	GCAB				
Garnet A514	140N	GCAB		_		_
HEAVYWEIGHT PAPER						
BlueFire H875P	740I, 745I, 750U, 751U, 751I	BW110	PS36	Royal CRS. Cut	1820,1919, 1948	KP510E, KP709



EINER (EINIQUINO)

Application/Grit Recommendation Guide

COARSER (STOCK REMOVAL

	SER (STOCK	REMO	VAL)															FINE	R (FIN	SHIN
36 Rough	40 hing to Ir	60 ntermedia	80 ate	100	120	150	180	220	240	280	320	360	400	500	600	800	1000	1200	1500	2000	2500
			Interm	ediate to	Finishi	ומ															
									Fine Fi	nishing											
																Ultra F	ine Finis	hing			
Rec	omr	mone																			
		nenc	led I		Ŭ	Weię		F.	WT.	D.	.w/T	ſ	`-W/T		3-W/T		_\//T				
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Paper Rolls



Best choice for fast cut rate and maximum dust extraction

BLAZE A995 MULTI-AIR CYCLONIC CERAMIC ALUMINA

- P-graded next-generation ceramic aluminum oxide abrasive for fastest cut rate and longest life with innovative spiral hole design to optimize dust extraction
- Proprietary D-weight Polyester-reinforced, flexible latex-saturated backing for 100% improvement in tear strength and edge durability providing longer life in all applications
- Waterbased, non-loading (No-Fil) stearate resists clogging and increases roll life; hook and loop back for easy
 mounting and changing



Best choice for the most demanding dry sanding applications

DRYICE A975 CERAMIC ALUMINA

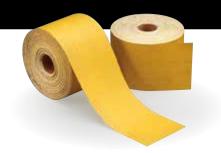
- P-graded, 100% SG ceramic alumina abrasive delivers fastest cut rate and longest life of any paper roll; available in Multi-Air Cyclonic version with laser-cut, spiral, vacuum-hole design to maximizes dust extraction
- Unique fiber reinforced, flexible B-or C- Weight latex saturated paper backing for 50% 60% improvement in tear strength while retaining flexibility; perforated for easy sizing
- · Water-based non-pigmented stearate No-Fil coating provides improved load resistance and no color transfer to work



Better choice for high performance dry sanding applications

A2750P ALUMINUM OXIDE

- Premium P-graded, heat treated, toughened aluminum oxide abrasive delivers superior life, fast cut rate, consistent finish
- Unique fiber reinforced, flexible B-weight latex saturated backing provides 50% 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating provides maximum load resistance; available in Multi-Air Cyclonic version for maximum dust collection



Good choice and value for dry sanding and finishing aluminum, fiberglass, composites, hard woods and soft woods

GOLD RESERVE A296 ALUMINUM OXIDE

- · P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent surface finish
- · Strong C-weight paper backing resists tearing while staying conformable and flexible
- · Water-based, non-loading No-Fil stearate coating minimizes clogging and increases disc life



Paper Rolls continued

Hook and Loop Paper Rolls Multi-Air Cyclonic					
TIER:	BEST	BEST	BEST	BEST	BETTER
TRADENAME:	BLAZE A995 NO-FIL Multi-Air Cyclonic	BLAZE A995 NO-FIL Multi-Air Cyclonic	DRY ICE A975 NO-FIL Multi-Air Cyclonic	DRY ICE A975 NO-FIL Multi-Air Cyclonic	A2750P NO-FIL Multi-Air Cyclonic
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide
BACKING WEIGHT:	D-Weight.	D-Weight.	C- & B-Weight	C- & B-Weight	B-Weight
BACKING ATTACHMENT:	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop
OTHER:	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated
SIZE:	2-3/4" x 13 yd	2-3/4" x 9 yd	2-3/4" x 13 yd	4-1/2" x 13 yd	2-3/4" x 13 yd
GRIT PKG./CASE	PART #	PART #	PART #	PART #	PART #
40 1/4		699573 65500			
80 1/4	699573 08899		636425 06113	662611 56064	666233 90523
120 1/4	699573 08900		636425 06114	662611 56065	666233 90522
150 1/4	699573 08901		636425 06117		666233 90521
180 1/4	699573 08902		636425 06118	662611 56067	666233 90520
220 1/4	699573 08903		636425 06119	636425 04663	666233 90519
240 1/4			636425 06120	662611 56068	
320 1/4			636425 06121	662611 56070	666233 90518
400 1/4			636425 06122	662611 56071	666233 90517
500 1/4			636425 06123		
600 1/4			636425 06124		

2-3/4" wide hook and loop paper rolls are perforated at 2-3/4" and 4-1/2" wide rolls are perforated every 4-1/2" which allow use on all standard lengths of hand blocks and file boards. Additional grit sizes available, contact your Norton rep for more details.

Hook and Loop Paper Rolls



TIER: BEST TRADENAME: DRY ICE A975 NO-FIL ABRASIVE: Ceramic Alumina BACKING WEIGHT: C- & B-Weight BACKING ATTACHMENT: Hook & Loop

	DAGNING WLIGHT.	C- a D-weigin
BACK	ING ATTACHMENT:	Hook & Loop
	OTHER:	P-Graded; Perforated
	SIZE:	2-3/4" x 13 yd
GRIT	PKG./CASE	PART #
80	1/4	636425 06261
120	1/4	636425 06259
150	1/4	636425 06258 NS
180	1/4	636425 06257
220	1/4	636425 06256
320	1/4	636425 06255
400	1/4	666233 29518
500	1/4	666233 29547
600	1/4	666233 29548

2-3/4" wide hook and loop paper rolls are perforated every 2-3/4" which allows use on all standard lengths of hand blocks and file boards.

Additional grit sizes available, contact your Norton rep for more details.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.



Paper Rolls continued

Sens Adhe	(Pressure sitive esive) er Rolls				6	0	0	0	6
	TIER:	BEST	BEST	BEST	BETTER	BETTER	BETTER	BETTER	GOOD
	TRADENAME:	DRY ICE A975 No-Fil	DRY ICE A975 No-Fil	DRY ICE A975 No-Fil	A275 OP No-Fil	A275 OP No-Fil	A275 OP No-Fil	A275 OP No-Fil	GOLD RESERVE A296 NO-FIL
	ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide				
	BACKING WEIGHT:	C-Weight.	C-Weight.	B-Weight.	B-Weight.	B-Weight.	B-Weight.	B-Weight.	C-Weight
BACI	KING ATTACHMENT:	PSA	PSA	PSA	PSA	PSA	PSA	PSA	PSA
	OTHER:	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded
	SIZE:	2-3/4" x 25 yd	2-3/4" x 30 yd	2-3/4" x 45 yd	2-3/4" x 25 yd	2-3/4" x 30 yd	2-3/4" x 45 yd	4-1/2 x 10 yd	2-3/4" x 25 yd
GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #
80	1/5	662611 49566			662611 31691			662611 31697	636425 06153
100	1/5					662611 31690		662611 31696	
120	1/5		662611 49564			662611 31689		662611 31695	636425 06152
150	1/5			662611 49563			662611 31688	662611 31694	636425 06151
180	1/5			662611 49562			662611 31687	662611 31693	636425 06150
220	1/5			662611 49561			662611 31686	662611 31692	636425 06149
240	1/5						662611 31685		
320	1/5			662611 49558			662611 31683		636425 06148
400	1/5			662611 49557			662611 31681		636425 06147
600	1/5						662611 31679		

Additional attachment options available as non-stock, contact your Norton rep for more details.

Roll Accessories



PSA Roll Dispenser

- · Heavy-duty wire dispenser has a vinyl coating to protect the work surface
- · Accommodates two 2-3/4" PSA rolls; stackable for multi-grit operations. Attach to wall or mount on cabinet

DESCRIPTION	STD. PKG.	PART #
PSA Roll Dispenser	1	636425 42773

PSA/Hook & Loop Sanding Blocks

- Ergonomically-shaped flexible foam blocks used with 2-3/4" rolls, fit comfortably in your hand
- Firm block produces a truly flat surface
- The soft block is designed for flat surfaces and contours

	BACK	ING ATTACHMEN	T: PSA	Hook & Loop
SIZE	DESCRIPTION	STD. PKG.	PART #	PART #
2-3/4 x 5	Soft	5	636425 42090	636425 42092
2-3/4 x 5	Firm	5	636425 42091	636425 42093
2-3/4 x 7-3/4	Soft	5		636425 42095
2-3/4 x 7-3/4	Firm	5	636425 42094	



Paper File Strips

Better choice for soft material applications

BLUEFIRE H875P ZIRCONIA ALUMINA

- · Strong zirconia alumina plus abrasive provides 2 3 times life over aluminum oxide products
- Strong E-weight paper, synthetically-coated for excellent durability and chip resistance plus superior bond system
 optimizes grain adhesion and extends product life
- Non-stearated (no anti-loading agents); non-contamination often required for prime auto and aerospace paint applications

Paper File Strips PSA (Pressure Sensitive Adhesive) and Non-PSA

Sensitive	Adh	esive)										Constant and
and Non-	PSA			Nines.				225				
		TIER:	BETTER	BETTER	BETTER	BETTER	i i	BETTER	BETTER		BETTER	GOOD
	TRA	DENAME:	A2750P No-Fil	A2750P No-Fil	A2750P No-Fil	A2750P No-Fil		BLUEFIRE H875P NO-FIL	BLUEFIRE H875P NO-FIL		BLUEFIRE H875P NO-FIL	GOLD RESERVE A296 NO-FIL
		ABRASIVE:		A/0	A/0	A/0	_	Z/A	Z/A		Z/A	A/0
			B-Weight	B-Weight	B-Weight	B-Weight	_	E-Weight	E-Weight	_	E-Weight	C-Weight
BACKII	VG ATTA	ACHMENT:		PSA	Hook/Loop	Hook/Loop Vac		Non-PSA	PSA		Hook/Loop	Hook/Loop
			P-Graded	P-Graded	P-Graded	P-Graded						
SIZE (W x L)	GRIT	PKG./ Case	PART #	PART #	PART #	PART #	PKG./ Case	PART #	PART #	PKG./ Case	PART #	
2-3/4 x 16	100	50/500				662611 31657						
	120	50/500				662611 31656						
	180	50/500				662611 31654						
2-3/4 x 16-1/2	36						50/250		662611 23610	25/125	662611 23616	
	40						50/250		662611 23609	-1 -	662611 23615	
	80	50/500		662611 31640	662611 31646		50/250		662611 23608	25/125	662611 23614	636425 06237 *
	100	50/500		662611 31639	662611 31645							636425 06238 *
	120	50/500			662611 31644							636425 06239 *
	150	50/500		662611 31637	662611 31643							636425 06240 *
	180	50/500		662611 31636	662611 31642							636425 06241 *
	220	50/500			662611 31641							636425 06242 *
2-3/4 x 17-1/2								662611 23622				
	40							662611 23621				
	80	50/500	662611 31652					662611 23620				
	100	50/500	662611 31651				50/250	662611 26512				
	120	50/500	662611 31650									
	150	50/500	662611 31649									
	180	50/500	662611 31648				50/250	662611 26511				
	220	50/500	662611 31647									
0 0 0 0	0 0	0 0 0										
0000	0 0	0 0 0	2-3/4 X 16 FILE	STRIPS								

2-3/4 X 16 FILE STI * 25/125

Sanding Boards







PSA/Non-PSA Sanding Board

- This sanding board has a cushioned surface
- Spring clips mounted at each end securely hold 2-3/4" x 16-1/2" PSA file strips and 2-3/4" x 17-1/2" non-PSA file strips

Hook and Loop and Non-PSA Sanding Board

- Lightweight, rugged design for easy sanding of plastic fillers
- Spring clips mounted at each end securely hold 2-3/4" x 16-1/2" hook and loop file strips and 2-3/4" x 17-1/2" non-PSA file strips
- · Air file shoe eliminates the need for clips. The quick-change backing positively locks and unlocks for fast use.

DESCRIPTION	STD. PKG.	PART #
PSA/Non-PSA File Strip Sanding Board	6	636425 42724
Hook and Loop/Non-PSA File Strip Sanding Board	5	636425 52836
Hook and Loop Air File Shoe	5	636425 52835



Stearated (Non-Loading) 9" x 11" Sheets



Best choice for moderate material removal

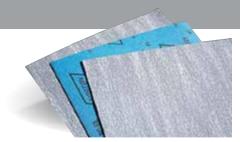
A259PS NO-FIL ALUMINUM OXIDE

- Premium heat-treated abrasive offers faster cut and long sanding life
- Open coat, non-pigmented, water-based stearate coating prevents color transfer and minimzes loading
- Increased backing weight, fiber-reinforcement and latex saturation offers better grain retention and tear-resistance yet is highly flexible for easy folding and unfolding

The better choice for sanding painted surfaces, composites, plastics or any material that tends to load

A2750P NO-FIL ALUMINUM OXIDE

- Premium, P-graded, heat-treated aluminum oxide abrasive for consistent surface finish, exceptional performance on all surfaces and coatings
- Unique fiber-reinforced, B-weight latex-saturated backing for 50 60 percent improvement in tear strength, exceptional flexibility, can be folded without cracking
- Non-pigmented, water based stearate (anti-clog) coating, open coat for best resistance to clogging and loading during sanding



The better choice for gel coats, hard composite substrates, abrasion-resistant coatings, and woodworking applications

DURITE A475 NO-FIL SILICON CARBIDE

- · P-graded, silicon carbide abrasive for easy penetration of the hardest surfaces
- Water based stearate, non-pigmented, No-Fil coating resists loading for the longest usable product life; no color transfer to work
- · Fiber-reinforced, latex paper backing provides flexibility and resistance to tearing



Good choice for finishing painted surfaces, composites, plastics, or any material that tends to load

GOLD RESERVE A296 NO-FIL ALUMINUM OXIDE

- · P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent scratch pattern
- · Water-based, non-loading (No-Fil) stearate resists clogging and increases life
- · Strong C-weight latex/paper backing resists tearing while staying conformable and flexible



Stearated (Non-Loading) 9" x 11" Sheets continued

9 x 11 Paper	Shee		JOBPACK			11
		TIER:	BEST	BETTER	BETTER	GOOD
	TI	RADENAME:	A259PS No-Fil	A2750P No-Fil	DURITE A475 No-Fil	GOLD RESERVE A296 No-Fil
		ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
	BACKI		C- & B-Weight	B-Weight	B-Weight	C-Weight
		OTHER:	P-Graded	P-Graded	P-Graded	P-Graded
SIZE (W x L)		PKG./				
	GRIT	CASE	PART #	PART #	PART #	PART #
9 x 11	80	50/250	076607 68174 *	662611 31634	662544 87393	636425 97878
	100	100/500	076607 68173 *	662611 31633	662544 87394	636425 97877
	120	100/500	076607 68172 *	662611 31632	662544 87395	636425 97876
	150	100/500	076607 68171 *	662611 31631	662544 87396	636425 97875
	180	100/500	076607 68168 *	662611 31630	662544 87397	636425 97874
	220	100/500	076607 68167 *	662611 31629	662544 87398	636425 97873
	240	100/500		662611 31628	662544 87399	636425 97872
	280	100/500		662611 31627		
	320	100/500	076607 68166 *	662611 31626	662544 87400	636425 97871
	400	100/500	076607 68165 *	662611 31624		636425 97870
	500	100/500		662611 31623		
	600	100/500		662611 31622		
	800	100/500		662611 31621		
	1000	100/500		662611 31620		
	1200	100/500		662611 31619		
	1500	100/500		662611 31618		

* Packaging Standards: A259PS Job Packs: 20 sheets per pack / 10 packs per standard package for a total of 200 sheets

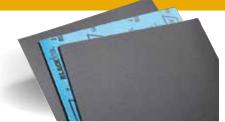
Rubber Hand Sanding Blocks

• Resilient rubber blocks that conform well to mild contours and flat surfaces

DESCRIPTION 2-3/4 x 5	STD. PKG. 5	PART # 076607 01889
3	Self-	
-	(A)	



Waterproof 9" x 11" Sheets



Best choice for superior cut and life in wet applications

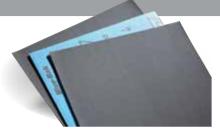
BLACK ICE T214 ALUMINUM OXIDE WATERPROOF

- Premium, P-graded, heat-treated aluminum oxide abrasive for ultimate cut and life in wet applications
- · Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling

Best choice for superior finish in wet applications

BLACK ICE T401 SILICON CARBIDE WATERPROOF

- Premium, JIS graded ultra-fine silicon carbide abrasive provides the ultimate finish in wet applications
- · Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling



Better choice for wet finishing applications

BLUE-BAK T414 SILICON CARBIDE

- · Sharp, ANSI graded silicon carbide abrasive for exceptional finishes in wet applications
- · Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling



Good choice for medium material removal in wet applications

TUFBAK T461 SILICON CARBIDE

- · ANSI graded silicon carbide abrasive for fast cutting with excellent finish in wet applications
- · Advanced resin bond system for excellent flexibility and abrasive adhesion
- Strong, waterproof C-weight backing is ideal for more aggressive applications while being environmentally stable, resists product curl in humidity



Waterproof 9" x 11" Sheets continued

9 x 11 Paper Sh	eets	7/50		T	M	I
		TIER: TRADENAME:	BEST BLACK ICE T214	BEST Black ice t401	BETTER BLUE-BAK T414	GOOD Tufbak T461
		ABRASIVE:	Aluminum Oxide	Silicon Carbide	Silicon Carbide	Silicon Carbide
		BACKING WEIGHT:		B-Weight	B-Weight	C-Weight
			P-Graded	JIS Graded	ANSI Graded	ANSI Graded
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #
9 x 11	60	50/250	FANI #	rani #		662611 01175
0.711	80	50/250				66261101170
	100	50/250				662611 01165
	120	50/250				662611 01160
	150	50/250				662611 01155
	180	50/250				662611 01150
	220	50/250	662611 39389		662611 39367	
	240	50/250	662611 39388		662611 39366	662611 30331
	280	50/250			662611 39365	
	320	50/250	662611 39386		662611 39364	662611 30332
	360	50/250			662611 39363	
	400	50/250	662611 39385		662611 39362	662611 30333
	500	50/250	662611 39384		662611 39361	
	600	50/250	662611 39383		662611 39360	662611 30334
	800	50/250	662611 39382			
	1000	50/250		662611 39381		
	1200	50/250		662611 39380		
	1500	50/250		662611 39379		
	2000	50/250		662611 39378		
	2500	50/250		662611 39377		

Waterproof Sanding Blocks - with "Grabbing" Power



Dual Density Wet Sanding Block

- No adhesive required: simply wrap a 5-1/2" x 9" (9" x 11" cut in half) sheet around the block
- The dense side is for more aggressive blocking, while the soft side is for color sanding
- Equalizes sanding pressure for fine grit applications

Holey Block

- No adhesive required: simply wrap a 5-1/2" x 9" (9" x 11" cut in half) sheet around the block
- A rugged, semi-rigid, multi-purpose sanding block engineered for flat to medium curved surfaces
- A tactical hole pattern side provides numerous cutting edges to create a 30% faster cut rate
- The plain side provides firmness and a comfortable, easy-to-hold surface

DESCRIPTION	STD. PKG.	PART #
Wet Sanding Block	12	636425 03728
Holey Block	8	636425 03729



All-Purpose 9" x 11" Paper Sheets



Good choice for your wood, metal or composite sanding projects

A211/A212/A213 ALUMINUM OXIDE

- P-graded, aluminum oxide grain, open-coat provides aggressive, long-lasting cutting action
- Use for dry, general purpose hand sanding on hardwood, metal, and composites
- Available in multiple backing weights: A212 A-weight; A213 C-weight, A211 D-weight

Good choice for use on soft woods such as pine



A513/A511 GARNET

- · Natural garnet abrasive is ideal for soft woods, such as pine, and produces an excellent, consistent finish
- · Use dry on bare wood prior to coating
- Available in two backing weights: A511 A-wt. and A513 C-wt. for heavy-duty to light-duty hand sanding

9 x 11 Paper		ets	11	11	11	JOBPACK	11	11	JOBPACK
		TIER:	GOOD	GOOD	GOOD	GOOD	GOOD	GOOD	GOOD
		RADENAME: ABRASIVE: ING WEIGHT:	A211 Aluminum Oxide D-Weight	A213 Aluminum Oxide C-Weight	A212 Aluminum Oxide A-Weight	MULTISAND A213/A212 Aluminum Oxide D-, C- & A-Weight	A513 Garnet D- & C-Weight	A511 Garnet A-Weight	WOODSAND A513/A511 Garnet D-, C- & A-Weight
		OTHER:	P-Graded	P-Graded	P-Graded	P-Graded		0	, 0
SIZE (W x L) 9 x 11	GRIT 36 40	PKG./CASE 25/125 25/125	662611 00335 662611 00330	PART #	PART #	PART #	PART #	PART #	PART #
	50 60	50/250 50/250	662611 00325	662611 00320			662611 01560		
	80	50/250		662611 00315			662611 01555	662611 01505	076607 01584 *
	100	100/500		662611 00295		076607 00358 *	662611 01535	662611 01500	076607 01583 *
	120	100/500		662611 00290		076607 00357 *	662611 01530	662611 01495	076607 01582 *
	150	100/500		662611 00285		076607 00356 *	662611 01525	662611 01490	076607 01581 *
	180	100/500			662611 00245	076607 00355 *		662611 01489	076607 01580 *
	220	100/500			076607 00156	076607 00354 *		662611 01488	076607 01579 *
* D /	Asst+	100/500		1 / 10		076607 00365 *			

* Packaging Standards: Job Packs: 25 sheets per pack / 10 packs per standard package for a total of 250 sheets + Assorted contains 6 each of 60, 100, 150 grit and 7 each of 220 grit

3-2/3 x 9 Paper Cut Sheets

Paper Cu	ut She	eets		
		TIER:	GOOD	GOOD
		TRADENAME:	GOLD RESERVE A296 NO-FIL	A213
		ABRASIVE:	Aluminum Oxide	Aluminum Oxide
		BACKING WEIGHT:	C-Weight	C-Weight
		OTHER:	P-Graded	P-Graded
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #
3-2/3 x 9	60	100/1000		662611 02925
	80	100/1000	780727 48788	662611 02920
	100	100/1000		662611 02900
	180	100/1000	780727 48540	
	220	100/1000	780727 48789	



COATED & NON-WOVEN ABRASIVES Film Sheets

Hook and Loop Cut Sheets - Perforated

Best choice for easy sanding of hard-to-reach areas

NORTON SUPERFLEXIBLE FILM

- Durable yet flexible film backing conforms better to surfaces and contours, preventing "over sanding" or "burn through"
- · Anti-loading stearate for optimum performance and long life
- Consistent scratch pattern and even finish



Norton Sanding Pads for SuperFlexible Film

The pads are made using very soft foam, specifically for hook and loop sheets and discs. The sanding pad's structure minimizes aggressive scratches and reduces peeling, reducing the need to change the backing pad frequently.

Soft Sanding Pads

6-11/16 x 5-1/8

P1500

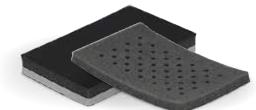
P1200

P800

P600

P400

PART #	APPLICATION	PKG/CS QTY
Soft Sanding Pad		
780727 42353	Manual sanding of hard-to-reach areas	8/1



Rigid/Soft Sanding Pads

PART #	APPLICATION	PKG/CS QTY					
Rigid/Soft Sandin	Rigid/Soft Sanding Pad						
780727 42355	Manual sanding of larger areas	4/1					









-

Surface finishing rolls are made of a non-woven nylon web impregnated with abrasive grain and resin bond.

Applications:

Abrasive Grain: Grit Range: **Roll Features:**

Light- to heavy-duty cleaning, deburring, blending, polishing, and finishing of metal, wood,

composite, plastics, stone, solid surface and painted surfaces.

Aluminum Oxide, Silicon Carbide

- Medium (M), Fine (F), Very Fine (VF), Ultra Fine (UF), Micro Fine (MF)
- · Economical alternative to cut pads · Can be cut to specific sizes

Machine Used:



SANDING SANDER

Application/Grit Recommendation Guide

MORE AGGRESSIVE, ROUGHER FINISH

LESS AGGRESSIVE, FINER FINISH

PRODUCT #:	#740	#644	#747	#635	#851	#777	HIGH STRENGTH
COLOR	Dark Tan	Maroon	Maroon	Gray	Gray	Maroon	Maroon
DESCRIPTION:	Heavy Duty	GP – Fine	GP Plus – Very Fine	Clean & Finish	General Cleaning	General Purpose	High Strength
	AO	AO	AO	SC	SC	AO	AO
GRIT SIZE:	Medium	Fine	Very Fine	Ultra Fine	Very Fine	Very Fine	Medium
	100 - 150	180 - 220	240 - 360	400 - 600	240 - 360	240 - 360	100 - 150
STEEL WOOL	4	2	1	00	00	1	4
EQUIVALENT:	Extra Coarse	Medium Coarse	Medium	Very Fine	Very Fine	Medium	Extra Coarse
	Smear-free Clean Bond technology	 Cleaning and deburring 	 Light cleaning, deburring and finishing 	 Light cleaning and finishing of most surfaces 	 Light cleaning and finishing of most surfaces 	 Light cleaning, deburring and finishing 	 Moderate deburring and surface blending
APPLICATIONS:	 2X life Most durable and aggressive cutting pad Heavy-duty removal rust oxidation 	 machinery metal parts plastic solid surface stone 	» machinery » metal parts » plastic » solid surface » stone	» steel, aluminum » denibbing plastic » scuffing acrylics	» steel, aluminum » denibbing plastic » scuffing acrylics	» machinery » metal parts » plastic » solid surface » stone	

						BEST	BETTER
617E (M 1)	COLOR	DECODIDITION	ADDACINE	GRIT SIZE	STD. PKG.	PART #	PART #
SIZE (W x L)		DESCRIPTION	ABRASIVE	312E	PKu.	FANI #	FANI#
Non-Woven Rolls							
4" x 30 Ft.	Maroon	High Strength Roll	A/0	М	3	662610 06358 NS	
	Dark Tan	740 Heavy-Duty Roll	A/0	М	3		662610 10081
	Maroon	644 General Purpose Fine Roll	A/0	F	4		662610 58364
	Maroon	High Strength Very Fine Roll	A/0	VF	4	662610 06373	
	Maroon	777 General Very Fine Roll	A/0	VF	4		662610 58361
	Maroon	747 General Purpose Plus Roll	A/0	VF	4		662610 51701
	Gray	851 General Cleaning Roll	S/C	VF	4		662610 58360
	Gray	635 Clean & Finish Roll	S/C	UF	5		662610 58357
6" x 30 Ft.	Maroon	High Strength Roll	A/0	М	2	662610 05182	
	Maroon	747 General Purpose Plus Roll	A/0	VF	3		662610 16430
	Maroon	High Strength Very Fine Roll	A/0	VF	3	662610 04281	
	Maroon	777 General Very Fine Roll	A/0	VF	3		662610 58376
	Gray	851 General Cleaning Roll	S/C	VF	3		662610 58377
2" x 15 Ft. Handy Roll Pack	Assorted	1 each A/O Fine, A/O VF, SC MF	-	-	1		662610 08108

NS Non-Stock, contact your Norton representative for current order quantities and lead times.



COATED & NON-WOVEN ABRASIVES Abrasive Sponges



Flexible, abrasive sanding sponges for a wide variety of curved, contoured or flat surface applications on wood, metal, paint, plastic, ceramics and drywall.

Applications: Benefits: Light stock removal, sanding sealer and wash-coats, touch-up or repair of primer, sanding contours and intricate shapes, and finishing

Can be used wet or dry

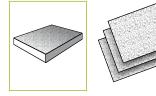
- - Clog resistant, washable, reusable
 - · Easy to use, can be folded without cracking
 - ConformableGenerate a consistent surface finish

Machine Used:



HAND SANDING

Why Choose Abrasive Sponges Versus Conventional Sheets?



Eliminate Clogging

- The combination of flexible foam backing material and abrasive grit adhesion continually releases sanded material
- · Any clogging can be washed out
- Pressure Control
- Foam backing allows optimum pressure distribution to prevent sanding through surfaces
- Pressure spots are eliminated providing even surface pattern

Adapt to Contours

- Flexible foam allows adaptability to contours, shapes or areas of limited access
- No folding or buckling results in an even pattern without scratching

FINER

FINER

Surface Finishing Chart – Contour Sponges versus Sheets

0	\sim	Λ		C	c	5
	U	А	n	0	ŗ	٦

SHEETS	P150	P180	P220	P280	P320	P400	P500	P600	P800	P1000	P1200	P1500	P2000
SPONGES	Medium 60												
			Fine 100										
					Extra Fine 1	50							
							Super Fine	180					
									Ultra Fine 2	20			
											Micro Fine	280/320	

Surface Finishing Chart – Sponges versus Sheets

COARSER

														
SHEETS	P80	P100	P120	P150	P180	P220	P280	P320	P400	P500	P600	P800	P1000	P1200
SPONGES	Extra Coars	se 36												
			Coarse 60											
					Medium 80) - 120								
							Fine 120 -	150						
									Very Fine 1	80 - 220				
													Micro Fine	280 - 320

Cross Reference Guide

	BETTER	GOOD	GOOD	GOOD	GOOD	GOOD
NORTON	SoftTouch	Contour	Small Area	Profile	Sealer Sanding	Flexible
3M	Softback	Contour	Full Size	High Flexibility	Woodworking	Pro Pads
Hermes	Single Side	-	Four Sided	-	Two Sided	-
Klingspor	_	-	-	-	Foam Sanding Pad	-
SIA	Flat Pad	-	Standard Block	-	Standard Pad	-



COATED & NON-WOVEN ABRASIVES Abrasive Sponges

For hand-sanding or finishing flat, curved, contoured and hard-to-reach areas on wood, metal, composites, paint and solid surfaces

SOFTTOUCH CONTOUR SPONGES - COATED 1 SIDE

4-

- Superior flexibility
- Premium foam substrate provides for an extremely smooth and uniform sanded surface

ZE (W x L x T) GRIT STD. PKG. PART #	
1/2 x 5-1/2 x 3/16 60 Medium 80 076607 030)74
100 Fine 80 076607 030)75
180 Super Fine 150 076607 030)76
220 Ultra Fine 80 076607 030)77
280 Micro Fine 80 076607 030)78



Good for sanding small diameters and contours

CONTOUR SPONGES - COATED 1 SIDE

 Thin, flexible; good for sanding small diameters and contours such as ceramics spindles, turnings and railings

	SIZE (W x L x T)	GRIT	STD. PKG.	PART #
s,	4-1/2 x 5-1/2 x 3/16	100 Fine	100	076607 02257
		150 Extra Fine	100	076607 02256
		220 Ultra Fine	100	076607 02255



Good for a wide variety of materials and sanding applications where moderate flexibility is needed

SMALL AREA GENERAL PURPOSE SPONGES – COATED 4 SIDES

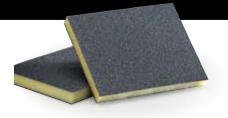
 Medium to firm density open cell polyurethane foam provides uniform support and moderately aggressive cutting action while generating a smooth surface

SIZE (W x L x T)	GRIT	STD. PKG.	PART #	BULK PKG.	PART #
4 x 2-3/4 x 1	36/80 Ex. Coarse/Med	24	076607 49505	250	076607 04735
	80/80 Med/Med	24	076607 49507	250	076607 01875
	80/120 Med/Fine	24	076607 49504	250	076607 02600
	120/120 Fine/Fine	24	076607 49506		



Good for corners and flat surfaces on wood, metal, plastic and paint

PROFILE SPONGES – CC)ATED 3 SID	ES		
 Ideal for cabinet sanding of raised profile doors 	SIZE (W x L x T)	GRIT 100 Modium	STD. PKG.	PART # 636425 36313
prome doors	4 x 2-3/4 x 1/2	100 Medium	500	6364



Good for sanding primers, sealers and between coats on furniture and cabinets

SEALER SANDING SPONGES – COATED 2 SIDES

 Very flexible; silicon carbide abrasive for sanding primers, sealers and between coats on furniture and cabinets

•	0.20 0.07	
	SIZE (W x L x T)	GRIT
	4-3/4 x 3-3/4 x 1/2	36 Extra Coars
		60 Coarse
		100 Medium

 GRIT
 BULK PKG.
 PART #

 36 Extra Coarse
 250
 63642502538

 60 Coarse
 250
 63642552870

 100 Medium
 250
 63642552869

 220 VeryFine
 250
 63642552869



Ideal for final sanding of surfaces, primer sanding, and between coats sanding

FLEXIBLE ABRASIVE SPONGES – COATED 1 SIDE

 Best initial price point for abrasive sponges

SIZE		STD.		BULK	
(W x L x T)	GRIT	PKG.	PART #	PKG.	PART #
3 x 4 x 1/2	60 Coarse	48	076607 04068	108	076607 01110
	80 Medium	48	076607 04067	108	076607 04070
	100 Medium	48	076607 04066	108	076607 00950
	150 Fine	48	076607 04065	108	076607 00949
	220 Very Fine			108	076607 04069



COATED & NON-WOVEN ABRASIVES Non-Woven Hand Pads and Sponges

Surface finishing hand pads are made of a non-woven nylon web impregnated with abrasive grain and resin bond. Applications: Light- to heavy-duty cleaning, deburring, blending, polishing, and finishing of metal, wood, composite, plastics, stone, solid surface and painted surfaces. Abrasive Grain: Aluminum Oxide, Silicon Carbide Grit Range: Medium (M), Fine (F), Very Fine (VF), Ultra Fine (UF), Micro Fine (MF), Non-Abrasive (-) Hand Pad Features: · Flexible; conform to work surface · Gentle action easily removes flashing or burrs without affecting dimension of workpiece • Non-loading; constant supply of new cutting edges • Non-rusting; no workpiece contamination · Resilient construction; long life, increased productivity; solvent resistant; waterproof **Sponge Pad Features:** • Non-woven material is laminated to a long-lasting sponge for the convenience of 2 pads in one Superior replacement for steel wool Machine Used: ITTERBUG ΗΑΝΓ SANDING

Application/Grit Recommendation Guide

MORE AGGRESSIVE, ROUGHER FINISH

LESS AGGRESSIVE, FINER FINISH

	all some							S			
PRODUCT #:	#740	#746	#644	#747	#796	#635	#748	THIN-FLEX VF	THIN-FLEX UF	THIN-FLEX BP	#456
COLOR:	Dark Tan	Gray	Maroon	Maroon	Green	Gray	Gray	Maroon	Gray	Gold	White
DESCRIPTION:	Heavy Duty	Blending	GP – Fine	GP Plus – Very Fine	Scouring	Clean & Finish	Final Shine	Cleaning	Cleaning	Blend Prep	Cleaning
ABRASIVE:	AO	SC	AO	AO	AO	SC	SC	AO	SC	AO	Non-Abrasive
GRIT SIZE:	Medium 100 - 150	Medium 100 - 150	Fine 180 - 220	Very Fine 240 - 360	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro Fine 800 - 1200	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro-Fine 800 - 1200	Non-Abrasive
STEEL WOOL EQUIVALENT:	4 Extra Coarse	3 Coarse	2 Medium Coarse	1 Medium	0 Fine	00 Very Fine	00 Very Fine	00 Very Fine	000 Extra Fine	000 Extra Fine	0000 Super Fine
APPLICATIONS:	 Smear-free Clean Bond technology 2X life Most durable and aggressive cutting pad Heavy-duty removal > rust > oxidation Deburring 	 Blending and deburring welds aluminum stainless 	 Cleaning and deburring machinery metal parts plastic solid surface stone 	 Light cleaning, deburring and finishing machinery machinery metal parts plastic solid surface stone 	 Removing stains, marks, rust, corrosion or oxidation from stainless equipment Light cleaning of metal surfaces 	 Light cleaning and finishing of most surfaces » steel, aluminum » denibbing plastic » scuffing acrylics 	 Final finishing » final rub on wood » final blend on metal » final finish on plastics and acrylics 	 Maximum flexibility for consistent finishes Cleaning blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	 Maximum flexibility for consistent finishes Cleaning blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	 Fine cleaning Fine polishing (most surfaces) Top coat finishing (water-based and solvent) 	 Scratch-free cleaning metal fiberglass stone solid surface ceramic Wood high- lighting rubbing

Cross Reference Guide

	COARSER										FINER
NORTON	#740	#746	#644	#747/847	#796	#635	#748	Thin-Flex VF	Thin Flex UF	#456	
3M	7440	7446	64659	7447/8447 Production Hand Pad	96	64660	7448	Multi-Flex Maroon	Multi-Flex Gray	7445	
Camel	Tan			Maroon	Green		Grey		_	White	
Mirka	—	—	—	Maroon/Red VF		—	_	Mirlon Total Maroon	Mirlon Total Gray	_	
Sait	Brown	_	_	Maroon	Green		Gray	_	_		
SIA	6912 Brown	6712 Grey	_	6912 Maroon	6312 Green	_	_		_	_	
Standard	HD-Tan AO	_	_	GP-Maroon VF	Green-AO	HP-VF	UF Gray	—		Cleanir White	ıg





COATED & NON-WOVEN ABRASIVES Non-Woven Hand Pads and Sponges

					TIER:	BEST	BETTER
SIZE (W x L)	COLOR	DESCRIPTION	ABRASIVE	GRIT SIZE	STD. PKG.	PART #	PART #
Hand Pads							
4-1/2 x 9	Maroon	Thin Flex Cleaning Pad	A/0	VF	25	666233 98062	
	Grey	Thin Flex Cleaning Pad	S/C	UF	25	666233 98063	
6 x 9	Dark Tan	740 Heavy-Duty Pad	A/0	Med	40	662610 74000	
	Gray	746 Blending Pad	S/C	Med	40		662610 74600
	Maroon	777 General Purpose Very Fine Pad	A/0	VF	60		662610 77700
	Maroon	747 General Purpose Plus Pad	A/0	VF	60	662610 74700	
	Maroon	847 General Purpose Plus Perforated Pad	A/0	VF	60	662610 84700	
	Green	796 Scouring Pad	A/0	VF	60		662610 79600
	Lt. Green	696 Food Pro Pad	A/0	VF	60		662610 69600
	Gray	851 General Cleaning Pad	S/C	VF	40		662610 85100
	Gray	635 Clean & Finish Pad	S/C	UF	60		662610 63500
	Gray	748 Final Shine Pad	S/C	MF	60		662610 74800
	White	456 Cleaning Pad	None	-	60		662610 45600
Hand Pad Holder							
3-1/4 x 5-1/2	N/A	Hand Pad Holder			10		662610 47583



Hand Pad Holder



THIN and FLEXIBLE: Perfect for Tight Spots

Norton Bear-Tex Thin-Flex High-Performance Hand Pads

- Achieve performance benefits of a coarse and fine grain product in one hand pad; fast cut and definitively better finish than competing pads
- Extremely thin and conformable; ideal for deburring, cleaning, blending, and finishing contoured surfaces and tight spaces
- · Special coated web design for superior and constant cutting action without added effort from user
- · Versatile; ideal for woodworking, metalworking, maintenance operations, and synthetics fabrication



COATED & NON-WOVEN ABRASIVES Foam Hand Pads

EINED

Rotolo Foam Sanding Pads

Application/Grit Recommendation Guide

COARSER

120	150	180	220	240	280	320	400	500	600	800	1000
Cleaning/F	Repairing										
			Final Sanding								
						Feather Edging	J				
								Basecoat Sar	nding		
										Clearcoat Sa	Inding



The better choice for fine sanding flat and curved surfaces

A2750P NO-FIL ROTOLO FOAM ROLLS

- Premium, P-graded, heat-treated aluminum oxide abrasive for consistent surface finish, exceptional performance on all surfaces and coatings
- Foam backing is perfect for hand sanding primer without leaving finger marks; 50% 60% improvement in tear strength versus conventional paper rolls; perforated for easy sizing
- Non-pigmented, water-based stearate No-Fil coating, open coat for best resistance to clogging and loading during sanding

		LIEK	BETTER
		TRADENAME	A2750P ROTOLO
		ABRASIVE	Aluminum Oxide
		OTHER	P-Graded
SIZE (W x L)	GRIT SIZE	ROLLS/STD. PKG.	PART #
4-1/2" x 82'	120	2	780727 35316
	150	2	780727 57584
	180	2	780727 57599
	220	2	780727 57600
	240	2	780727 57602
	320	2	666233 57606
	400	2	666233 57608
	500	2	666233 57611
	600	2	666233 57612
	800	2	666233 57613
	1000	2	666233 57616

DETTER



Perforated every 5-1/2"



COATED & NON-WOVEN ABRASIVES Flexible Diamond-Coated Hand Pads

Diamond coated hand pads: shaping, rapid stock removal, touch-up and repair on ceramics, stone, marble, glass, composites and hard materials; polishing of dies and molds Quadroflex diamond hand pads: surface conditioning, repairs, and removing flash and burrs



Norton flexible diamond coated hand pads combine the durability and aggressiveness of diamond, with a flexible backing.

Applications:

Size Range: Grit Range: Abrasive Types: Machine Used: on aircraft composites and windmill blades 3-1/2" x 2-1/8" 60 – 1500 Diamond





Better choice for shaping, rapid stock removal, surface conditioning, touch-up, repair, and polishing

FLEXIBLE DIAMOND-COATED HAND PADS – CONVENTIONAL AND QUADROFLEX CURVED

- Durable yet lightweight conformable backing is adaptable to a variety of shapes and conditions with long lasting
 performance; offers a uniform finish for improved surface quality
- Can be used wet or dry; color-coded by grit size for easy identification
- Conventional hand pads with precision dot pattern for an aggressive, consistent, fast cut rate and reduced dust and loading; Quadroflex curved hand pads offer ergonomic advantages and longest life for lowest overall total cost





			TIER	BETTER	BETTER
			TRADENAME:	DIAMOND COATED HAND PADS	QUADROFLEX CURVED DIAMOND COATED HAND PADS
			ABRASIVE:	Diamond	Diamond
SIZE (L x W)	COLOR	MESH	STD. PKG.	PART #	PART #
3-1/2 x 2-1/8	Green	60	1	662603 06360	690141 21517
	Black	120	1	662603 06361	690141 21518
	Red	200	1	662603 06362	690141 23529
	Yellow	400	1	662603 05852	690141 23530
	White	800	1	662603 06363	690141 23531
	Blue	1500	1	662603 06364	
	Kit (one each	of above)	1	662603 07720	

power... In the palm of Your hand

Portable Tools and the specialty abrasive products to go along with them. Access hard-to-reach areas with ease with the Norton line of specialty products.





PORTABLE TOOLS AND SPECIALTIES Mini Angle Sander

Put the world right in the palm of your hand with our 2" and 3" Norton Mini Angle Sanders. Small, compact enough to get into those hard-to-reach areas, and powerful enough to finish the job fast and efficiently.

Specifications for:	2" Mini Angle Air Sander	3" Mini Angle Air Sander
Weight of tool:	1.6 lbs. (0.742kg)	1.8 lbs. (0.816kg)
Compressed air:	6.2 bar (90psi)	6.2 bar (90psi)
Maximum permissible operating pressure:	6.2 bar (90psi)	6.2 bar (90psi)
Horsepower:	.45	.9
Free speed:	22,000 rpm	20,000 rpm
Air consumption @90psi:	85 liters/min (3 CFM)	116 liters/min (4.1 CFM)
Noise characteristic value in accordance with EN ISO 15744 (ISO 15744):		
A-weighted sound pressure level at workstation	87.3 dB	83.2 dB
 A-weighted sound pressure level 	98.3 dB	94.2 dB
 Peak C-weighted instantaneous sound pressure level at workstation 	<130 dB	<130 dB
Measurement uncertainty (Standard):	3.00 m/s ²	5.92 m/s ²
Vibration value according to EN ISO 28927-3:	0.84 m/s ²	1.09 m/s ²
Recommended lubrications:	Air oil 20#	Air oil 20#
Sanding tool specifications:	Pad Size 2" Collet	Pad size 3" Collet
Applications and suitability:	Collet Chuck 1/4" (6mm) Surface preparation, grind wel finishing applications.	Collet Chuck 1/4" (6mm) ds, spot sanding and light-duty



MINI ANGLE SANDERS

- A double-bearing spindle generates superb concentricity, reducing vibrations allowing for longer use and finer finishes
- · Finesse your projects by having the ultimate control in both precision and power with the speed regulator
- · Get better tool handling along with reduced fatigue with the ergonomic and streamlined non-slip grip

DESCRIPTION	STD. PKG.	PART #
Mini Angle Sanders and Kits		
2" Mini Angle Sander	1	662611 50076
2" Kit Includes:	1	662611 50077
• 1 – 2" Sander		
 25 – 2" 36 Grit Blaze R980P 3-Ply TR Discs (66261162318) 		
 50 – 2" Medium Grit Rapid Prep Non-Woven TR Discs (66261009190) 		
 1 – 2" Medium Density Back-Up Pad (66261055103) 		
3" Mini Angle Air Sander	1	699573 82154
3" Kit Includes:	1	699573 82155
• 1 – 3" Sander		
 25 – 3" 36 Grit Blaze R980P 3-Ply TR discs (66261162328) 	11 m	
 25 – 3" Medium Grit Rapid Prep Non-Woven TR discs (66261017522) 		
• 1 – 3" Medium Density Back-Up Pad (662610 55105)		

Industrial Market - Full-Line

PORTABLE TOOLS AND SPECIALTIES Mini Flap Discs

Mini-flap discs are ideal for use in tight spaces. They feature layered flaps which wear away evenly during use exposing new abrasive grain. The lightweight plastic backing helps to absorb vibration. They can help eliminate the conventional 2-step process in grinding edges and removing welds and rust.

Grinding, stock removal, edge chamfering/beveling, weld blending, deburring/deflashing,

Applications:

Size Range: **Grit Range: Abrasive Grain: Abrasive Flaps: Attachment: Machine Used:**

rust removal, blending, cleaning, and finishing in small areas or tight spots. 2" and 3" Quick-Change 36 - 120 Ceramic Alumina, Zirconia Alumina Polyester TR (Type III) and TS (Type II) Backing Plate Material: Extra Heavy-Duty Plastic





NDRTDN

SAINT-GOBAIN

Best choice for beveling, blending, deburring, and stock removal in tight spaces

BLAZE R980P CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain lasts 50% 200% longer than many flap discs on stainless steel, cobalt, chrome, Inconel, titanium and other hard-to-grind materials
- Flexible, high-strength, plastic backing plates absorb vibration for optimized ergonomics
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably faster cut rate

Better choice for blending, deburring, and stock removal in tight places

BLUEFIRE R860 ZIRCONIA ALUMINA

- High-performance zirconia alumina abrasive for aggressive cut and long life
- · Flexible, high-strength, plastic backing plates absorb vibration for optimized ergonomics
- · Polyester flaps for improved durability and minimal loading on aluminum



BEST	BETTER	BEST	BETTER
BLAZE R980P	BLUEFIRE R860	BLAZE R980P	BLUEFIRE R860
Ceramic Alumina	Zirconia Alumina	Ceramic Alumina	Zirconia Alumina
Polyester	Polyester	Polyester	Polyester
Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic
TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)
Ì	Ì	S	S
PART #	PART #	PART #	PART #
776960 90145	776960 90165		776960 90175
776960 90146	776960 90166		776960 90176
776960 90147	776960 90167	776960 90157	776960 90177
776960 90148	776960 90168	776960 90158	776960 90178
776960 90149	776960 90169	776960 90159	776960 90179
776960 90150	776960 90170	776960 90160	776960 90180
776960 90151	776960 90171	776960 90161	776960 90181
776960 90152	776960 90172	776960 90162	776960 90182
776960 90153	776960 90173	776960 90163	776960 90183
776960 90154	776960 90174	776960 90164	776960 90184
MAX. RPM	STD. PKG.	TR (TYPE III)	TS (TYPE II)
	MAX. RPM	MAX. RPM STD. PKG.	MAX. RPM STD. PKG. TR (TYPE III)

1





Industrial	Market -	Full-Line
IIIuusulai	iviainti -	I UII-LIII

2" and 3" Medium Density Back Up Pads

30,000

08834168539

08834164922





Tool-free, twist-on and -off fastening systems make fast work of disc changes to maximize productivity by minimizing downtime.

Applications:

Size Range: Grit Range: Abrasive Grain: Backing: Cloth Flex: Attachment: **Back-up Pads: Machine Used:**

Fiber and NorKut trimmable hard plastic discs: welding, grinding and blending; heavy metal removal; light deburring and finishing Cloth discs: light- to medium-pressure grinding; blending, leveling and finishing applications; for use on contours or flat surfaces Diamond: Grinding ceramic, glass, composites, carbide and ceramic coatings, fiberglass, and reinforced plastics 3/4" - 4" diameter 24 - 320 Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide, Diamond Fiber, cloth, or polymer 3-ply (more aggressive), 2-ply (standard), Type TS (II), Type TR (III), and Type TP (I) Rubber with hardness variations for different applications



MINI ANGLE SANDER

Coated Abrasive Quick-Change Disc Availability

Fiber

- The most heavy-duty discs with resin over resin construction on heavy-duty vulcanized fiber backing
- Premium grain for applications from heavy stock removal to surface blending

NorKut

- Unique polymer backing resists cracking and breakage and can be cut down up to the 1" core
- Use the cores to grind "pinch" welds and other hard-to-reach areas



Diamond

Unique, aggressive, diamond grain pattern on a flexible cloth backing

Cloth 3-Plv

These heavy-duty, 3-ply polyester laminate construction discs are the most aggressive and durable cloth discs on the market

Cloth 2-Ply

Our standard 2-ply laminate construction creates an aggressive and durable cloth disc for flat surfaces

Quick-Change Attachment Systems and Cross Reference Guide

Each system enables quick, safe disc changes, reducing downtime and operating expenses.

Type TS (Type II)

- · Features a turn-on/turn-off style fastener
- · Fastener is made of metal





- Type TR (Type III) · Features a roll-on/roll-off style fastener
- · Fastener is made of plastic



Type TP (Type I)

- Features a snap-on/snap-off style fastener
- · Fastener is made of nylon



NORTON	TS (Type II)	TR (Type III)	TP (Type I)	
3M	Roloc TS/TSM	Roloc TR	Roloc TP	
Standard	TS (SocAtt)	TR (Lockit)	TP (ClickOn)	
Superior	Type S	Type R	-	
Arc	Type S	Type R	Type P	
Pferd	Type CD	Type CDR	-	
Sait	SAIT-LOK	SAIT-LOK-R	-	
Camel	Turn On	Roll On	-	
Klingspor	QMC	QRC	-	
Garryson	Type S	Type R	-	







Material/Application-to-Product Recommendation Guide

	BEST	BETTER		GOOD	
	Blaze R980P	BlueFire R887D	BlueFire R860	Gemini R766	Merit R422
Stainless Steel / Titanium / Super Alloys	•	•		•	
Mild Carbon Steel / Welds			•	•	
Ferrous Metals / Cast Iron			•	•	
Brass / Bronze / Aluminum			•	•	
Paint / Glue / Adhesive				•	
Concrete / Stone / Fiberglass					•

Application/Grit Recommendation Guide

COARSER (GRINDING)

24	36	40	50	60	80	100	120	150	180	240	320
Heavy Stock R	emoval										
	Medium Stock	Removal									
	Edge Chamferi	ng/Beveling									
		Weld Removal									
			Heavy Deburri	ng							
				Blending							
					Light Deburrin	g					
							Cleaning				
									Finishing		

Cross Reference Guide

4

TOTAL PERFORMANCE

	BEST		BETTER	GOOD	
Abrasive	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide	Silicon Carbide
Backing	Fiber	Cloth	Cloth	Cloth	Cloth
-	BlazeX F970, Blaze F980	Blaze R980P	BlueFire R860, R887D	Gemini R766	Merit R422
3M	782C, 785C, 787C, 982C, 985C, 987C, 988C	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	561D	361F, 363F	421A, 441D, 461F
Standard	Ceramic, Ceramic Pro	Ceramic Pro, Ceramic	Zirconia	A/O Extra, A/O Pro	Silicon Carbide
Superior	—	Ceramic G.A.	Premium Zirc	A/O with Grinding Aid	
Arc			Zirconia/Y Standard	A/O/X Plus Coolant	
Pferd	CO, CO Cool	Ceramic	ZA Z	Aluminum Oxide A-Plus, Aluminum Oxide A-INOX-FORTE	Silicon Carbide SiC
Sait	7S,7A, 9S		Z	3A	C-W
Camel	Ceramic		Zirconia AO		_
Klingspor	CS570, FS966	CS610	Alumina Zirconia	_	CS333X
Garryson	—	Ceramic	_	_	



FINER (FINISHING)

INITIAL PRICE

->>





Best choice for stainless steel, titanium, and super alloys

BLAZEX F980 CERAMIC ALUMINA

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- · Strong fiber backing for strength and tear resistance
- · Supersized design for stainless steel and hard-to-grind materials

For tough applications and stainless steel

BLAZE F980 CERAMIC ALUMINA FIBER

- 100% ceramic grain constantly exposes sharper edges to deliver highest productivity at lowest overall costs vs. competitive lower-ratio ceramic discs
- Strong fiber backing, heavier and more rigid than conventional cloth discs, adds strength and tear resistance, and
 allows additional pressure for better results when grinding difficult materials
- Advanced self-lubricating grain treatment provides coolest cut and significantly faster cut rates; excels on hard-to-grind materials like 300 and 400 Series stainless and exotic alloys



Best choice for carbon steel and other soft-to-grind materials

BLAZEX F970 CERAMIC ALUMINA FIBER

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Heavier fiber backing for additional strength and tear resistance
- · Non-supersized design for carbon steel and soft-to-grind materials

		TIER:	BEST	BEST	BEST
		TRADENAME:		BLAZE F980	BLAZEX F970
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
		BACKING:	Fiber – Heavy Duty	Fiber – Heavy Duty	Fiber – Heavy Duty
		OTHER:	Supersize	Supersize	-
		ATTACHMENT:	TR (Type III)	TR (Type III)	TR (Type III)
			٩	Ì	Ì
SIZE (D)	GRIT	STD. PKG.		PART #	
2	24	25		776960 90139	
	36	25	662610 58704		780727 09008
	50	25		662610 58705	78072709009
	60	25		662610 58706	780727 09010
	80	25		662610 58707	780727 09011
3	24	25		776960 90140	
	36	25	662610 58708		780727 09012
	50	25		662610 58709	780727 09013
	60	25		662610 58711	780727 09014
	80	25		662610 58712	780727 09015

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.

TECH TIP

Use the new next generation Norton BlazeX F970 fiber quick-change discs for carbon steel jobs.





Best choice for tough applications, titanium, super alloys, and stainless steel (3-ply) or contoured surfaces (2-ply)

BLAZE R980P CERAMIC ALUMINA

- 100% ceramic grain constantly exposes sharper edges to deliver highest productivity at lowest overall costs vs. competitive lower-ratio ceramic discs
- · Improved resin bond system maximizes grain retention for longer product life
- Advanced self-lubricating grain treatment provides coolest cut with significantly faster cut rates while minimizing loading on hard-to-grind materials

Better choice for soft metals, wood, stainless steel, and carbon

BLUEFIRE R860 ZIRCONIA ALUMINA

- Premium, versatile, self-sharpening zirconia grain provides aggressive cut and up to 30% longer life versus competitive zirconia discs
- 2-ply polyester backing for improved durability and reducing loading on aluminum
- Durable Y-weight, polyester waterproof backing stands up to demanding applications: high-pressure and hard-to-grind exotic alloys



Better choice for stainless steel, titanium and other exotic alloys

BLUEFIRE R887D ZIRCONIA ALUMINA

- Self-sharpening, zirconia alumina abrasive with supersized grinding aid provides cooler cut, and longer life on hard-to-grind materials
- Durable, Y-weight, 2-ply polyester waterproof blend back stands up to these demanding applications
- Minimized heat build-up allows these discs to outlast conventional aluminum oxide and zirconia alumina discs in many applications

Good choice when initial price is the primary consideration

GEMINI R766 ALUMINUM OXIDE

- · Versatile aluminum oxide abrasive for aggressive cut and longer life than competitive aluminum oxide discs
- Durable Y-weight 2-ply polyester backing and coating for additional life and faster cut rate on moderately-demanding applications
- · Good choice when initial price is the primary purchasing consideration



Good choice for non-ferrous materials

MERIT R422 SILICON CARBIDE

- · Sharp, silicon carbide abrasive provides high initial cut and penetration to resist loading on soft metals
- Strong, X-weight, 2-ply cotton backing construction for extended durability and reduced edge wear
- · When completion time is important, sharp silicon carbide abrasive gets non-ferrous blending jobs done quickly



Ceramic Alumina Quick-Change Cloth Discs

			10 10 10 N	A	0	
			50 50 50 F	4 36 -	E	
		TIER:	BEST	BEST	BEST	BEST
		TRADENAME:	BLAZE R980P	BLAZE R980P	BLAZE R980P	BLAZE R980P
		ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
		BACKING:	Polyester 3-Ply Heavy-Duty	Polyester 3-Ply Heavy-Duty	Polyester 2-Ply Standard	Polyester 2-Ply Standard
		OTHER:	Supersize	Supersize	Supersize	Supersize
			TS (Type II)	TR (Type III)	TS (Type II)	TR (Type III)
		ATTACHMENT:				٢
SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #
1-1/2	36	100	662611 62307	662611 62308	636425 95401	
	50	100	662611 62309	662611 62310		
	60	100	662611 62311	662611 62312	636425 95447	636425 95468
	80	100	662611 62313	662611 62314	636425 95450	
	120	100	662610 43379	662610 43380	662610 43416	
2	36	25	662611 62317	662611 62318	636425 95452	636425 95470
	50	25	662611 62319	662611 62320	636425 95456	636425 95472
	60	25	662611 62321	662611 62322	636425 95458	636425 95476
	80	25	662611 62323	662611 62324	636425 95459	636425 95478
	100	25	662610 43382	662610 43383		662610 43419
	120	25	662610 43384	662610 43386	662610 43420	662610 43421
3	36	25	662611 62327	662611 62328	636425 95460	636425 95479
	50	25	662611 62329	662611 62330	636425 95462	636425 95480
	60	25	662611 62331	662611 62332	636425 95463	636425 95481
	80	25	662611 62333	662611 62334	636425 95464	636425 95493
	100	25	662610 43389	662610 43390		662610 43423
	120	25	662610 43391	662610 43392	662610 43424	662610 43425

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.



Quick-Change Test Kit "D"

- Part # 088341**65001**
- Includes 150 discs, assorted grits, in 1", 2", and 3" diameters and 3" back-up pads
- Primarily aluminum oxide cloth quick-change discs
- Several zirconia alumina and aluminum oxide FlexEdge discs are included





Zirconia Alumina Quick-Change Cloth Discs

		TIER:	BETTER	BETTER	BETTER	BETTER	BETTER
		TRADENAME:	BLUEFIRE R860	BLUEFIRE R860	BLUEFIRE R887D	BLUEFIRE R887D	BLUEFIRE R887D
		ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
		BACKING:	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard
		OTHER:			Supersize	Supersize	Supersize
		ATTACHMENT:	TS (Type II)	TR (Type III)	TS (Type II)	TR (Type III)	TP (Type I)
			\bigcirc	Ì	\bigcirc	I A A A A A A A A A A A A A A A A A A A	
ZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
	50	100				088341 67095 NS	088341 67011 NS
	60	100	662611 38608			088341 67096 NS	088341 67012 NS
	80	100	662611 38607			088341 67097	088341 67013 NS
	120	100				088341 67099	088341 67015 NS
1/2	36	100	662611 38624	662611 21041			
	50	100				088341 67102	088341 67018 NS
	60	100	662611 38621	662611 21043	088341 67061	088341 67103	088341 67019 NS
	80	100	662611 38620	662611 21044	088341 67062	088341 67104	
	120	100				088341 67106	
	24	100	662611 38638 *	662611 38672 *			
	36	100	662611 38637 *	662611 38671	088341 67065	088341 67107	088341 67023
	40	100	00001100001*	00001100020*	088341 67066	08834167108	00004403003
	50	100	662611 38635 *	662611 38670 *	088341 65583	08834167109	08834167025
	60	100	662611 38634 *	662611 21048 *	08834167068	088341 67110	08834167026
	80	100	662611 38633 *	662611 21049 *	08834167069	08834167111	08834167027
	120	100 50	00001100005*	00001100075*	088341 67071	088341 67113	088341 67029
	24 36	50	662611 38665 * 662611 38664 *	662611 38675 *	00024167070	00024167114	00004167000
	40	50	002011 38004	662611 38674 *	088341 67072 088341 67073	088341 67114	088341 67030
	40 50	50	662611 38662 *	662611 38673 *	08834167073	088341 67116	088341 67032
	50 60	50	662611 38661 *	662611 38673 *	08834167074	08834167116	08834167032
	80	50	662611 38660 *	662611 21053 ************************************	08834167076	08834167118	08834167033
	120	50	00201130000	00201121034	08834167078	08834167120	0003410/034
	36	50			08834167079	0003410/120	
	50	50	662611 38681 *		0003410/0/3		
	60	50	662611 37343 *				088341 67040 NS
	80	50	662611 37343		088341 67083 NS	all the second s	00034107040 113
	00	00	UULUII JUU/J				

* Standard Package = 25 discs

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

BlueFire R860

Proprietary new grain shape and chemistry for faster cutting and longer life on a wide range of materials.

CHESTING.



Aluminum Oxide Quick-Change Cloth Discs

			640	6	4 64 2
			40-00		
		TIER:	GOOD	GOOD	GOOD
		TRADENAME:		GEMINI R766	GEMINI R766
		ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		BACKING:	Polyester	Polyester	Polyester
			2-Ply Standard	2-Ply Standard	2-Ply Standard
		ATTACHMENT:	IS (Type II)	TR (Type III)	TP (Type I)
				Ì	
SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #
/4	40	100			699573 99739
, '	50	100	699573 99604		699573 99740
	60	100	699573 99605	699573 99673	699573 99741
	80	100	699573 99606	699573 99674	699573 99742
	36	100	699573 99614	699573 99682	699573 99750
	40	100			699573 99751
	50	100	699573 99616		699573 99752
	60	100	699573 99617	699573 99685	699573 99753
	80	100	699573 99618	699573 99686	699573 99754
	100	100	699573 99619	699573 99687	699573 99755
	120	100	699573 99620	699573 99688	699573 99756
	180	100	699573 99622	699573 99690	699573 99758
	240	100	699573 99623	699573 99691	699573 99759
-1/2	36	100	699573 99626	699573 99694	699573 99762
	40	100	699573 99627	699573 99695	699573 99763
	50	100	699573 99628	699573 99696	699573 99764
	60 80	100 100	699573 99629	699573 99697	699573 99765
	100	100	699573 99630 699573 99631	699573 99698 699573 99699	699573 99766
	120	100	699573 99632	699573 99700	699573 99768
	150	100	033013 33032	03307 3337 00	699573 99769
	180	100	699573 99634	699573 99702	699573 99770
	240	100	699573 99635	699573 99703	00001000110
2	24	100	699573 99637	699573 99705	699573 99773
	36	100	699573 99638	699573 99706	699573 99774
	40	100	699573 99639	699573 99707	699573 99775
	50	100	699573 99640	699573 99708	699573 99776
	60	100	699573 99641	699573 99709	699573 99777
	80	100	699573 99642	699573 99710	699573 99778
	100	100	699573 99643	699573 99711	699573 99779
	120	100	699573 99644	699573 99712	699573 99780
	150	100	699573 99645	699573 99713	699573 99781
	180	100	699573 99646	699573 99714	699573 99782
	240	100	699573 99647	699573 99715	699573 99783
	320	100	699573 99648	699573 99716	699573 99784
}	24	50	699573 99649	699573 99717	699573 99785
	36	50	699573 99650	699573 99718	699573 99786
	40	50	699573 99651	699573 99719	699573 99787
	50 60	50 50	699573 99652 699573 99653	699573 99720 699573 99721	699573 99788 699573 99789
	80	50	699573 99654	699573 99721 699573 99722	699573 99790
	100	50	699573 99655	699573 99723	699573 99791
	120	50	699573 99656	699573 99724	699573 99792
	120	50	699573 99657	699573 99725	033013 33132
	180	50	699573 99658	699573 99726	699573 99794
	240	50	699573 99659	699573 99727	699573 99795
	320	50	699573 99660	699573 99728	699573 99796
ł	36	50	699573 99661	699573 99729	
	50	50		699573 99731	
	60	50	699573 99664		699573 99800
	80	50		699573 99733	

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.



Silicon Carbide Quick-Change Cloth Discs

		TIER:	GOOD	GOOD	GOOD
		TRADENAME:	MERIT R422	MERIT R422	MERIT R422
		ABRASIVE:		Silicon Carbide	Silicon Carbide
		BACKING:		Cotton Standard	Cotton Standard
		ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)
			\bigcirc	Ì	
SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #
	40	100	088341 65252 NS	088341 64275 NS	
	60	100	088341 65254	088341 64163 NS	088341 62168 NS
	80	100	08834165255	088341 66155 NS	088341 62169 NS
	120	100		088341 64837 NS	088341 62171 NS
	180	100	088341 65259 NS	08834167313 NS	088341 62173 NS
	40	50	088341 65267 NS	088341 64277 NS	
	60	50		088341 64850 NS	
	80	50		088341 66159 NS	088341 62188 NS
	120	50	088341 65272 NS	088341 66160 NS	088341 62190 NS
	180	50		08834168177 NS	

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

Specialty Quick-Change Discs

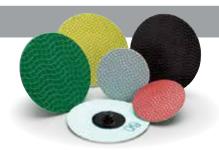


Better choice for hard-to-grind areas where flexibility is not required

NORKUT ZIRCONIA ALUMINA POLYMER

- Durable zirconia alumina grain is resin bonded to a unique polymer backing which resists cracking and breaking; can be trimmed to the 1 Inch core
- Used with a quick change mandrel: 7/16-20 threaded for hand-held pneumatic grinders or 1/4 inch mandrel for automotive drills
- · Use for deburring and blending; use the core to grind pinch welds and other hard-to-reach areas

		TIER:	BETTER			
		TRADENAME:	NORKUT	•		
		ABRASIVE:	Zirconia Alumina	-		
		BACKING:	Extra HD Polymer		TIER:	BETTER
		ATTACHMENT:	Threaded Hole		ATTACHMENT:	Threaded Hole
SIZE (D)	GRIT	STD. PKG.	PART #	SIZE (D)	STD. PKG.	PART #
NorKut Discs				Mandrels		
3	24	20	636425 03656	7/16-20 Mandrel	5	636425 03659
	36	20	636425 03657	1/4" Mandrel	5	636425 03660
	50	20	636425 03658			



Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings

D7210 DIAMOND QUICK-CHANGE TR (TYPE III)

- Unique, durable diamond abrasive pattern increases life and lowers costs versus standard coated and diamond discs; color-coded backing for easy grit/application identification
- · Removes rust and scale on other material; producing metallurgical stamps and coupons

			Th	ER: BETTER
SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Dia	mond Coate	ed Quick-Chang	e TR (Type III) Di	scs
2	Green	60	12	662603 11778
	Black	120	12	662603 11779
	Red	200	12	662603 11780
	Yellow	400	12	662603 11781
	White	800	12	662603 11782

			TIE	R: BETTER
SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Dia	amond Coated	l Quick-Chang	e TR (Type III) Dis	SCS
3	Green	60	12	662603 11783
	Black	120	12	662603 11784
	Yellow	400	12	662603 11786



Non-woven quick-change discs are a combination of strong synthetic mesh and quality abrasives, bonded together by a smear-resistant adhesive. The open construction of the non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

Applications:

Size Range: Grit Range: Abrasive Grain: Attachment: Back-up Pads: Machine Used: Medium-light stock removal, beveling, deburring/deflashing, rust removal, blending, cleaning and finishing, polishing, and decorative finishing 3/4" – 4" diameter X-Coarse, Coarse, Medium, Fine, Very Fine, Super Fine Ceramic Alumina, Engineered Aluminum Oxide, Aluminum Oxide, Silicon Carbide Quick-Change Type TR (Type III), Type TS (Type II) Rubber with hardness variations for different applications



Quick-Change Attachment Systems and Cross Reference Guide

Each system enables quick, tool-free, safe disc changes, reducing downtime and operating expenses.

Type TS (Type II)

• Features a turn-on/turn-off style fastener



Type TR (Type III)

- Features a roll-on/roll-off style fastener
- Fastener is made of plastic



NORTON	TS	TR	
3M	Roloc TS/TSM	Roloc TR	
Standard	TS (SocAtt)	TR (Lockit)	
Superior	Type S	Type R	
Arc	Type S	Type R	
Pferd	Туре СD	Type CDR	
Sait	SAIT-LOK	SAIT-LOK-R	
Camel	Turn On	Roll On	
Klingspor	QMC	QRC	
Garryson	Type S	Type R	

Application/Grit Recommendation Guide

MOST AGGRESSIVE

LEAST AGGRESSIVE

NORTON	Rapid Strip	Vortex Rapid Blend Deburring & Blending	Vortex Rapid Prep	Rapid Prep	HS Buffing, Buffing	Rapid Polish
0 I D I		Deputring & Dienuing				
Scale Removal	First Choice					
Stock Removal	First Choice	Second Choice				
Heavy Deburring	Second Choice	First Choice				
Light Deburring		First Choice	Second Choice			
Light Finishing			First Choice	Second Choice		
Blending			First Choice	Second Choice		
Cleaning			Second Choice	First Choice		
Finishing				First Choice	Second Choice	
Polishing						First Choice







Cross Reference Guide

HEAVY/LIGHT DEBURRING

LIGHT DEBURRING/BLENDING/CLEANING/FINISHING

	BEST	BETTER	BEST	BETTER	BEST	BETTER	BEST
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend, Deburring & Blending	Vortex Rapid Prep	Rapid Prep	HS Buffing
3M	Clean and Strip XT PRO,	Clean & Strip Clean Strip XT	Deburr and Finish PRO	EXL Unitized	SE	Surf Cond, SL	_
	Clean and Strip XT PRO Extra Cut						
Standard	_	Cleaning Disc	-	500-900 Series Unitized	_	FE, GP, RC	Buff & Blend - HS, Buff & Blend
Fiberal/SIA	-	-	-	-	_	Meteor, Type B & C	_
Superior	-	Type R	-	XL Unitized	-	FD, GD, CC	HS, HD A/O
Arc	-	Arcstrip	-	-	-	Surface Cond	Blend & Finish
Pferd	_	Policlean	-	_	-	Finishing Disc - Hard & Soft	_
Sait	_	SAIT-Strip	-	-	-	HD, GP	Sand-Light Blending
Camel	_	EZ Strip - Black	_	_	_	_	-
Klingspor	-	-	_	-	-	-	-
Garryson	-	-	-	-	-	Surface Cond	-
Bibielle	_	Strip-It Black	_	BUR Unitized	_	DCR	_

Abrasive/Grit/Density Key

ABRASIVE	SILICON CARE	IDE		ALUM	CERAMIC ALUMINA	
	SHARPER, FIN	ER/BRIGHTER SCRAT	CH PATTERN	MORE DUI	RABLE, LONGER LAST	TING, POLISHED FINISH
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)	VF (240-360)	SF (400-600)
	FASTER, AGGF	RESSIVE CUT, ROUGH	ER FINISH		REDUCED C	UT RATE, FINER FINISH
DENSITY	2					9
	SOFT, OPEN, C	ONFORMABLE, LESS	BURNING/LOADING	HARDER, MORE	DURABLE, FASTER CU	ITTING, BETTER FINISH





Quick-Change Stripping Discs



Best choice for removing coatings on a variety of substrates, such as wood, metal and plastics

BLAZE RAPID STRIP CERAMIC ALUMINA

- Blaze ceramic grain cuts 2X faster than competitive discs; leaves a thoroughly cleaned surface, ensuring excellent
 adhesion in subsequent processes such as coating, painting and soldering
- Open web construction for minimal loading; great alternative to wire brushes
- · Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish



RAPID STRIP SILICON CARBIDE

- · Sharp silicon carbide abrasive provides fast aggressive cutting action
- Open web construction for minimal loading; great alternative to wire brushes
- Advanced resin bond prevents shedding, snagging, gouging, and rework

			-		
		TIER:	BEST		BETTER
		TRADENAME:	BLAZE RAPID STRIP		RAPID STRIP
		ABRASIVE:	Ceramic Alumina		Silicon Carbide
		GRADE:	XC		XC
		ATTACHMENT:	TR (Type III)	_	TR (Type III)
			Ì		٢
SIZE (DIAMETER)	MAX. RPM	STD. PKG.	PART #	STD. PKG.	PART #
2	15,500	25	666233 03912	10	662610 13402
3	12,000	25	662610 96557	10	662610 13403
4 TR+	8,000	5	666233 03921 *	5	662610 16580 *

*TR+ attachment show in the group image above

Quick-Change back-up pads shown at the end of this section.





3D Unified Quick-Change Deburring & Blending Discs



Best technology for heavy deburring and finishing

BLAZE RAPID BLEND CERAMIC ALUMINA

- Blaze SG ceramic alumina grain provides quickest cut rate and up to 8X longer life than competitive aluminum oxide discs
- · Superior resin chemistry resists shedding when used on sharp edges; ideal for deburring
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus competitive discs with one bottom layer of abrasive

Best choice for weld blending, polishing and deburring

VORTEX RAPID BLEND ALUMINUM OXIDE

- Patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit with the finish of finer grits
- · Special resin bond for consistent performance with no smearing
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus
 competitive discs with one bottom layer of abrasive



Better choice for light deburring, blending, and cleaning

RAPID BLEND NEX ALUMINUM OXIDE

- · Quality aluminum oxide delivers durability and long life
- · Resin formula delivers smear-free finishes
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus
 competitive discs' one bottom layer of abrasive

TECH TIP

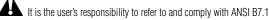
3D Construction

• The 3D construction means the abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus discs with one single bottom layer of abrasive.











How to Grind & Blend in One Step! Non-Woven Discs **youtube.com/watch?v=FgSLez3MKj8**





3D Unified Quick-Change Deburring & Blending Discs

$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$		ied Quick-Cha ng & Blending		Discs		TIER:	BEST	Bast
ABRASIVE: Ceramic Alumina Engineered Aluminum Oxide ATTACHMENT: TS (Type II) TS (Type II) SIZE ABRASIVE GRIT DENSITY MAX. STD. PART # 1 x 1/4 Ceramic Alumina XC 1 35,000 100 66623313920					TRAF			
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(0 x T) ABRASIVE GRIT DENSITY RPM PKG. PART # PART # 1 x 1/4 Ceramic Alumina XC 1 35,000 100 66623313920 1-1/2 x 1/4 Ceramic Alumina XC 1 35,000 80 66623313920 2 x 1/4 Aluminum Oxide C 5 30,000 40 66261132884 Aluminum Oxide C 8 30,000 40 66261132885 2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070								
(0 x T) ABRASIVE GRIT DENSITY RPM PKG. PART # PART # 1 x 1/4 Ceramic Alumina XC 1 35,000 100 66623313920 1-1/2 x 1/4 Ceramic Alumina XC 1 35,000 80 66623313920 2 x 1/4 Aluminum Oxide C 5 30,000 40 66261132884 Aluminum Oxide C 8 30,000 40 66261132885 2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070							\bigcirc	\bigcirc
1 x 1/4 Ceramic Alumina XC 1 35,000 100 66623313920 1-1/2 x 1/4 Ceramic Alumina XC 1 35,000 80 66623313922 NS 2 x 1/8 Aluminum Oxide C 5 30,000 40 66261132884 Aluminum Oxide C 8 30,000 40 66261132885 2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070			ODIT	DENOITY		STD.	DADT #	DADT #
1-1/2 x 1/4 Ceramic Alumina XC 1 35,000 80 66623313922 NS 2 x 1/8 Aluminum Oxide C 5 30,000 40 66261132884 Aluminum Oxide C 8 30,000 40 66261132885 2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070	· · · ·			DENSITY				PARI #
2 x 1/8 Aluminum Oxide C 5 30,000 40 66261132884 Aluminum Oxide C 8 30,000 40 66261132885 2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070					,			
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2 x 1/4 Ceramic Alumina XC 1 22,000 25 66623313925 Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070	2 x 1/8			-				
Aluminum Oxide C 5 30,000 60 66261132886 Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070				8)			662611 32885
Aluminum Oxide C 8 30,000 60 66261132887 Aluminum Oxide M 1 22,000 25 66254497070	2 x 1/4			1			666233 13925	
Aluminum Oxide M 1 22,000 25 662544 97070				-				
		Aluminum Oxide	-	8	30,000			662611 32887
		Aluminum Oxide	М	1	22,000	25		662544 97070
	3 x 1/8	Aluminum Oxide	С	5	22,000	40		662611 32890
Aluminum Oxide C 8 22,000 40 662611 32891		Aluminum Oxide		8	22,000			662611 32891
3 x 1/4 Ceramic Alumina XC 1 15,000 25 666233 13931	3 x 1/4	Ceramic Alumina	XC	1	15,000	25	666233 13931	
Aluminum Oxide C 5 22,000 40 662611 32894		Aluminum Oxide	С	5	22,000	40		662611 32894
Aluminum Oxide C 5 22,000 40 662611 32895		Aluminum Oxide	С	5	22,000	40		662611 32895
Aluminum Oxide M 1 15,000 25 662544 97069		Aluminum Oxide	Μ	1	15,000	25		662544 97069

For unified wheels with arbor holes or spindle mounts, see the Non-woven Unified Wheel section. Quick-Change back-up pads shown at the end of this section.

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

3D Unified Quick-Change Deburring & Blending TR Discs

Deburriı	ng & Blending	TR	Discs		TIED		0	
				TDAC		BEST	BEST	BETTER
						BLAZE RAPID BLEND	VORTEX RAPID BLEND	RAPID BLEND NEX
						Ceramic Alunima	Engineered Aluminum Oxide	Aluminum Oxide
				ALIAC	HIVIEN I.	TR (Type III)	TR (Type III)	TR (Type III)
						Ì	Ì	Ì
SIZE				MAX.	STD.			
(D x T)	ABR.	GRIT	DENSITY	RPM	PKG.	PART #	PART #	PART #
1 x 1/4	Ceramic Alumina	XC	1	35,000	100	666233 13919		
1-1/2 x 1/4	Ceramic Alumina	XC	1	35,000	80	666233 13921 NS		
2 x 1/8	Aluminum Oxide	С	5	30,000	40		662611 32882	
	Aluminum Oxide	С	8	30,000	40		662611 32883	
	Aluminum Oxide	М	4-6	22,000	60		662544 25632 NS	
	Aluminum Oxide	М	7-9	22,000	60		662544 33509 NS	
2 x 3/16	Aluminum Oxide	М	2-3	22,000	60		662544 28236 NS	
2 x 1/4	Ceramic Alumina	XC	1	22,000	25	666233 13923		
	Aluminum Oxide	С	7-9	22,000	60			662610 14921
	Aluminum Oxide	М	1	22,000	25		662544 97067	
	Aluminum Oxide	М	2-3	22,000	60		662544 28237	662610 14897
	Aluminum Oxide	М	4-6	22,000	60		662544 13660	662610 14911
	Aluminum Oxide	М	7-9	22,000	60		662544 33510	662610 14935
	Silicon Carbide	F	2	22,000	60			662610 14889
	Silicon Carbide	F	3	22,000	60			662610 17306
3 x 1/8	Aluminum Oxide	С	5	22,000	40		662611 32888	
	Aluminum Oxide	С	8	22,000	40		662611 32889	
	Aluminum Oxide	М	4-6	15,000	40		662610 93556	
	Aluminum Oxide	М	7-9	15,000	40		662610 90909	
3 x 3/16	Aluminum Oxide	М	7-9	15,000	40		662544 28239 NS	
3 x 1/4	Ceramic Alumina	XC	1	15,000	25	666233 13930		
	Aluminum Oxide	С	5	22,000	40		662611 32892	
	Aluminum Oxide	С	8	22,000	40		662611 32893	
	Aluminum Oxide	С	7-9	15,000	40			662610 14922
	Aluminum Oxide	M	1	15,000	25		662544 97068	
	Aluminum Oxide	М	2-3	15,000	40		662544 28238	662610 14898
	Aluminum Oxide	М	4-6	15,000	40		662544 13661	662610 14912
	Aluminum Oxide	М	7-9	15,000	40		662544 06395	662610 14936
	Aluminum Oxide	F	4-6	15,000	40			662610 15419
	Silicon Carbide	F	2	15,000	40			662610 14890
	Silicon Carbide	F	3	15,000	40			662610 16005
NO Maria	2	•		. 0,000				

NS Non-stock, contact your Norton representative for current order quantities and lead-times.



Quick-Change Surface Preparation Discs



Best choice for aggressive stock removal and blending in one step

RAPID PREP XHD

- Coarse and Medium discs solve your most aggressive stock removal and blending challenges, remove weld lines, weld spatter, weld discoloration and blend surfaces in a single step
- Improve cut control and surface blending over traditional coated discs with our unique combination of a conformable fiber matrix and premium ceramic grain
- XHD Coarse discs for aggressive weld removal and surface blending on steels and Medium discs on softer metals/ alloys

		ABRA	TIER: BEST NAME: RAPID PREP XHD ASIVE: Ceramic Alumina MENT: TR (Type III)
SIZE (DIAMETER)	MAX. RPM	STD. PKG.	PART #
Coarse			
2	20,000	50	662611 70271
3	18,000	25	662611 70273
4	12,000	25	662611 70274
Medium			
2	20,000	50	662611 70285
3	18,000	25	662611 70286
4	12,000	25	662611 70287





Quick-Change Surface Preparation Discs



Best choice for finishing and blending applications

VORTEX RAPID PREP

- Proprietary engineered Vortex aluminum oxide abrasive grain and coating method combine maximum cutting speed with the consistent finish of finer grits to reduce process times by 50+% by combining multiple grit sequences to 1 step
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life and provides added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

Better choice for finishing and blending applications

RAPID PREP ALUMINUM OXIDE

- Quality aluminum oxide abrasive grain coating provides up to 20% higher cut rate and 50% better performance than competitive products
- Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as it does with other competitive products
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

			BEST	BETTER	BEST	BETTER
		TRADENAME:	VORTEX RAPID PREP	RAPID PREP	VORTEX RAPID PREP	RAPID PREP
		ABRASIVE:	Engineered A/O	Aluminum Oxide	Engineered A/O	Aluminum Oxide
		ATTACHMENT:	TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)
			Ì	٩	\bigcirc	\bigcirc
ZE (DIAM.)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
ktra Coarse						
/4	25,000	50	666233 25001	666233 40002	666233 35324	
	25,000	50	666233 25004		666233 25003	666233 40006
-1/2	20,000	50	666233 25007	666233 40011	666233 25006	666233 40010
	20,000	50	666233 35326	662610 16373	666233 35325	662610 17819
	18,000	25	666233 35327	662610 16994	666233 25010	662610 17818
	12,000	25	666233 35329	662610 16374		
oarse						
/4	25,000	50	666233 25013	666233 40021	666233 35410	662610 95015
	25,000	50	666233 25015	666233 40023	666233 35537	662610 24310
-1/2	20,000	50	666233 35411	662610 47579	666233 25017	666233 40026
	20,000	50	666233 35414	662610 09191 NS	666233 35413	662610 09183
	18,000	25	666233 35417	662610 09194	666233 35416	662610 09186
	12,000	25	666233 35419	662610 08822		
ledium	,					
/4	25,000	50	666233 25020	666233 40032	666233 35420	662544 28059
	25,000	50	666233 35422	662544 82331	666233 35421	662544 82327
-1/2	20.000	50	666233 35424	662544 82332	666233 35423	66254482328
.,_	20.000	50	666233 35427	66261009190*	666233 35426	662610 09182
	18,000	25	666233 35430	662610 17522	666233 35429	662610 09185
	12,000	25	666233 35432	662610 08821		662610 55350
ine	12,000	20	00020000102	0020100021		00201000000
/4	25,000	50	666233 25026	666233 40058	666233 25025	
	25.000	50	666233 25029	666233 40064	666233 25028	666233 40062
-1/2	20,000	50	666233 25032	666233 40070 NS	666233 25031	666233 40068
1/2	20,000	50	666233 25035	666233 40077	666233 25034	666233 40074
	18.000	25	666233 25038	666233 40085	666233 25037	666233 40082
	12,000	25	666233 25041	666233 40092	00020010001	00020010002
ery Fine	12,000	20	00020020011	00020010002		
/4	25.000	50	666233 25044	666233 40044	666233 25043	666233 40042
	25,000	50	666233 25047	662544 82339	666233 25046	662544 82335
-1/2	20,000	50	666233 25050	662544 82340	666233 25049	662544 82336
1/2	20,000	50	666233 35433	662610 09189 *	666233 25052	662544 82337
	18,000	25	666233 35437	662610 09192	666233 35436	662610 09184
	12,000	25	0002000401	666233 40053	000200 01400	00201003104
uper Fine	12,000	20		000200700000		
	20,000	50		662610 91459		
2	18.000	25		662610 91460		





Quick-Change Buffing/Polishing Discs



lest choice for light removal of paint or rust

HIGH STRENGTH BUFFING DISCS

- Aluminum oxide grain delivers a combination of consistent cut rate and uniform finish
- Tough yet conformable high-strength discs are smear-proof and resist tearing on burrs and sharp edges
- Our strongest non-woven buffing and polishing disc

Better choice for finishing to a mirror like shine



RAPID POLISH

- · Quick-change discs with premium quality pressed hardened felt for polishing to a mirror like finish
- Use with our without polishing compound
- Soft padding is Ideal for final finishing with no vibration



Good choice for light removal of rust, coatings or oxidation

MERIT BUFFING/POLISHING DISCS

- This aluminum oxide grain and resin bond combination produce a smooth cut rate and smear-free, uniform finish
- Non-woven nylon fibers are laminated to tough yet conformable nylon backing that resists tearing on burrs and sharp edges
- · Designed for light removal of coatings oxidation or rust without affecting the base product

			TIER.	BEST	BEST	GOOD	GOD			BETTER
		TRAD	ENAME:	HIGH-STRENGTH	HIGH-STRENGTH	MERIT BUFFING/ Polishing	MERIT BUFFING/ Polishing			RAPID POLISH
		AB	RASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide			Felt
		Bi	ACKING:			Nylon Laminated	Nylon Laminated			
		ATTAC	HMENT:	TR (Type III)	TS (Type II)	TR (Type III)	TS (Type II)			TR (Type III)
				Ì		Ì				Ì
	0.017	MAX.	STD.	D4.D7 //				MAX.	STD.	
SIZE (D)	GRIT	RPM	PKG.	PART #	PART #	PART #	PART #	RPM	PKG.	
-1/2	M	20,000	100			088341 66368	088341 66392			
	1	20,000	100	7700000110		088341 66369	00004100004			
2	<u>C</u>	18,000	50	776960 00149	0000448484410	088341 61649	088341 66394		50	0000440400
	M	18,000	50	088341 64064	088341 64244 NS	088341 66303	088341 66395	-	50	088341 64407
	+	18,000	50			088341 66304	088341 66396			
	VF	18,000	50	088341 63987 NS	088341 64245 NS	088341 66305	088341 66405			
}	С	12,000	25	776960 00150		088341 61651	088341 66397			
-			05		088341 64252 NS	088341 66308	088341 66398	-	50	088341 64408
-	М	12,000	25	088341 64065	00034104232 113				00	00001101100
-	M F	12,000	25 25	088341 64065	00034104232 113	08834166309	08834166399		00	

NS Non-stock, contact your Norton representative for current order quantities and lead times.

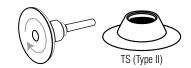
See page 80 for Rapid Polish Compound Stick.

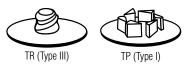


PORTABLE TOOLS AND SPECIALTIES Quick-Change Disc Accessories

Quick-Change Back-up Pads

- · Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications
- Soft density pads are used for contours and fine finishing work





DENSITY			TS (TYPE II)	TR (TYPE III)	TP (TYPE I)
••••	40,000	1	662610 54014 NS		662610 54013 NS
Medium	40,000	1	088341 64206	088341 64038	088341 64001
Medium	40,000	1	088341 64651	088341 64037	088341 64002
Hard	30,000	1	08834164622		08834163996 NS
Medium	30,000	1	08834164146	08834161174	08834164003
Hard	30,000	1	08834164624	08834164643	08834163997
Medium	30,000	1	08834164198	08834164922	088341 64004
Soft	30,000	1	08834161625	08834164641	088341 63949 NS
Hard	20,000	1	08834161626	08834164036	08834163998
Medium	20,000	1	08834164113	08834164949	08834164005
Soft	20,000	1	08834164626	088341 64644 NS	088341 63948 NS
Medium	15,000	1	08834164135	08834164655	
Medium	8,000	1		636425 55106	
k-Change Back	-up Pads				VENDIBLE
Medium	30,000	5	666233 41082	666233 41083	
Medium	20,000	5		666233 41085	
	Medium Hard Medium Hard Medium Soft Medium Soft Medium Medium K-Change Back Medium	Back-up Pads 40,000 Medium 40,000 Medium 40,000 Medium 40,000 Hard 30,000 Medium 30,000 Medium 30,000 Medium 30,000 Medium 30,000 Medium 30,000 Soft 20,000 Medium 20,000 Soft 20,000 Medium 15,000 Medium 8,000 K-Change Back-up Pads Medium 30,000	DENSITY RPM PKG. Back-up Pads 40,000 1 Medium 40,000 1 Medium 40,000 1 Hard 30,000 1 Medium 20,000 1 Medium 20,000 1 Medium 20,000 1 Medium 15,000 1 Medium 15,000 1 Medium 8,000 1 K-Change Back-up Pads Medium 30,000	DENSITY RPM PKG. TS (TYPE II) Back-up Pads 40,000 1 66261054014 NS Medium 40,000 1 08834164206 Medium 40,000 1 08834164206 Medium 40,000 1 08834164651 Hard 30,000 1 08834164622 Medium 30,000 1 08834164146 Hard 30,000 1 08834164198 Soft 30,000 1 08834161625 Hard 20,000 1 08834161626 Medium 20,000 1 08834164133 Soft 20,000 1 08834164135 Medium 15,000 1 08834164135 Medium 8,000 1 4834164135 Medium 8,000 1 4834164135 Medium 8,000 1 4834164135 Medium 30,000 5 66623341082	DENSITY RPM PKG. TS (TYPE II) TR (TYPE III) Back-up Pads 40,000 1 66261054014 NS Medium 40,000 1 08834164206 08834164038 Medium 40,000 1 08834164206 08834164037 Hard 30,000 1 08834164651 08834164037 Hard 30,000 1 08834164622 Medium 30,000 1 08834164624 08834164643 Medium 30,000 1 08834164624 08834164643 08834164643 Medium 30,000 1 0883416455 08834164641 Hard 20,000 1 0883416125 08834164641 Hard 20,000 1 0883416125 08834164036 Medium 20,000 1 0883416413 088341644949 Soft 20,000 1 0883416426 0883416444 MS Medium 15,000 1 0883416426 08834164655 Medium 15,000 1

All Quick-Change back-up pads have a 1/4" solid steel shank.

NS Non-stock. Contact your Norton representative for current order quantities and lead times. Vendible back-up pad Std. Pkg. Qtys: 1 pad per pack; 5 packs per carton. Order in multiples of 5.

Replacement Medium Density Rubber Pads for Quick-Change TP (Type I) Back-up Pads

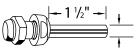
· When the rubber pad has worn away, but the steel components of your quick-change back-up are still serviceable, order these replacement rubber pads.

SIZE (D)	MODEL #	STD. PKG.	PART #					
Quick-Change Replacement Rubber Back-up Pads								
3/4	RR75	1	088341 64008 NS					
4	RR40	1	088341 64013 NS					
NO Month	I O I I I I I I I I I I I I I I I I I I	and the first factor and the second second second	and the second freed three second					

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Replacement Assemblies and Shanks for Quick-Change Back-up Pad

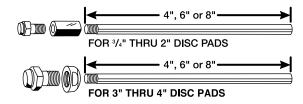
· Assemblies replace all the steel components of a quick-change back-up pad. This shank replaces the screw-in 1/4" solid steel shank only.



088341 64016 NS
088341 64303

NS Non-stock. Ask your Norton representative for current order quantities and lead-times

Extension Mandrels and Assembly

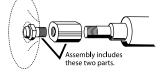


DIAMETER	MODEL #	LENGTH	STD. PKG.	PART #					
Extension Mandrels and Assembly – TP (Type I)									
3/4 - 2	EMN-14	4"	1	088341 64017 NS					
3/4 - 2	EMN-16	6"	1	088341 64018 NS					
3/4 - 2	EMN-18	8"	1	088341 64019 NS					
3 - 4	EMN-34	4"	1	088341 64020 NS					
3 - 4	EMN-36	6"	1	088341 64026 NS					
3 - 4	EMN-38	8"	1	088341 64021 NS					
			• • •						

All extension mandrels are non-stock, Contact your Norton representative for current order quantities and lead-times.

MNA-1 Pad Adapters

· Convert a TP (Type I) back-up pad 1/4" diameter solid shank to a threaded shank

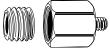


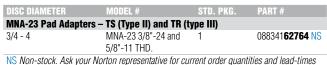
DISC DIAMETER	MODEL NO.	STD. PKG.	PART #						
MNA-1 Pad Adapters – TP (Type I)									
3/4 - 2	MNA 1/4-20 THD.	1	088341 61176 NS						
3/4 - 2	MNA 3/8-24	1	088341 64055 NS						
3/4 - 2	MNA 5/8-11	1	088341 63001 NS						
3 - 4	MNA 1/4-20	1	088341 63002 NS						

3 - 4 MNA 5/8-11 08834164028 NS All pad adapters are non-stock. Contact your Norton representative for current order quantities and lead-times.

MNA-23 Pad Adapters

- · For use on a right angle grinder: convert TS (Type II) and TR (Type III) back-up pad 1/4" diameter solid shanks to threaded shanks.
- The larger 5/8"-11 adapter (for 4-1/2" discs) is used alone to convert to a 5/8"-11 thread.
- The 3/8"-24 insert (for 4" discs) is screwed into the 5/8"-11 adapter to create a 3/8"-24 thread adapter.





1/4" Diameter Extension Mandrel

USE WITH TP (TYPE I), TS (TYPE II), TR (TYPE III)								
MODEL NO.	LENGTH	STD. PKG.	PART #					
1/4" Diameter Extension Mandrel 1/4-20 Thread								
EM-144	4"	1	088341 54185					
EM-146	6"	1	088341 54186					
EM-148	8"	1	088341 54187					





PORTABLE TOOLS AND SPECIALTIES Die Grinder

Our new Norton pneumatic die grinder quickly and comfortably accomplishes many portable applications without changing machines – including jobs for abrasive specialties (cartridge and spiral rolls...), small diameter flap wheels, mounted points, and carbide burrs.

Neight of tool:	1.4 lbs.
Compressed air:	6.2 bar (90psi)
Maximum permissible operating pressure:	6.2 bar (90psi)
Recommended operating pressure:	6.2 bar (90psi)
lorsepower:	0.9HP
Free speed:	25,000 rpm
Air consumption @90psi:	85 l/min (3 CFM)
Noise characteristic value in accordance with EN ISO 15744 (ISO 15744):	
 A-weighted sound pressure level at workstation 	87.3 dB
 A-weighted sound power level 	98.3 dB
 Peak C-weighted instantaneous sound pressure level at workstation 	< 130 dB
 Measurement uncertainty (Standard) 	3 dB
/ibration value according to EN ISO 28927-12:	3.00 m/s ²
Measurement uncertainty (Standard):	0.84 m/s ²
Recommended lubrications:	Air drill oil 20#
Sanding tool specifications:	Pad Size 2" Collet
	Chuck 1/8" (3 mm) and 1/4" (6 mm)
Applications and suitability:	Final surface finishing, chamfering, deburring of architectural millwork, sheet metal and surface prep, zinc casting, aluminum products, injection molds, etc.; general sanding and polishing.



Put the power right in the palm of your hand with our die grinder

PNEUMATIC DIE GRINDER

- Comfortable during prolonged use thanks to vibration-limiting technology, ergonomic design, and streamlined non-slip grip
- Adaptable to the needs of each job with speed regulation and two collet inserts in 1/8" and 1/4"
- Compatible with many accessories including cartridge rolls, spiral rolls, square pads, cross pads, overlap slotted discs, flap wheels, mounted points and carbide burrs

DESCRIPTION	STD. PKG.	PART #
Norton Pneumatic Die Grinder		
Single Die Grinder with 1/8" and 1/4" collets	1	699573 08000
Die Grinder Kit*	1	699573 08001
Kit includes:		

1 die grinder with 1/8" and 1/4" collets 100 – 3/8" x 1-1/2" x 1/8", 80 grit Merit R228 cartridge rolls (088341**80232**) 1- M9 cartridge roll mandrel (088341**81209**) 10 – 1" x 1" x 1/4" shank, 60 grit Blaze R920 flap wheels (662611**51170**)

- 5-1" x 1" W220, 1/4" x 1-1/2" spindle Gemini 38A60-P mounted points (61463624566)
- 1 1/2" x 1" SF5 Double-Cut carbide burr (699573**08021**)



How to Use a Pneumatic Die Grinder nortonsga.us/44yj2 Or Visit nortonsga.us/diegrinder





PORTABLE TOOLS AND SPECIALTIES Cartridge Rolls



Cartridge rolls are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive. A valuable abrasive tool for reaching into corners, where larger diameter tools cannot work

Applications:

Stock Shapes: Grit Range: Abrasive Grain: Backing: Construction: Maximum RPM:

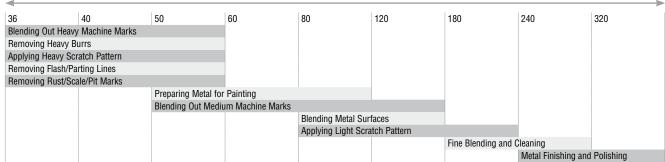
Machine Used:

Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing or removing machine tool marks, and edge breaking. Cartridge rolls, half-glued 36 - 320 Ceramic Alumina, Aluminum Oxide X-weight cotton, X-weight poly-cotton All cartridge roll part numbers shown are resin bond, half-glued. Quarter and full glue are also available for quotation as made-to-order products. 1/8" to 1/2" – 23,000 5/8" to 1" – 18,000 1" to 1-1/2" – 15,000 DIE GRINDER

Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)





Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain provides greatest productivity with significantly faster cut rates; resists wear resulting in 50% – 300% longer life; supersized for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- · Constructed of rolled and half-glued abrasive strips that break down to expose next layer of abrasive



PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide or zirconia alumina alternatives
- · Improved resin bond system provides longer life; supersized for cool cutting
- Versatile X-weight poly cotton backing for flexibility and life

Good starting specification for flash removal, polishing, or removing machine tool marks and edge breaking on all types of metal

MERIT R228 ALUMINUM OXIDE

- Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- · Constructed of rolled and half-glued abrasive strips that break down to expose next layer of abrasive



PORTABLE TOOLS AND SPECIALTIES Cartridge Rolls

Continued

0/10/11/2/1/0	00	100		
Use M-9 Mandrel				
Some part numbers are no status, order quantities and			ur Norton representative for	

Continued

5/16 x 1-1/2 x 1/8

Refer to the back of this section for mandrels.

		TIER:	GOOD
		TRADENAME:	MERIT R228
		ABRASIVE:	Aluminum Oxide
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/16 x 3/4 x 3/32	80	100	088341 80005
3/16 x 1 x 3/32	60	100	088341 80023
Use M-2E Mandrel	80	100	088341 80024
	100	100	088341 80025
	120	100	088341 80026
	150	100	088341 80027
	180	100	088341 80028
	240	100	088341 80030
1/4 x 3/4 x 1/8	80	100	088341 80043
Use M-3 or M-7 Mandrel			
1/4 x 1 x 1/8	50	100	088341 80060
Use M-4 or M-8 Mandrel	60	100	088341 80061
	80	100	088341 80062
	100	100	088341 80063
	120	100	088341 80064
	150	100	088341 80065
	180	100	088341 80066
	320	100	088341 80070
1/4 x 1-1/2 x 1/8	50	100	088341 80079
Use M-9 Mandrel	60	100	088341 80080
	80	100	088341 80081
	100	100	088341 80082
	120	100	088341 80083
	150	100	088341 80084
	180	100	088341 80085
	320	100	088341 80089
1/4 x 2 x 1/8	80	100	088341 80100
Use M-10 Mandrel	120	100	088341 80102
5/16 x 1 x 1/8	80	100	088341 80138
Use M-4 or M-8 Mandrel	120	100	088341 80140

TIER: BES

ABRASIVE:

STD. PKG.

OTHER:

TRADENAME: BLAZE R920

Ceramic Alumina

94384

94394

94397

94392

94398

94393

94396

94399

Supersize

BETTER

PINK R928

Supersize

Ceramic Alumina

39765

39766

39767

39768

39769

39770

39771

39772

39774

		TIER:	GOOD
		TRADENAME:	MERIT R228
		ABRASIVE:	Aluminum Oxide
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 3/4 x 1/8 Use M-7 Mandrel	120	100	088341 80197
3/8 x 1 x 1/8	60	100	088341 80213
Use M-8 Mandrel	80	100	088341 80214
	100	100	088341 80215
	120	100	088341 80216
	150	100	088341 80217
	180	100	088341 80218
	240	100	088341 80220
3/8 x 1-1/2 x 1/8	36	100	088341 80228
Use M-9 Mandrel	40	100	088341 80229
	50	100	088341 80230
	60	100	088341 80231
	80	100	088341 80232
	100	100	088341 80233
	120	100	088341 80234
	180	100	088341 80236
	240	100	088341 80238
	320	100	088341 80240
3/8 x 2 x 1/8	60	100	088341 80250
Use M-10 Mandrel	80	100	088341 80251
	120	100	088341 80253
1/2 x 1 x 1/8	50	100	088341 80287
Use M-8 Mandrel	60	100	088341 80288
	80	100	088341 80289
	120	100	088341 80291
	150	100	088341 80292
	180	100	088341 80293
	240	100	088341 80295
• • • •			



www.nortonabrasives.com





1/4 x 1-1/2 x 1/8

Use M-9 Mandrel

3/8 x 1-1/2 x 1/8

Use M-9 Mandrel

1/2 x 1-1/2 x 1/8

Use M-9 Mandrel



PORTABLE TOOLS AND SPECIALTIES Cartridge Rolls



		TIER:	GOOD
		TRADENAME:	MERIT R228
		ABRASIVE:	Aluminum Oxide
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	40	100	088341 80305
Use M-9 Mandrel	50	100	088341 80306
	60	100	088341 80307
	80	100	088341 80308
	100	100	088341 80309
	120	100	088341 80310
	150	100	088341 80311
	180	100	088341 80312
	240	100	088341 80314
	320	100	088341 80316
1/2 x 2 x 1/8	60	100	088341 80326
Use M-10 Mandrel	80	100	088341 80327
	120	100	088341 80329
1/2 x 2 x 3/16	60	100	088341 80350
Use M-17 Mandrel	80	100	088341 80653
	120	100	088341 80338
5/8 x 1 x 3/16 Use M-15 Mandrel	80	100	088341 80364
5/8 x 1-1/2 x 1/8	60	100	088341 80275
Use M-9 Mandrel	80	100	088341 80789
5/8 x 1-1/2 x 3/16	60	100	088341 80382
Use M-16 Mandrel	80	100	088341 80383
5/8 x 2 x 1/8	60	100	088341 82505
Use M-10 Mandrel	80	100	088341 81080
5/8 x 2 x 3/16	60	100	088341 80401
Use M-10 Mandrel	80	100	088341 80402
3/4 x 1 x 1/8 Use M-8 Mandrel	80	100	088341 80469
3/4 x 1 x 3/16	80	100	088341 80459
Use M-15 Mandrel	120	100	088341 80461

			Cox S
		TIER:	GOOD
		TRADENAME:	MERIT R228
		ABRASIVE:	Aluminum Oxide
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/4 x 1-1/2 x 1/8	60	100	088341 80490
Use M-9 Mandrel	80	100	088341 80527
	120	100	088341 80487
3/4 x 1-1/2 x 3/16	50	100	088341 80476
Use M-16 Mandrel	60	100	088341 80477
	80	100	088341 80478
	120	100	088341 80480
	180	100	088341 80482
3/4 x 1-1/2 x 1/4	60	100	088341 80489
100/box 400/case	80	100	088341 80358
Use M-21 Mandrel	120	100	088341 80488
	150	100	088341 82807
3/4 x 2 x 1/8 Use M-10 Mandrel	60	100	088341 80791
3/4 x 2 x 3/16	40	100	088341 80494
Use M-17 Mandrel	60	100	088341 80496
	80	100	088341 80497
	100	100	088341 80498
	120	100	088341 80499
3/4 x 2 x 1/4	60	100	088341 80506
Use M-22 Mandrel	80	100	088341 81297
	100	100	08834180509
	120	100	088341 80507
1 x 1-1/2 x 1/8 Use M-9 Mandrel	80	100	088341 80584
1 x 1-1/2 x 1/4	60	100	088341 80587
Use M-21 Mandrel	80	100	088341 80583
1 x 2 x 3/16	60	100	088341 80591
Use M-17 Mandrel	80	100	08834180592
1 x 2 x 1/4	60	100	08834180603
Use M-22 Mandrel	80	100	088341 80606

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. Continued

Refer to the back of this section for mandrels.



PORTABLE TOOLS AND SPECIALTIES Spiral Rolls



Spiral rolls are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive.

Used on inside surfaces and inside corners where other abrasive shapes cannot reach. **Applications:** Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking. Full taper (all stock part numbers), half taper, and sidewall taper 36 - 240 **Abrasive Grain:** Ceramic Alumina, Aluminum Oxide X-weight cotton, X-weight poly cotton **Construction:** All spiral roll part numbers shown are full tapered, resin bond, half glued Half-tapered and sidewall-tapered are available for quotation as made-to-order products Quarter and full glue are also available for quotation as made-to-order products 1/8" to 1/2" - 23,000 **Maximum RPM:** 5/8" to 1" - 18,000 1" to 1-1/2" - 15,000

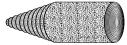




Full Taper

- Especially useful for grinding/polishing of channels, fillets and radii, and deburring small holes
- Full taper used when the area to be finished is hard to reach with a full cartridge roll
- · The tapered roll conforms to smaller areas
- Fits into irregular concaves, contours, channels

All part numbers shown are full tapered



Half Taper

- Used when the area to be finished is not narrow but a beginning point on the roll is needed
- The portion of the roll that is not tapered is then used to finish off the sides
- Available for quotation as made-to-order products



Sidewall Taper

- The portion of the roll that is tapered guides the roll down to the area to be finished
- The sidewall then finishes off the sides Available for quotation as made-to-order products

FINER (FINISHING)

Application/Grit Recommendation Guide

COARSER (GRINDING)

36	40	50	60	80	120	180	240	320
Blending Out Heavy	/ Machine Marks							
Removing Heavy B	urrs							
Applying Heavy Sci	ratch Pattern							
Removing Flash/Pa	rting Lines							
Removing Rust/Sca	ale/Pit Marks							
		Preparing Metal for	Painting					
		Blending Out Media	um Machine Marks					
				Blending Metal Sur	faces			
				Applying Light Scra	tch Pattern			
						Fine Blending and C	Cleaning	
							Metal Finishing and	Polishing



PORTABLE TOOLS AND SPECIALTIES Spiral Rolls



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the premium, sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant; supersized for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive

Better choice for accessing tight areas and where long life and fast cut are required

PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide or zirconia alumina alternatives
- · Improved resin bond system provides longer life; superiszed for fast cutting
- · Versatile X-weight poly cotton backing for flexibility and life



Good choice for cooler grinding/polishing of channels, fillets and radii, and deburring small holes at a low initial price

MERIT R228 ALUMINUM OXIDE

- Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive



PORTABLE TOOLS AND SPECIALTIES
Spiral Rolls

			BEST	BETTER	GOOD
			BLAZE R920	PINK R928	MERIT R228
		ABRASIVE:		Ceramic Alumina	Aluminum Oxide
	0.01	OTHER:		Supersize	
SIZE (D x L x H)	GRIT	STD. PKG.	PART #	PART #	PART #
3/8 x 1 x 1/8	60	100			088341 81714
Jse M-8 Mandrel	80	100			088341 81715
	120	100			088341 81717
3/8 x 1-1/2 x 1/8	60	100	662611 94481	699573 39775	088341 81724
Jse M-9 Mandrel	80	100	662611 94490	699573 39785	088341 81708
	120	100	662611 94491	699573 39787	088341 81727
	180	100			088341 81709
I/2 x 1 x 1/8	60	100			088341 81734
Jse M-8 Mandrel	80	100			088341 81735
	120	100			088341 81737
1/2 x 1-1/2 x 1/8	50	100			088341 81743
Jse M-9 Mandrel	60	100	662611 94484	699573 39790	088341 81744
	80	100	662611 94492	699573 39791	088341 81745
	100	100			088341 81746
	120	100	662611 94495	699573 39792	088341 81747
	180	100			088341 81749
	240	100			088341 81750
1/2 x 2 x 1/8	60	100			08834181754
Jse M-10 Mandrel	80	100			08834181755
	120	100			08834181757
5/8 x 1-1/2 x 1/8 Jse M-9 Mandrel	100	100			088341 81776
5/8 x 1-1/2 x 3/16 Jse M-16 Mandrel	80	100			088341 81444
3/4 x 1-1/2 x 1/8 Jse M-9 Mandrel	80	100			088341 80886
3/4 x 1-1/2 x 3/16	60	100			088341 81808
Jse M-16 Mandrel	80	100			088341 81809
	120	100			088341 81811
3/4 x 2 x 3/16 Jse M-17 Mandrel	60	100			088341 81820
1 x 1-1/2 x 1/8 Jse M-9 Mandrel	60	100		699573 39790	088341 81240
1 x 2 x 3/16	60	100			088341 81878
Jse M-17 Mandrel	80	100			08834181879

Refer to the back of this section for mandrels.





PORTABLE TOOLS AND SPECIALTIES Square & Cross Pads, Overlap Slotted Discs

Square pads, cross pads and overlap slotted discs are all used on high-speed pneumatic tools for deburring, blending, cleaning, and polishing applications. All of these abrasive specialties are designed for applications in small, tight, hard-to-access locations on parts that are being finished.

Benefits:	Variety of shapes and sizes to fit application Shapes provide flexibility for the application the sanding action	1 0 9
	Cross pads allow visibility of the surface wh material is removed	ile sanding, to ensure correct amount of
Grit Range:	50 – 180	
Abrasive Grain:	Ceramic Alumina, Aluminum Oxide	
Backing:	X-weight cotton, X-weight poly-cotton	
Construction	Standard quick-change eyelet for easy mour minimizes downtime; Mandrel use increases	5 1 5
Maximum RPM:	1" Diameter – 25,000	3" Diameter – 12,000 to 14,000
	1-1/2" to 2" Diameter - 18,000 to 23,000	4" Diameter - 8,000 to 12,000
	2-1/2" Diameter – 14,000 to 18,000	5" to 6" Diameter – 5,500 to 7,500
Machine Used:		

DIE GRINDER

Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)

50	60	80	100	120	150	180
Light Stock Removal	00	00	100	120	150	100
	Edge Chamfering/Bevelin	g				
	Blending					
		Deburring/Deflashing				
				Cleaning		
					Finishing	



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the sharp, longest-lasting ceramic abrasive grains and advanced supersize grinding aid for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Corners wear down consistently, exposing fresh abrasive; as these become round, they become less aggressive and run even smoother, with less stock removal – to retain workpiece shape



Better choice for accessing tight areas and where long life & fast cut are required

PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide and zirconia alternatives
- Improved resin bond system provides longer life; supersized for cool cutting
- Versatile X-weight poly cotton backing for flexibility and life

Good for most ID deburring and polishing applications

MERIT R228 ALUMINUM OXIDE

- Versatile, quality aluminum oxide abrasive grain ensures good cut rate
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Corners wear down consistently, exposing fresh abrasive; as these become round, they become less aggressive and run even smoother, with less stock removal – to retain workpiece shape



PORTABLE TOOLS AND SPECIALTIES Square & Cross Pads, Overlap Slotted Discs



Square Pads



- - · Corners wear down consistently exposing fresh abrasive; the pad becomes round for less aggressive stock removal
 - · Grind almost as fast as hard wheels, but are much smoother and easier to control
 - · For quick blending of channels, fillets, corners, or spotting flat surfaces

				•	e	•
			TIER:	BEST	BETTER	GOOD
			TRADENAME:	BLAZE R920	PINK R928	MERIT R228
			ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide
			OTHER:	Supersize	Supersize	
SIZE (L x W x T)	EYELET	GRIT	STD. PKG.	PART #	PART #	PART #
1 x 1 x 6 ply	8-32	80	100			088341 84826
1 x 1 x 8 ply		80	100			088341 84124
1-1/2 x 1-1/2 x 1/2	1/4-20	60	100			088341 84463
		80	100			088341 84125
2 x 2 x 1/2	1/4-20	60	100	662611 94520	699573 40138	
		80	100	662611 94552		088341 84397
		120	100	662611 94554	699573 40141	
2 x 2 x 3/4	1/4-20	80	100			088341 84394
3 x 3 x 1/4	1/4-20	60	100	662611 94531		
		120	100	662611 94556		
3 x 3 x 1/2	1/4-20	50	100			088341 82152
		60	100	662611 94528	699573 40146	088341 82057
		80	100	662611 94557		088341 84336

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Refer to the back of this section for mandrels.



PORTABLE TOOLS AND SPECIALTIES Square & Cross Pads, Overlap Slotted Discs



Cross Pads



- - . The shape of cross pads enables you to see through to the contact area, and provides greater flexibility than square pads to conform to variable internal diameters
 - Used for close-tolerance polishing of small radii and channels, deburring, and finishing of bell-mouth configurations
 - All pads are furnished with standard quick-change eyelet, as listed
 - · Plain hole sizes must be specified and are available for quotation as made-to-order products

					•	0 0	
				TIER:	BEST	GOOD	
				TRADENAME:	BLAZE R920	MERIT R228	
				ABRASIVE:	Ceramic Alumina	Aluminum Oxide	
				OTHER:	Supersize		
SIZE (L x W x T)	PLY	EYELET	GRIT	STD. PKG.	PART #	PART #	
3/4 x 3/4 x 3/8	8	3-48	80	100		088341 85578	
1 x 1 x 3/8	8	3-48	60	100		088341 84943	
			80	100		08834185519	
			100	100		08834184195	
			120	100		088341 85164	
1-1/2 x 1-1/2 x 1/2	8	8-32	60	100	662611 94496	08834184258	
			80	100	662611 94508	08834184465	
			100	100		08834182196	
			120	100	662611 94511	08834182148	
2 x 2 x 1/2	8	8-32	60	100		088341 82156	
			80	100		088341 82157	
			120	100		08834182132	
2 x 2 x 3/4	8	8-32	60	100	662611 94502	08834184128	
			80	100	662611 94513	088341 84194	
			120	100	662611 94516		
2-1/4 x 2-1/4 x 1/2	8	8-32	80	100		08834184402	
2-1/2 x 2-1/2 x 3/4	8	8-32	80	100		088341 84206	
3 x 3 x 1	8	1/4-20	60	100	662611 94504	08834182135	
			80	100	662611 94549	088341 84119	
			120	100	662611 94551	08834184116	
3 x 3 x 1	8	1/4-20	60	100			
	10	1/4-20	80	100		088341 82140	
	8	1/4-20	120	100			
3 x 3 x 1-1/2	10	1/4-20	80	100		088341 82184	
4 x 4 x 1	8	1/4-20	60	100		088341 84142	
			80	100		088341 84135	
			120	100		088341 84377	

* Pink R928 3 x 3 x 1 are 8 ply.

Ceramic Alumina and Alumina Oxide cross pads are also available upon request as made-to-order products.

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Refer to the back of this section for mandrels.



Square & Cross Pads, Overlap Slotted Discs

Overlap Slotted Discs



Overlap Slotted Discs

- · Used for deburring and polishing radii, holes and cylinder walls
- Our "2 to a set" configuration cuts on the inward motion only
- The "4 to a set" configuration, assembled back to back, cuts on both the inward and outward motions
- All discs are furnished with standard quick-change eyelet
- Plain hole sizes must be specified and are available for quotation as made-to-order products

			TICO		
			TIER:	BEST	GOOD
			TRADENAME:	BLAZE R920	MERIT R228
			ABRASIVE:	Ceramic Alumina	Aluminum Oxide
DIA		0.017	OTHER:	Supersize, 2 Per Set	2 Per Set
DIA.	EYELET	GRIT	STD. PKG.	PART #	PART #
1	8-32	60	100		088341 84346
		80	100		088341 84019
		100	100		088341 84224
		120	100		088341 84151
1-1/4	8-32	60	100		088341 84270
		80	100		088341 84065
		100	100		088341 84291
		120	100		088341 84084
1-1/2	8-32	60	100	662611 95051	088341 84066
		80	100	662611 95368	088341 84079
		100	100		088341 84279
		120	100		088341 86035
1-3/4	8-32	60	100		088341 84655
		80	100		088341 84042
2	8-32	60	100	662611 95054	
		80	100	662611 95055	088341 84076
		100	100		088341 84145
		120	100	662611 95056	
2-1/2	8-32	80	100		088341 84444
3	1/4-20	60	100	662611 95057	088341 84041
		80	100	662611 95058	088341 84077
		100	100		088341 84082
		120	100		088341 84344
4	1/4-20	60	100		088341 84000
		120	100		088341 85155
4-1/2	1/4-20	100	100		088341 84431

All overlap slotted discs are available (made-to-order) reinforced with a fiber washer

Ceramic Alumina and Alumina Oxide overlap slotted discs are also available upon request as made-to-order products. Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Quick-Change Mandrels for Overlap Slotted Discs, Square and Cross Pads

CROSS PAD SIZE DIA.	SQUARE PAD SIZE DIA.	OVERALL LENGTH	MODEL NO.	THD. SIZE	PART #
1/4, 3/8, and 1/2 wide		2-1/2	MM48-4	3-48	088341 83162
3/4, 1 wide	Up thru 1-1/2 sq. x 1/2 thick	3	MM32-4	8-32	088341 83163
	2 sq. x 1/4 or 3/8 thick	4	MM-32-4-4	8-32	088341 21680
		6	MM-32-4-6	8-32	088341 21681
All pads 2-1/2 x 1-1/2 and larger	2 sq. x 1/4 or 1/2 thick and larger	3	MM20-4	1/4-20	088341 83164

For overlap slotted discs, choose a mandrel with the same thread size as the disc



QUICK-CHANGE MANDREL



EXTENDED MANDREL



PORTABLE TOOLS AND SPECIALTIES Spiral Bands

Best product for blending and polishing contours when smooth running is a primary concern. Used for finishing hard-to-reach areas, removing parting lines, imperfections, and burrs on all surfaces.

Spiral construction avoids shadow marks and provides smooth, chatter-free cutting action.

Achieves close tolerances when finishing curved, contoured, and hard-to-reach areas. Fast

cutting and removes toughest metal. Bands are easily removed and replaced.

Benefits:

Grit Range: Abrasive Grain: Backing: Other: Machine Used:

24 - 320 Ceramic Alumina, Aluminum Oxide X-weight cotton Use with rubber expanding drum



Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)

24	36	40	50	60	80	120	180	240	320
Heavy Stoc	k Removal								
	Blending Ou	ut Heavy Machine	Marks						
	Removing H	Heavy Burrs							
	Applying He	eavy Scratch Patte	rn						
	Removing F	Flash/Parting Lines	6						
	Removing F	Rust/Scale/Pit Mar	ks						
			Preparing I	Metal for Painting					
			Blending O	ut Medium Machin	e Marks				
					Blending Me	tal Surfaces			
					Applying Lig	ht Scratch Pattern			
							Fine Blendin	g and Cleaning	
								Metal Finishi	ng and Polishing



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the next-generation of sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant
- · Advanced, full resin bond system designed to promote exceptional grain retention for additional product life
- X-weight cotton backing and spiral construction avoid shadow marks and provide smooth, chatter-free cutting action

Good starting specification for all types of metal

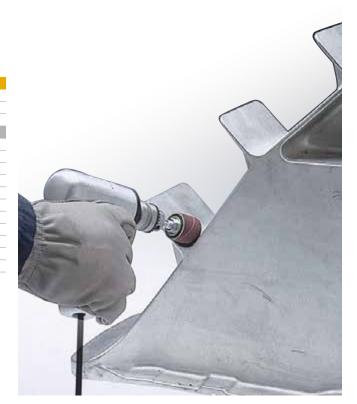


MERIT R228 ALUMINUM OXIDE

- Tough and durable quality aluminum oxide abrasive removes tough metal
- · X-weight cotton backing and spiral construction avoid shadow marks and provide smooth, chatter-free cutting action
- · Achieves close tolerances on curved, contoured, and hard-to-reach areas

Industrial Market - Full-Line

PORTABLE TOOLS AND SPECIALTIES Spiral Bands







TIER: BEST RADENAME: BLAZE R920 ABRASIVE: Ceramic Alumina OTHER: Supersize PART # 66261146014 66261146017
ABRASIVE: Ceramic Alumina OTHER: Supersize . PART # 66261146014
OTHER: Supersize . PART # 662611 46014
. PART # 662611 46014
662611 46014
662611 46017
662611 46018
662611 46021
662611 46022
662611 46025
662611 46026
662611 46029
662611 46030
662611 46033
662611 46034



0	
GOOD	
MEDIT DOOD	_

TIER: COOD TRADENAME: MERIT R228 ABRASIVE: Aluminum Oxic

			ABRASIVE:	Aluminum Oxide
	0017	STOCK	NON-STOCK	
SIZE (D x W)	GRIT	PKG. QTY.	MOQ	PART #
1x1	36	100/box	300	088341 96072
	40	100/box	300	088341 96073
	50	100/box	300	088341 96184
	60	100/box	300	08834196075
	80	100/box	300	08834196074
	120	100/box	300	08834196177
1 x 1-1/2	36	100/box	200	08834196525
1 x 2	80	100/box	200	088341 96268
1 x 3	36	100/box	100	08834196665
	50	100/box	100	08834197688
	60	100/box	100	08834196676
	120	100/box	100	08834196197
1-1/2 x 1-1/2	36	100/box	200	08834196164
	50	100/box	200	088341 96176
	60	100/box	200	08834196091
	80	100/box	200	08834196165
0 1 1				

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Continued

TIER	GOOD
TRADENAME	MERIT R228
ABRASIVE	Aluminum Oxide
NON-STOCK	
MOQ	PART #
300	088341 96645
300	088341 96228
300	08834196179

SIZE (D x W)	GRIT	PKG. QTY.	MOQ	PART #
3/8 x 1	80	100/box	300	088341 96645
1/2 x 1/2	50	100/box	300	088341 96228
	80	100/box	300	088341 96179
	100	100/box	300	088341 96189
	120	100/box	300	088341 96069
	180	100/box	300	08834196209
1/2 x 1	36	100/box	300	088341 96591
	60	100/box	300	088341 96212
	80	100/box	300	088341 96215
1/2 x 2	80	100/box	200	08834196669
3/4 x 3/4	60	100/box	300	088341 96168
	80	100/box	300	088341 96161
3/4 x 1	36	100/box	300	088341 96261
	50	100/box	300	088341 96515
	60	100/box	300	088341 96070
	80	100/box	300	088341 96071
	120	100/box	300	088341 96219
3/4 x 1-1/2	60	100/box	300	088341 96554
	80	100/box	300	088341 96249
3/4 x 2	80	100/box	200	088341 96756

STOCK

PORTABLE TOOLS AND SPECIALTIES Spiral Bands



1-1/2 x 1-1/2 x

2 x 1

2 x 2

2-1/4 x



08834196270

08834196729

08834195857



		TRADENAME:	GOOD MERIT R228 Aluminum Oxide
GRIT	STOCK PKG. OTY.	NON-STOCK Moo	PART #
60	100/box	200	088341 96067
80	100/box	200	08834196533
60	100/box	100	08834196703
80	100/box	100	08834196809
120	100/box	100	08834196343
80	100/box	200	088341 96166
120	100/box	200	088341 96595
36	100/box	200	08834196110
60	100/box	200	08834196173
36	100/box	100	088341 97140
50	100/box	100	08834196620
	80 60 80 120 80 120 36 60 36	GRIT PKG. QTY. 60 100/box 80 100/box 60 100/box 80 100/box 120 100/box 80 100/box 120 100/box 120 100/box 120 100/box 36 100/box 36 100/box 36 100/box 36 100/box	TRADENAME: ABRASIVE: STOCK GRIT NON-STOCK PKG. QTY. NON-STOCK MOQ 60 100/box 200 80 100/box 200 80 100/box 100 80 100/box 100 80 100/box 100 120 100/box 200 120 100/box 200 36 100/box 200 60 100/box 200 36 100/box 200 36 100/box 100

100

100

100

				GOOD MERIT R228
			ABRASIVE:	Aluminum Oxide
SIZE (D x W)	GRIT	STOCK PKG. QTY.	NON-STOCK Moq	PART #
3 x 2	80	100/box	100	088341 96265
3 x 3	36	100/box	100	088341 96262
	50	100/box	100	08834196253
	60	100/box	100	088341 96188 NS
	80	100/box	100	08834196159
	100	100/box	100	08834196250

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Expanding Rubber Drums

80

120

150

100/box

100/box

100/box

Spiral Bands are easily removed and replaced on the rubber expanding drum.





TIER: GOOD TRADENAME: RUBBER EXPANDING DRUMS

LIEK:	GUUD
TRADENAME:	RUBBER
	EXPANDING DRUM
STD.	
PKG.	PART #
1	08834196914 NS

DRUM Diameter	WIDTH	SHANK DIAMETER	MAX. RPM	STD. PKG.	PART #
1/4	1/2	1/8	30,000	1	088341 96030
3/8	1/2	1/4	30,000	1	088341 96944 NS
3/8	1	1/8	18,000	1	088341 96011 NS
1/2	1/2	1/4	30,000	1	088341 96904
1/2	1	1/4	15,000	1	088341 96906
1/2	1-1/2	1/4	12,000	1	088341 96907
1/2	2	1/4	10,000	1	088341 96908
3/4	1/2	1/4	27,000	1	088341 96909 NS
3/4	3/4	1/4	24,000	1	088341 96910 NS
3/4	1	1/4	17,000	1	088341 96911
3/4	1-1/2	1/4	10,000	1	08834196912
3/4	2	1/4	10,000	1	088341 96913
NS Non-stor	ck_contact_vo	ur Norton reni	esentative for	current order	quantities

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

					EXPANDING DRUM
DRUM		SHANK	MAX.	STD.	
DIAMETER	WIDTH	DIAMETER	RPM	PKG.	PART #
1	1/2	1/4	20,000	1	088341 96914 NS
1	1	1/4	18,000	1	088341 96916
1	1-1/2	1/4	10,000	1	088341 96917
1	2	1/4	8,000	1	088341 96918
1-1/2	1	1/4	12,000	1	088341 96921
1-1/2	1-1/2	1/4	10,000	1	088341 96922
1-1/2	2	1/4	8,000	1	088341 96923
2	1	1/4	11,000	1	088341 96926
2	1-1/2	1/4	8,000	1	088341 96927
2	2	1/4	6,000	1	088341 96928
3	1	3/8	3,000	1	088341 96929 NS
3	2	3/8	3,000	1	088341 96930 NS
3	3	3/8	3,000	1	08834196931



PORTABLE TOOLS AND SPECIALTIES Tapered Cone Points

Tapered cone points are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive. Tapered cone points are similar to cartridge rolls but their shape lends greater accessibility to many difficult-to-reach work areas. They are used for deburring holes and in close tolerance work areas.

Applications:	Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking.
Grit Range:	50 - 320
Abrasive Grain:	Aluminum Oxide
Backing:	X-weight cotton
Construction:	Popular sizes and mandrels are listed, with additional sizes available upon request as made-to-order products
	Ceramic alumina and silicon carbide cone points are available upon request as made-to-order products
Maximum RPM:	1/8" to 1/2" - 23,000
	5/8" to 1" - 18,000
	1" to 1-1/2" — 15,000
Machine Used:	
	DIE GRINDER

Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)

36	40	50	60	80	120	180	240	320
Blending Out	Heavy Machine Marks							
Removing He	avy Burrs							
Applying Hea	vy Scratch Pattern							
Removing Fla	sh/Parting Lines							
Removing Ru	ist/Scale/Pit Marks							
		Preparing Metal fo	r Painting					
		Blending Out Medi	um Machine Marks					
				Blending Metal Sur	faces			
				Applying Light Scra	atch Pattern			
						Fine Blending and (Cleaning	
							Metal Finishing and	l Polishing



Good starting specification for flash removal, polishing, or removing machine tool marks and edge breaking on all types of metal in difficult-to-reach work areas

MERIT R228 ALUMINUM OXIDE TAPERED CONE POINTS

- · Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive

		TIER	GOOD
		TRADENAME	MERIT R228
		ABRASIVE	Aluminum Oxide
SIZE (D x L)	GRIT	STD. PKG.	PART #
3/16 x 1	60	500	088341 86893
Use K-110 Mandrel	80	500	088341 80918
	100	500	088341 82197
	120	500	088341 82199
	150	500	08834182200
	180	500	088341 86894
	240	500	088341 86895
	320	500	08834182855

		IIER	GUUD
		TRADENAME	MERIT R228
		ABRASIVE	Aluminum Oxide
SIZE (D x L)	GRIT	STD. PKG.	PART #
5/16 x 1-1/2	80	500	088341 80873
Use B-20 Mandrel	100	500	088341 82043
	120	500	088341 82717
	150	500	088341 86890
	240	500	088341 82044
	320	500	088341 82537

Continued

Refer to next page for mandrels.



PORTABLE TOOLS AND SPECIALTIES Mandrels

Cartridge and Spiral Roll Mandrels

MODEL #	PILOT DIA.	PILOT LENGTH	SHANK DIA.	SHANK LENGTH	OVERALL LENGTH	PART #
Cartridge and S	piral Roll Mandrels					
M-2E	3/32	3/4	1/4	1	3	088341 83799 NS
M-2	3/32	1	1/8	1	3	088341 81202
M-3	1/8	1/2	1/8	1	2-1/2	088341 81203
M-4	1/8	3/4	1/8	1	2-1/2	088341 81204
M-5	1/8	1	1/8	1	2-3/4	088341 81205
M-6	1/8	1-1/2	1/8	1	2-1/2	088341 81206 NS
M-7	1/8	1/2	1/4	1-1/4	2-1/4	088341 81207
M-8	1/8	3/4	1/4	1-1/4	2-1/2	088341 81208
N-9	1/8	1	1/4	1-1/4	2-3/4	088341 81209
VI-10	1/8	1-1/2	1/4	1-1/4	3-1/4	088341 81210
И-11	1/8	2	1/4	1-1/4	4	088341 81211 NS
И-12	3/16	1/2	1/8	1-1/4	2-1/4	088341 81212 NS
M-13	3/16	3/4	1/8	1-1/4	2-1/2	08834181213 NS
VI-14	3/16	1/2	1/4	1-1/4	2-1/2	088341 81214 NS
VI-16	3/16	1	1/4	1-1/4	3	088341 81216
VI-17	3/16	1-1/2	1/4	1-1/4	3-1/2	088341 81217
VI-18	3/16	2	1/4	1-1/4	4	088341 81218
И-19	1/4	1/2	1/4	1-1/4	2-1/2	08834181219 NS
M-21	1/4	1	1/4	1-1/4	3	088341 81221
Л-22	1/4	1-1/2	1/4	1-1/4	3-1/2	088341 81222
Л-23	1/4	2	1/4	1-1/4	4	08834181223 NS
Л-24	5/16	3/4	1/4	1-1/4	2-3/4	088341 81224 NS
Л-25	5/16	1	1/4	1-1/4	3	088341 81225 NS
Л-26	5/16	1-1/2	1/4	1-1/4	3-1/2	088341 81226 NS
Л-27	5/16	2	1/4	1-1/4	4	088341 81227 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times. Standard Package = 1

Recommended Pilot Length for Mandrels

	0
3/4 Roll Length	Use 1/2 Pilot
1 Roll Length	Use 3/4 Pilot
1-1/2 Roll Length	Use 1 Pilot
2 Roll Length	Use 1-1/2 Pilot

Extra Shank Length Mandrels for Cartridge Rolls and Spiral Rolls

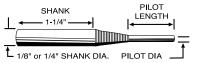
MODEL #	SHANK LENGTH	OVERALL LENGTH	PART NO.				
Extras Shank Length Mandrels							
M-8-4	4	5-1/4	088341 80116				
M-8-6	6	7-1/4	088341 80122				
M-9-2.5	2-1/2	4	088341 80096				
M-9-3	3	4-1/2	088341 80129				
M-9-4	4	5-1/2	088341 80074 NS				
M-9-6	6	7-1/2	088341 80131				
M-10-4	1-3/4	4	088341 80092 NS				
M-10-6	3-3/4	6	08834180145				

All Extra Shank Length mandrels are 1/4" diameter

NS Non-stock. Contact your Norton representative for current order quantities and lead-times. Standard Package = 1

Tapered Cone Point Mandrels

DESCRIPTION	SHANK	PART #
Cone Point Mandrels		
A-10	1/4	088341 81300
B-20	1/4	088341 81301
C-30	1/4	088341 81302
D-40	1/4	088341 81303
E-50	1/4	088341 81304
F-60	1/4	088341 81305
G-70	1/4	088341 81306
I-90	1/4	088341 81308
K-110	1/8	088341 81310
Standard Package = 1		



PORTABLE TOOLS AND SPECIALTIES Test Kits





These test kits feature the most popular range and sizes of our coated specialty products in convenient kit formats. Ideal for small job shops, or for travelling to a job site. Our cartridge roll kits are great when you need a small quantity, but a wide range of grits and sizes



Ceramic Alumina Cartridge Roll Test Kit

• Part # 662610**66726**

· Kit includes a variety of our ceramic alumina cartridge rolls, spiral rolls and mandrels in popular sizes and grits.

Aluminum Oxide Cartridge Roll Test Kit "CR"

- Part # 088341**81061**
- Includes over 120 pieces of our most popular sizes, grits and shapes with their appropriate mandrels.





Porting Test Kit "APK-MO"

- Part # 08834169032
- The samples in this kit highlight specialties for general metal and wood working polishing and finishing applications.



PORTABLE TOOLS AND SPECIALTIES Non-Woven Specialties

Cross Buffs

Best choice for blending, cleaning and polishing

CROSS BUFFS

- Unique design is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- Premium aluminum oxide grain for excellent cutting and finishing
- · Firm durable web for high resistance to tearing on burrs and sharp edges

				TIER: BEST
			TRADEN	AME: HIGH STRENGTH
			ABRAS	SIVE: Aluminum Oxide
			ATTACHN	IENT: 8-32 Eyelet
SIZE (D x W)	GRIT	PLY	STD. PKG.	PART #
1-1/2 x 1/2	Medium	2	100	088341 89308
	Very Fine	2	100	088341 89307 NS
	Very Fine	3	100	088341 89309 NS

8-32 eyelets: Attach to MM32-4 mandrel. Part No. 08834183163 (See description at end of Overlap lotted Disc Section) NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Surface Preparation Stars



The perfect item for ID work

MERIT SURFACE PREPARATION STARS

- Star shape design is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- · Premium aluminum oxide grain for excellent cutting and finishing
- · Firm durable web for high resistance to tearing on burrs and sharp edges

		TIER:	GOOD
		TRADENAME:	MERIT SURFACE PREP
		ABRASIVE:	Aluminum Oxide
		ATTACHMENT:	1/4-20 Eyelet
SIZE (D x EYELET)	GRIT	STD. PKG.	PART #
1-1/2 x 1/4-20	С	100	088341 85923
	VF	100	088341 85925
2 x 1/4-20	С	100	088341 85926 NS
	Μ	100	088341 85927 NS
	VF	100	088341 85928 NS
3 x 1/4-20	С	100	088341 85929 NS
	Μ	100	088341 85678 NS
	VF	100	088341 85931 NS
4 x 1/4-20	Μ	100	088341 85933 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

1/4-20 eyelets attach to MM20-4 mandrel, Part # 08834183164 (See description at end of Overlap Slotted Disc Section.)





PORTABLE TOOLS AND SPECIALTIES Non-Woven Specialties

Non-Woven 1/4" Steel Shank Disc Wheels



BLAZE RAPID STRIP DISCS

- · Ceramic alumina grain provides 2X cut rate, 2X life over silicon carbide products
- · Advanced resin bond does not shed on rust-encrusted pieces, and prevents gouging and rework; does not snag when used for deburring
- Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering

Best choice for light deburring and finishing



DISC WHEELS

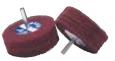
- · Durable, longer lasting aluminum oxide abrasive leaves a more polished finish
- · Discs are ganged together to form a wheel that is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- . These wheels are mounted on a 1/4 inch steel mandrel embedded in a strong epoxy core



TIER: B TRADENAME: BLAZE RAPID STRIP

				ADI	NASIVE. Gerannic Alumina
SIZE (D x 1/4 SHANK)	GRIT	PLY	MAX. RPM	STD. PKG.	PART #
4	Extra Coarse	1 Ply	8,000	5	776960 05713 NS
4	Extra Coarse	2 Ply	8,000	5	666233 75051 NS
	AL 1 1 1 1				

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.



					TIER: BEST
				TRAD	ENAME: HIGH-STRENGTH
				AB	RASIVE: Aluminum Oxide
SIZE (D x 1/4 SHANK)	GRIT	PLY	MAX. RPM	STD. PKG.	PART #
-	Medium	2 Ply	12,000	10	088341 31551
	Medium	4 Ply	12,000	10	088341 31554
	Medium	2 Ply	8,000	10	088341 31558
	Very Fine	3 Ply	8,000	10	088341 31560
}	Medium	4 Ply	8,000	10	088341 31496
	Fine	5 Ply	8,000	10	088341 31557
	Very Fine	5 Ply	8,000	10	088341 31497
	Fine	3 Ply	6,000	10	088341 31562 NS
	Medium	4 Ply	6,000	10	088341 31564
)	Medium	2 Ply	4,000	10	088341 31567 NS
	Medium	4 Ply	4,000	10	088341 31570
	Fine	5 Ply	4,000	10	088341 31571 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Disc wheels are constructed by number of plys.

Used for a wide range of metal fabrication and welding applications including stock removal,

Flap wheels are an ideal choice for a wide variety of blending, deburring and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away, continually exposing fresh abrasives.

Applications:

Size Range:

Grit Range: Abrasive Grain:

Machine Used:

blending, deburring, cleaning, finishing, and polishing Flap wheels with mounted steel shanks: 3/8" - 3" diameter Flap wheels with mounted 1/4"-20 thread: 1" - 3" diameter Flap wheels with arbor holes: 3" - 16" diameter 40 - 320

Ceramic Alumina, Aluminum Oxide Blend, Aluminum Oxide



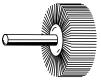
Shape Recommendation Guide

Shape

VDRTDN

SAINT-GOBAIN

Description/Application



Flap Wheels with Mounted Steel Shanks

Flap Wheels with Mounted 1/4"-20 Thread

air tools when using other abrasive products.

Wheels are designed with a 1/4"-20 thread and flange as an integral part of the wheel. These threads facilitate the quickest changes on air tools using flap wheels exclusively, as there are no special tools needed to change the flap wheel. Also allow extended reach with accessory mandrels.

Wheels are designed with a 1/8" or 1/4" steel shank as an integral part of each wheel. These shanks run through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on



Flap Wheels with Arbor Holes

For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.

Application/Grit Recommendation Guide

COARSER (G	RINDING)						FINER (FINISHING)
40	50	60	80	120	180	240	320
Blending Out He	avy Machine Marks	S					
Removing Heav	y Burrs						
Applying Heavy	Scratch Pattern						
Removing Flash	/Parting Lines						
Removing Rust	Scale/Pit Marks						
	Preparing M	letal for Painting					
	Blending Out	t Medium Machine Marks					
			Blending Metal Surf	aces			
			Applying Light Scra	tch Pattern			
					Fine Blending a	nd Cleaning	
						Metal Finishin	g and Polishing

BLAZE, PINK, R369 HIGH PERFORMANCE See Non-Woven Flap Wheel section for Interleaf Flap Wheels R207

INTERLEAF





Best choice for hard-to-grind materials, including superalloys (cobalt, inconel, and titanium) and stainless steel

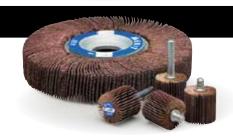
BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the next-generation of sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant
- X-weight cotton flaps provide conformability and even wear
- · Advanced self-lubricating grain treatment reduces heat on hard-to-grind materials

Better choice for blending, deburring and finishing on a wide range of materials

PINK R928 CERAMIC ALUMINA

- Ceramic grain provides better performance than zirconia alternatives
- Improved resin bond system provides longer life
- Versatile X-weight poly cotton backing for flexibility and life



Good choice for more durable flap wheel applications where aggressive cut and superior life are required

MERIT R369 HIGH PERFORMANCE A/O BLEND

- · Long-lasting premium aluminum oxide blend with 2 to 3 times longer life
- Delivers an excellent cut rate on finishing operations
- · Heavy cotton blended flaps provide extended durability, conformability, and superior wear resistance



Better choice for more flexible flap wheel applications where finish is required

MERIT R207 ALUMINUM OXIDE

- · Solid-performing aluminum oxide abrasive delivers uniform stock removal and long life
- · Heavy X-weight cotton flaps provide conformability and even wear
- · Good general purpose starting specification for small deburring and cleaning jobs



Flap Wheel Test Kits

- Mini 1/4"-20 Thread Test Kit "CQ"
- Part # 088341**38001**
- Includes ten, 1" to 3" diameter, 1/4"-20 thread mini flap wheels
- Each kit includes a 1/4"-20 QC-4 quick-change adapter
- Mini1/4" Steel Shank Test Kit "CMM"
- Part # 08834138004
- Includes ten wheels, 1" to 3" diameter in various grits
- The flap wheels are mounted on a 1/4" diameter hardened steel shank

Micro Mini 1/8" Steel Shank Test Kit "MMC"

- Part # 08834131493
- Includes 5 wheels, 3/8" to 1-3/16" in diameter
- The flap wheels are mounted on a 1/8" diameter hardened steel shank
- Ideal for fast polishing and light deburring of holes or grooves



Micro-Mini Flap Wheels with 1/8" Mounted Steel Shanks

- The smallest flap wheels, ranging from 3/8" to 1-3/16" diameter, mounted on a 1/8" diameter steel shank
- Provide fast polishing and light deburring of internal workpieces with holes or grooves as small as 1/2"



			TIER:	GOOD	
			TRADENAME:	MERIT R369	
			ABRASIVE:	Premium Aluminum Oxide	
			BACKING:	Y-Weight Cotton	
SIZE (D x W x SK.)	ODIT	MAX.	STD. PKG.	DADT #	
3/8 x 3/8 x 1/8	GRIT 60	RPM		PART # 088341 37470	S 3
3/8 X 3/8 X 1/8	80	40,000	10		3,
	120	40,000	10	088341 37471 088341 37472	
		,			
	180 240	40,000	10 10	088341 37473 088341 37474	
	320	40,000	10		
5/8 x 5/8 x 1/8		40,000	10	088341 37475	0
0/0 X 0/0 X 1/0	60	37,000		088341 37480	3
	80	37,000	10 10	088341 37481	
		37,000		088341 37482	
	180 240	37,000	10	088341 37483	
	320	37,000 37,000	10 10	088341 37484 088341 37485	1
E/0 x 2/4 x 1/0					I.
5/8 x 3/4 x 1/8	80	37,000	10 10	088341 37541	
	120	37,000 37,000	10	088341 37542 088341 37543	
		,			1
	240 320	37,000	10 10	088341 37544 088341 37545	- P
3/4 x 3/16 x 1/8		37,000			
3/4 X 3/10 X 1/8	60 80	35,000	10 10	08834137550	
	120	35,000 35,000	10	088341 37551 088341 37552	
	120	35,000	10		
	240		10	088341 37553 088341 37554	1
	320	35,000 35,000	10	08834137555	I.
3/4 x 3/8 x 1/8	60	35,000	10	088341 37560	
3/4 X 3/0 X 1/0	80	35,000	10	088341 37561	
	120	35,000	10	088341 37562	
	120	35,000	10	088341 37563	S
	240	35,000	10	088341 37564	
	320	35,000	10	088341 37565	q
3/4 x 1/2 x 1/8	60	35,000	10	08834137570	
J/4 X 1/2 X 1/0	80	35,000	10	088341 37571	
	120	35,000	10	08834137572	
	120		10	08834137573	
	240	35,000 35,000	10	088341 37574	
	320		10	088341 37575	
	520	35,000	IU	0003413/3/3	

			TIER: TRADENAME:	MERIT R369
			ABRASIVE:	Premium Aluminum Oxide
			BACKING:	Y-Weight Cotton
		MAX.	STD.	, in the second s
SIZE (D x W x SK.)	GRIT	RPM	PKG.	PART #
8/4 x 5/8 x 1/8	60	35,000	10	088341 37580
	80	35,000	10	088341 37581
	120	35,000	10	088341 37582
	180	35,000	10	088341 37583
	240	35,000	10	088341 37584
	320	35,000	10	088341 37585
8/4 x 3/4 x 1/8	60	35,000	10	088341 37590
	80	35,000	10	088341 37591
	120	35,000	10	08834137592
	240	35,000	10	08834137594
	320	35,000	10	08834137595
-3/16 x 1/8 x 1/8	80	30,000	10	088341 37491
	120	35,000	10	088341 37492
	180	35,000	10	08834137493
	320	35,000	10	088341 37495
-3/16 x 3/16 x 1/8	60	30,000	10	088341 37508
	80	35,000	10	088341 37501
	120	35,000	10	088341 37502
	180	35,000	10	088341 37503
	240	35,000	10	088341 37504
	320	35,000	10	088341 37505
-3/16 x 3/8 x 1/8	80	30,000	10	088341 37511
	120	35,000	10	088341 37512
	180	35.000	10	08834137513
	240	35,000	10	088341 37514
	320	35,000	10	088341 37515

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.



Micro-Mini Test Kit "MMC"

- Part # 088341**31493**
- Includes five wheels, 3/8" to 1-3/16" diameter in various grits, mounted on a 1/8" diameter hardened steel shank
- The "MMC" kit is ideal for fast polishing and light deburring of internal holes or grooves as small as 1/2"





Mini Flap Wheels with 1/4" Mounted Steel Shanks

• Small flap wheels, ranging from 1" to 3" diameter, mounted on a 1/4" diameter steel shank

· Very durable, long-lasting mini flap wheels for demanding, heavy stock removal applications

							Since
			TIER:	BEST	BETTER	GOOD	GOOD
			TRADENAME:	BLAZE R920	PINK R928	MERIT R369	MERIT R207
			ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Premium Aluminum Oxide	Aluminum Oxide
				X-Weight Cotton	X-Weight Poly/Cotton	Y-Weight Cotton	X-Weight Cotton
SIZE (D x W x SK.)	GRIT	MAX. RPI	M STD. PKG.	PART #	PART #	PART #	PART #
1 x 1/2 x 1/4	80	30,000	10				
	120	30,000	10				
1 x 5/8 x 1/4	40	30,000	10			088341 37105	
	60	30,000	10			088341 37100	636425 02576
	80	30,000	10			088341 37101	636425 02577
	120	30,000	10			088341 37102	636425 02578
	180	30,000	10			088341 31536	
	240	30,000	10			088341 37104	
1 x 1 x 1/4	40	30,000	10		699573 39701	088341 31259	
	60	30,000	10	662611 51170	699573 39702	088341 37310	636425 02580
	80	30,000	10	662611 51171	699573 39703	088341 37311	636425 02581
	120	30,000	10	662611 51172	699573 39704	088341 37312	636425 02582
	180	30,000	10			088341 37313	
	240	30,000	10			088341 37114	
	320	30,000	10			088341 37315	
1-3/8 x 5/8 x 1/4	60	30,000	10			088341 37320	
	80	30,000	10			088341 37321	
	120	30,000	10			088341 37322	
	180	30,000	10			088341 37323	
	240	30,000	10			088341 37324	
1-1/2 x 1/2 x 1/4	60	25,000	10				
	80	25,000	10				
1-1/2 x 1 x 1/4	40	25,000	10			088341 35140	
	60	25,000	10			088341 37340	636425 02592
	80	25,000	10			088341 37141	636425 02593
	120	25,000	10			088341 37142	636425 02594
	180	25,000	10			088341 37343	
	240	25,000	10			088341 32101	
1-1/2 x 1-1/2 x 1/4	40	25,000	10			088341 30642	
	60	25,000	10			088341 30643	
	80	25,000	10			088341 30644	
	120	25,000	10			088341 30641	
	180	25,000	10			088341 30695	
2 x 1/2 x 1/4	60	25,000	10				
	80	25,000	10				
	120	25,000	10				
2 x 3/4 x 1/4	40	25,000	10			088341 37158	
	60	25,000	10			088341 37160	
	80	25,000	10			088341 37161	
	120	25,000	10			088341 37162	
	180	25,000	10			088341 37163	

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. Continued





Mini Flap Wheels with 1/4" Mounted Steel Shanks continued

			7/50			0000	
			TRADENAME:	BEST BLAZE R920	BETTER PINK R928	GOOD MERIT R369	GOOD MERIT R207
						Premium	
			ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide	Aluminum Oxide
			BACKING:	X-Weight Cotton	X-Weight Poly/Cotton	Y-Weight Cotton	X-Weight Cotton
SIZE (D x W x SK.)	GRIT	MAX. RP	M STD. PKG.	PART #	PART #	PART #	PART #
2 x 1 x 1/4	40	25,000	10		699573 39705	088341 37377	
	60	25,000	10	662611 51173	699573 39706	088341 37370	636425 02600
	80	25,000	10	662611 51174	699573 39711	088341 37371	636425 02601
	120	25,000	10		699573 39712	088341 37372	636425 02602
	180	25,000	10			088341 37373	
	240	25,000	10			088341 37374	
	320	25,000	10			088341 37375	
2 x 1-1/2 x 1/4	40	25,000	10			088341 37183	
	60	25,000	10			088341 37380	
	80	25,000	10			088341 37381	
	120	25,000	10			088341 37382	
	180	25,000	10			088341 37383	
2-1/2 x 1 x 1/4	40	20,000	10			088341 37408	
	60	20,000	10			088341 37410	636425 02608
	80	20,000	10			088341 37411	636425 02609
	120	20,000	10			08834137412	636425 02610
	180	20,000	10			088341 37413	
	240	20.000	10			08834137633	
	320	20,000	10			08834137415	
2-1/2 x 1-1/2 x 1/4	60	20,000	10			08834137420	
	80	20.000	10			08834137421	
	120	20,000	10			088341 37422	
3 x 1/2 x 1/4	60	20,000	10				636425 02612
	120	20,000	10				636425 02614
3 x 3/4 x 1/4	60	20,000	10			088341 37440	000 12002011
	80	20,000	10			088341 37441	
3 x 1 x 1/4`	40	20,000	10		699573 39713	088341 37456	
0 X 1 X 1/ 1	60	20,000	10	662611 51176	699573 39714	088341 37450	636425 02620
	80	20,000	10	662611 51177	699573 39715	088341 37451	636425 02621
	120	20,000	10	662611 51178	699573 39716	088341 37252	636425 02622
	180	20,000	10			088341 37253	
	240	20,000	10			088341 35339	
	320	20,000	10			088341 35341	
3 x 2 x 1/4	40	12,000	10			088341 37460	
5 X E X 1/ 1	60	12,000	10			088341 37260	
	80	12,000	10			088341 37261	
	120	12,000	10			088341 37262	
	120	12,000	10				

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.



Mini 1/4" Steel Shank Test Kit "CMM"

- Part # 08834138004
- Includes ten wheels, 1" to 3" diameter in various grits mounted on a 1/4" diameter hardened steel shank





Mini Flap Wheels with 1/4"-20 Thread

- Mini flap wheels ranging from 1" to 3" diameter, mounted on a 14-20 thread that allows you to quickly spin the wheels
 on and off with no tools
- Designed for polishing and finishing intricate surfaces; cost-effective replacement for brushes, rubber points, and felt bobs



$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$	OD
ABRASIVE: Ceramic Alumina Premium Aluminum Oxide Alu BACKING: X-Weight Poly/Cotton Y-Weight Cotton X-Veight Cotton X-Ve	
BACKING: X-Weight Poly/Cotton Y-Weight Cotton X-Veight Cotton SIZE (D x W x THD.) GRIT MAX. RPM STD. PKG. PKG. PART # PART # PA 1 x 5/8 x 1/4-20 60 30,000 10 08834131001 630 120 30,000 10 08834131003 630 120 30,000 10 08834131003 630 120 30,000 10 69957339718 08834131002 630 1 x 1 x 1/4-20 40 30,000 10 69957339719 08834131009 630 80 30,000 10 69957339720 08834131010 630 240 30,000 10 69957339721 08834131012 630 320 30,000 10 08834131012 630 630 630 240 30,000 10 08834132001 633 633 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 633 120 30,000 10 <th>ERIT R207</th>	ERIT R207
MAX. STD. PKG. PART # PART # PART # PA 1 x 5/8 x 1/4-20 60 30,000 10 08834131001 636 80 30,000 10 08834131002 636 120 30,000 10 08834131003 636 120 30,000 10 69957339718 08834131003 636 1 x 1 x 1/4-20 40 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 08957339721 08834131012 320 30,000 10 08834131012 320 30,000 10 08834132001 636 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 637 120 30,000 10 08834132001 637 32002 633 120 30,000 10	ıminum Oxide
SIZE (D x W x THD.) GRIT RPM PKG. PART # PART # PA 1 x 5/8 x 1/4-20 60 30,000 10 08834131001 636 80 30,000 10 08834131002 633 120 30,000 10 08834131003 636 120 30,000 10 69957339718 08834131003 636 1 x 1 x 1/4-20 40 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339720 08834131010 636 240 30,000 10 08834131012 306 306 306 240 30,000 10 08834131012 306 <td>Weight Cotton</td>	Weight Cotton
1 x 5/8 x 1/4-20 60 30,000 10 08834131001 636 80 30,000 10 08834131002 636 120 30,000 10 08834131003 636 1x 1 x 1/4-20 40 30,000 10 69957339718 08834131008 636 1 x 1 x 1/4-20 40 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 08834131012 636 320 30,000 10 08834131013 637 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 637 80 30,000 10 08834132001 637 637 240 30,000 10 08834132001 637 637 637 637 637 637 637 637 637 6	
80 30,000 10 08834131002 636 120 30,000 10 08834131003 636 1 x 1 x 1/4-20 40 30,000 10 69957339718 08834131003 636 60 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 69957339721 08834131012 636 320 30,000 10 08834131012 636 320 30,000 10 08834131013 636 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132001 637 80 30,000 10 08834132002 637 120 30,000 10 08834132003 636 120 30,000 10 08834132	
120 30,000 10 08834131003 636 1 x 1 x 1/4-20 40 30,000 10 69957339718 08834131027 60 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 633 120 30,000 10 69957339721 08834131010 636 240 30,000 10 69957339721 08834131010 636 240 30,000 10 08834131012 636 60 30,000 10 08834132001 636 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132001 636 80 30,000 10 08834132002 637 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636	6425 02624
1 x 1 x 1/4-20 40 30,000 10 69957339718 08834131027 60 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 08834131012 320 30,000 10 08834131012 320 30,000 10 08834132001 636 636 636 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 120 30,000 10 08834132002 633 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	6425 02625
60 30,000 10 69957339719 08834131008 636 80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 08834131012 320 30,000 10 08834131012 320 30,000 10 08834132001 636 636 636 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132002 638 120 30,000 10 08834132002 638 120 30,000 10 08834132003 636 120 30,000 10 0883413203 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	6425 02626
80 30,000 10 69957339720 08834131009 636 120 30,000 10 69957339721 08834131010 636 240 30,000 10 08834131012 320 30,000 10 08834131013 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132002 636 120 30,000 10 08834132003 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	040500000
120 30,000 10 69957339721 08834131010 638 240 30,000 10 08834131012 08834131012 08834131013 320 30,000 10 08834132001 638 <td< td=""><td>642502628</td></td<>	6425 02628
240 30,000 10 08834131012 320 30,000 10 08834131013 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132002 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	6425 02629
320 30,000 10 08834131013 1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132002 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	6425 02630
1-3/8 x 5/8 x 1/4-20 60 30,000 10 08834132001 636 80 30,000 10 08834132002 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	
80 30,000 10 08834132002 636 120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	040500000
120 30,000 10 08834132003 636 1-5/8 x 1 x 1/4-20 40 25,000 10 08834132051	6425 02632
1-5/8 x 1 x 1/4-20 40 25,000 10 088341 32051	6425 02633
	6425 02634
634 <u>634</u> 634	C 405 00000
	6425 02638
	6425 02639
	6425 02640
180 25,000 10 088341 32018	
	6425 02643
	6425 02644
2 x 3/4 x 1/4-20 60 25,000 10 088341 33008	
80 25,000 10 088341 33009	
120 25,000 10 088341 33010	
180 25,000 10	
2 x 1 x 1/4-20 40 25,000 10 699573 39722 088341 33044	
	6425 02646
,	6425 02647
	6425 02648
180 25,000 10 088341 33018	
240 25,000 10 088341 33019	
320 25,000 10	
2 x 1-1/2 x 1/4-20 60 25,000 10 088341 35201	
80 25,000 10 088341 35202	
120 25,000 10 088341 35203	
2-1/2 x 1 x 1/4-20 40 20,000 10 088341 34061	
	6425 02654
80 20,000 10 088341 34023	
120 20,000 10 088341 34024	C40500050
	6425 02659
3 x 3/4 x 1/4-20 80 20,000 10 088341 35009	
120 20,000 10 088341 35010	
3 x 1 x 1/4-20 40 20,000 10 699573 39737 088341 35230	
	6425 02664
	6425 02665
	6425 02666
180 20,000 10 088341 35018	
240 20,000 10 088341 35019	

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. For adapters for flap wheels with 1/4"-20 thread, see the end of this section



PORTABLE TOOLS AND SPECIALTIES Flap Wheels

3" - 8" Flap Wheels with Arbor Holes

- Flap wheels ranging from 3" to 8" diameter with arbor holes
- · Heavy cotton backing and premium abrasive grains combine to provide superior life with aggressive cut on a wide range of polishing and finishing applications



				GOOD MERIT R369	GOOD MERIT R207
				Premium Aluminum Oxide	Aluminum Oxide
			BACKING:	Y-Weight Cotton	X-Weight Cotton
SIZE (D x W x H)	GRIT	MAX. RPM			PART #
3 x 2 x 3/8	80	12.000	10	088341 35051	
	120	12,000	10	088341 35052	
3-1/2 x 1 x 5/8	40	12.000	10	088341 22001	
	60	12,000	10	088341 22003	
	80	12,000	10	088341 22004	
	120	12.000	10	088341 22006	
	180	12,000	10	088341 22007	
	240	12,000	10	088341 22008	
	320	12,000	10	088341 22009	
3-1/2 x 1-1/2 x 5/8	40	12.000	10	088341 22011	
,,, -	60	12,000	10	088341 22013	
	80	12,000	10	088341 22014	
	120	12.000	10	088341 22016	
	180	12,000	10	088341 22018	
3-1/2 x 2 x 5/8	40	12.000	10	088341 22022	
0 1/2 / 2 / 0/0	60	12,000	10	088341 22024	
	80	12,000	10	088341 22025	
	120	12,000	10	088341 22027	
	180	12,000	10	088341 22028	
4 x 1 x 5/8	40	12,000	10	088341 22032	
	60	12,000	10	088341 22034	636425 02673
	80	12,000	10	088341 22035	636425 02674
	120	12,000	10	088341 22037	636425 02675
	180	12,000	10	088341 22038	
	240	12,000	10	088341 22039	
	320	12,000	10	088341 22040	
4 x 1-1/2 x 5/8	40	12,000	10	088341 22042	
	60	12,000	10	088341 22042	
	80	12,000	10	088341 22045	
	120	12,000	10	088341 22047	
	240	12,000	10	088341 22050	
4 x 2 x 5/8	40	12,000	10	088341 22053	
	60	12,000	10	088341 22055	
	80	12,000	10	088341 22056	
	120	12,000	10	088341 22058	
	120				
	240	12,000	10	088341 22060	

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. For flap wheel with arbor hole adapters and bushings, see the end of this section. Continued





3" - 8" Flap Wheels with Arbor Holes continued

			TIER·	BEST	GOOD	GOOD
			TRADENAME:		MERIT R369	MERIT R207
			ABRASIVE:	Ceramic Alumina	Premium Aluminum Oxide	Aluminum Oxide
			`BACKING:	X-Weight Cotton	Y-Weight Cotton	X-Weight Cotton
SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #
5 x 1-1/2 x 5/8	40	12,000	10		088341 22063	
	60	12,000	10		088341 22065	
	80	12,000	10		088341 22066	
	120	12,000	10		088341 22068	
	180	12,000	10		088341 22070	
	240 320	12,000	10 10		088341 22071 088341 22072	
6 x 1/2 x 1	40	6,000	10		088341 23001	
0 X 1/2 X 1	60	6,000	10		08834123003	
	120	6,000	10		088341 23005	
	150	6,000	10		088341 22198	
	180	6,000	10		088341 23006	
6 x 1 x 1	40	6,000	5		088341 23009	
	60	6,000	5	662611 46104	088341 23011	636425 02680
	80	6,000	5	662611 46105	08834123012	636425 02681
	120	6,000	5	662611 46106	088341 23014	636425 02682
	150	6,000	5		088341 23015	
	180	6,000	5		088341 23016	
	240	6,000	5		088341 23017	
6 x 1-1/2 x 1	40	6,000	5		088341 23020	
	60	6,000	5		088341 23022	636425 02686
	80	6,000	5			636425 02687
	120	6,000	5		088341 23025	
	180	6,000	5		088341 23027	
	240	6,000	5		088341 23028	
6 x 2 x 1	320 40	6,000 6,000	5 5		088341 23029 088341 23031	
0 X Z X I	60	6,000	5		088341 23033	636425 02691
	80	6,000	5		088341 23034	636425 02692
	120	6,000	5		088341 23036	636425 02694
	180	6,000	5		088341 23038	
	240	6,000	5		088341 23039	
	320	6,000	5		08834123040	
6 x 3 x 1	80	6,000	3		08834123056	
	120	6,000	3		088341 23058	
	180	6,000	3		088341 23060	
	240	6,000	3		088341 23061	
8 x 1 x 1	40	4,500	3		088341 23070	
	60	4,500	3		088341 23072	
	80	4,500	3		08834123073	
	120	4,500	3		08834123075	
0 v 0 v 1	180	4,500	3		088341 23077	
8 x 2 x 1	40	4,500	3		08834123092	62642502700
	60 80	4,500 4,500	3		088341 23094 088341 23095	636425 02700 636425 02701
	120	4,500	3		08834123095	00042002701
	120	4,500	3		08834123099	
	320	4,500	3		088341 23101	
<u> </u>	010	1,000				

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. For flap wheel with arbor hole adapters and bushings, see the end of this section.





10" - 16" Large Flap Wheels with Arbor Holes

Wide range of applications:

- · For polishing/grinding jobs in production work as well as clean-up and maintenance jobs
- Work on metals, plastic, rubber and wood

Easy to operate:

• No adjustments, dressing, or preparation required before or during operation

- Fewer rejected parts:
- More forgiving than other abrasive products
- Reduce the possibility of flattening, gouging and surface deformation

			TIER:	GOOD
		7	RADENAME:	MERIT R369
			ABRASIVE:	Premium Aluminum Oxide
			BACKING:	Y-Weight Cotton
SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #
10 x 1 x 1-3/4	40	4,000	4	088341 22223
	80	4,000	4	088341 24003
	120	4,000	4	088341 24005
	180	4,000	4	088341 24007
	240	4,000	4	088341 22889
	320	4,000	4	088341 24009
10 x 1-1/2 x 1-3/4	60	4,000	4	088341 24022
	80	4,000	4	088341 24023
	180	4,000	4	088341 24027
10 x 2 x 1-3/4	60	4,000	2	088341 24042
	80	4,000	2	088341 24043
	120	4,000	2	088341 24045
	180	4,000	2	088341 24047
10 x 3 x 1-3/4	60	4,000	2	088341 24077
	80	4,000	2	088341 22316
	180	4,000	2	088341 22132
12 x 1 x 1-3/4	60	3,000	4	088341 24085
	80	3,000	4	088341 22349
	120	3,000	4	088341 22311
	180	3,000	4	088341 22315
12 x 2 x 1-3/4	40	3,000	2	088341 22248
	60	3,000	2	088341 22250
	120	3,000	2	088341 22269
	150	3,000	2	088341 22270
	240	3,000	2	088341 22273
	320	3,000	2	088341 22275
12 x 4 x 1-3/4	180	2,400	1	088341 20017

			TIER:	GOOD
			TRADENAME [.]	MERIT R369
			ABRASIVE:	Premium Aluminum Oxide
				Y-Weight Cotton
SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #
14 x 1 x 1-3/4	60	2,400	1	088341 20020
-,	120	2.400	1	08834120022
14 x 2 x 1-3/4	60	2,400	1	08834120028
-,	80	2,400	1	08834123215
	120	2,400	1	088341 22907
	240	2,400	1	088341 20032
14 x 3 x 1-3/4	120	2,400	1	088341 20035
14 x 4 x 1-3/4	240	2,000	1	088341 20041
16 x 1 x 1-3/4	80	2,400	1	088341 20043
	120	2,400	1	088341 20044
	240	2,400	1	088341 20046
16 x 2 x 1-3/4	60	2,400	1	088341 20047
	120	2,400	1	088341 20050
	180	2,400	1	088341 20051
	240	2,400	1	088341 20052
16 x 3 x 1-3/4	120	2,400	1	088341 20055

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

For flap wheel with arbor hole adapters and bushings, see the end of this section.



Adapter and Bushings for Flap Wheels with Arbor Holes

WHEEL DIAMETER	ADAPTERS	PART #
Shank Adapters		
3-1/2	1/4 Shank	088341 25001
3-1/2	3/8 Shank	088341 25007 NS
4 – 8	1/4 Shank	088341 25003
Threaded Mounting	Adapters	
4 – 8	5/8-11 Thread	088341 25027
Reducing Bushings		
6-8	1 to 3/8	088341 25016 NS
	1 to 1/2	088341 25017
	1 to 5/8	088341 25018 NS
	1 to 3/4	088341 25019 NS
	1 to 7/8	088341 25020 NS
10 - 16	1 to 5/8	088341 22069 NS

Standard packages = 1 adapter, 1 pair of bushings NS Non-stock. Contact your Norton representative for current order quantities and lead-times. For additional aluminum reducing bushings see non-woven convolute wheel section









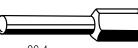


Adapters for 1/4"-20 Thread Mini and Arbor Hole Flap Wheels

MODEL #	DESCRIPTION	PART #
Adapters		
ADAPT C	Fits 3 x 2 x 3/8 arbor flap wheel	088341 37009 NS
MA-100	Fits A.H. Mini Wheel	088341 37007 NS
QC-8	1/8 x 5/8	088341 37002 NS
QC-4	1/4 SK. Dia. x 5/8 SK. L.	088341 37001
QC-44	1/4 x 4	088341 37003
QC-46	1/4 x 6	088341 37004
QC-48	1/4 x 8	088341 37005
QC-T	1/4-20 Thread	088341 37012
QC-T	3/8-24 Thread	088341 37010

Standard package = 1 adapter

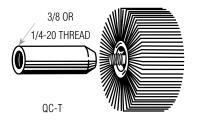
Other thread sizes available for quotation NS Non-stock. Contact your Norton representative for current order quantities and lead-times.





QC-46

MM











Merit Sand-O-Flex Wheels

With their firm cushioning brushes, Sand-O-Flex's abrasive strips are forced into, around and over corners, hollow and fluted surfaces, and small openings. Pressure is distributed evenly over the surface to prevent loss of detail and the flattening of rounded areas; for sanding metals, woods, plastics, rubber and ceramic.

PORTABLE TOOLS AND SPECIALTIES

Flap Wheels

Sand-O-Flex wheels eliminate the need to hand-sand and are designed to fit most standard equipment. They load quickly and easily by turning the index knob as needed, allowing you to change grit size in minutes. Sand-O-Flex refills are available both scored (for finer, less aggressive work) and unscored. And, with the use of adapters, Sand-O-Flex wheels will fit most electric bench grinders.

Sand-O-Flex Wheel - Model 350-RP

- Diameter: 6-1/2" overall, 4" diameter high-impact plastic body
- 1" wide abrasive strips backed by 8 cushioning brushes
- 1/4" diameter steel shank
- Weight: 9-1/2 oz.
- Maximum operating speed: 2,400 RPM
- Special adapter required for bench grinder use
- Some assembly required

		TIER:	GOOD
		TRADENAME:	MERIT SAND-O-FLEX
		ABRASIVE:	Aluminum Oxide
MODEL #	GRIT	STD. PKG.	PART #
Sand-O-Flex Wheel			
350-RP		1	088341 11051
Comes assembled with 80 grit A/O resin bond scored refill and brushes			
Sand-O-Flex Accessories			
Replacement Brushes for 350-RP; 8 per set		1 set	088341 13003
Resin Bond Refills			
350-RP SCORED	60	10	088341 11052
	80	10	088341 11053
	100	10	088341 12114
	120	10	088341 11054
	180	10	088341 11057
Glue Bond Refills			
350-RP SCORED	80	10	088341 12054
	100	10	088341 12055
	120	10	088341 12056
350-RP UNSCORED	80	10	088341 12044





Non-woven surface finishing flap wheels are an ideal choice for a wide variety of blending and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away continually exposing fresh abrasives.

There are two types of non woven flap wheels: non-woven only abrasive flaps where finishing is the primary application, and interleaf with alternating cloth and non-woven abrasive flaps (less conformable, more aggressive) for stock removal and finishing. Interleaf flap wheels must always be run in the direction indicated by the arrow.

Used for a wide range of metal fabrication and welding applications including blending, deburring, cleaning, finishing, and polishing Flap wheels with mounted steel shanks: 2" - 4" diameter Flap wheels with arbor holes: 3" - 12" diameter 60 - 320

Abrasive Grain: Machine Used:

Applications:

Size Range:

Grit Range:

Aluminum Oxide



Application/Grit Recommendation Guide

COARSER (GRINDING)

NDRTDN

SAINT-GOBAIN

FINER (FINISHING)

NON- WOVEN FLAP WHEEL

60	80	120	180	240	320
Preparing Metal for Painting					
Blending Out Medium Mach	ine Marks				
	Blending Metal Surfaces				
	Applying Light Scratch Patter	n			
		Fine Blending and Cleaning			
				Metal Finishing and Polishing	

INTERLEAF FLAP WHEEL



Better choice for fine grit light cleaning and finishing

NON-WOVEN FLAP WHEELS

- · Premium aluminum oxide grain with durable resin bond and web that wears away continually exposing fresh abrasives
- Tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- · Designed with a steel shank as an integral part of the wheel or with and arbor hole



Good choice for fine grit cleaning and blending and finishing applications

MERIT INTERLEAF FLAP WHEELS

- Alternating cloth and non-woven flaps make interleaf wheels less conforming and more aggressive than non-woven flap wheels, but less aggressive than all-cloth flap wheels
- Premium aluminum oxide grain with durable resin bond and web that wears away continually exposing fresh abrasives
- Tough yet conformable to intricate shapes and contours without changing the workpiece dimension





PORTABLE TOOLS AND SPECIALTIES Non-Woven Flap Wheels



1/4" Mounted Steel Shanks

Wheels are designed with a 1/4" steel shank as an integral part of each wheel. These shanks run through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on air tools when using other abrasive products.



Arbor Hole Mounts

For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.



DEAD TEV NON

Non-Woven

					I KADENAME:	BEAR-IEX NUN-WUVEN	BEAK-IEX NUN-WUVEN
SIZE		NON-WOVEN	MAX.	STD.			
(D x W x SK./AH.)	ABRASIVE	GRIT	RPM	PKG.		PART #	PART #
2 x 1 x 1/4	A/0	Very Fine	12,000	20		662610 51717	
	A/0	Medium	12,000	20		662610 51716	
	A/0	Very Fine	12,000	20		662610 51719	
	A/0	Medium	12,000	20		662610 51718	
3 x 2 x 1/4	A/0	Medium	8,000	10		662610 58474	
6 x 1 x 2	S/C	Very Fine	3,000	4			662610 58450
	S/C	Fine	3,000	4			662610 58451
	A/0	Fine	3,000	4			662610 58487
	A/0	Medium	3,000	4			662610 58456
8 x 1 x 3	A/0	Fine	2,500	3			662610 58491
8 x 2 x 3	A/0	Fine	2,500	2			662610 58493
	A/0	Medium	2,500	2			662610 00889
12 x 2 x 5	A/0	Medium	1,900	1			662610 05070

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.



GOOD

GOOD

Interleaf

Interleaf						TRADENAME: MERIT INTERLEAF MERIT INT	ERLEAF
SIZE		COATED	NON-WOVEN	MAX.	STD.		
(D x W x SK./AH.)	ABRASIVE	GRIT	GRIT	RPM	PKG.	PART # PART #	
2 x 1 x 1/4	A/0	60	Very Fine	12,000	10	088341 38122	
	A/0	80	Very Fine	12,000	10	088341 38123	
	A/0	120	Very Fine	12,000	10	088341 44457	
	A/0	180	Very Fine	12,000	10	088341 44458	
	A/0	320	Very Fine	12,000	10	088341 44459	
2 x 1-1/2 x 1/4	A/0	80	Very Fine	12,000	10	088341 38125	
	A/0	120	Very Fine	12,000	10	088341 38126	
	A/0	320	Very Fine	12,000	10	088341 38128 NS	
3 x 1 x 1/4	A/0	60	Very Fine	12,000	10	088341 38129	
	A/0	80	Very Fine	12,000	10	088341 38130	
	A/0	120	Very Fine	12,000	10	088341 38118	
	A/0	180	Very Fine	12,000	10	088341 38120	
	A/0	320	Very Fine	12,000	10	088341 38119	
3 x 2 x 1/4	A/0	120	Very Fine	8,000	10	088341 44460	
	A/0	180	Very Fine	8,000	10	088341 44461	
3 x 2 x 3/8	A/0	60	Very Fine	12,000	10	088341 390	DO NS
	A/0	120	Very Fine	12,000	10	088341 390	D1 NS
	A/0	240	Very Fine	12,000	10	088341 390 2	28 NS
	A/0	320	Very Fine	12,000	10	088341 390 2	24 NS
4 x 2 x 1/4	A/0	80	Very Fine	12,000	10	088341 21115	
	A/0	120	Very Fine	12,000	10	088341 20458	
4 x 2 x 5/8	A/0	60	Very Fine	12,000	10	088341 260 2	25 NS
	A/0	240	Very Fine	12,000	10	088341 260	14 NS
	A/0	320	Very Fine	12,000	10	088341 260 2	27 NS
6x1x1	A/0	120	Very Fine	6,000	10	088341 260	D6 NS
	A/0	240	Very Fine	6,000	10	088341 260	30 NS
6 x 2 x 1	A/0	80	Very Fine	6,000	10	088341 260	D9 NS
	A/0	180	Very Fine	6,000	10	088341 260	18 NS
6 x 3 x 1	A/0	80	Very Fine	6,000	6	088341 260	55 NS
Non-stock Cor	taat vour Norto	n ronrocontati	ive for current order	auantities and	load_times		

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Refer to Non-Woven Convolute Wheel section for Flap Wheel Reducing Bushings.



Flaps of abrasive cloth are stacked, inserted into a holder, and then attached to a mandrel. The flaps are designed to break down during use and reveal the next layer of abrasive.

To create an interleaf bore polisher, cloth flaps are mixed with non-woven flaps.

Applications:

For deburring, sizing, cleaning and polishing the interior diameters of cylinders, tubes and hydraulic fittings. Flaps adjust automatically to inside diameter, polishing the entire surface area with each pass.

Bore polishers are self-centering, so they apply equal pressure to full wall of inside diameter. Spring action design gives faster inside diameter cleaning, deburring and polishing to cylinders, deep bores and tubes.

Interleafed bore polishers are designed to polish and finish in one easy application. The abrasive flaps cut, while the non-woven flaps apply a fine finish. 60 - 240 Aluminum Oxide

Grit Range: Abrasive Grain:

Application-to-Product Shape Recommendation Guide

Shape	Application
Solid Flaps	 For 5/8" to 1" interior diameter bores
B-3 Series	 3 abrasive packs 1-1/2" wide, bonded to hub
	Use with QC-5 mandrel Part # 088341 54182
Solid Flaps	For 1" to 4" interior diameter bores
B-4 Series	 4 abrasive packs 1-1/2" wide, bonded to hub
	Use with BPM-4 mandrel Part # 08834154183
Solid Flaps	For 2" to 5-7/8" interior diameter bores
B-8 Series	 8 abrasive packs 1-1/2" wide, bonded to hub
*	Use with BPM-8 mandrel Part # 08834154184
Scored Flaps	Available upon request as made-to-order products.
Interleaf	Cloth flaps are mixed with non-woven flapes. Interleaf bore polishers do double duty. Designed to polish and finish in one easy application, they are the ideal choice when close tolerances must be maintained, while giving an interior a polished finish.

Application/Grit Recommendation Guide

COARSER (MATERIAL R	EMOVAL)			FINE	R (FINISHING)
<					
60	80	120	180	240	
Blending Out Medium Machin	e Marks				
Sizing Cylinders					
	Deburring Cylinders				
	Blending Metal Surfaces				
	Cleaning Cylinders				
	Applying Light Scratch Pattern				
			Fine Blending and Cleaning		
			Metal Finishing and Polishi	ng	
<					
SOLID FLAP		SCORED			INTERLEAF

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NDRTDN

SAINT-GOBAIN



PORTABLE TOOLS AND SPECIALTIES Bore Polishers

Aluminum Oxide Bore Polishers

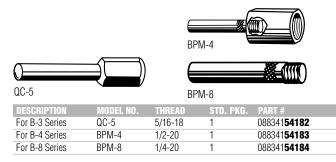
			TIER: TRADENAME:	GOOD Merit R369
			ABRASIVE:	Aluminum Oxide
			BACKING:	Y-weight Cotton/Poly
DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #
Bore Polishers - Soli	d Flap B·	·3 and B-4 Se	ries	
B-305	60	25,000	10	088341 54190
Fits ID 5/8 to 1	80	25,000	10	088341 54191
	120	25,000	10	088341 54193
	180	25,000	10	088341 54195
	240	25,000	10	08834154197
B-405	60	22,000	10	08834154091
Fits ID 1 to 1-1/2	80	22,000	10	088341 54092
	120	22,000	10	088341 54093
	180	22,000	10	088341 54094
B-410	60	20,000	10	088341 54100
Fits ID 1-1/2 to 2	80	20,000	10	08834154101
	120	20,000	10	08834154102
	180	20,000	10	08834154103
	240	20,000	10	088341 54104
B-415	60	16,000	10	08834154109
Fits ID 2-1/8 to 2-1/2	80	16,000	10	08834154110
	120	16,000	10	08834154111
	180	16,000	10	08834154112
B-420	60	15,000	10	08834154118
Fits ID 2-1/2 to 3	80	15,000	10	08834154119
	120	15,000	10	08834154120
	180	15,000	10	08834154121
B-425	60	10,000	10	088341 54127
Fits ID 3-1/8 to 4	80	10,000	10	088341 54128
	120	10,000	10	08834154129
	180	10,000	10	08834154130

NS Non-stock. Contact your Norton representative for current order quantities	
and lead-times.	

			TIER: TRADENAME:	GOOD Merit R369
			ABRASIVE:	
DECODIDEION	ADIT		BACKING:	Y-weight Cotton/Pol
DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #
Bore Polishers – Solia			10	000004454400
B-810	60	16,000	10	088341 54136
Fits ID 2 to 2-1/2	80	16,000	10	088341 54137
	120	16,000	10	088341 54138
	180	16,000	10	088341 54139 NS
	240	16,000	10	088341 54140 NS
B-815	60	15,000	10	088341 54145
Fits ID 2-5/8 to 3	80	15,000	10	088341 54146
	120	15,000	10	088341 54147
	180	15,000	10	088341 54148 NS
	240	15,000	10	088341 54149 NS
B-820	60	10,000	10	088341 54154
Fits ID 3-1/8 to 4	80	10,000	10	088341 54155
	120	10,000	10	088341 54156
	180	10,000	10	088341 54157
	240	10,000	10	088341 54158 NS
B-825	60	8,000	10	088341 54163
Fits ID 4-1/4 to 5-1/4	80	8,000	10	088341 54164
	120	8,000	10	088341 54165
	180	8,000	10	088341 54166
	240	8,000	10	088341 54167
B-830	60	8,000	10	088341 54172
Fits ID 5-1/4 to 5-7/8	80	8,000	10	088341 54173
	120	8,000	10	088341 54174
	180	8,000	10	088341 54175
	240	8,000	10	088341 54176
Bore Polishers – Scor	ed Flaps			
Available on request as m	-	ler products		

Bore Polishers – Interleaf						
B-405 Interleaf	80	22,000	10	088341 50271		
Fits ID 1 to 1-1/2	180	22,000	10	088341 50273		

Mandrels for Bore Polishers



Extension Mandrels for Bore Polishers

DIAMETER x LENGTH	MODEL NO.	THREAD	STD. PKG.	PART #
1/4 x 4	EM-144	1/4-20	1	088341 54185
1/4 x 6	EM-146	1/4-20	1	088341 54186
1/4 x 8	EM-148	1/4-20	1	088341 54187

To extend a B-4 series bore polisher, attach the adapter piece of the BPM-4 mandrel to the bore polisher, then attach the desired length extension mandrel above to the BPM-4 adapter piece. To extend a B-8 series bore polisher, attach the desired length extension mandrel above directly to the bore polisher.



Bore Polisher Test Kit "BP"

• Part # 088341**54181**

 Contains ten bore polishers and two mini 1/4"-20 thread flap wheels in assorted sizes and grits for finishing 1" to 5" interior diameters, and mandrel for 1/4" chuck.







FlexDrum abrasive segments sweep away flaws. Their extreme longevity and perfect balance make them well-suited for automatic as well as offhand use. Hubs and abrasive segments can be combined to fit your job perfectly.

Blending out parting lines on castings, smoothing out pre-ground welded areas, removing **Applications:** burrs and work flaws, graining stainless, brush-finishing and satin-finishing aluminum, removing rust, deflashing molded plastic and rubber parts, and preparing surfaces for painting or plating. Diameter of loaded FlexDrum: 8" - 18" **Size Range:** Width of FlexDrum: 1-1/2" - 12" Custom die-cut segments as well as extra wide segments, in widths up to 144" are also available as made-to-order products. **Grit Range:** 50 - 240Resin or glue Heavyweight cotton **Abrasive Grain:** Premium Aluminum Oxide

Shape/Application Recommendation Guide



Plain Segment For flat or mildly contoured surfaces



Bond:

Backing:

1/4 Scored (SC) Segment Great for complex parts

· Provides a fine finish



1/2 Slash (SL) Segment Great for mild and moderate contours



Interleaf Segment

- · Plain cloth segments are mixed with non-woven segments. Interleaf FlexDrums do double duty. Designed to polish and finish in one easy application,
- Available upon request as made-to-order product

Loading Flex Drum Hubs



FlexDrum hub end plate removes for easy loading of abrasive segments.



Custom profiled segments eliminate break-in resulting in maximum productivity. Contact your sales representative for more information.



Plain Segments – for flat or mildly curved surfaces

		TIER:	GOOD						
		TRADENAME:	MERIT R369						
		ABRASIVE:	A/0						
		BACKING:	Y-weight Cotton						
		GRIT:	50	60	80	100	120	180	240
WIDTH	TRIM LENGTH*	STD. PKG.	PART #						
1-1/2	2-3/4	12	088341 55002	088341 55003	088341 55004		088341 55006	088341 55008	088341 55010
2	2-3/4	12	088341 55013	088341 55014	088341 55015	088341 55016		088341 55019	
2	4	20		088341 55313	088341 55314			088341 55318	
2	5	20		088341 55568					
3	2-3/4	12		088341 55026	088341 55027		088341 55029	088341 55031	
3	4	20			088341 55326			088341 55330	
3	5	20		08834155579			088341 55582		
4	2-3/4	12	088341 55036				088341 55040		
4	4	20	088341 55336	088341 55337	088341 55338		088341 55340		
4	5	20		088341 55590					

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times.

1/4" Scored Segments – for complex parts and providing a fine finish

			TIER:	GOOD					
			TRADENAME:	MERIT R369					
			ABRASIVE:	A/0	A/0	A/0	A/0	A/0	A/0
			BACKING:	Y-weight Cotton					
			GRIT:	50	60	80	100	120	180
WIDTH	TRIM LTH.*	SCORE	STD. PKG.	PART #					
1-1/2	2-3/4	1/4	12		088341 55083	088341 55084		088341 55086	088341 55088
2	2-3/4	1/4	12	088341 55094	088341 55095	088341 55096	088341 55097	088341 55098	088341 55100
3	2-3/4	1/4	12		088341 55107	088341 55108	088341 55109		088341 55112
4	2-3/4	1/4	12	088341 55117	088341 55118	088341 55119		088341 55121	088341 55123

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times.

1/2" Slashed Segments - for mild and moderate contours

			TIER:	GOOD				
			TRADENAME:	MERIT R369				
			ABRASIVE:	A/0	A/0	A/0	A/0	A/0
			BACKING:	Y-weight Cotton				
			GRIT:	60	80	120	180	240
WIDTH	TRIM LTH.*	SLASH	STD. PKG.	PART #				
2	4	1/2	20	088341 55420			088341 55425	088341 55427
2	5	1/2	20			088341 55639		
3	4	1/2	20		088341 55432			
4	4	1/2	20		088341 55445	088341 55447		088341 55451
4	5	1/2	20		088341 55659			

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times. *Trim Length is the actual usable length of segment when loaded

TECH TIP

FlexDrums can be used for polishing large IDs. Just load half the segments with a wheel diameter ½" to 1" larger than the ID of your workpiece.



Hub Units

- FlexDrum hubs are perfectly balanced, last indefinitely and are available in widths from 1-1/2" to 12"
- · Extra wide widths are available up to 144" as made-to-order products

MODEL NO.	D x W	ARBOR HOLE/THREAD	SEGMENTS PER HUB	PART #
FlexDrum Hub Units				
81.5-B	2-3/8 x 1-1/2	1 AH	12	088341 40065
82-B	2-3/8 x 2	1 AH	12	088341 41049
		5/8-11 THD	12	088341 40048
83-B	2-3/8 x 3	1 AH	12	088341 41018
		5/8-11 THD	12	088341 40034
34-B	2-3/8 x 4	1 AH	12	088341 40066
		5/8-11 THD	12	088341 40049
122-B	4 x 2	1-1/4 AH	20	088341 40050
123-B	4 x 3	1-1/4 AH	20	088341 40051
124-B	4 x 4	1-1/4 AH	20	088341 40061
142-B	6 x 2	1-1/4 AH	30	088341 40062
143-B	6 x 3	1-1/4 AH	30	699573 99208
144-B	6 x 4	1-1/4 AH	30	088341 41060
340-B2	8 x 2	1-1/4 AH	40	636425 92550
340-B4	8 x 4	1-1/4 AH	40	636425 92548

All FlexDrum hub units are non-stock; contact your Norton representative for current order quantities and lead-times.



12" WHEEL WHEN LOADED



2-3/8" DIAMETER HUB WITH 1" ARBOR HOLE 8" WHEEL WHEN LOADED



2-3/8" DIAMETER HUB ALSO AVAILABLE WITH 5/8"-11 ARBOR

8" WHEEL WHEN LOADED



14" OR 16" WHEEL WHEN LOADED





FlexDrum Reference Charts

FlexDrums can be mounted on any type of arbor.

Weights

0	
DIAMETER	WEIGHT
Weight of Hubs*	
4" Diameter Hub	1.5 lbs./inch of width
6" Diameter Hub	2 lbs./inch of width
8" Diameter Hub	2.5 lbs./inch of width
Weight of Hubs with Segme	nts*
4" Diameter Hub	3.4 - 4 lbs./inch of width
6" Diameter Hub	5 - 5.5 lbs./inch of width
8" Diameter Hub	6.75 - 7 lbs./inch of width
*Approximate values. Actual we	ight will depend on abrasive type and overall width of hub.

FlexDrum Maximum RPM

WHEEL DIAMETER	MAXIMUM RPM
8	4,500
12	3,000
14	2,500
16	2,200
18	2,000

Recommended H.P. Required

HUB	H.P.
4" Diameter Hub	1/2 H.P. /inch of width
6" Diameter Hub	3/4 H.P./inch of width
8" Diameter Hub	1 H.P./inch of width

Recommended Surface Feet per Minute for using EloyDrum Whoole on Various Materials

for using FlexDrum Wheels	s on Various Materials
MATERIAL	SFPM
Mild Steel	5,000
Stainless Steel	6,500
Alloy Steel	5,000
Titanium	3,500
Hard Aluminum	5,500
Nonferrous	5,000
Rubber	4,500
Hardwood (edge breaking)	4,000
Softwood	3,500
Thermoplastic	3,000

SPEC CHECK



ElexDrum Hub Specification Chart

MODEL NO.	82-B	121-B	141-B	840-B	
Diameter of Finished Wheel	8	12	14 or 16	16 or 18	
Diameter of Hub Alone	2-3/8	4	6	8	
Arbor Hole	1 or	3/4 to	1 to	1-1/4	
	5/8-11 thd	1-3/4	3-1/2	to 5	
Segments Per Hub	12	20	30	40	

How to Determine Diameter of Finished FlexDrums

HUB DIAMETER	TRIM LENGTH (X2)	FINISHED WHEEL
2-3/8	2-3/4	8
4	4	12
4	5	14
6	4	14
6	5	16
8	4	16
8	5	18

TECH TIP

For surface feet per minute, use the following calculation: SFPM=.262 x DIA (in inches) x RPM.





L2

Our double-cut style carbide burrs have stronger tooth formulation and numerous cutting edges to outperform other double-cut carbide burrs with better stock removal, granular chip break, and longer life.

Pair up these long-lasting burrs with our pneumatic die grinder to quickly and comfortably accomplish many portable applications on one machine – including jobs using specialties, small diameter flap wheels, and mounted points.

Applications: Shapes: Shank Diameter:

Machine Used:

Deburring, medium-to-light surface cleaning and stock removal, weld removal and prep, chamfering A, B, C, D, F, G, H, L, M



Understanding the Product

-	.	
Burr	Dimens	sions

D1	L1	D2	L2		
HEAD DIAMETER	HEAD LENGTH	SHANK DIAMETER	OVERALL BURR LENGTH (OL)	L1	

TECH TIP

Each carbide burr is packed individually in a clear, protective plastic case with Norton-blue end-caps. Each burr is marked with the burr head diameter and length for easy identification.



Double cut burrs are a popular choice because of their universal cutting style

DOUBLE CUT CARBIDE BURRS

- Hard tungsten carbide burrs with strong tooth formulations and numerous cutting edges for extended life and less changeover downtime versus other cutting tools
- · Higher stock removal, and smaller, granular chip-break on hard-to-grind workpieces versus other carbide burrs
- Perform well at higher temperatures and can be used longer than high-speed steel tools even if your operation generates some heat



SINGLE CUT CARBIDE BURRS

- Single spiral carbide burrs make deburring aluminum and non-ferrous materials an ease
- Extra sharp edges and fast debris removal keeps you on task for better production
- · Perform well at higher temperatures and can be used longer than high-speed steel tools

SC C



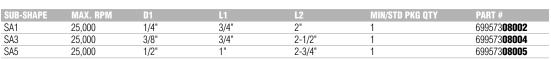
Carbide Burrs for Standard Metal Removal



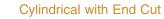
Cylindrical without End Cut

The ends of these burrs are flat, with no cutting edges and are used for contour finishing and to get into right-angled corners.

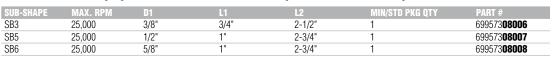








The cutting edge at the end of the burr makes these burrs a good choice for contour finishing.





Ball-Nosed Cylindrical

Use these round-nosed burrs for smoother operation and better tool control.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SC1	25,000	1/4"	3/4"	2"	1	699573 08009
SC2	25,000	5/16"	3/4"	2-1/2"	1	699573 08010
SC3	25,000	3/8"	3/4"	2-1/2"	1	699573 08011
SC5	25,000	1/2"	1"	2-3/4"	1	699573 08012
SC5	25,000	1/2"	1"	6"	1	699573 60679
SC6	25,000	5/8"	1"	2-3/4"	1	699573 08013



Ball Shape

Use these carbide burrs to create a concave and to hollow out a workpiece.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SD1	25,000	1/4"	1/4"	2"	1	699573 08014
SD3	25,000	3/8"	5/16"	2-1/8"	1	699573 08016
SD5	25,000	1/2"	7/16"	2-3/16"	1	699573 08017





Ball-Nosed Tree

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Designed to round off edges and make concave cuts.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SF1	25,000	1/4"	3/4"	2"	1	699573 08018
SF2	25,000	5/16"	3/4"	2-1/2"	1	699573 08019
SF3	25,000	3/8"	3/4"	2-1/2"	1	699573 08020
SF3	25,000	3/8"	3/4"	6"	1	699573 60689
SF5	25,000	1/2"	1"	2-3/4"	1	699573 08021
SF5	25,000	1/2"	1"	6"	1	699573 60691
SF6	25,000	5/8"	1"	2-3/4"	1	699573 08022



Carbide Burrs for Standard Metal Removal



Tree with Taper

The taper allows access to hard-to-reach areas, such as angled contours.



SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SG1	25,000	1/4"	3/4"	2"	1	699573 08023
SG3	25,000	3/8"	3/4"	2-1/2"	1	699573 08025
SG5	25,000	1/2"	1"	2-3/4"	1	699573 08026
SG5	25,000	1/2"	1"	6"	1	699573 60712
SG6	25,000	5/8"	1"	2-3/4"	1	699573 08027



SH Flame Shape

Great for channel working and shaping due to its long fluted sides and rounded head.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SH5	25,000	1/2"	1-1/4"	6"	1	699573 66822





Ball-Nosed Cone

This cone shape is excellent for imparting fine finishes.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SL2	25,000	5/16"	7/8"	2-3/4"	1	699573 08028
SL3	25,000	3/8"	1 3/16"	2-15/16"	1	699573 08029
SL4	25,000	1/2"	1 3/16"	3"	1	699573 08030
SL4	25,000	1/2"	1-3/16"	6"	1	699573 60720



Pointed Cone

51

Ideal for rounded edges or reaching difficult, tight areas.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SM5	25,000	1/2"	7/8"	6"	1	699573 60767

Carbide Burr Kit

	SUB-SHAPE Carbide Burr Kit*	MIN/STD PKG QTY 1	PART # 699573 08060
	* Kit Includes one each of: SA5 (69957308005), SF3 (69957308020), SF5 (69957308021)), SG5 (699573 08026) , and SL4 (699.	
Maria			
- delate			



Carbide Burrs for Aluminum and Non-Ferrous Materials



Cylindrical without End Cut

The ends of these burrs are flat, with no cutting edges and are used for contour finishing and to get into right-angled corners.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SA3 NF	25,000	3/8"	3/4"	21/2"	1	699573 40148
SA5 NF	25,000	1/2"	1"	2-3/4"	1	699573 40149



Ball-Nosed Tree

Designed to round off edges and make concave cuts.

	0	0				
SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SF3 NF	25,000	3/8"	3/4"	2-1/2"	1	699573 40154
SF5 NF	25,000	1/2"	1"	2-3/4"	1	699573 60647



SL Ball-Nosed Cone This cone shape is excellent

This cone shape is excellent for imparting fine finishes.

SUB-SHAPE	MAXRPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SL4 NF	25,000	1/2"	1-1/4"	6"	1	699573 60651

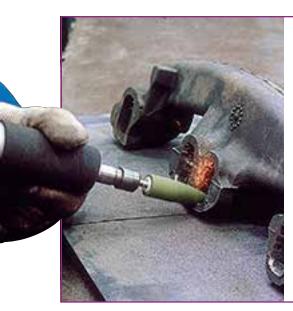


we've got you covered FROM DIY TO TOOLCRIB TO PRODUCTION FLOOR

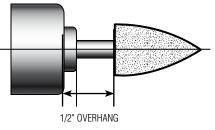
Available in vitrified bond, resin bond, center lap and cotton fiber, and in a variety of shapes our mounted points offer fast, free cutting grinding and finishing capability. Produce sharp edges with the Norton line of sharpening stones - bringing solutions for craftsmen and hobbyists alike for over 190 years.

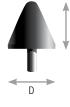


PRECISION OFFHAND/PORTABLE Mounted Points



Measurement Guide





wide range of shapes.

Aerospace Tool and Die Construction Metal Fabrication Automotive Cutlery Mold Shops

Foundries

A, B, and W

DIE AND

PENCIL

GRINDER

Aluminum Oxide

Stainless Steel Equipment

Industries:

Abrasive Grain:

Machine Used:

Shape Availability:

Description of Overhang

Overhang is the distance between the grinder chuck and the abrasive on the spindle. The larger the overhang, the lower the maximum safe operating speed.

Size

Measured by diameter (D) x thickness (T)

HORIZONTAL/

STRAIGHT SHAFT

PORTABLE GRINDER

Resin bond, vitrified bond, center lap, and cotton fiber mounted points are available in a

Ceramic Alumina, Zirconia Alumina, Zirconia Alumina / Aluminum Oxide Blend,

Cotton Fiber

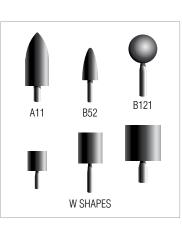


Good for blending and polishing

COTTON FIBER ALUMINUM OXIDE - RESIN BOND

- · Aluminum oxide grain provides an excellent blend of cut rate and life
- · The cotton fibers ensure smooth, chatter-free grinding
- Designed for blending and polishing in one step; use 80 grit for most materials and 120 for polishing and stainless steel applications

				TIER: TRADENAME: ABRASIVE:	GOOD COTTON FIBER Aluminum Oxide	
SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #
Cotton Fi	ber Mounted Pa					
A11	7/8 x 2	1/4	19,860	5/25	A80-HBF3	614636 22664
B52	3/8 x 3/4	1/8	45,370	5/25	A120-HBF3	614636 20242
B121	1/2" Ball	1/8	45,370	5/25	A80-HBF3	614636 22657
W163	1/4 x 1/2	1/8	60,000	5/25	A80-HBF3	614636 22655
			60,000	5/25	A120-HBF3	614636 22656
W176	3/8 x 1/2	1/8	45,370	5/25	A80-HBF3	614636 22654
W185	1/2 x 1/2	1/8	34,500	5/25	A80-HBF3	614636 22649
W187	1/2 x 1	1/8	20,620	5/25	A80-HBF3	614636 22651
W220	1x1	1/4	25,500	5/25	A80-HBF3	614636 22646



† Spindle length is 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.



Center Lap





Better for Excell-O center lap and similar machines

CENTER LAP ALUMINUM OXIDE - VITRIFIED BOND

- Specially formulated wheel treatment provides added lubricity to the wheel, minimizing risk of metallurgical damage
- The larger diameter spindle ensures minimal deflection and rigid support
- Precise dimensional tolerances ensure accurate location of part centers

				TIER:	BETTER						
				TRADENAME:	CENTER LAP						
				ABRASIVE:	Aluminum Oxide						
SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #					
Center Lap Mounted Points											
-	1/2 x 2**	1/2	65,000	5/25	A80-VVM	614636 21421					
-	1 x 2**	1/2	15,900	5/25	A80-VVM	614636 22926					
10.1.11	I will be d d (All										

CH TIP

Dress the center lap mounted points frequently to ensure accurate and smooth center holes.

It is the user's responsibility to refer to and comply with ANSI B7.1

† Spindle length is 1-1/4

Maximum RPM valid to 1/2" overhang. See package insert for other overhangs. ** Pointed 60°

Resin Bond



Best choice for fast stock removal

NORZON ZIRCONIA ALUMINA - RESIN BOND

- · Zirconia alumina abrasive blend for 2X faster cut rate than standard aluminum oxide
- Strong grain and specially formulated organic bond provide 4X greater life than aluminum oxide points, while • reducing vibration and wheel chatter
- · Ideal for removing parting lines, fins and small risers from castings, and smoothing and blending of welded areas



Better choice for fast stock removal and long life

CHARGER Z/A & A/O BLEND – RESIN BOND

- Durable zirconia alumina and aluminum oxide abrasive blend delivers 35% faster cut rate than standard aluminum oxide; an aggressive, free cut, and more parts cleaned in less time to substantially increase productivity
- · Specially formulated organic bond provides 2X greater life than standard resin bonds while reducing vibration and wheel chatter
- Better choice for removing parting lines, fins and small risers from castings, and smoothing and blending welded areas
- Charger mounted point pre-packed in small packages are ideal for vending machines, pegboards, small jobs, and carrying to job site

				TIER:	BEST		BETTER			
				TRADENAME:	NORZON		CHARGER			
				ABRASIVE:	Zirconia Alumina		Zirconia Alumina/Aluminum Oxide			
SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #		
Resin Bo	ond Mounted I	Points								
A1	3/4 x 2-1/2	1/4	19,800	5/25	NZ24-UBXR1	614636 16457	Charger	614636 16458		
A3	1 x 2-3/4	1/4	16,100	5/25	NZ24-UBXR1	614636 16459	Charger	614636 16460		
A11	7/8 x 2	1/4	19,860	5/25	NZ24-UBXR1	614636 16463	Charger	614636 16464		
W189	1/2 x 2	1/4	24,000	5/25	NZ24-UBXR1	614636 16465	Charger	614636 16466		
W197	5/8 x 2	1/4	21,000	5/25	NZ24-UBXR1	614636 16467				
W207	3/4 x 1-1/2	1/4	24,000	5/25			Charger	614636 16470		
W208	3/4 x 2	1/4	18,750	5/25	NZ24-UBXR1	614636 16471				
W220	1 x 1	1/4	25,500	5/25	NZ24-UBXR1	614636 17520	Charger	614636 17521		
			25,500	5 V						
W221	1 x 1-1/2	1/4	19,120	5/25	NZ24-UBXR1	614636 16473	Charger	614636 16474		
W222	1 x 2	1/4	15,900	5/25	NZ24-UBXR1	614636 16475	Charger	614636 16476		
t Spindle length is 1-1/2"										

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.

NS Non-stock; contact your Norton representative for current order quantities and lead times.



Vitrified Bond





QUANTUM CERAMIC ALUMINA - VITRIFIED BOND

- Quantum grain with unique, engineered ceramic grain and shape, specifically developed for high-volume, high-speed alloy grinding operations
- Minimal loading and heat build-up; provide up to 33% longer life and 37% better metal removal rates versus other ceramic points
- · Versatile; optimized for all low-, medium-, and high-force vitrified applications
- Oil and Gas 36 grit mounted points; specifically engineered to efficiently grind the carbide matrix material of oil field drill heads

Better medium grit option for blending and deburring

PINK ALUMINUM OXIDE - VITRIFIED BOND

- Sharp versatile 86A aluminum oxide grain is free cutting and resists burn
- · Excellent form holding compared to more friable white aluminum oxides
- Medium grit for blending and deburring



Good value for general purpose, small job shop applications

GEMINI ALUMINUM OXIDE - VITRIFIED BOND

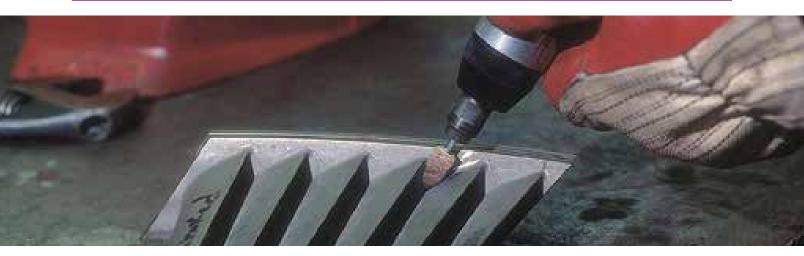
- 38A abrasive is designed to be cool cutting to minimize burn
- · High temperature vitrified bond maximizes form holding and life
- Wide grit range for stock removal, blending/deburring, and finishing/polishing

TECH TIP

- For best mounted point performance, always run the mounted point at the maximum allowable speed according to ANSI B7.1. Refer to the speed chart included in each shipment for proper operating speeds.
- Use "A" shapes for medium- to heavy-duty blending.
- Use "B" shapes for light deburring and finishing/polishing.
- Use "W" shapes for offhand and precision grinding of medium to heavy stock.
- Use 36 grit and coarser for rough grinding.
- · Use 60 and 90 grits for imparting fine finishes or when grinding on narrow surfaces.



It is the user's responsibility to refer to and comply with ANSI B7.1





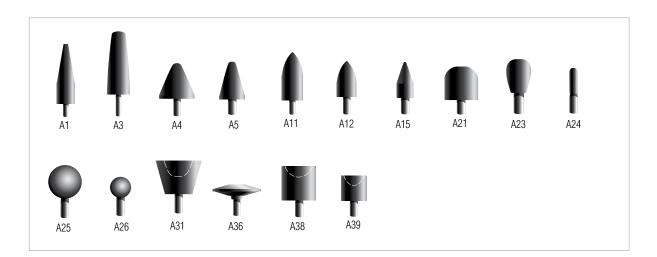
PRECISION OFFHAND/PORTABLE Mounted Points

Vitrified Bond

				TIER:	BEST		BETTER		GOOD	
				TRADENAME:	QUANTUM		PINK		GEMINI	
				ABRASIVE:	Ceramic Alum	ina	86A Alumin	um Oxide	38A Alumini	um Oxide
				MIN./						
SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
	Bond Mounted P			T Ku.	51 20		JILU		51 20	
A1	3/4 x 2-1/2	1/4	19,800	25/250	Oil & Gas 36	614636 86139				
AI	3/4 x 2-1/2	1/4	19,800	5/25	3NQ80	690831 49139	86A80-S	690786 45335	38A36-T	614636 24374
A1	3/4 x 2-1/2	1/4	19,800	5/25	311000	03003143103	00400 0	030700-3003	38A60-P	614636 24375
A3	1 x 2-3/4	1/4	16,100	25/250	Oil & Gas 36	614636 86138			00/100 1	01100024010
A3	1 x 2-3/4	1/4	16,100	5/25	011 & 013 00	01100000100	86A80-S	690786 45333	38A36-T	614636 24377
A3	1 x 2-3/4	1/4	16,100	5/25			00/100 0		38A60-P	614636 24378
A4	1-1/4 x 1-1/4	1/4	30,560	5/25					38A60-P	614636 24380
A5	3/4 x 1-1/8	1/4	45,000	5/25			86A80-S	690786 45339	38A36-T	614636 24381
A5	3/4 x 1-1/8	1/4	45,000	5/25					38A60-P	61463624382
A11	7/8 x 2	1/4	19,860	5/25	3NQ80	690831 49141			38A36-T	61463624384
A11	7/8 x 2	1/4	19,860	5/25			86A80-S	690786 45336	38A60-P	61463624385
A12	11/16 x 1-1/4	1/4	48,000	5/25			86A80-S	690786 45344	38A60-P	614636 24388
A15	1/4 x 1-1/16	1/4	72,750	5/25					38A60-P	614636 24391
A21	1x1	1/4	34,500	5/25					38A60-P	614636 24392
A23	3/4 x 1	1/4	39,370	5/25					38A60-P	614636 24394
A24	1/4 x 3/4	1/4	76,500	5/25					38A60-P	614636 24395
A25	1" Ball	1/4	35,620	5/25			86A80-S	690786 45341	38A60-P	614636 24396
A26	5/8" Ball	1/4	61,120	5/25					38A60-P	614636 24397
A36	1-5/8 x 3/8	1/4	23,520	25/250	0il & Gas 36	662531 45562				
A36	1-5/8 x 3/8	1/4	23,520	5/25					38A60-P	614636 24404
A38	1x1	1/4	34,500	5/25			86A80-S	690786 45345	38A60-P	614636 24406
A39	3/4 x 3/4	1/4	47,250	5/25					38A60-P	614636 24407

† Standard spindle size is 1/4" x 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.





PRECISION OFFHAND/PORTABLE **Mounted Points**

Vitrified Bond

				TIER:	BEST		BETTER		GOOD	
				TRADENAME:	QUANTUN	l	PINK		GEMINI	
				ABRASIVE:	Ceramic Al	umina	86A Alumin	um Oxide	38A Alumin	um Oxide
				MIN./						
SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
	Bond Mounted P			- Total						
B42	1/2 X 3/4	1/8	33,570	5/25					38A60-P	614636 24412
B44	7/32 x 3/8	1/8	68,400	5/25					38A60-P	614636 24414
B52	3/8 x 3/4	1/8	45,370	5/25			86A80-S	690786 45334	38A60-P	614636 24420
B52	3/8 x 3/4	1/4	81,000	5/25					38A60-P	614636 24419
B52	3/8 x 3/4	1/8	45,370	5/25					38A90-Q	614636 24422
B53	5/16 x 5/8	1/8	60,000	5/25			86A80-S	690786 45340	38A60-P	614636 24423
B81	3/4 x 3/16	1/8	50,930	5/25			86A80-S	690786 45347		
B97	1/8 x 3/8	1/8	105,000	5/25	3NQ80	690831 49048	86A80-S	690786 45337	38A60-P	614636 24451
B121	1/2" Ball	1/8	45,370	5/25			86A80-S	690786 45338	38A60-P	614636 24466
B122	3/8" Ball	1/8	61,650	5/25	3NQ80	690831 49050	86A80-S	690786 45360	38A60-P	614636 24470
B123	3/16" Ball	1/8	104,250	5/25					38A60-P	614636 24472
B124	1/8" Ball	1/8	105,000	5/25					38A90-Q	614636 24474
B135	1/4 x 1/2	1/8	60,000	5/25			86A80-S	690786 45342	38A60-P	614636 24484

† Spindle size is 1/8" or 1/4" x 1-1/2" *** Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.



$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$	
ABRASIVE: Ceramic Alumina 86A Aluminum Oxide 38A Aluminum SHAPE SIZE (0 x T) DIA.† RPM* STD. PKG. SPEC PART # SPEC PART # SPEC Vitrified Bond Mounted Points – W Shapes W154 3/16 x 1/2 1/8 70,500 5/25 3NQ80 69083149133 38A60-P 38A60-P 38A60-P 900 9000000000000000000000000000000000000	
SHAPE SIZE (D x T) SPINDLE DIA.† MAX. RPM* SPEC PKG. PART # SPEC PART # SPEC Vitrified Bond Mounted Points W Shapes	Dxide
SHAPE SIZE (D x T) SPINDLE DIA.+ MAX. RPM* STD. PKG. SPEC PART # SPEC PART # SPEC Vitrified Bond Mounted Points - W Shapes	
W154 3/16 x 1/2 1/8 70,500 5/25 3NQ80 69083149133 38A60-P 9 W163 1/4 x 1/2 1/8 60,000 5/25 86A80-S 69078645346 38A60-P 9 W164 1/4 x 3/4 1/8 45,900 5/25 38A60-P 38A60-P 9 W176 3/8 x 1/2 1/8 45,370 5/25 38A60-P 9 38A60-P 9 W177 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P 9 W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 9 9 9 W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 9	PART #
W163 1/4 x 1/2 1/8 60,000 5/25 86A80-S 69078645346 38A60-P W164 1/4 x 3/4 1/8 45,900 5/25 38A60-P 38A60-P W176 3/8 x 1/2 1/8 45,370 5/25 38A60-P 38A60-P W177 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 9078645355 38A60-P W185 1/2 x 1/2 1/8 34,500 5/25 86A80-S 69078645354 W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 W188 1/2 x 1-1/2 1/4 61,500 5/25 86A80-S 69078645354 W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P <td< td=""><td></td></td<>	
W164 1/4 x 3/4 1/8 45,900 5/25 38A60-P W176 3/8 x 1/2 1/8 45,370 5/25 38A60-P W176 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P W177 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 38A60-P W185 W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 W188 38A60-P W189 38A60-P W189 30,370 5/25 38A60-P W189 38A60-P W189 38A60-P W189 38A60-P W189 38A60-P W200 3/4 x 1 34,500 5/25 38A60-P W205 38A60-P W205 38A60-P W205 38A60-P W215 1 x 1/8	14636 24497
W176 3/8 x 1/2 1/8 45,370 5/25 38A60-P W177 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 38A60-P 0 W185 1/2 x 1/2 1/8 34,500 5/25 86A80-S 69078645354 38A60-P 0 W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 0 </td <td>1463624504</td>	14636 24504
W177 3/8 x 3/4 1/8 33,750 5/25 86A80-S 69078645355 38A60-P W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 38A60-P 0 W185 1/2 x 1/2 1/8 34,500 5/25 86A80-S 69078645354 38A60-P 0 W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 38A60-P 0 W188 1/2 x 1-1/2 1/4 61,500 5/25 86A80-S 69078645354 38A60-P 0 W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 38A60-P 0 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 0 38A60-P 0 W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P 0 W215 1 x 1/8 1/8 38,200 5/25 38A60-P 0 0 W215 1 x 1/2 1/4 38,200 5/25 38A60-P 0	14636 24505
W179 3/8 x 1-1/4 1/4 20,415 25/250 0il & Gas 36 69083154055 W185 1/2 x 1/2 1/8 34,500 5/25 38A60-P 38A60-P W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 W185 1/2 x 1-1/2 1/4 30,370 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W215 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W215 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25<	14636 24517
W185 1/2 x 1/2 1/8 34,500 5/25 38A60-P 38A60-P W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 W185 1/2 x 1-1/2 1/4 30,370 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 38	14636 24518
W185 1/2 x 1/2 1/4 61,500 5/25 86A80-S 69078645354 W188 1/2 x 1-1/2 1/4 30,370 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P 9078645356 W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P 9078645356 38A60-P 9078645356 38A60-P 9078645356 38A60-P 9078645356 38A60-P 9078645359 38A60-P	
W188 1/2 x 1-1/2 1/4 30,370 5/25 38A60-P W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 38A60-P 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 38A60-P	14636 24525
W189 1/2 x 2 1/4 24,000 25/250 0il & Gas 36 61463686137 W189 1/2 x 2 1/4 24,000 5/25 38A60-P 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 38A60-P 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 38A60-P	
W189 1/2 x 2 1/4 24,000 5/25 38A60-P W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 38A60-P 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 38A60-P	14636 24530
W200 3/4 x 1/8 1/8 50,930 5/25 86A80-S 69078645356 38A60-P W205 3/4 x 1 1/4 34,500 5/25 38A60-P 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 86A80-S 69078645359 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 38A60-P	
W205 3/4 x 1 1/4 34,500 5/25 38A60-P W215 1 x 1/8 1/8 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 86A80-S 69078645359 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 38A60-P	14636 24531
W215 1 x 1/8 1/8 38,200 5/25 38A60-P 0 W218 1 x 1/2 1/4 38,200 5/25 38A60-P 0 W218 1 x 1/2 1/4 38,200 5/25 38A60-P 0 W220 1 x 1 1/4 25,500 5/25 86A80-S 69078645359 38A60-P 0 W222 1 x 2 1/4 15,900 5/25 38A60-P 0	14636 24543
W218 1 x 1/2 1/4 38,200 5/25 38A60-P 38A60-P W220 1 x 1 1/4 25,500 5/25 86A80-S 69078645359 38A60-P 9078645359 W222 1 x 2 1/4 15,900 5/25 38A60-P 9078645359 38A60-P 9078645359	1463624550
W220 1 x 1 1/4 25,500 5/25 86A80-S 69078645359 38A60-P W222 1 x 2 1/4 15,900 5/25 38A60-P 3	14636 24560
W222 1 x 2 1/4 15,900 5/25 38A60-P	14636 24564
W222 1 x 2 1/4 15,900 5/25 38A60-P	14636 24566
	14636 24569
W235 1-1/2 x 1/4 1/4 25,470 5/25 86A80-S 690786 45343 38A60-P	14636 24583
	14636 24585
	14636 24587
	14636 24588
	1463624592

*f Spindle size is 1/8" or 1/4" x 1-1/2" * Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.*







Since 1823, Norton stones have lead the marketplace with conventional and diamond benchstones, waterstones, sharpening systems, files, slips and specialty stones for industrial, commercial and DIY sharpening applications. Our comprehensive line of sharpening and finishing products is the industry's broadest line with premier performance and quality.

Aluminum Oxide (India), Silicon Carbide (Crystolon), Arkansas (Soft and Hard Translucent),

Deburring, dimensioning, sharpening, honing

Coarse, Medium, Fine, Extra Fine, Ultra Fine

Applications: Grit Range: **Abrasive Types:**

Machine Used:

and Diamond

HAND SHARPENING

Application-to-Product Recommendation Guide **Benchstones Abrasive Files**

	Coarse/Medium Sharpening	Fine Stoning	Finish Honing
Chip Breakers	-	Fine Crystolon Benchstone	-
Draw Knives	Coarse Crystolon	Fine	Ascent
	Benchstone	India Benchstone	Benchstone
Scrapers	Coarse Crystolon	Fine India	Ascent
	Benchstone	Benchstone	Benchstone
Chisels (Wood)	Coarse Crystolon	Fine India	Ascent
	Benchstone	Benchstone	Benchstone
	1000 Waterstone	4000 Waterstone	8000 Waterstone
Plane Blades	Coarse Crystolon	Fine India	Ascent
	Benchstone	Benchstone	Benchstone
	1000 Waterstone	4000 Waterstone	8000 Waterstone

Slips

	Coarse/Medium Sharpening	Fine Stoning
Milling Cutter	Medium India Round Edge Slip	Fine India Round Edge Slip
Carbide Tools		Fine Crystolon Slip for Carbide Tools

	Coarse/Medium Sharpening	Fine Stoning	Finish Honing
Form Cutter	Coarse or Medium India Knife Blade	Fine India Knife Blade	-
Keyways	Coarse or Medium India Square File	Fine India Square File	-
Lathe Bits	Medium India Square File	Fine India Square File	_
Radius Tools	Medium India Round File	Fine India Round File	-
Reamers	Medium India Reamer Stone	Fine India Reamer Stone	_
Router Bits	-	Fine India Square File	-
Saws	Coarse India Triangular File	Fine India Tapered Triangular File	-
Center Punches	Medium India Triangular File	Fine India Triangular File	-
Magnetic Chucks	Medium Crystolon Round File	Fine India Round File	_
Molding Cutters*	Coarse or Medium India File	Fine India File	-
Countersinks	Coarse India Triangular File	Fine India Triangular File	Hard Arkansas Triangular File
Tap Threads	-	Fine India Triangular File	_

* Select shape to fit configuration

Instructional Videos



Sharpening Stones Playlist

📎 nortonsga.us/kb542

Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life - to make all your sharpening, honing, etc. applications easier.



Relative Sharpening Comparisons for Norton Products

Crystolon (Silicon Carbide); India (Aluminum Oxide)	Arkansas (Soft, Hard Translucent)	Diamond Stones	Waterstones	Coated Abrasives (Waterproof Sandpaper)		Diamond Compound
			JIS	CAMI	FEPA	MICRON
			(Japan)	(USA)	(Europe)	Size
					P100	141
Coarse Crystolon					P120	127
				120		116
Coarse India					P150	97
				150		93
Vedium Crystolon				180	P180	78
		Extra Coarse Diamond (220)	Norton 220		P220	65
				220		60
					P240	58
/ledium India				240		53.5
					P280	52.5
						50
					P320	46
ine Crystolon						45
<u> </u>		Coarse Diamond (325)		280		43
		\			P360	40.5
			360	320		36
ine India					P400	35
				360		29
					P600	25.8
				400		23
	Soft Arkansas	Fine Diamond (600)	600		P800	22
						20
			800	600	P1200	16
			Norton 1000	700		14
				800	P1500	12.6
			1200			11
					P2000	10.3
			1500	1000		9.2
						9
				1500	P2500	8.4
					. 2000	7.5
	Hard Translucent Arkansas		Norton 4000	2000		6
				2000		5
			Norton 8000			3
						1.2
						1
			15000			0.5



Benchstones



Extremely hard and wear resistant

ASCENT BENCHSTONES

- Fine and Ultra-fine Ceramic benchstones produce a keener edge that possible with traditional sharpening stones
- Designed to work on all types of knife and tool steels, Ceramic benchstones are the best choice for honing and polishing an already sharp edge
- · These smooth finished stones are best used dry or with a very small amount of water

			TIER:	BEST
SIZE (L x W x H)	QTY./ Case	SPEC.		PART #
Ascent Single Gri	t Benchs	tones		
4 x 1 x 1/2	1	Fine		690786 43670
	1	Ultra Fine		690786 43671
6 x 2 x 1/2	1	Fine		690786 43672
	1	Ultra Fine		690786 43673
8 x 2 x 1/2	1	Fine		690786 43674
	1	Ultra Fine		690786 43675
8 x 3 x 1/2	1	Fine		690786 43676
	1	Ultra Fine		690786 43677
11-1/2 x 2-1/2 x 1/2	1	Fine		690786 43678
	1	Ultra Fine		690786 43679

Better choice for sharpening tools and knives



PRECISION BENCHSTONES

- Jewelers' Benchstones These stones are excellent for sharpening the fine, precision cutting tools used by jewelers, engravers and artisans
- Penknife Precision Benchstones Ideal for sharpening cutting tools, laboratory blades, surgical instruments, engravers' and die makers' tools, and pocket knives to the keenest edge

			TIER:	BETTER	
SIZE (L x W x H)	QTY./ Case	SPEC.		PRODUCT #	PART #
Precision Bench	stones –	Jewelers'			
4 x 2 x 3/8	5	Ultra Fine – Hard Translucent Arkansas		HB24	614636 87525
6 x 2 x 3/8	5	Ultra Fine – Hard Translucent Arkansas		HB26	614636 87530
Jewelers' stones ar	re packed ir	n individual boxes within a case. Order in multiples	of sto	nes/case.	
Precision Bench	stones –	Penknife			
3 x 1 x 3/8	5	Extra Fine – Soft Arkansas		SB13	614636 87560
		Ultra Fine – Hard Translucent Arkansas		HB13	614636 87550
4 x 1 x 3/8	5	Extra Fine – Soft Arkansas		SB14	614636 87565
		Ultra Fine – Hard Translucent Arkansas		HB14	614636 87555



Benchstones



Better choice for edge shaping and honing

SINGLE GRIT ABRASIVE BENCHSTONES

- Crystolon sharp premium silicon carbide abrasive, delivers fast stock removal for quick edge shaping with minimal loading
- India smooth cutting aluminum oxide abrasive produces a strong, keen, long-lasting edge and is the choice for the best blend of cut rate and finish
- Arkansas Natural premium Novaculite quarried in Arkansas and available in Soft or Hard Translucent

		TIF	R: BETTER	
	QTY./	TIL		
SIZE (L x W x H)	CASE	SPEC.	PRODUCT #	PART #
Single Grit Benchsto	nes – Crys	stolon (Silicor	Carbide)	
4 x 1 x 1/4	5	Coarse	CJB14	614636 85470
	5	Medium	MJB14	614636 85465
	5	Fine	FJB14	614636 85460
4 x 1 x 1/2	5	Coarse	CJB24	614636 85485
	5	Medium	MJB24	614636 85480
	5	Fine	FJB24	614636 85475
5 x 2 x 5/8	5	Medium	MJB35	614636 85495
	5	Fine	FJB35	614636 85490
6 x 2 x 1	5	Coarse	CJB6	614636 85510
	5	Medium	MJB6	614636 85505
	5	Fine	FJB6	614636 85500
8 x 2 x 1	5 5	Coarse	CJB8	614636 85525
	5	Medium	MJB8	614636 85520
	5	Fine	FJB8	614636 85515
8 x 3 x 1/2	5 5	Coarse	CJB83	614636 54459 *
		Medium	MJB83	614636 54458 *
	5	Fine	FJB83	614636 54457 *
11-1/2 x 2-1/2 x 1/2	1	Coarse	JM3	614636 85980 #
	1	Medium	JM6	614636 85975 #
Single Grit Benchsto	nes – Sofi	t Arkansas		
8 x 2 x 3/4-1	5	Extra Fine	SB8	614636 85680

		TIE	R: BETTER	
	QTY./	0000		
SIZE (L x W x H)	CASÉ	SPEC.	PRODUCT #	PART #
Single Grit Benchsto	ones – Indi	ia (Aluminum (Oxide)	
4 x 1 x 1/4	5	Coarse	CB14	614636 85580
	5	Medium	MB14	614636 85575
	5	Fine	FB14	614636 85570
4 x 1 x 1/2	5	Coarse	CB24	614636 85595
	5	Medium	MB24	614636 85590
	5	Fine	FB24	614636 85585
5 x 2 x 5/8	5	Medium	MB35	614636 85605
	5	Fine	FB35	614636 85600
6 x 2 x 1	5	Coarse	CB6	614636 85620
	5	Medium	MB6	614636 85615
	5	Fine	FB6	614636 85610
8 x 2 x 1	5	Coarse	CB8	614636 85635
	5 5	Medium	MB8	614636 85630
	5	Fine	FB8	614636 85625
8 x 3 x 1/2	5	Coarse	CB83	614636 54462 *
	5	Medium	MB83	614636 54461 *
	5	Fine	FB83	614636 54460 *
11-1/2 x 2-1/2 x 1/2	1	Medium	IM6	614636 54214 #
	1	Fine	IM9	614636 85970 #
Single Grit Benchsto	ones – Har	d Translucent	Arkansas	
4 x 2 x 3/4-1	5	Ultra Fine	HB4	614636 85655
6 x 2 x 3/4-1	5	Ultra Fine	HB6	614636 85660
8 x 2 x 3/4-1	5	Ultra Fine	HB8	61463685665

8 x 2 x 3/4-1 5 Extra Fine SB8 * May be used as replacement stone for IM-83 Sharpening System.

May be used as replacement stone for IM-313 Sharpening Stone System.

These benchstones (except for 8 x 3 x 1/2 and vendibles) are packed in individual boxes within a case. Order in multiples of stones/case.



Benchstones



Better choice for economical solution for general sharpening and finishing with one stone

COMBINATION GRIT ABRASIVE BENCHSTONES

Crystolon Combination

Coarse and fine grit sharp-cutting silicon carbide abrasive surfaces for general sharpening (to moderate tolerances) when the speed of sharpening is more important than the fineness of the cutting edges. Gray in color.

- India Combination
 Coarse and fine grit aluminum oxide abrasive surfaces produce strong, keen, long-lasting edges on quality tools.
 Orange/brown in color.
- Crystolon/India Combination
 Fast-sharpening, medium grit silicon carbide (Crystolon) and fine aluminum oxide (India) abrasive surfaces for keen, long-lasting edges on quality tools. Crystolon side is dark gray in color, India side is orange.
- Giant Combination Stones
 11-1/2" and 12" bench oil stones are used to sharpen large edge tools with long sweeping strokes.

Application-to-Product Recommendation Guide

	FAST CUT STOCK REMOVAL	INITIAL SHARPENING	FINAL SHARPENING	HONING	SHARPEST EDGE
Grit Size	Coarse	Medium	Fine	Extra Fine	Ultra Fine
Abrasive	Crystolon	Crystolon	India	Soft Arkansas	Hard Arkansas
Product/Color	Grey	Grey	Orange	Milky White	Translucent

	0.000		<i>TIER:</i> BETTER	
SIZE (L x W x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Combination Grit Be	enchstone	es – Crystolon (Silicon Carbide)		
4 x 1 Round	5	Coarse/Fine	JB64	614636 85435
4 x 1-3/4 x 5/8	5	Coarse/Fine	JB134	614636 85440
5 x 2 x 3/4	5	Coarse/Fine	JB45	614636 85445
6 x 2 x 1	5	Coarse/Fine with Anniversary Box	JB6	614636 85450
8 x 2 x 1	5	Coarse/Fine with Anniversary Box	JB8	614636 85455
11-1/2 x 2-1/2 x 1	2	Coarse/Fine	JUM3	614636 85840
12 x 2-1/2 x 1-1/2	2	Coarse/Fine	JUM4	614636 85855
Combination Grit Be	enchstone	es – India (Aluminum Oxide)		
4 x 1 Round	5	Coarse/Fine	IB64	614636 85545
4 x 1-3/4 x 5/8	5	Coarse/Fine	IB134	614636 85550
5 x 2 x 3/4	5	Coarse/Fine	IB45	614636 85555
6 x 2 x 1	5	Coarse/Fine with Anniversary Box	IB6	614636 85560
8 x 2 x 1	5	Coarse/Fine with Anniversary Box	IB8	614636 85565
11-1/2 x 2-1/2 x 1	2	Coarse/Fine	IM2	614636 85851
Combination Grit Be	enchstone	es – Crystolon/India		
6 x 2 x 1	5	Medium/Fine	IC6	614636 85643
11-1/2 x 2 x 1	2	Medium/Fine	IC11	614636 87239

These benchstones are packed in individual boxes within a case. Order in multiples of stones/case.



Waterstones

Waterstones are synthetic stones designed to be softer than oil stones. These softer grade stones are used with water as the lubricant (versus oil) to develop a fast cutting slurry. The Norton Waterstone system was designed in a carefully planned sequence to create sharpening efficiency. You get the level of abrasiveness you need at each stage, without wasting time trying to sharpen your tools on a grit that is too fine, too soon.



Better choice for producing superior edges on planes and straight chisels

WATERSTONES

- · Synthetic stones designed to work together, with water for fast sharpening, fine finish
- · Softer than traditional oilstones providing lapping action for superb results with low pressure
- Color-coded by grit: 220 grit for repairing badly damaged tools, 1000 grit for initial cut, 4000 grit for excellent finishing, and 8000 grit for polishing

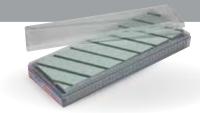
Better choice for raising slurry



PREP STONE

- This synthetic stone enhances the performance of waterstones by speeding up the slurry-making process needed to cut and polish with waterstones
- This prep stone is designed to raise the slurry on waterstones without significantly altering the dimensions of the stone
- Waterstones are great for producing superior edges for planes and straight chisels

Better choice for producing flat surfaces on waterstones



FLATTENING STONE

- · Coarse grit silicon carbide stone promotes fast results
- · Diagonal grooves increase swarf removal
- · Superbly flat with hard bond to produce extremely flat surfaces on all waterstones

		7	TER: BETTER
	QTY./		
SIZE (L x W x H)	CASE	SPEC.	PART #
Waterstones - Sing	le Grit		
8 x 3 x 1	5	220	614636 89505
	5	1000	614636 89506
	5	4000	614636 89507
	5	8000	614636 89508
Set	1	4 Stones: 220, 1000, 4000, 8000 Grit	614636 24334
Waterstones – Com	bination Gr	/it	
8 x 3 x 1	5	220 / 1000	614636 24335
	5	1000 / 4000	614636 24450
	5 5	1000 / 8000	699366 55039
	5	4000 / 8000	614636 24336
Prep Stone			
20mm x 20mm x 3"	5	Aluminum Oxide	662434 39361
Flattening Stone			
9 x 3 x 3/4	5	Silicon Carbide	699366 87444
Waterstone Kit			
N/A	1	Kit includes: 1-220/1000 and 1-4000/8000 waterstone, 1 flattening stone	076607 87943

Waterstones are packed in individual boxes within a case. Order in multiples of stones/case.

Instructional Videos



Sharpening Stones Playlist **onrtonsga.us/kb542**

Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life – to make all your sharpening, honing, etc. applications easier.

TECH TIP

Maximizing Waterstone Performance

- Wet waterstone
- Rub evenly with the prep stone to create slurry
- Evening off the high spots will make for less-frequent flattening of the waterstones
- Waterstones wear concave with use; periodically flatten with flattening stone



Diamond Benchstones

Made in the USA, these benchstones have unique stackable non-skid rubber feet designed to keep the diamond plate steady while you sharpen, and efficiently stacked for space-saving storage when not in use. Our simple grit-size color-coding makes them easy to differentiate.



Better choice for producing superior edges on planes and straight chisels

STACKABLE DIAMOND BENCHSTONES

- Flat, diamond surface plated onto a nickel coated steel bar precision ground to a tolerance of .001 in. for fast, even blade and tool edge sharpening
- · Continuous diamond sharpening surface for excellent sharpening performance across entire surface of stone
- · Choose 220 grit for badly worn tools, 325 for initial sharpening, 600 grit for final sharpening
- · Color-coded tabs on stones and packaging for easy identification of grit sizes for use and displaying
- · Stackable; the stones firmly stack on top of each other for easy, small-profile storage
- · Non-skid rubber base stays in place while sharpening for smoother, efficient sharpening

		TIER:	BETTER			
SIZE WITH RUBBER FEET (L x W x H)	QTY./ Case	SPEC.	PART #			
Stackable Diamond Benchstones						
6 x 2 x 1/4*	5	D220	662532 68082			
6 x 2 x 1/4*	5	D325	662532 68081			
6 x 2 x 1/4*	5	D600	66253268080			

Diamond benchstones are packed in individual boxes within a case. Order in multiples of stones/case.



6" stones come retail packaged

Sharpening Stone Oil



Better choice for improving sharpening stone performance

SHARPENING STONE OIL

- · Highly refined lubricating oil which is specifically formulated for sharpening stone use
- Will not load or "gum-up" sharpening stones, meets U.S. Pharmacopoeia standards for mineral oil purity; may be used around food preparation operations
- · Equally ideal for all lubricating jobs

QTY./ CASE SPEC. PRODUCT # PART # Sharpening Stone Oil 4-1/2 oz. 20 Oil XB1 61463687760			TIER:	BETTER				
	SIZE		SPEC.	PRODUCT #	PART #			
4-1/2 oz. 20 Oil XB1 614636 87760	Sharpening Ston	Sharpening Stone Oil						
	4-1/2 oz.	20	Oil	XB1	614636 87760			
1 Pint 20 Oil XB5 614636 87770	1 Pint	20	Oil	XB5	614636 87770			
1 Quart 5 Oil XB2 614636 87775	1 Quart	5	Oil	XB2	614636 87775			

TECH TIP

- All oil stones are porous in nature; oil is required to keep the pores open and working efficiently
- Use Norton oil to optimize the performance of Crystolon, India and Arkansas stones
- While sharpening knives, blades and tools, be careful to keep fingers away from sharp edges



Sharpening Systems

Tri-Stone Systems

The base of the tri-stone system acts as an oil reservoir permitting continuous submersion of the unused stones, keeping them clean and saturated, ready for immediate use and years of utility. Rotating the handle brings the desired stone into position for sharpening. All offer a range of replacement stones to replace worn or damaged stones, or substitute different specifications to customize the system.



Better choice for large, straight-edged tool sharpening

IM313 MULTI-OILSTONE SHARPENING SYSTEM

- Considered by many to be the ultimate sharpening system, the IM313 contains three oil stones. The 11-1/2" stone length permits long, sweeping strokes for faster and more precise sharpening and honing of all large, wider straight-edged tools. The heavy base has a non-skid bottom.
- Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- Each IM313 system is included with a pint of Norton oil, plastic angle guide, and reservoir unit

Better choice for a versatile, multi-size tool and knife sharpener

IM200 PROFESSIONAL SHARPENING SYSTEM

- The smaller 8" stone IM200 system provides the same quality sharpening features as the IM313 making it the perfect choice for small restaurants and home DIYers
- Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- Contains 4-1/2 oz. of lubricating oil, plastic angle guide, and the reservoir unit



Better choice for small straight-edged tool sharpening

IM100 3-IN-1 TOOL AND KNIFF SHARPENING SYSTEM

- The smallest system, designed for general sharpening, the IM100 is an affordable choice for small knives, cutlery, and woodworking tools
- · Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- 4-1/2 oz. of lubricating oil and a reservoir unit included

Portable Sharpening Systems



IM83 PORTABLE SHARPENING STONE SYSTEM

- Sturdy metal latches secure the cover and storage case where small tools can be housed. The IM83 system is designed like all our other sharpening systems; the stones can be replaced to customize the unit to
- Ideal for industrial toolrooms, restaurants, knife manufacturers, DIYers, and sportsmen
- Both IM83 systems include 3 sharpening stones, and a reservoir carrying case; the oil stone system also
- IM83-W Portable Waterstone System Tool Repair to Fine Finishes This portable sharpening system is equipped with a carefully engineered sequence of waterstones for clean, efficient sharpening. The waterstones can easily be maintained with the flattening stone provided
- IM83-O Portable Oil Stone System Straight-Edged Tool Sharpening The coarse silicon carbide (Crystolon) stone in this system repairs damaged edges quickly; the medium aluminum oxide (India) stone imparts a durable, smooth cutting edge; and the fine aluminum oxide (India) stone provides the final sharpening and polishing stage



Sharpening Systems

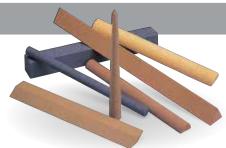
Portable Sharpening Systems

	0 ,		<i>IER:</i> BETTER	
SIZE	QTY./ Case	SPEC.	PRODUCT #	PART #
M313 Multi-Oilstone Sh	narpening Sy	stem		
11-1/2 x 2-1/2 x 1/2	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 1 Pint Oil, Angle Guide, Reservoir Unit	IM313	614636 85960
M200 Professional Sha	rpening Syst	em		
3 x 2 x 3/8	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 4-1/2 oz. Oil, Angle Guide, Reservoir Unit	IM200	614636 91260
M100 3-in-1 Tool and K	nife Sharpen	ing System		
x 2 x 1/2	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 4-1/2 oz. Oil, Reservoir Unit	IM100	614636 85356
M83 Portable Systems				
3 x 3 x 1/2	1	Oilstones: 1 Coarse Crystolon, 1 Medium India, 1 Fine India, 4-1/2 oz. Oil, Reservoir Carrying Ca	se IM83-0	662435 82823
3 x 3 x 1	1	Waterstones: 1 ea. of 1000, 4000, 8000 Grit, 1 Flattening Stone, Reservoir Carrying Case	IM83-W	662435 82825

For sharpening system replacement stones: see single grit benchstone charts, or your Norton representative for replacement stones and parts which may be used as replacements or to customize your system.

Abrasive Files

Norton abrasive files hold their shape while imparting the finest, most uniform finish on precision machine parts and in tool and die making. They are ideal for any deburring, chamfering or radiusing job, or for filing delicate parts. Select the file shape that matches the contour of the surface being stoned.



Better choice for any deburring, chamfering or radiusing job, or for filing delicate parts

ABRASIVE FILES

- Crystolon Files Fast-acting silicon carbide products, Crystolon files are designed for use where moderate tolerances are acceptable, and speed of sharpening is more important than fineness
- India Files India files are ideal when close tolerance, and strong, keen, long-lasting edges are needed
- Hard Translucent Arkansas Files Hard Arkansas has an ultra fine grit that produces the finest edge possible while maintaining tolerances unequalled by any other abrasive file. It will also produce a highly polished finish

Square Abrasive Files

Square File applications range from dimensioning keyways to maintain fit, stoning faces on router bits, touching-up edges of reamer teeth, and lapping/honing to close tolerances to produce the finest edge on precision instruments, die work and delicate tools.



		TI	ER: BETTER	
SIZE (L x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Square Abrasi	ive Files – (Crystolon (Silic	on Carbide)	
4 x 1/2	5	Medium	MJF44	614636 86045
	5	Fine	FJF44	614636 86040
Square Abrasi	ive Files – I	Hard Transluce	nt Arkansas	
3 x 1/4	5	Ultra Fine	HF13	614636 86590
3 x 3/8	5	Ultra Fine	HF33	614636 86595
3 x 1/2	5	Ultra Fine	HF43	614636 86600
All square files a	are hulk nack	ed		

All square files are bulk packed

		7	IER: BETTER	
SIZE (L x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Square Abrasi	ve Files – I	ndia (Aluminu	m Oxide)	
4 x 1/4	5	Coarse	CF14	614636 86075
1 / 1/ 1	5	Medium	MF14	614636 86070
	5	Fine	FF14	614636 86065
4 x 3/8	5	Coarse	CF34	614636 86090
	5	Medium	MF34	614636 86085
	5	Fine	FF34	614636 86080
4 x 1/2	5	Coarse	CF44	614636 86105
	5	Medium	MF44	614636 86100
	5 V	Medium	MF44-V	662533 25913
	5	Fine	FF44	614636 86095
6 x 1/2	5	Coarse	CF46	614636 86120
	5	Medium	MF46	614636 86115
	5	Fine	FF46	614636 86110
6 x 5/8	5	Medium	MF56	614636 86130
	5	Fine	FF56	614636 86125
6 x 3/4	5	Coarse	CF66	614636 86150
	5	Medium	MF66	614636 86145
	5	Fine	FF66	614636 86140
6 x 1	5	Coarse	CF76	614636 86165
	5	Medium	MF76	614636 86160
	5	Fine	FF76	614636 86155

V = Vendible Package. Ideal for vending machines, small jobs, and carrying to job site. Pre-packed in sturdy boxes of 5 per pack. Order by total number of stones needed in multiples of 5.



Abrasive Files

Triangular Abrasive Files

Triangular Files are used for a variety of deburring, chamfering and radiusing applications including cleaning tap threads, stoning cutting surfaces of milling cutters, lapping honing tools, dies and molds, and putting precision points on center punches.

The India line also offers Tapered Triangles, used by mechanics and tool and die makers to impart the correct edge in the least time.



		TI	ER: BETTER	
	QTY./			
SIZE (L x H)	CASE	SPEC.	PRODUCT #	PART #
Triangular Ab	rasive Files	s – Crystolon (S	ilicon Carbide)	
4 x 1/4	5	Fine	FJF114	614636 86185
4 x 1/2	5	Fine	FJF144	614636 86205
Triangular Ab	rasive Files	s – Hard Translu	cent Arkansas	
3 x 1/4	5	Ultra Fine	HF113	614636 86620
3 x 3/8	5	Ultra Fine	HF133	614636 86625
3 x 1/2	5	Ultra Fine	HF143	614636 86630
All Triongular fi	loo ara hullur	aakad		

All Triangular files are bulk packed

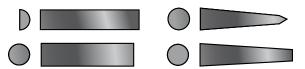
Round Abrasive Files

Half Round Files offer both a round and a flat surface for imparting a fine finish on precision machine parts, tools and dies.

Round Files are ideal for deburring, chamfering, radiusing, lapping, honing, cleaning radius tools to a burr-free edge, and dimensioning compound curves on templates.

Round Pointed Files are ideally suited for engravers and die sinkers for stoning difficult recesses on instruments and die tools.

Round Tapered Files are used by craftsmen, woodworkers, and die makers as their unique shape imparts the correct edge quickly.



		7	IER: BETTER	
SIZE (L x D)	QTY./ Case	SPEC.	PRODUCT #	PART #
Half Round Ab	rasive File	s – India (Alum	inum Oxide)	
4 x 1/4	5	Medium	MF314	614636 86355
	5	Fine	FF314	614636 86350
4 x 3/8	5	Medium	MF334	614636 86385
	5	Fine	FF334	614636 86380
4 x 1/2	5	Coarse	CF344	614636 86405
	5	Medium	MF344	614636 86400
	5	Fine	FF344	614636 86395

All Half-Round and Round files are bulk packed

PRECISION OFFHAND/PORTABLE Sharpening Stones

	ÔTV /	1	ER: BETTER	
SIZE (L x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Triangular Abi	rasive Files	– India (Alumi	num Oxide)	
4 x 1/4	5	Coarse	CF114	614636 86240
	5	Medium	MF114	614636 86235
	5	Fine	FF114	614636 86230
4 x 3/8	5	Coarse	CF134	614636 86255
	5	Medium	MF134	614636 86250
	5	Fine	FF134	614636 86245
4 x 1/2	5	Coarse	CF144	614636 86270
	5	Medium	MF144	614636 86265
	5	Fine	FF144	614636 86260
6 x 1/2	5	Coarse	CF146	614636 86285
	5	Medium	MF146	614636 86280
	5	Fine	FF146	614636 86275
6 x 5/8	5	Medium	MF156	614636 86295
	5	Fine	FF156	614636 86290
6 x 3/4	5	Medium	MF166	614636 86310
	5	Fine	FF166	614636 86305
6 x 1	5	Medium	MF176	614636 86325
	5	Fine	FF176	614636 86320
Triangular Tap	ered Abras	ive Files – Ind	ia (Aluminum Oxid	e)
4 x 1/2 x 1/4	5	Medium	MF544	614636 86685
	5	Fine	FF544	614636 86680

		Th	ER: BETTER	
SIZE (L x D)	QTY./ Case	SPEC.	PRODUCT #	PART #
Round Abrasiv	e Files – C	rystolon (Silico	n Carbide)	
4 x 1/4	5	Medium	MJF214	614636 86430
	5	Fine	FJF214	614636 86425
4 x 3/8	5	Medium	MJF234	614636 86440
Round Abrasiv	e Files – Ir	ndia (Aluminum	Oxide)	
4 x 1/4	5	Coarse	CF214	614636 86480
7 / 1 / 7	5	Medium	MF214	614636 86475
	5	Fine	FF214	614636 86470
4 x 3/8	5	Coarse	CF234	614636 86495
	5	Medium	MF234	614636 86490
	5	Fine	FF234	614636 86485
4 x 1/2	5	Coarse	CF244	614636 86510
	5	Medium	MF244	614636 86505
	5	Fine	FF244	614636 86500
6 x 1/2	5	Coarse	CF246	614636 86525
	5	Medium	MF246	614636 86520
	5	Fine	FF246	614636 86515
6 x 5/8	5	Medium	MF256	614636 86535
6 x 3/4	5	Medium	MF266	614636 86550
6 x 1	5	Medium	MF276	614636 86565
Round Abrasiv	e Files – H	ard Translucen	t Arkansas	
3 x 1/4	5	Ultra Fine	HF813	614636 86800
Round Pointed	Abrasive	Files – India (Al	luminum Oxide)	
3 x 5/16 Base	5	Medium	MF723	614636 86745
	5	Fine	FF723	614636 86740
Round Pointed	Abrasive	Files – Hard Tra	Inslucent Arkansa	IS
3 x 1/4 Base	5	Ultra Fine	HF863	614636 86825
Round Tapered	Abrasive	Files – India (A	luminum Oxide)	
4 x 1/2 x 1/4	5	Medium	MF644	614636 86655
	5	Fine	FF644	614636 86650

Industrial Market - Full-Line



Abrasive Files

Diamond-Shaped Abrasive Files

Diamond-shaped Files are precision sharpening favorites for cleaning acute angles in dies and molds, and for stoning geometric chasers and sewing machine feeds.



			TIER: BETTER			
	QTY./					
SIZE (L x W x H)	CASE	SPEC.	PRODUCT #	PART #		
Diamond-Shape	d Abrasive	e Files – Indi	a (Aluminum Oxide)		
4 x 9/16 x 3/16	5	Coarse	CT134	614636 86720		
	5	Medium	MT134	614636 86715		
	5	Fine	FT134	614636 86710		
Diamond-Shaped Abrasive File – Hard Translucent Arkansas						
3 x 1/2 x 3/16	5	Ultra Fine	HF843	614636 86815		
All Diamond-shaped files are bulk packed						

Beveled Abrasive Files

Beveled Files are preferred by exacting artisans, jewelers, mechanics, and watchmakers for honing the finest of finishes. These extremely hard files provide years of service.



		Ti	ER: BETTER	
	QTY./			
SIZE (L x W x H)	CASE	SPEC.	PRODUCT #	PART #
Beveled Abrasi	ve File –	Hard Transluce	nt Arkansas	
3 x 3/8 x 1/8	5	Ultra Fine	HF833	614636 86810
All Reveled files a	re hulk nad	rked		

All Beveled files are bulk packed

Flat Abrasive Files

The Flat File is the choice of mechanics, artisans and jewelers. This long lasting file produces the finest finishes.



		7	TER: BETTER	
SIZE (L x W x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Flat Abrasive F	ile – Harc	l Translucent A	Arkansas	
3 x 3/8 x 1/8	5	Ultra Fine	HF823	614636 86805
All Flat files are h	ulk nacked			

All Flat files are bulk packed

Oval Abrasive Files

The Oval File's shape makes it ideal for finishing and honing recesses or curved edges of precision instruments.



			TIER: BETTER	
SIZE (L x W x H)	QTY./ Case	SPEC.	PRODUCT #	PART #
Oval Abrasive Fi	le – Hard	Translucent	Arkansas	
3 x 1/2 x 3/16	5	Ultra Fine	HF853	614636 86820
All Oval files are bu	ulk packed			

See the "Norton Professional Sharpening Products and Dressing Sticks Catalog #200" on nortonabrasives.com to view the complete list and descriptions of our many sharpening products.

Knife Blade Abrasive Files

Knife Blade Files are used by clock and watch makers to quickly sharpen, hone, and maintain the edges and points of cutting tools.



		7	<i>IER:</i> BETTER	
	QTY./	0050		DADT #
SIZE (L x W x H)	CASE	SPEC.	PRODUCT #	PART #
Knife Blade Abr	asive Fil	es – India (Aluı	ninum Oxide)	
4 x 1 x 1/8 Back	5	Coarse	CF724	614636 86780
	5	Medium	MF724	614636 86775
	5	Fine	FF724	614636 86770
Knife Blade Abr	asive Fil	e – Hard Transl	ucent Arkansas	
3 x 3/4 x 1/8	5	Ultra Fine	HF873	614636 86830
All Knife Blade file	s are bulk	packed		

Abrasive File Sets

Hard Translucent Arkansas File Set

This set provides a selection of our most popular square, triangular, round and knife blade files in ultra fine Hard Translucent Arkansas for honing and polishing a wide range of configurations.

Hard Translucent Arkansas-India File Set

This set contains an assortment of files for finishing, honing and polishing applications. It contains a selection of the most popular square, triangular, round and knife blade files in both fine grit India and ultra fine grit Hard Translucent Arkansas.



		TIER: BETTER	
SIZE (L x W x H)	QTY./ Case	PRODUCT #	PART #
	Franslucent Arka	nsas	
	1		614636 86839
1 Each of Ultra Fin	e Hard Arkansas HF	13, HF113, HF813, and HF873	
File Set - Hard 1	Franslucent Arka	nsas and India (Aluminum (Dxide)
	1	•	614636 86840
1 Each of Ultra Fin	e Hard Arkansas HF	13, HF43, HF113, HF813, HF87	73,

1 Each of Ultra Fine Hard Arkansas HF13, HF43, HF113, HF813, HF873, and Fine India FF14, FF44, FF114, FF214, FF724



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Abrasive Files

Engravers' Chuck & Points

Engravers' Points are the choice of professional die-makers for cleaning tight corners and recesses where close tolerances and accuracy are a must. The Engravers' Chuck is a knurled nickel-plated tool designed to hold the Engravers' Point.

		TIER	BETTER		
SIZE (L x POINT)	QTY./ Case	SPEC.	PRODUCT #	PART #	********
Engravers' Chuck					
Engravers' Chuck	5		XT1	614636 87485	
Engravers' Point – India (Aluminum Oxid	e)				
1 x 1/8 Point	5	Fine	FT11	614636 87495	
Engravers' Point – Soft Arkansas					
1 x 1/8 Point	5	Extra Fine	AT11	614636 87490	

All Engravers' Chucks and Points are bulk packed.

Silversmith Precision Files

These aluminum oxide precision-shaped stones are designed for use by silversmiths and mechanics for close tolerance lapping, touching-up instruments, and for cleaning tools and dies.

		TIE	R: BETTER	
SIZE	QTY./ Case	SPEC.	PRODUCT #	PART #
Silversmith Precision Files - India (Alumi	inum Oxide)			
4 x 5/16 x 3/16 x 5/16 x 1/16 - X	5	Medium	MF414	614636 86855
	5	Fine	FF414	614636 86850
4 x 1/2 x 1/16 - BB	5	Medium	MF444	614636 86960
	5	Fine	FF444	614636 86955
4 x 1/2 x 1/4 x 5/16 x 1/8 - EE	5	Medium	MF474	614636 87005
	5	Fine	FF474	614636 87000 NS

All Silversmith Precision Files are bulk packed.



Pocket Stones



Better choice for outdoor enthusiasts

POCKET STONES

- · Convenient and easily transported
- · Ideal for outdoor enthusiasts to sharpen scissors, knives, axes, etc.
- Available in a protective case

		TH	R: BETTER	
	QTY./			
SIZE (L x W x H)	CASE	SPEC.	PRODUCT #	PART #
Sportsman Pocket Stone - India (Al	uminum Oxide)			
3 x 1-1/2 x 1/2	50	Coarse/Fine	IBP4	614636 90705
Pocket Stone – India (Aluminum Ox	ide)			
4 x 3/4 x 1/4	25	Fine	IBP4	614636 24153
Pocket Stone with Case - India (Alu	ıminum Oxide)			
3 x 7/8 x 3/8 with case	50	Fine	FBP3	614636 91122
Pocket Stone with Case - Crystolon	(Silicon Carbide)		
3 x 7/8 x 3/8 with case	50	Fine	JP14	614636 90703
Fish Hook Stone With Pouch - Cryst	tolon Half-Round	(Silicon Carbide)		
3 x 1/2 with pouch	50	Fine		614636 24072
All Dealest Ctance are bully peaked				

All Pocket Stones are bulk packed.



Abrasive Slips

PRECISION OFFHAND/PORTABLE Sharpening Stones



Better choice for imparting fine, uniform finishes

ABRASIVE SLIPS

- · Norton abrasive slips impart the finest, most uniform finishes on curved knives and tools, molders' knives, wood gouges, bead planers, and carbide-tipped tools
- The Crystolon and India stones are designed for preliminary sharpening; the Norton Hard Translucent Arkansas stones are the choice for achieving the finest finish possible
- . These fast-acting slips hold their shape and are long lasting

Carbide Tool Slips

Crystolon (silicon carbide) Slips are used to maintain the edge of carbide tools - keeping regrinding costs and time to an absolute minimum. Not oil-filled.

Round Edge Slips

Round Edge Slips are ideal for precision sharpening and honing of bead planers, curved knives and tools, molders' knives and wood gouges.



inves and wood gouges.				
		TIEF	: BETTER	
0175	QTY./ Case	0770		D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D 1 D
SIZE		SPEC.	PRODUCT #	PART #
Carbide Tool Slips – Crystolor	•		0.1700	
3-1/2 x 3/4 x 1/2	5	Coarse	CJT63	614636 87295
	5	Medium	MJT63	614636 87290
	5	Fine	FJT63	614636 87285
Set of Three Above	5	Coarse, Medium & Fine	J63	614636 87300
Carbide Tool Slips – India (Al	uminum Oxide)			
2-1/4 x 7/8 x 3/16	5	Medium	MS12	614636 87215
Round Edge Slips – Crystolon	(Silicon Carbid	le)		
4-1/2 x 1-3/4 x 1/4 x 3/32	5	Medium	MJS24	614636 87080
	5	Fine	FJS24	614636 87075
4-1/2 x 1-3/4 x 1/2 x 3/16	5	Coarse	CJS44	614636 87100
	5	Medium	MJS44	614636 87095
	5	Fine	FJS44	614636 87090
6 x 2-1/4 x 3/4 x 3/8	5	Medium	MJS66	614636 87110
	5	Fine	FJS66	614636 87105
Round Edge Slips – India (Alu	minum Oxide)			
4 x 1 x 7/16 x 3/16	5	Medium	MS14	614636 87140
	5	Fine	FS14	61463687135
4-1/2 x 1-3/4 x 1/4 x 3/32	5	Coarse	CS24	61463687155
, , , ,	5	Medium	MS24	61463687150
	5	Fine	FS24	614636 87145
4-1/2 x 1-3/4 x 3/8 x 1/8	5	Coarse	CS34	614636 87170
	5	Medium	MS34	61463687165
	5	Fine	FS34	614636 87160
4-1/2 x 1-3/4 x 1/2 x 3/16	5	Coarse	CS44	614636 87185
,,_,,_,	5	Medium	MS44	614636 87180
	5	Fine	FS44	614636 87175
5 x 1 x 5/16 x 3/32	5	Medium	MS15	614636 87195
	5	Fine	FS15	614636 87190
Round Edge Slips – Soft Arkaı			. 510	
4 x 1-3/4 x 3/8 x 1/8	5	Extra Fine	SS4	614636 87055
Round Edge Slips – Hard Trans	-		001	01100001000
3 x 1-3/4 x 1/4 x 1/16	SIUCCIIL AIRAIIS 5	ultra Fine	HS3	614636 87040
4 x 1-1/4 x 1/4 x 1/8	5	Ultra Fine	HS14	614636 87050
4 x 1-3/4 x 3/8 x 1/8	5	Ultra Fine	HS14 HS4	614636 87045
4 X 1-3/4 X 3/0 X 1/0	Э	UILLA FILLE	п 0 4	0140300/045

All Slips are bulk packed.

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Specialty Stones





Better choice for specific sharpening or deburring applications

SPECIALTY STONES

 Norton continues to offer specialty stones with optimum specifications and unique shapes that conform to, and quickly sharpen, specific tools

Specialty Stones for Machine Tools

Gouge Sharpening Stone

This stone has a unique shape for sharpening and lapping inside and outside curved surfaces on gouges and other cutting tools.

Jointer Stones

These stones provide a fast method of restoring and maintaining the cutting edges of mechanical jointing devides on automatic planers.

Machine Knife Stone

Crystolon (silicon carbide) machine knife stones offer both coarse and fine sides for sharpening and honing paper and cloth-cutting knives and planer knives on the machine. The groove around the middle of the stone protects fingers and provides a secure hold.

Reamer Stones

Durable, fast-cutting stones designed for imparting a professional edge on reamers, taps, and rough rounders on shoe machine tools.

Boat Stones

Boat Stones are medium grit, medium grade stones that are easy to hold and use. Excellent for deburring and breaking sharp edges on dies, fixtures and machined parts, and for deburring grinder magnetic chucks.

		TIER	BETTER	
	QTY./	0000		"
SIZE	CASE	SPEC.	PRODUCT #	PART #
Gouge Sharpening Stone – India (Alumin	um Oxide)			
6 x 2 x 1 x 1/2 x 3/8	5	Fine	FS76	614636 87305
Jointer Stones				
4 x 3/4 x 3/8 – Crystolon (Silicon Carbide)	5	Medium	JE74	614636 87335
Machine Knife Stone - Crystolon (Silicon	Carbide)			
4" Diam. x 1-1/2" Thick	5	Coarse/Fine	JB74	614636 87570
Reamer Stones - India (Aluminum Oxide)				
4-1/2 x 1 x 5/16	10	Medium	MT124	614636 87420
	10	Fine	FT124	614636 87415
5 x 1 x 3/16	10	Medium	MT125	614636 87430
	10	Fine	FT125	614636 87425
6 x 1 x 1/4	10	Medium	MT126	614636 87440
	10	Fine	FT126	614636 87435
Boat Stone - Crystolon (Silicon Carbide)				
9 x 2-1/2 x 1-1/2	10	37C80-HV		614636 10369
Boat Stone – India (Aluminum Oxide)				
9 x 2-1/2 x 1-1/2	10	38A60-IVBE		614636 10503

Boat and Reamer Stones are bulk packed. All these other Specialty Stones are packed in individual boxes within a case.



Large Specialty Stones

Tradesmen's Utility Stones

Used for sharpening trimming knives and as an abrasive file in many different industries. The JT910 does not have a handle, while the JT920 and JT930 have wooden handles.

Sickle and Scythe Stones

These silicon carbide stones quickly produce a fast-cutting edge on sickles, scythes, and brush hooks. These stones are most frequently chosen where the speed of sharpening is the primary consideration.

	TIE	R: BETTER	
QTY./			
CASE	SPEC.	PRODUCT #	PART #
Silicon Car	bide)		
10	Medium	JT910	614636 87665
10	Coarse/Fine	JT930	614636 87675
10	Medium	JT920	614636 87670
10	Coarse	TJ3	614636 87731
10	Coarse	TD1	614636 87715
10	Coarse	JD2	614636 87750
	CASE Silicon Car 10 10 10 10 10	CASE SPEC. Silicon Carbide) 10 10 Medium 10 Coarse/Fine 10 Medium 10 Coarse 10 Coarse 10 Coarse	CASESPEC.PRODUCT #Silicon Carbide)10MediumJT91010Coarse/FineJT9301010MediumJT92010CoarseTJ310CoarseTD1

Utility File

A long wedge-shaped stone with four flat sides designed for sharpening coarse cutting edges on cutting implements and edged garden tools. Wooden handles make them easy to use. They will outlast and out-sharpen metal files.





Retail Packaged Sharpening Products

Our retail-packaged line brings Norton quality to your distributor showroom, vending machine, tool crib, and your tool box. Each stone is specifically designed for a popular sharpening application and packaged to sell or carry to the job site.



SIZE (L x W x H)SPEC.QTY./ CASEPART #Axe and Hatchet Sharpener $3 \times 5/8$ roundCoarse/Fine Crystolon (Silicon Carbide)1007660785316Pocket Knife Sharpener $3 \times 7/8 \times 3/8$ Fine Crystolon (Silicon Carbide)507660787600 $3 \times 7/8 \times 3/8$ with caseMedium India (Aluminum Oxide)507660787937 $3 \times 1-1/2 \times 1/2$ with caseCoarse/Fine India (Aluminum Oxide)507660787630Economy Tool & Knife Benchstone6Coarse/Fine Crystolon (Silicon Carbide)507660787933 $6 \times 2 \times 3/4$ Coarse/Fine India569210426152 $8 \times 2 \times 3/4$ Coarse/Fine India (Aluminum Oxide)1061463685755Chisel & Planer Blade Sharpener8Coarse/Fine India (Aluminum Oxide)1007660787936Household Knife & Tool Sharpener7-1/2Fine Crystolon (Silicon Carbide)507660787936Household Knife & Tool Sharpener7-1/2Fine Crystolon (Silicon Carbide)507660787939Farm Tool Sharpener99-1/2 x 1-3/8 x 1/2Medium Crystolon (Silicon Carbide)1007660787938Sharpening Stone Oil4-1/2 oz.Oil507660787938Arappening Steel1/2 x 10Round file with rubber handle866253240433Vitrified Dressing Stick			TIFR	BETTER	
SiZE (L x W x H)SPEC.CASEPART #Axe and Hatchet SharpenerCoarse/Fine Crystolon (Silicon Carbide)1007660785316Pocket Knife Sharpener3 x 7/8 x 3/8Fine Crystolon (Silicon Carbide)5076607876003 x 7/8 x 3/8 with caseMedium India (Aluminum Oxide)5076607879373 x 1-1/2 x 1/2 with caseCoarse/Fine India (Aluminum Oxide)507660787630Economy Tool & Knife Benchstone6 $2 x 3/4$ Coarse/Fine Crystolon (Silicon Carbide)507660787933 $6 x 2 x 3/4$ Coarse/Fine India569210426152 $2 x 3/4$ Coarse/Fine India569210426633Coarse/Fine IndiaCoarse/Fine India (Aluminum Oxide)1061463685755 $2 x 3/4$ Coarse/Fine India (Aluminum Oxide)1007660787936Household Knife & Tool Sharpener $3 x 2 x 3/4$ Coarse /Fine India (Aluminum Oxide)1007660787936Household Knife & Tool Sharpener $7 - 1/2$ Fine Crystolon (Silicon Carbide)507660787939Farm Tool Sharpener $3 - 7/2 x 1 - 3/8 x 1/2$ Medium Crystolon (Silicon Carbide)1007660787939Farm Tool Sharpener $3 - 7/2 x 1 - 3/8 x 1/2$ Medium Crystolon (Silicon Carbide)1007660787938Sharpening Stone Oil $4 - 1/2 o c$ Oil507660787938Sharpening Stene Oil $4 - 1/2 o c$ Oil507660787938Sharpening Steel $1 - 1/4 x 3/4$ Coarse Crystolon (Silicon Carbide)1007660787938Sharpening Steel $1 - 2 x 1 - 3/8 x $					
3 x 5/8 roundCoarse/Fine Crystolon (Silicon Carbide)1007660785316Pocket Knife Sharpener3 x 7/8 x 3/8Fine Crystolon (Silicon Carbide)5076607876003 x 7/8 x 3/8 with caseMedium India (Aluminum Oxide)5076607879373 x 1-1/2 x 1/2 with caseCoarse/Fine India (Aluminum Oxide)507660787630Economy Tool & Knife Benchstone $6 x 2 x 3/4$ Coarse/Fine Crystolon (Silicon Carbide)507660787933 $6 x 2 x 3/4$ Coarse/Fine India569210426152 $8 x 2 x 3/4$ Coarse/Fine India (Aluminum Oxide)1069210426633Coarse/Fine IndiaCoarse/Fine India (Aluminum Oxide)1061463685755Chisel & Planer Blade Sharpener $8 x 2 x 3/4$ Coarse/Fine India (Aluminum Oxide)1007660787936Household Knife & Tool Sharpener $7-1/2$ Fine Crystolon (Silicon Carbide)507660787939Farm Tool Sharpener9-1/2 x 1-3/8 x 1/2Medium Crystolon (Silicon Carbide)1007660787938Sharpening Stone Oil4-1/2 oz.Oil07600787938Sharpening Steel1/2 x 1-3/8 x 1/2Medium Crystolon (Silicon Carbide)1007660787938Sharpening Steel1/2 x 1-3/8 x 1/2Medium Crystolon (Silicon Carbide)1007660787938Sharpening Steel1/2 x 1-3/8 x 1/2Medium Crystolon (Silicon Carbide)	SIZE (L x W x H)	SPEC.		PART #	
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$\begin{array}{c c c c c c c } 3 \times 7/8 \times 3/8 & Fine Crystolon (Silicon Carbide) & 5 & 07660787600 \\ 3 \times 7/8 \times 3/8 & with case & Medium India (Aluminum Oxide) & 5 & 07660787937 \\ 3 \times 1-1/2 \times 1/2 & with case & Coarse/Fine India (Aluminum Oxide) & 5 & 07660787630 \\ \hline \hline \\ \hline $	3 x 5/8 round	Coarse/Fine Crystolon (Silicon Carbide)	10	076607 85316	
$\begin{array}{c c c c c c c } 3 \times 7/8 \times 3/8 \mbox{ with case } & Medium India (Aluminum Oxide) & 5 & 07660787937 \\ \hline 3 \times 1-1/2 \times 1/2 \mbox{ with case } & Coarse/Fine India (Aluminum Oxide) & 5 & 07660787630 \\ \hline Economy Tool & Knife Benchstone & & & & \\ \hline Coarse/Fine Crystolon (Silicon Carbide) & 5 & 07660787933 \\ \hline Coarse/Fine India & 5 & 69210426152 \\ \hline 8 \times 2 \times 3/4 & Coarse/Fine India (Aluminum Oxide) & 10 & 69210426633 \\ \hline Coarse/Fine India (Aluminum Oxide) & 10 & 69210426633 \\ \hline Coarse/Fine India (Aluminum Oxide) & 10 & 07660787936 \\ \hline Chisel & Planer Blade Sharpener & & & \\ \hline 8 \times 2 \times 3/4 & Coarse/Fine India (Aluminum Oxide) & 10 & 07660787936 \\ \hline Household Knife & Tool Sharpener & & & \\ \hline 7-1/2 & Fine Crystolon (Silicon Carbide) & 5 & 07660787939 \\ \hline Farm Tool Sharpener & & & \\ \hline 10 \times 1-1/4 \times 3/4 & Coarse Crystolon (Silicon Carbide) & 10 & 07660787730 \\ \hline Lawn & & Garden Tool Sharpener & & \\ \hline 9-1/2 \times 1-3/8 \times 1/2 & Medium Crystolon (Silicon Carbide) & 10 & 07660787938 \\ \hline Sharpening Stone Oil & & & \\ \hline 4-1/2 \ Oxin & & \\ \hline 1/2 \times 10 & Round file with rubber handle & 8 & 66253240433 \\ \hline Vitrified Dressing Stick & & \\ \hline \end{array}$	Pocket Knife Sharpener				
$\begin{array}{c c c c c c } 3 \times 1-1/2 \times 1/2 \mbox{ with case } & Coarse/Fine India (Aluminum Oxide) & 5 & 07660787630 \\ \hline Economy Tool & Knife Benchstone & & & & \\ \hline Coarse/Fine Crystolon (Silicon Carbide) & 5 & 07660787933 \\ \hline Coarse/Fine India & 5 & 69210426152 \\ \hline 8 \times 2 \times 3/4 & Coarse/Fine India (Aluminum Oxide) & 10 & 69210426633 \\ \hline Coarse/Fine India (Aluminum Oxide) & 10 & 61463685755 \\ \hline Chisel & Planer Blade Sharpener & & & \\ \hline Coarse/Fine India (Aluminum Oxide) & 10 & 07660787936 \\ \hline Household Knife & Tool Sharpener & & & \\ \hline 7-1/2 & Fine Crystolon (Silicon Carbide) & 5 & 07660787939 \\ \hline Farm Tool Sharpener & & & \\ \hline 10 \times 1-1/4 \times 3/4 & Coarse Crystolon (Silicon Carbide) & 10 & 07660787730 \\ \hline Lawa & Garden Tool Sharpener & & & \\ \hline 9-1/2 \times 1-3/8 \times 1/2 & Medium Crystolon (Silicon Carbide) & 10 & 07660787938 \\ \hline Sharpening Stone Oil & & & \\ \hline 4-1/2 \ Oxil & Oxid & 5 & 07660787940 \\ \hline Sharpening Steel & & & \\ \hline 1/2 \times 10 & Round file with rubber handle & 8 & 66253240433 \\ \hline Vitrified Dressing Stick & & \\ \hline \end{array}$	3 x 7/8 x 3/8		5	076607 87600	
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Chisel & Planer Blade Sharpener 8 x 2 x 3/4 Coarse/Fine India (Aluminum Oxide) 10 07660787936 Household Knife & Tool Sharpener 7-1/2 Fine Crystolon (Silicon Carbide) 5 07660787939 Farm Tool Sharpener 10 x 1-1/4 x 3/4 Coarse Crystolon (Silicon Carbide) 10 07660787730 Lawn & Garden Tool Sharpener 9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 Sharpening Stone Oil 4-1/2 oz. Oil 5 07660787940 Sharpening Steel 10 10 07660787940 10 Yat 10 Round file with rubber handle 8 66253240433 Vitrified Dressing Stick Vitrified Dressing Stick Vitrified Dressing Stick	8 x 2 x 3/4		10		
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Farm Tool Sharpener 10 x 1-1/4 x 3/4 Coarse Crystolon (Silicon Carbide) 10 07660787730 Lawn & Garden Tool Sharpener 9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 Sharpening Stone Oil 4-1/2 oz. Oil 5 07660787940 Sharpening Steel 1/2 x 10 Round file with rubber handle 8 66253240433 Vitrified Dressing Stick	Household Knife & Tool	Sharpener			
10 x 1-1/4 x 3/4 Coarse Crystolon (Silicon Carbide) 10 07660787730 Lawn & Garden Tool Sharpener 9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 Sharpening Stone Oil 10 07660787940 10 4-1/2 oz. 0il 5 07660787940 Sharpening Steel 10 10 10 1/2 x 10 Round file with rubber handle 8 66253240433 Vitrified Dressing Stick Vitrified Dressing Stick Vitrified Dressing Stick	7-1/2	Fine Crystolon (Silicon Carbide)	5	076607 87939	
Lawn & Garden Tool Sharpener Vertical Sharpening 9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 Sharpening Stone Oil 4-1/2 oz. 0il 5 07660787940 Sharpening Steel 1/2 x 10 Round file with rubber handle 8 66253240433 Vitrified Dressing Stick Vertical Steel Vertified Dressing Stick Vertified Dressing Stick	Farm Tool Sharpener				
9-1/2 x 1-3/8 x 1/2 Medium Crystolon (Silicon Carbide) 10 07660787938 Sharpening Stone Oil	10 x 1-1/4 x 3/4	Coarse Crystolon (Silicon Carbide)	10	076607 87730	
Sharpening Stone Oil 5 07660787940 4-1/2 oz. Oil 5 07660787940 Sharpening Steel	Lawn & Garden Tool Sha	rpener			
4-1/2 oz. 0il 5 07660787940 Sharpening Steel	9-1/2 x 1-3/8 x 1/2	Medium Crystolon (Silicon Carbide)	10	076607 87938	
Sharpening Steel Image: Starpening Steel <th image:="" starpening="" ste<="" td=""><td></td><td></td><td></td><td></td></th>	<td></td> <td></td> <td></td> <td></td>				
1/2 x 10 Round file with rubber handle 8 66253240433 Vitrified Dressing Stick	4-1/2 oz.	Oil	5	076607 87940	
Vitrified Dressing Stick	Sharpening Steel				
	1/2 x 10	Round file with rubber handle	8	662532 40433	
1 x 1 x 6 Medium Silicon Carbide 5 076607 10466	Vitrified Dressing Stick				
	1 x 1 x 6	Medium Silicon Carbide	5	076607 10466	



Knife and Scissor Sharpener

The knife and scissor mechanical sharpener is a quick and portable tool for hundreds of sharpening applications.

SPECIFICATION	QTY./ Case	PART #
Knife and Scissor Sharpener		
Carbide. Case contains 4 each of red, green, and yellow.	12	07660787520



Non-Slip Silicon Sharpening Stone Mat

This thin and flexible 8" x 14" mat is large enough to handle all conventionally-sized sharpening stones. A textured surface keeps the mat firmly in place during use. Ideal for use with stones sold without a non-skid base. It can also be used in conjunction with stone holders to keep them extra secure.

Can be rolled or folded for compact storage. Easily cleaned with soap and water.

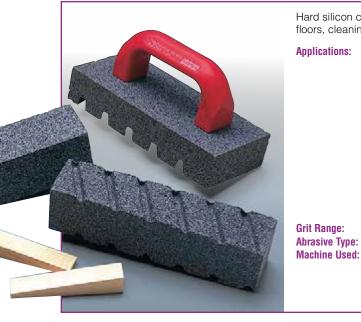
SPECIFICATION	QTY./ Case	PART #
Non-Slip Silicon Sharpening Stone Mat		
8 x 14	25	690786 48467

Norton Professional Sharpening Products and Dressing Sticks

See the "Norton Professional Sharpening Products and Dressing Sticks Catalog #200" on nortonabrasives.com to view the complete list and descriptions of our many sharpening products.



PRECISION OFFHAND/PORTABLE **Rubbing Bricks**



Hard silicon carbide rubbing bricks are used for heavy-duty applications such as rubbing floors, cleaning and scouring castings, rubbing down concrete, and removing mold marks.

Applications:

Floor Rubbing Bricks – are used to rub down concrete and remove mold marks. These are designed to fit the chucks of common concrete floor grinding equipment. Reusable wooden wedges anchor the bricks to the equipment chucks.

Plain Hand Rubbing Bricks – are the choice of mechanics and foundry workers for dressing grinding wheels and cleaning or scouring castings.

Fluted Hand Rubbing Bricks - are used by masons and stone workers for rubbing down concrete and removing mold marks. The diagonal flutes provide sharp edges, a clean shearing action, and carry away debris.

Fluted Hand Rubbing Bricks with Handle – make quick work of removing mold marks and rubbing down concrete. The firmly attached handle reduces fatigue and facilitates overhead, wall, and floor work.

Griddle Bricks - quickly clean away carbon build-up and other residue on your grill without leaving fibers, which grill brushes often do.

6-120 Silicon Carbide



ELECTRIC FLOOR STRIPPER













QTY./ CASE	SPEC.	ABRASIVE	PART #
ng Bricks with	Wooden Wed	iges	
6	C6-R	Silicon Carbide	614636 53292
6	C10-R	Silicon Carbide	614636 53293
6	C24-R	Silicon Carbide	614636 53294
6	C80-R	Silicon Carbide	614636 53295
		6 C6-R 6 C10-R 6 C24-R	Bricks with Wooden Wedges 6 C6-R Silicon Carbide 6 C10-R Silicon Carbide 6 C24-R Silicon Carbide

SIZE (L x W x H)	QTY./ CASE	PART #
Wooden Wedges		
	6	614636 85297

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PRODUCT #	PART #
Plain Hand Rubbin	ng Bricks				
8 x 2 x 2	5	C24	Silicon Carbide	BP28	614636 87830

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PRODUCT #	PART #
Fluted Hand Ru	ubbing Bricks				
6 x 2 x 2	5	C20	Silicon Carbide	BF26	614636 87840
8 x 2 x 2	5	C20	Silicon Carbide	BF28	614636 87845

SIZE (L x W x H)	QTY./ CA	SE SPEC.	ABRASIVE	PRODUCT #	PART #
Fluted Hand Rubb	ing Bricks	with Handle			
6 x 3 x 1	5	C20	Silicon Carbide	BFH6	614636 87800
8 x 3-1/2 x 1-1/2	5	C20	Silicon Carbide	235	614636 87795

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PART #
Griddle Brick				
4-1/2 x 3 x 2	5	Medium	Alundum	614636 87870



Precision Grinding Wheels

improve your **PROCESS, PRODUCTIVITY, AND COST POSITION**

You know the industry-leading performance of our engineered abrasives. Norton R&D has now created new formulations of these abrasives with our exclusive, proprietary Norton Vitrium³ (VS3) bond. You won't get better productivity from any other grinding wheels and segments.

- Cooler cutting with better chip clearance; improved coolant flow; significantly reduced burn
- · Reduced wheel loading
- Improved part quality
- Improved precision profile; ultra-radius accuracy
- Extended wheel life
- Reduced dressing frequency and cost
- Improved cycle and process time
- Able to run at higher operating speed; increased throughput and productivity
- Leverage existing equipment; optimize machine efficiency



iGrind App

Created by Norton engineers and updated based on feedback from you, the Norton iGrind app features calculators and conversion tools designed to help optimize your grinding processes.

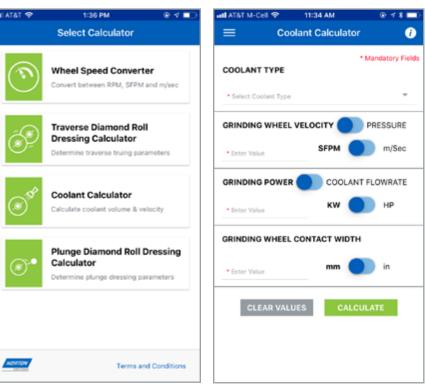
With Norton iGrind, you can calculate the starting parameters for traverse or plunge truing your grinding wheel, determine the ideal setup for delivering coolant to the grinding zone, and convert wheel speeds between RPM, SFPM (Surface Feet Per Minute), and M/Sec to ensure a safe grinding operation.

nortonabrasives.com/en-us/igrind

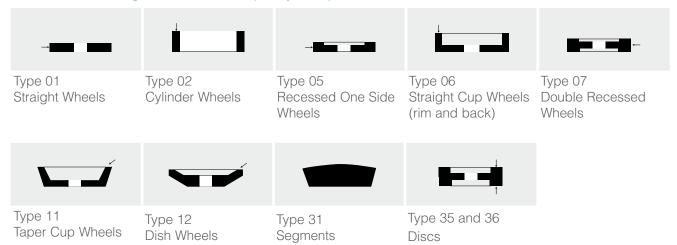
App Features:

- · Wheel Speed Convertor
- Traverse Diamond Roll Dressing Calculator
- Coolant Calculator
- Plunge Diamond Roll Dressing Calculator
- Stationary Tool Dressing Calculator





Standard Grinding Wheel and Periphery Shapes



PRECISION GRINDING WHEELS Bonded Abrasives Basics



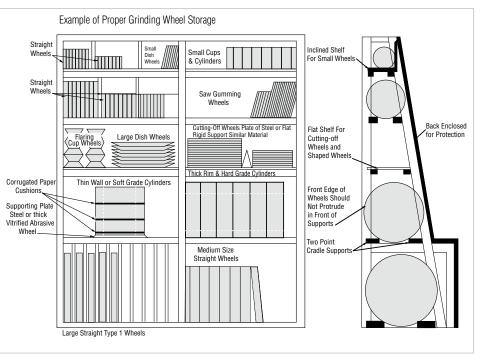
How to Read an Abrasive Product Specification

Shelf Life and Proper Storage of Grinding Wheels

It has always been Saint-Gobain Abrasives recommendation that resinoid bonded grinding wheels be used within 2 years from the date of manufacture. This recommendation assumes that resinoid bonded grinding wheels have been stored under ideal storage conditions. It might be true that under ideal storage conditions resinoid bonded grinding

wheels can survive without any degradation in strength for well over two years. However, it is always wise to suspect any wheels over two years old and have them reinspected or re-speed tested to determine if there has been any degradation in strength. If the wheels are stored under less than ideal conditions, they might have a much shorter shelf life depending upon the severity of storage conditions. These same comments also apply to rubber and shellac bonded grinding wheels.

As for vitrified grinding wheels, the shelf life is less influenced by humidity and adverse storage conditions as compared to resinoid, rubber or shellac, but even vitrified grinding wheels do not have an infinite shelf life. The best procedure and the best rule of thumb is to have any wheel that is two years old or older re-speed tested and reinspected to ensure it is fit for use. The procedure for having this done and the charges will be explained by our Customer Service Department, but the cost of shipping as well as the cost of re-inspection is the customer's responsibility. Also, any wheels rejected or otherwise lost in the re-inspection process will also be the responsibility of the customer.



Keep in mind, however, that this procedure is good to verify the reliability of a product but must not be performed until you are ready to consume the wheel. If wheels are sent back after the two year time frame for re-inspection and re-testing and then put back on the shelf, there is no telling how long they will be fit for use after that last inspection. Therefore, these wheels must be consumed as soon as is practical.



The Norton bench and pedestal wheel line consists of numerous wheel diameters and arbor sizes, abrasive types and grit sizes. Our offering answers all metal removal, deburring, shaping and sharpening needs: white aluminum oxide for high-speed tool steels, brown aluminum oxide for carbon steel, and silicon carbide for non-ferrous metals and carbide tooling.

Offhand deburring and sharpening of parts and tools

Applications: Size Range: Grit Range: **Abrasive Types: Bushings**: Machine Used:

Premium Ceramic Alumina, Aluminum Oxide, Silicon Carbide Telescopic arbor bushings to fit all popular grinders are packaged with the wheel BENCH

5" - 18"

24 - 150

GRINDER



GRINDER

Application/Grit Recommendation Guide

COARSER (GRINDING)

FINER (FINISHING)

24	36	46	60	80	100	150
Heavy Stock Removal						
	Medium Stock Removal					
		Light Stock Removal				
			Deburring/Shaping			
				Sharpening		
					Final Finishing	

ECH TIP

- Unsecured machines can move, causing grinding breakage and injury. Fixed-based bench and pedestal grinders MUST be secured.
- Do not grind wood, plastic, or any other non-metallic material on a bench or pedestal grinder.
- · All bench and pedestal wheels must be dressed to prevent loading. Loading can cause excessive heat, damage to the workpiece, and wheel breakage. Dressing exposes new cutting edges and provides chip clearance.
- Recommended starting dressing stick: 1" x 1" x 6" 37C24-SVK Part # 61463610462

It is the user's responsibility to refer to and comply with ANSI B7.1

Bench and Pedestal Wheel Arbor Bushings

WHEEL DIAMETER	WHEEL Center Hole	1/2"	5/8"	3/4"	7/8"		1-1/4"
5", 6", 7" 8"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•

These size bushings shipped free of charge with your wheel order.













PREMIUM CERAMIC ALUMINA 3SG

- Type 01 straight wheel with ceramic alumina grain has fast cut, minimal burn, and long wheel life
- · High performance bond for versatility and exceptional form holding
- · Especially great for hollow grinding of plane blades and chisels; telescoping bushings to fit popular arbor hole sizes

Better choice for light metal removal and sharpening of high-speed tool steels (55 Rc and higher)

PREMIUM WHITE ALUMINUM OXIDE

- Type 01 straight wheel with premium white aluminum oxide for maximum cut rate and cool grinding action on hardened or high-speed tool steels
- · Vitrified bonded for superb shape holding and resistance to wear
- Better choice for deburring and tool sharpening on bench and pedestal grinders; telescoping bushings to fit popular arbor hole sizes

Better choice for light to medium stock removal

57A ALUMINUM OXIDE

- Type 01 straight wheel, the better choice for the end-user that needs a specific grit size and hardness for engineered applications
- · Vitrified bond for superb shape holding and resistance to wear
- · Excellent choice for deburring and tool sharpening on bench and pedestal grinders

Better choice for medium grit and grade for light to medium stock removal on carbide tooling and non-ferrous materials

39C SILICON CARBIDE

- Type 01 straight wheel with sharp, green silicon carbide; use for performance applications on carbide tooling and non-ferrous materials
- · Vitrified bond for superb shape holding and resistance to wear
- · Excellent choice for deburring and tool sharpening on bench and pedestal grinders

Good choice for all general-purpose bench and pedestal applications

GEMINI ALUMINUM OXIDE

- Type 01 straight wheel with quality, aluminum oxide for general purpose bench and pedestal grinder applications on steel
- · Vitrified bond for superb shape holding and resistance to wear
- Good choice for deburring and tool sharpening on bench and pedestal grinders; telescoping bushings to fit popular arbor hole sizes



GEMINI SILICON CARBIDE

- Type 01 straight wheel with sharp, green silicon carbide for general-purpose applications on carbide tooling and non-ferrous materials
- · Vitrified bond for superb shape holding and resistance to wear
- · Available in many sizes and coarse to fine grits; for sharpening to fine shaping applications





		TIER:	BEST		BETTER	-	BETTER	7
		TRADENAME:		RAMIC ALUMINA	PREMIUM ALUN		57A	
		ABRASIVE:	3SG Ceramic A		White Aluminum		Brown Aluminum	Ovide
	MAX.	MIN./STD.	Jou ociamic A	lumma	White Aluminari	UNIUG	Drown Aluminum	OXIUC
SIZE (D x T x H)	RPM	PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
6 x 3/4 x 1	4,140*	1/5	3SG-46K	076607 05411	Medium 60	076607 88246		
	4,140*	1/5	3SG-60I	076607 04684	Fine 100	076607 88247		
	4,140*	1/5	3SG-80K	076607 05412	Very Fine 150	07660788248		
	4,140*	1/5	3SG-100I	076607 04682				
6 x 1 x 1	4,140*	1/5	3SG-46K	07660705413	Medium 60	07660788261		
	4,140*	1/5	3SG-80K	076607 05414	Fine 100	07660788262		
	4,140	1/5			Very Fine 150	07660788263		
Bx1x1	3,600	1/5			Medium 60	076607 88281		
	3,600	1/5	3SG-46K	076607 05421	Fine 100	076607 88282		
	3,600	1/5	3SG-60I	076607 04659	Very Fine 150	076607 88283		
	3,600	1/5	3SG-80K	076607 05422				
	3,600	1/5	3SG-100I	076607 04657				
10 x 1 x 1-1/4	2,485	1/5					57A46-MVBE	662531 16274
	2,485	1/5					57A60-MVBE	662531 16273
12 x 1 x 1-1/4	2,070	1/5					57A46-MVBE	662532 20947
12 x 2 x 1-1/2	2,070	1/4					57A36-0VBE	662532 20952
	2,070	1/4					57A46-MVBE	662532 20953
14 x 2 x 1-1/2	1,800	1/3					57A24-QVBE	662533 19972
	1,800	1/3					57A36-0VBE	662533 19973
	1,800	1/3					57A46-MVBE	662533 19974
4 x 2-1/2 x 1-1/2	1,800	1/2					57A24-QVBE	662533 19976
	1,800	1/2					57A46-MVBE	662533 19975
14 x 3 x 1-1/2	1,800	1/2					57A36-0VBE	662533 19977
18 x 3 x 1-1/2	1,275	1/2					57A24-QVBE	662534 62610

* Max. RPM for Premium Ceramic Alumina Wheels is 5,410

Bench and Pedestal Wheel Arbor Bushings

WHEEL Diameter	WHEEL Center Hole	1/2"	5/8"	3/4"	7/8"		1-1/4"
5", 6", 7"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•

These size bushings shipped free of charge with your wheel order.







39C (GREEN) / 37C (GRAY) Silicon Carbide



GEMINI SILICON CARBIDE Green Silicon Carbide

	Al	BRASIVE:	Brown Aluminum	Oxide		Silicon Carbide			Green Silicon Car	bide
	MAX.	MIN./ Std.			MIN., Std.			MIN./ Std.		
SIZE (D x T x H)	RPM	PKG.	SPEC	PART #	PKG.	SPEC	PART #	PKG.	SPEC	PART #
5 x 1/2 x 1	4,965	1/5	Medium 60/80	076607 88202						
	4,965	1/5	Fine 100/120	07660788201						
i x 3/4 x 1	4,965	1/5	Medium 60/80	07660788210						
	4,965	1/5	Fine 100/120	07660788205						
5x1x1	4,965	1/5	Medium 60/80	07660788225						
5 x 1/2 x 1	4,140	1/5	Coarse 36/46	662528 36132				1/5	Medium 60	662528 36571
	4,140	1/5	Medium 60/80	66252836131				1/5	Fine 80	662528 36572
	4,140	1/5	Fine 100/120	66252836133				1/5	Extra Fine 120	662528 36573
x 3/4 x 1	4,140	1/5	Coarse 36/46	07660788245				1/5	Medium 60	662528 37190
	4,140	1/5	Medium 60/80	07660788240				1/5	Fine 80	662528 37191
	4,140	1/5	Fine 100/120	07660788235				1/5	Extra Fine 120	662528 37192
6x1x1	4,140	1/5	Coarse 36/46	076607 88260				1/5	Medium 60	662528 37187
	4,140	1/5	Medium 60/80	07660788255				1/5	Fine 80	662528 37193
	4,140	1/5	Fine 100/120	07660788250				1/5	Extra Fine 120	662528 37194
′x1x1	3,600	1/5	Coarse 36/46	076607 88275				1/5	Medium 60	662529 42300
	3,600	1/5	Medium 60/80	076607 88270				1/5	Fine 80	662529 42301
	3,600	1/5	Fine 100/120	07660788265				1/5	Extra Fine 120	662529 42302
x 3/4 x 1	3,600	1/5	Coarse 36/46	07660788278				170	Extra 1 mo 120	
	3,600	1/5	Medium 60/80	076607 88277						
	3.600	1/5	Fine 100/120	662530 42317						
3 x 1 x 1	3,600	1/5	Very Coarse 24	662530 44454				1/5	Medium 60	662530 44087
	3,600	1/5	Coarse 36/46	076607 88286				1/5	Fine 80	662530 44534
	3,600	1/5	Medium 60/80	076607 88285				1/5	Extra Fine 120	662530 44535
	3,600	1/5	Fine 100/120	076607 88280				170	Extra 1 mo 120	00200011000
0 x 1 x 1-1/4	2,485	1/2	Very Coarse 24	662531 60788				1/2	Medium 60	662531 44536
0 / 1 / 1 / 1	2,485	1/2	Coarse 36/46	07660788295				1/2	Fine 80	662531 60366
	2,485	1/2	Medium 60/80	07660788290				1/2	1 110 00	00200100000
	2,485	1/2	Fine 100/120	662531 60350						
0 x 1-1/4 x 1-1/4	2,485	1/2	Coarse 36/46	662531 61250						
5	2,485	1/2	Medium 60/80	662531 61251						
0 x 1-1/2 x 1-1/4	2,485	1/2	Coarse 36/46	662531 61393	1/5	39C60-IVMT	662531 16265			
	2,485	1/2	Medium 60/80	662531 61395	., 0		302001.0200			
2 x 1-1/2 x 1-1/2	2,070	1/2	Coarse 36/46	662532 63052						
	2,070	1/2	Medium 60/80	66253263053						
2 x 2 x 1-1/4	2,070	.,_						1/2	Medium 60	662532 63359
	2,070							1/2	Fine 80	66253263360
2 x 2 x 1-1/2	2,070	1/2	Very Coarse 24	662532 63054				1/ -		30200200000
	2,070	1/2	Coarse 36/46	66253263055						
	2,070	1/2	Medium 60/80	66253263056	1/4	39C60-KVMT	662532 20942			
4 x 2 x 1-1/2	1,800	1/2			1/3	37C24-RVK	662533 19967			
	1,800				1/3	39C60-JVMT	66253319968			
	1,000				1/0	0000000000	00200013300			

Bench and Pedestal Wheel Arbor Bushings

WHEEL	WHEEL						
DIAMETER	CENTER HOLE	1/2"	5/8"	3/4"	7/8"		1-1/4"
5", 6", 7"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•
These size h.	ahing ahing all for	a af abau					

These size bushings shipped free of charge with your wheel order.



PRECISION GRINDING WHEELS Sawgumming Wheels



Keep circular saws, band saws and other cutting tools razor sharp when you use the NorZon NZ ZA Type 01 sawgumming wheel. Featuring a resin bond to provide a smooth performance and deliver exceptional strength, this hardy wheel is specially designed for use in timber industries and for woodworking and saw manufacturing applications. Ideal for frequent use, the wheel has a zirconia alumina abrasive that ensures sharp cuts while it enhances the wheel's durability.

Applications: Size Range: Abrasive Grain: Shape: Machine Used: Tool Sharpening 12" Zirconia Alumina Type 01 Straight





Best choice for saw sharpening in the timber, woodworking, and saw manufacturing industries

NORZON NZ ZIRCONIA ALUMINA

- Durable, sharp zirconia alumina abrasive delivering the highest performance under frequent use conditions
- Strong, yet smooth-running resin bond
- Designed to excel at shaping and resharpening various types of saws including large circular and band saw blades used primarily for timber harvesting

			TIER:	BEST
			TRADENAME:	NORZON NZ
			ABRASIVE:	Zirconia Alumina
SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #
Type 01 Straight				
12 x 5/8 x 1-1/4	3,025	5	SG2981	662532 62303
12 x 3/4 x 1-1/4	3,025	5	SG2181	662532 62305
12 x 3/4 x 1-1/4	3,025	5	SG2981	662532 62306 NS
12 x 3/4 x 1-1/4	3,025	5	SG2981	662532 62307
12 x 7/8 x 1-1/4	3,025	5	SG2981	662532 62462
12 x 7/8 x 1-1/4	3,025	5	SG2181	662532 62461 NS
12 x 1 x 1-1/4	3,025	5	SG2981	662532 62487 NS

NS Non-stock, Contact your Norton representative for current order quantities and lead-times.





Used on surface, cylindrical, and tool and cutter grinders, Norton precision, form-holding vitrified toolroom wheels maximize your productivity. Available in latest-generation ceramic alumina, aluminum oxide, and silicon carbide – for every ferrous and non-ferrous MRO, small job shop, and production operation.

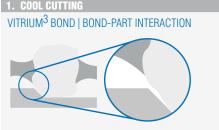
Applications: Shapes:

Size Range: Grit Range: Abrasive Grain: Surface grinding, tool and cutter grinding, and resharpening Type 01 Straight, Type 02 Cylinder, Type 05 and 07 Recessed 1 and 2 Sides, Type 06 and 11 Straight and Flaring Cups, Type 12 Dish, Type 20 Concaved 1 Side, and Type 35 Plate Mounted Disc 3/4" – 18" diameter 46 – 220 Ceramic Alumina, Aluminum Oxide, Silicon Carbide

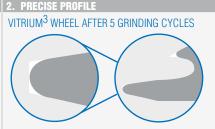
Material-to-Product Recommendation Guide

PERFORMANCE/PRODUCTIVITY **APPLICATION / MATERIAL** Narrow Contact Area Medium Contact Area Wide Contact Area BETTER BETTER BETTER GOOI **Tool Resharpening** Heavy Stock Removal (> .004) HSS & Tool Steel RC 50-68 5SG46-KVS 32A46-JVBE 38A46-JVBE 5SG46-GVSP 32A46-GVBEP 38A46-GVBEP 3SGR46-GVP2 48A46-GVP2 38A46-GVP2 Moderate Stock Removal (.002-.004) HSS & Tool Steel RC 50-68 5SG60-KVS 32A60-KVBE 38A60-KVBE 5SG60-JVS 32A60-JVBE 38A60-JVBE 5SG60-GVSP 32A60-GVBEP 38A60-GVBEP 3SGR60-GVP2 48A60-GVP2 Carbide 39C60-JVMT 39C60-JVMT Surface Grinding Heavy Stock Removal (> .004) HSS & Tool Steel RC 50-68 5NQ46-JVS 32A46-JVBE 38A46-JVBE 5SG46-IVS 32A46-IVBE 38A46-IVBE 5SG46-GVSP 32A46-GVBEP 38A46-GVBEP 400 Series Stainless 3SGR46-GVP2 48A46-GVP2 38A46-GVP2 Soft Steels RC 30-45 5SG46-KVS 32A46-KVBE 38A46-KVBE 5SG46-JVS 32A46-JVBE 38A46-JVBE 5SG46-HVSP 32A46-HVBEP 38A46-HVBEP 300 Series Stainless 3SGR46-HVP2 48A46-HVP2 38A46-HVP2 Cast Iron: Ductile & Gray 5SG46-KVS 32A46-KVBE 38A46-KVBE 5SG46-JVS 32A46-JVBE 38A46-JVBE 5SG46-HVSP 32A46-HVBEP 38A46-HVBEP 3SGR46-GVP2 48A46-HVP2 38A46-HVP2 Non-ferrous Alloys 39C46-JVMT 39C46-IVMT Moderate Stock Removal (.002-.004) HSS & Tool Steel RC 50-68 5NQ60-JVS 32A60-JVBE 38A60-JVBE 5SG60-IVS 32A60-IVBE 38A60-IVBE 5SG60-GVSP 32A60-GVBEP 38A60-GVBEP 400 Series Stainless 3SGR60-GVP2 48A60-GVP2 Soft Steels RC 30-45 5SG60-KVS 32A60-KVBE 38A60-KVBE 5SG60-JVS 32A60-JVBE 38A60-JVBE 3SGR60-HVP2 32A60-HVBEP 38A60-HVBEP 38A60-HVP2 300 Series Stainless 48A60-HVP2 Cast Iron: Ductile & Gray 5SG60-KVS 32A60-KVBE 38A60-KVBE 5SG60-JVS 32A60-JVBE 38A60-JVBE 3SGR60-HVP2 32A60-HVBEP 38A60-HVBEP 48A60-HVP2 38A60-HVP2 Non-ferrous Alloys 39C60-JVMT 39C60-IVMT Light Stock Removal and Finishing (<.001) HSS & Tool Steel RC 50-68 32A80-IVBE 38A80-IVBE 38A80-HVBE 32A80-JVBE 38A80-JVBE 32A80-HVBE 400 Series Stainless Soft Steels RC 30-45 32A80-KVBF 38A80-KVBE 32A80-JVBF 38A80-JVBE 32A80-IVBE 38A80-IVBF 300 Series Stainless 32A80-KVBE 38A80-KVBE 32A80-IVBE 38A80-IVBE Cast Iron: Ductile & Gray 32A80-JVBE 38A80-JVBE Nonferrous Alloys 39C80-JVMT 39C80-IVMT 39C80-HVMT

Upgrade to Vitrium³ to improve your process and productivity in 3 ways Vitrium³ bond (VS3) wheels for enhanced-performance are available with these abrasives: NQN, NQ, SG, 32A, and 48A



Improved holding power (using less bond-to-abrasive ratio) exposes a larger grain surface area, improving freer cut rate.



Superior grain-holding properties significantly improve wheel form and corner holding vs. other bond systems – reducing dressing time and dresser wear.



High Speed – Norton Vitrium³ bond provides the ultimate wheel strength. This allows for high speed operation on equipment designed and rated for high speed.



Vitrified Wheel Bonds

Bond Description

VS3	Quantum (white) and Norton SG (white): Patented technology produces a strong, exceptionally cool-cutting bond with unprecedented form holding; able to run at higher operating speed; increased throughput and productivity; versatile, for all areas of contact
VS3P	Quantum (white) Norton SG (white): Porous bond; use where heat is an issue; patented technology produces a strong, exceptionally cool- cutting bond with unprecedented form holding; versatile, for all areas of contact
VS	Quantum (white) and Norton SG (blue): High stock removal; narrow/medium contact area; roughing/finishing; cool cutting
VSP	Quantum (white) and Norton SG (blue): Porous bond; use where heat is an issue; high stock removal; medium/wide contact area; cool cutting; high chip clearance
VBE	32A (purple), 38A (white) and 57A (brown): General purpose; narrow/medium contact area; versatile; economical.
VBEP	32A (purple) and 38A (white): Porous bond; use where heat is an issue; medium/wide contact area; cool cutting; high chip clearance; high stock removal
V	38A (orange): For fine grit, form/corner holding applications; narrow contact area
VK	37C (black) and 39C (green): Designed specifically for silicon carbide abrasives; medium to narrow area of contact ; for non-steel applications
VMT	Bond specifically formulated for use with silicon carbide abrasives
VCP	32A (purple) and 23A (blue/grey): Induced-pore, wide contact area, surface/creepfeed grinding applications
VP2	3SGR (ruby), 48A (ruby), 25A (pink) and 38A (white): Unique, controlled-porosity (NORPOR) bond for heat-sensitive applications

TECH TIP

SELECTNG A WHEEL WITH THE CORRECT BOND TYPE

- Use VBE, V, VS, VS3, VK, and VMT bonds for general purpose applications or medium contact areas.
- Use VBEP, VSP, VS3P, VCP, and VP2 bonds on wide contact areas where heat is an issue.



It is the user's responsibility to refer to and comply with ANSI B7.1

Application/Grit Recommendation Guide

Grit	Requirement	Finish	Minimum Corner Radius
46	General Purpose	32 Ra and rougher	0.020"
60	Commercial Finish	32 Ra and better	0.016"
80 - 100	Fine Finish	20 Ra and better	0.0105"
120	Very Fine Finish	10 Ra and better	0.006"
150	Corner-Form Holding		0.005"
180	Corner-Form Holding		0.0035"
220	Corner-Form Holding		0.0026"

Cross Reference Guide

NORTON	CAMEL	CINCINNATI	RADIAC	TYROLIT	WINTERTHUR
Quantum 5NQ	_	5M5B	—	_	—
3SGR	AS3	3BP	7BP, 8BP	_	—
5SG	SZA	5MSB	7BW, 8BW	_	—
25A	PA	12A	RAA	88A	57A
32A	AZ	4A, 12A, 29A, 32A	32A, WRA	90A	67A, 68A
38A	83A, WA, AZ (Blue)	9A, 10A, 11A, 82A	WA, 9A	88A, 89A	53A, 49A, 42A
48A	_	_	RA	91A	68A
53A	91A, DA	29A, 97A	43A, 45A, 97A, WPA	50A	61A, 64A
57A	94A, CGW, A	A, AK	A	A, 52A	A
37C	_	6C	С	10	С
39C	—	5C	GC	С	11C



Take Advantage of VMT Technology!

VMT bond technology, along with advanced silicon carbide grain, offers wheels which excel in grinding a wide range of non-ferrous and hard-to-grind materials

Features & Benefits

- Improved form holding
- Higher wheel life
- Reduced power draw
- Shorter grind cycles
- Increased productivity



Starting Recommendations for Truing and Dressing Norton Toolroom Wheels

TRUING & DRESSING: DRESSING STICK STARTING RECOMMENDATIONS

Size/ Spec.	High Performance Stick Part #	Size/ Spec.	Conventional Stick Part #
3 x 1/2 x 1/4" Norbide	614636 10148	6 x 1 x 1" 37C24-SVK	614636 10462
		8 x 1 x 1" 37C24-SVK	614636 10471
		Other sizes are available. See	the Dressing Stick section.

DRESSING: SINGLE POINT DRESSING TOOL STARTING RECOMMENDATIONS

		Ceramic (NQ, Norto 37C & 39C Wheels		25A, 32A, 38A, 48A, 53A, 57A, 64A, 86A Wheels		
Wheel Sizes	Tool Shank Diameter	Product No.	Part #	Product No.	Part #	
Up to 7"	3/8	BCSG2M6	662601 57007	BC2M6	662601 95000	
	7/16	BCSG2M7	662601 56905	BC2M7	662601 95001	
8" to 10"	3/8	BCSG3M6	662601 57008	BC3M6	662601 95002	
	7/16	BCSG3M7	662601 56906	BC3M7	662601 95003	
12" to 14"	3/8	BCSG5M6	662601 57009	BC5M6	662601 95004	
	7/16	BCSG5M7	662601 56907	BC5M7	662601 95005	

These tools are a standard recommendation; see the "Diamond Tool" section for additional tools

See the Fliesen Tool section for Furioso tools, engineered specifically for Quantum vitrified wheel dressing

<u>TECH TIP</u>

Wheel Dressing

Single Point Diamond Tools

- Rigidly mount Single Point tools at a 10°-15° angle to the wheel centerline with a line drawn through the center of the wheel, pointing in the direction of wheel travel
- Point of contact should be slightly below centerline of wheel
- Use coolant whenever possible
- Normal infeed is .001" per pass
- Lead selections range from .002" .010" per wheel revolution
- Rotate the tool 1/4 turn periodically to maintain a sharp point
- Use VBE, V, VS, VK bonds for general purpose applications or medium contact areas.
- Use VBEP, VSP, VS3P, VCP, VP2 bonds on wide contact areas where heat is an issue.

Multi-Point Diamond Tools

- Most multi-point tools are used for straight face dressing
- · Tool should have full face contact with the wheel
- With new tool, 3 to 5 passes at .005" per pass should be taken to expose diamonds
- Infeed per pass .001" .002"
- Use coolant whenever possible
- Use appropriate lead (and traverse rate)

Contact your Norton representative for proper tool selection for Targa (TG) wheels



It is the user's responsibility to refer to and comply with ANSI B7.1

Dressing Ceramic Wheels

- Use our specially designed Norton SG diamond tools when dressing ceramic wheels
- When first using a Norton SG tool, make 3 to 5 passes at .005" infeed to ensure full face contact between the dressing tool and wheel face
- Reduce normal dressing infeed by half. Do not exceed infeed of .002" per pass.
- The lead selection should be between .006" .030" per wheel revolution. Faster traverse with Norton SG tools generally provides an open wheel face that can maximize productivity of the ceramic abrasive.
- To optimize applications using ceramic abrasives and/ or tools, normal dressing parameters must change.
 Reduce infeed by 25%. Significant reductions in the amount of infeed and frequency of dress will result in substantially lower cost per part ground.
- See the Fliesen Tool section for Furioso tools, engineered specifically for Quantum vitrified wheel dressing.



Troubleshooting Guide

- Check the obvious first. Before changing the grinding wheel specification, investigate the following most common causes for most grinding problems:
- 1. Diamond dressing tool condition (check if worn or dull, rotate tool or replace if necessary)
- 2. Coolant direction, volume and filtration
- 3. Wheel dressing procedures (dress more open to free up cut rate, dress more closed to improve finish)

PROBLEM	POSSIBLE CAUSE	CORRECTION			
Workpiece burn	Poor coolant direction	Redirect coolant into grinding zone			
	Restricted or low coolant volume	Increase coolant volume			
	Wheel too hard	Use one grade softer wheel			
	Wheel structure too closed	Use porous bond wheel			
	Wheel dressed too fine	Dress wheel coarser, more "open"			
	Worn dressing tool	Inspect, rotate or replace dressing tool			
	Work speed too slow	Increase work speed			
	Infeed too fast	Reduce stock removed per pass or upgrade to 5SG or 5NQ			
Wheel loading and glazing	Wheel too fine	Use coarser grit or softer grade wheel			
	Wheel too hard	Use one grade softer wheel			
	Too durable abrasive	Use a sharper, more friable abrasive			
	Poor coolant quality	Change coolant or use high detergent type			
	Wheel structure too closed	Use a porous bond wheel			
	Wheel too finely dressed	Dress wheel very open			
	Diamond dressing tool worn	Replace diamond and dress coarse (open)			
	Depth of cut too small	Increase feed and traverse speed			
natter	Unsupported work	Increase work support			
	Machine vibration	Check for worn bearings			
	Too heavy cut rate	Reduce cut rate			
	Wheel too hard	Use one grade softer wheel			
	Wheel structure too closed	Use a porous bond wheel			
	Wheel out of balance	Check wheel balance or try new wheel			
Chatter marks on workpiece	Worn spindle bearings	Check and correct for truth and end play			
	Wheel out of truth	Redress wheel and check mounting			
	Poorly clamped wheel	Check tightness of mounting nuts			
	Glazed face of wheel	Redress wheel with sharp dressing tool			
Poor surface finish	Incorrect wheel dress	Dress wheel finer (slow down dressing tool traverse)			
	Worn dressing tool	Inspect, rotate, or replace dressing tool			
	Too coarse grit size	Use a finer grit size			
	Wheel too hard	Use softer grade			
Not holding form	Wheel too soft	Use one grade harder wheel			
	Wheel structure too open	Use a more closed wheel structure			
lot holding corner	Incorrect wheel dress	Dress wheel finer. Face and side true wheel.			
	Too large grit size	Use smaller grit size (maximum grit diameter less than 1.5 times			
		corner radius)			
	Wheel too soft	Use harder grade wheel			
	Wheel structure too open	Use more closed structure wheel			





Best choice for versatility, maximum performance and cost savings

QUANTUM (5NQ) CERAMIC ALUMINA

- Revolutionary, proprietary, engineered ceramic grain shape and chemistry for all low-, medium- and high-force
 applications ranging from cast iron, to stainless steel, and hard-to-grind Inconel and titanium
- Proven tough vitrified bond stands up to extreme grinding forces; perform well on old and new CNC cutting tool, cylindrical and surface grinding machines
- 33% to 100% longer life, 30% higher MRR (material removal rate), and 15% lower threshold power versus competitive ceramic products

Best choice for high productivity, low total per-part grinding cost

SG CERAMIC ALUMINA

- Exceptionally high-performance ceramic alumina and friable aluminum oxide abrasive blend for fast stock removal, cool, superior cutting; 3 - 5 times more life than aluminum oxide wheels; double rough stock removal rate versus conventional abrasives
- High performance bond for versatility (for grinding high speed tool steels, hardened and soft steels, and aerospace alloys) and exceptional form holding
- Self-sharpening abrasive minimizes burn and dressing to maximize sharp edge on tools and dies for longer life in production

Better choice for medium-to-heavy stock removal

32A ALUMINUM OXIDE

- Strong, sharp monocrystalline aluminum oxide grain, ideal for precision production medium-to-heavy stock removal applications
- The most versatile vitrified bond, especially recommended for CNC cutting tool machines, and cylindrical and surface grinding
- · Grinds with an exceptional cool, fast cutting action, requires minimum dressing

Good choice for light grinding of tool steel

38A ALUMINUM OXIDE

- Friable aluminum oxide abrasive for cool and burn-free cutting toolroom applications with light-to-moderate feed rates
- The most versatile vitrified bond, especially recommended for CNC cutting tool machines, and cylindrical and surface grinding applications on hard and very heat-sensitive high-speed tool steels; cool fast cutting
- · Consistent quality for excellent balance and dimensional accuracy time after time



GEMINI ALUMINUM OXIDE

- · Specially blended aluminum oxide abrasive for many surface and cylindrical grinding applications
- · Durable vitrified bond for high stock removal on narrow to medium contact areas
- · Good general-purpose choice when a broad range of parts are ground on one machine





Vitrified Wheels For Steel Applications

		TIED.	BEST	C	BETTER			GOOD	8
		TRADENAME:	QUANTUM / NOI		32A		_	38A	
			Ceramic Alumina		Aluminum Oxide			Aluminum Oxide	
		M MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
ype 01 Straig									
x 1/2 x 3/8	16,235	10/50			32A60-KVBE	662434 28214			
x 1/4 x 1/2	10,825	10/50			32A60-KVBE	662435 28696	10/50	00400 11/055	000 10500000
x 1/2 x 3/8	10,825	10/50			32A60-KVBE	662435 28825	10/50	38A60-JVBE	662435 29032
x 1/2 x 1/2 x 1 x 1/2	10,825 10,825	10/50			32A60-KVBE	662435 28828	10/10	38A60-MVBE	662435 29145
X I X I/Z	10,825						10/10	38A80-MVBE	662435 29146
x 1/4 x 1/2	8,120	1/10			32A60-KVBE	662435 29532	1/10	38A60-KVBE	662435 29777
X 1/ 1 X 1/ E	8,120	1710			OLNOO TAVDE		1/10	38A100-IVBE	662435 29782
x 1/4 x 3/4	8,120	1/10			32A60-KVBE	662435 29736	1,10	00/1100 1102	00210020102
x 1/2 x 1/2	8,120	.,					1/10	38A60-KVBE	662435 29947
	8,120						1/10	38A100-KVBE	662435 29954
x 1/2 x 3/4	8,120	1/10			32A60-KVBE	662435 29849	1/10	38A60-KVBE	662435 29961
	8,120	1/10			32A80-KVBE	662435 29850			
x 1 x 1/2	8,120						1/10	38A60-MVBE	662435 30126
x 1/8 x 1-1/4	4,140	1/10			32A80-KVBE	662528 35361	1/10	38A150-LVBE	662528 35506
x 1/4 x 1/2	4,140	1/10			32A60-KVBE	662528 35784		00100 10/05	
x 1/4 x 1-1/4	4,140	1/10			32A60-KVBE	662528 35786	1/10	38A60-KVBE	662528 35803
	4,140						1/10	38A80-KVBE	662528 35807
x 1/2 x 1/2	4,140	1/10			32A60-KVBE	662528 36394	1/10 1/10	38A150-KV 38A60-KVBE	662528 35759 662528 36530
X 1/2 X 1/2	4,140	1/10			SZAUU-RVDE	00202030394	1/10	38A80-KVBE	662528 36548
x 1/2 x 1-1/4	4,140	1/10			32A46-KVBE	662528 36380	1/10	38A46-KVBE	662528 36520
X 1/2 X 1 1/ 1	4,140	1/10	5SG60-KVS	662528 03344	32A60-KVBE	662528 36396 B	1/10	38A60-KVBE	662528 36533
	4,140	1/10		00202000011	32A80-JVBE	662528 36405	1/10	38A80-KVBE	662528 36550
	4,140	.,					1/10	38A120-KVBE	662528 36664
x 3/4 x 1/2	4,140	1/10			32A60-KVBE	662528 37420			
x 3/4 x 5/8	4,140						1/10	38A60-KVBE	662528 37444
x 3/4 x 1-1/4	4,140	1/10			32A60-KVBE	662528 37421	1/10	38A60-KVBE	662528 37445
x 1 x 1-1/4	4,140	1/10			32A60-KVBE	662528 37921 B			
x 1/8 x 1-1/4	3,275	1/10			32A60-IVBE	662529 39112	1/10	38A80-IVBE	662529 39219
	3,600	1/10			001.40.111/DE	00050000000000	1/10	38A100-KVBE	662529 39223
x 1/4 x 1-1/4	3,600	1/10		00040405053	32A46-HVBE	662529 39543	1/10	38A46-HVBE	662529 39690
	3,600	1/10	5NQ46-IVS3	662434 95257	32A46-IVBE	662529 39544	1/10	38A46-IVBE	662529 39691 662529 09755
	3,600	1/10 1/10	5NQ60-JVS3	662532 93579	32A46-JVBE 32A46-KVBE	662529 39545 662529 39862	1/10 1/10	38A46-JVBE 38A60-HVBE	662529 09755
	3,600	1/10	5SG46-IVS	662529 40207 B	32A60-HVBE	662529 39547	1/10	38A60-IVBE	662529 39696
	3,600	1/10	33040-173	00232340207 0	32A60-IVBE	662529 39548 B	1/10	38A60-JVBE	662529 39698
	3,600	1/10	5SG60-IVS	662529 39459 B	32A60-IVBE	662532 88569 S	1/10	38A60-KVBE	662529 39700
	3,600	1/10	50000 110		32A60-JVBE	662529 39549 B	1/10	38A80-HVBE	662529 39707
	3,600	1/10			32A60-KVBE	662529 39552 B	1/10	38A80-IVBE	662529 39808
	3,600	1/10	5SG60-JVS	662529 39460	32A60-KVBE	662532 88570 S	1/10	38A80-JVBE	662529 39809
	3,600	1/10	5SG60-KVS	662529 39461 B			1/10	38A80-KVBE	662529 39812
	3,600	1/10			32A80-HVBE	662529 39557	1/10	38A100-IVBE	662529 39823
	3,600	1/10	5SG80-IVS	662529 39462	32A80-IVBE	662529 39658 B			
	3,600	1/10	5SG80-JVS	662529 39463	32A80-IVBE	662532 88571 S	1/10	38A100-JVBE	662529 39826
	3,600	1/10	5SG80-KVS	662529 39464	32A80-JVBE	662529 39660 B	1/10	38A100-KVBE	662529 39827
	3,600	1/10	5SG100-JVS	662529 39467	32A80-KVBE	662529 39662 B	1/10	38A100-LVBE	662529 39830
	3,600	1/10	5SG100-KVS	662529 39468 B	32A80-KVBE	662532 88572 S	1/10	38A120-JVBE	662529 39833
	3,600	1/10			32A100-IVBE	662529 39670 B	1/10	38A120-KVBE	662529 39834
	3,600 3,600	1/10 1/10			32A100-IVBE 32A100-JVBE	662529 39670 B	1/10 1/10	38A150-KVBE 38A150-LVBE	662529 39838 662529 39839
	3,600	1/10			32A100-JVBE	662532 88573 S	1/10	38A150-LVBE	662529 39639
	3,600	1/10			32A100-IVBL	662529 39673 B	1/10	38A220-KV	662529 39521
	3,600	1/10			SEATON INPL		1/10	38A220-LV	662529 39529
	3,600	1/10			32A120-IVBE	662529 39680	1/10	38A220-LVBE	662529 39847
	3,600	1/10			32A120-KVBE	662529 39682	1/10	38A220-MV	662529 39530
	3,600	1/10			32A220-LVBE	662529 39689			
x 3/8 x 1-1/4	3,600	1/10			32A60-KVBE	662529 40276	1/10	38A60-KVBE	662529 40294
	3,600	1/10			32A80-KVBE	662529 40284	1/10	38A80-IVBE	662529 40297



Vitrified Wheels For Steel Applications continued

		TIER:	BEST BETTER					GOOD		
		TRADENAME:	QUANTUM / NO	RTON SG	32A / 48A			38A / 25A / GEN	IINI	
		ABRASIVE:	Ceramic Alumina		Aluminum Oxide		_	Aluminum Oxide		
SIZE (D x T x H)	MAX. RP	M MIN./STD. PKG.		PART #	SPEC.	PART #	MIN./STD. PKG.		PART #	
ype 01 Straig										
	120.00 414			00050075050		00050044000	1/10		00000040040	
′ x 1/2 x 1-1/4	3,600	1/10	5NQ46-HVS3	662533 75053	32A46-FVBEP	662529 41203	1/10 1/10	25A46-HVP2	662529 16219	
	3,600 3,600	1/10 1/10	5NQ46-IVS3	690831 59103	32A46-GVBE 32A46-GVBEP	662529 40862 662529 41204 B	1/10	25A60-HVP2 38A46-GVBE	662529 16221 662529 41022	
	3,600	1/10	5NQ46-JVS3	690831 59104	32A46-HVBE	662529 40863 B	1/10	38A46-GVBEP	662529 41323	
	3,600	1/10	5NQ60-GVS3P	690831 59105	32A46-HVBE	662532 88775 S	1/10	38A46-HVBE	662529 41023	
	3,600	1/10	5NQ60-IVS3	662533 75047	32A46-HVBEP	662529 41205 B	1,10	oortio IIVDE	00202011020	
	3,600	1/10	5NQ60-JVS3	690831 59106	der no nite en	002020	1/10	38A46-HVBEP	662529 41324	
	3,600	1/10			32A46-IVBE	662529 40864 B	1/10	38A46-HVP2	662529 16223	
	3,600	1/10	3SGP46-GVSP	662529 11717	32A46-IVBE	662532 88776 S	1/10	38A46-IVBE	662529 41024	
	3,600	1/10	3SGR46-HVP2	662529 16211	32A46-IVBEP	662529 41206	1/10	38A46-JVBE	662529 41026	
	3,600	1/10	3SGR60-HVP2	662529 16213			1	38A46-JVBE	662532 88767	
	3,600	1/10	5SG46-GVSP	662529 40522	32A46-JVBE	662529 40865 B	1/10	38A46-KVBE	662529 41028	
	3,600	1/10			32A46-JVBE	662532 88777 S	1/10	38A60-HVBE	662529 41035	
	3,600	1/10	5SG46-HVSP	662529 41130			1/10	38A60-HVBEP	662529 41330	
	3,600	1/10	5SG46-IVS	662529 40193 B	32A46-KVBE	662529 40867 B	1/10	38A60-IVBE	662529 41036	
	3,600	1/10	5SG46-IVS	662532 88788 S	00154 1005		1/10	38A60-JVBE	662529 41038	
	3,600	1/10	500 40 IV /0D	000500 40700	32A54-IVBE	662529 40873	1	38A60-JVBE	662532 88766	
	3,600	1/10	5SG46-IVSP	662529 40523	32A60-GVBEP	662529 41313	1/10	38A60-KVBE	662529 41041	
	3,600	1/10	5SG46-JVS	662529 40194 B	32A60-HVBE	662529 40879 B	1 1/10		00000044077	
	3,600	1/10	5SG46-JVS	662532 88789 S	32A60-HVBEP	662529 41314	1/10	38A60-LVBE	66252911677	
	3,600 3,600	1/10 1/10	5SG46-JVS3 5SG46-KVS	662434 95263 662529 40195	32A60-IVBE 32A60-IVBE	662529 40880 B 662532 88779 S	1/10 1/10	38A80-HVBE 38A80-IVBE	662529 41047 662529 41048	
	3,600	1/10	5SG60-GVSP	662529 40524	SZAUU-IVDE	00233200119 3	1/10	38A80-JVBE	662529 41048	
	3,600	1/10	5SG60-IVS	662529 40196 B	32A60-JVBE	662529 40882 B	1/10	38A80-KVBE	662529 41049	
	3,600	1/10	33000-143	00202040130 0	32A60-JVBEP	662529 41316	1	JUAUU-INIDL	00232341034	
	3,600	1/10			02/100 07021	00202041010	1/10	38A80-LVBE	662529 41056	
	3,600	1/10	5SG60-IVSP	662529 40525	32A60-KVBE	662529 40885 B	1/10	38A100-IVBE	662529 41163	
	3,600	1/10	5SG60-JVS	662529 40197 B	32A60-KVBE	662532 88782 S	1/10	38A100-JVBE	662529 41165	
	3,600	1/10			32A60-LVBE	662529 40888	1/10	38A100-KVBE	66252941168	
	3,600	1/10			32A80-HVBE	662529 40894	1/10	38A120-JVBE	66252941174	
	3,600	1/10	5SG60-KVS	662529 40198	32A80-IVBE	662529 40895 B	1/10	38A120-KVBE	662529 41175	
	3,600	1/10	5SG60-LVS	662529 40199	32A80-IVBE	662532 88783 S	1/10	38A150-JVBE	662529 41179	
	3,600	1/10	5SG80-IVS	662529 40200	32A80-JVBE	662529 40897 B	1/10	38A150-MV	662529 40595	
	3,600	1/10	5SG80-IVSP	662529 40527	32A80-KVBE	662529 40899 B	1/10	38A220-QV	662529 40605	
	3,600	1/10	5SG80-JVS	662529 40201 B	32A80-KVBE	662532 88784				
	3,600	1/10			32A80-LVBE	662529 40900	10/10	Gemini 46-I	662532 46800	
	3,600	1/10	5SG80-KVS	662529 40202	32A100-IVBE	662529 40907	10/10	Gemini 46-J	662532 46802	
	3,600	1/10	5SG80-LVS	662529 40203	32A100-JVBE	662529 41008				
	3,600	1/10	5SG100-JVS	662529 40204	32A120-LVBE	662529 41018 B				
	3,600	1/10	5SG100-KVS	662529 40205	32A120-LVBE	662532 88786 S	40/40	0	000500 -005	
	3,600	1/10			48A46-HVP2	662529 16215 B	10/10	Gemini 60-K	662532 46821	
7 5/0 4 4/4	3,600	1/10			48A60-HVP2	662529 16217 B				
7 x 5/8 x 1-1/4 7 x 3/4 x 1-1/4	3,600	1/10	5SG46-IVS	00050040004	32A60-IVBE	662529 41762	1/10		00050044050	
	3,600	1/10		662529 42304	32A46-GVBEP	662529 42070	1/10	38A46-HVBE	662529 41950	
	3,600 3,600	1/10 1/10	5SG46-KVS 5SG60-JVS	662529 42305 662529 42307	32A46-HVBE 32A46-IVBE	662529 41930 662529 41931	1/10 1/10	38A46-KVBE 38A60-IVBE	662529 41954 662529 42207	
	3,600	1/10	5SG60-KVS	662529 42307	32A40-IVBL	662529 41935	1/10	38A60-KVBE	662529 42267	
	3,600	1/10		002020 42JUU	32A40-RVBL	662529 41935	1/10	SUNUU INDL	00202342000	
	3,600	1/10			32A60-KVBE	662529 41943				
	3,600	1/10			32A80-IVBE	662529 41946				
x 1 x 1-1/4	3,600	1/10	5SG60-JVS	662529 42429	32A46-HVBE	662529 42513	1/10	38A46-HVBE	662529 42534	
	3,600	1/10	5SG60-KVS	662529 42430	32A46-JVBE	662529 42268	.,			
	3,600	1/10	-		32A60-IVBE	662529 42524				
	3,600	1/10			32A60-KVBE	662529 42709				

B Best Seller; performs well in a variety of applications for many satisfied customers \$ Single Pack

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.



Vitrified Wheels For Steel Applications continued

				2				R	8
				6	E				
		TIER:	BEST		BETTER			GOOD	
		TRADENAME:		RTON SG	32A / 48A		-	38A / 25A / G	
			Ceramic Alumina		Aluminum Oxide			Aluminum Oxid	
SIZE (D x T x H)		MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straigh	nt 💦 🖉								
8 x 1/4 x 1-1/4	3,105 / 3,600*	1/10	5SG60-KVS	662530 43351 *	32A46-HVBE	662530 43412	1/10	38A60-IVBE	662530 43431 *
	3,105 / 3,600*	1/10	5SG80-KVS	662530 43353 *	32A46-IVBE	662530 43310	1/10	38A60-JVBE	662530 43432 *
	3,600	1/10			32A46-KVBE	662530 43413	1/10	38A60-KVBE	662530 10825
	3,600	1/10			32A60-IVBE	662530 43416 B	1/10	38A80-IVBE	662530 43437
	3,600	1/10			32A60-IVBE	662532 88796 S	1/10	38A80-JVBE	662530 43439
	3,600 3,600	1/10 1/10			32A60-JVBE 32A60-KVBE	662530 43417 662530 43399	1/10 1/10	38A80-KVBE 38A100-IVBE	662530 43461 662530 43445
	3,600	1/10			32A00-RVBE	662530 43399	1/10	38A100-IVBE	662530 43445
	3,600	1/10			32A80-KVBE	662530 43458 B	1/10	38A120-KVBE	662530 43447
	3,600	1/10			32A00-KVBE	662532 88797 S	1/10	38A120-KVBE	662530 43450
	3,600	1/10			32A80-LVBE	662530 43425	1/10	OUNTOU INVEL	002000-10-101
	3,600	1/10			32A100-IVBE	662530 43426			
	3,600	1/10			32A100-KVBE	662530 43428			
8 x 3/8 x 1-1/4	3,600	1/10			32A60-KVBE	662530 43565			
8 x 1/2 x 1-1/4	3,105 / 3,600*	1/10	5NQ46-HVS3	662533 87211	32A46-GVBEP	662530 43882 B	1/10	25A46-HVP2	662530 19354 *
	3,105	1/10	5NQ46-IVS3	690831 59107	32A46-HVBE	662530 43712 B	1/10	38A46-HVBE	662530 43746
	3,105	1/10			32A46-HVBE	662532 88800 S			
	3,105 / 3,600*	1/10	5NQ46-JVS3	690831 59108 *	32A46-HVBEP	662530 43883 *† B	1/10	38A46-HVBEP	662530 43891 †
	3,105	1/10					1/10	38A46-IVBE	662530 43749
	3,105 / 3,600*	1/10	5NQ60-GVS3P	690831 59109			1/10	38A46-JVBE	662530 43752 *
	3,105 / 3,600*	1/10			32A46-IVBE	662530 43713 B	1/10	38A46-KVBE	662530 43762 *
	3,600	1/10	5NQ60-JVS3	690831 59110			1/10	38A60-HVBE	662530 43756
	3,600	1/10			32A46-JVBE	662530 43715 B	1/10	38A60-IVBE	662530 43757
	3,105 / 3,600*	1/10	3SGP46-HVSP	662530 11505	32A46-JVBE	662532 88801 * S	1/10	38A60-JVBE	662530 43858 *
	3,600	1/10	3SGP46-JVH	662530 13796	001401005	000500407400	1/10	38A60-KVBE	662530 43861
	3,600	1/10	3SGR46-GVP2	662530 19345	32A46-KVBE	662530 43716 B	1/10	38A80-IVBE	662530 43866
	3,600 3,600	1/10 1/10	3SGR46-HVP2 3SGR60-HVP2	662530 19346 662530 19348	32A60-GVBEP	662530 43887 †	1/10 1/10	38A80-JVBE 38A80-KVBE	662530 13787 662530 43869
	3,105 / 3,600*	1/10	5SG46-GVSP	662530 43649	32A60-GVBEF	662530 43724 *	1/10	38A100-KVBE	662530 43809
	3,600	1/10	33040-0731	00203043043	32A60-HVBEP	662530 43888	10/10	Gemini 46-H	662532 46841 *
	3,105 / 3,600*	1/10	5SG46-HVSP	66253043915*†		662530 43725 * B	10/10	Gemini 46-1	662532 46843
	3,105 / 3,600*	1/10	5SG46-IVS	662530 44089 B	32A60-IVBE	662532 88802 * S	10/10	Gemini 46-J	662532 46845 *
	3,105 / 3,600*	1/10	5SG46-IVS	662532 88804 S		662530 43727 * B	10,10		002002
	3,105 / 3,600*	1/10	00010110	002002000010	32A60-KVBE	662530 43729 * B			
	3,105 / 3,600*	1/10	5SG46-IVSP	662530 43650	32A60-KVBE	662532 88803 * S			
	3,600	1/10	5SG46-JVS	662530 44090 B	32A80-HVBE	662530 43733			
	3,600	1/10	5SG46-JVS	662532 88806 S	32A80-IVBE	662530 43734			
	3,600	1/10	5SG46-KVS	662530 44091	32A80-JVBE	662530 43736			
	3,600	1/10	5SG60-GVSP	662530 43651 †	32A80-KVBE	662530 43737			
	3,600	1/10	5SG60-IVS	662530 44092	32A100-IVBE	662530 43740			
	3,600	1/10			32A100-KVBE	662530 43742			
	3,600	1/10	5SG60-IVSP	662530 43652	48A46-HVP2	662530 19350 B			
	3,600	1/10	5SG60-JVS	662530 44093 B					
	3,600	1/10	5SG60-KVS	662530 44094					
	3,600	1/10	5SG80-JVS	662530 44096					
	3,600	1/10	5SG80-KVS	662530 44097					
	3,600	1/10	5SG100-KVS s for many satisfied	662530 19435					Continued

S Single Pack

* Indicates wheel max RPM has been tested to 3,600 as explained in the tech tip below

TIP

- * 8" Type 01 and Type 05 Vitrified Toolroom Wheels' Maximum Operating Speeds:
- Stock NorPor VP2 wheels = 3,600 RPMs
- All other 46 grit, J grade and harder = 3,600 RPMs
- All other 54 grit, I grade and harder = 3,600 RPMs
- All other 60 grit and finer, H grade and harder = 3,600 RPMs
- † Exceptions to the rule: speed-tested to 3,600 RPM
- All other specifications = 3,105 RPMs

It is the user's responsibility to refer to and comply with ANSI B7.1



Vitrified Wheels For Steel Applications continued

		TIED.	BEST BETTER					G000		
		TRADENAME:			32A / 48A			38A / 57A		
				IIUN 30			_			
		ABRASIVE:	Ceramic Alumina		Aluminum Oxide			Aluminum Oxide		
SIZE (D x T x H)		MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #	
Type 01 Straigl	ht 🖉									
8 x 3/4 x 1-1/4	3,105	1/10	5NQ46-IVS3	690831 59111	32A46-GVBEP	662530 44195	1/10	38A46-HVBE	662530 44175	
	3,105	1/10			32A46-HVBE	662530 44159	1/10	38A46-IVBE	66253044177	
	3,600	1/10	5NQ46-JVS3	690831 59112	32A46-HVBEP	662530 44196 *†		38A46-KVBE	662530 44180	
	3,105 / 3,600*	1/10		00000100112	32A46-IVBE	662530 44215	1/10	38A60-IVBE	662530 44184 *	
	3,105 / 3,600*	1/10			32A46-JVBE	662530 44161 *	1/10	OUNCO IVEL	00200044104	
	3,105 / 3,600*	1/10	5NQ60-GVS3P	690831 59113	32A46-KVBE	662530 44165 *				
	3,600	1/10	5NQ60-JVS3	690831 59114	32A60-GVBEP	662530 44198				
			21ND0-1A22	09083139114						
	3,600	1/10	500.40 11/0	00050044000	32A60-HVBE	662530 44168				
	3,105 / 3,600*	1/10	5SG46-IVS	662530 44098	32A60-IVBE	662530 44169 *				
	3,600	1/10	3SGP46-JVH	662530 13792	32A60-JVBE	662530 44171				
	3,600	1/10	5SG46-JVS	662530 44099 B	32A60-KVBE	662530 44173				
	3,600	1/10			32A80-KVBE	662530 44064				
	3,600	1/10	5SG60-IVS	662530 44101						
	3,600	1/10	5SG60-JVS	662530 44102						
	3,600	1/10	5SG60-KVS	662530 44103						
3 x 1 x 1-1/4	3,105 / 3,600*	1/10	5SG46-KVS	662530 02588 *	32A46-HVBE	662530 44616	1/10	38A46-IVBE	662530 44636	
, , , , , , , , , , , , , , , , , , ,	3,105 / 3,600*	1/10	5SG60-GVSP	662530 03228 *†	32A46-IVBE	662530 44617	1/10	38A60-IVBE	662530 44456 *	
	3,600	1/10	5SG60-IVS	662530 02639	32A46-KVBE	662530 44622	1/10	57A60-MVBE	662530 44270	
	3,600	1/10	33000-143	0020002000	32A60-IVBE	662530 44624	1/10	JI AUU-IVIVDL	00203044270	
10 1/1 0	3,600	1/10			32A60-KVBE	662530 44629	4	00400 10/05	000504 40530	
10 x 1/4 x 3	2,485						1	38A80-KVBE	662531 49572	
10 x 1/2 x 3	2,485	1			32A60-JVBE	662531 49729	1	38A60-KVBE	662531 49859	
	2,485						1	38A80-KVBE	662531 49865	
10 x 3/4 x 3	2,485	1			32A46-IVBE	662531 60024	1	38A46-JVBE	662531 60158	
	2,485	1			32A60-IVBE	662531 60137	1	38A60-IVBE	662531 60163	
	2,485	1			32A60-KVBE	662531 60143				
10 x 1 x 1-1/4	2,485	1			32A60-KVBE	662531 60774				
10 x 1 x 2	2,485	1			32A46-IVBE	662531 60749				
10 x 1 x 3	2,485	1	5SG46-GVSP	662531 60494	32A46-HVBE	662531 60747	1	38A46-IVBE	662531 60889	
	2,485	1	5SG46-IVS	662531 60400	32A46-IVBE	662531 60750	1	38A46-JVBE	662531 60892	
	2,485	1	5SG46-JVS	662531 60401	32A46-JVBE	662531 60754	1	38A60-IVBE	662531 60898	
	2,485	1	300-0 370	00200100401	32A46-KVBE	662531 60758	1	38A60-KVBE	662531 60900	
		1	ECCAC KUC	00050100400			I	JOAUU-IVDL	00233100900	
	2,485		5SG46-KVS	662531 60402	32A60-IVBE	662531 60769				
	2,485	1	50000 11/0	00050400400	32A60-KVBE	662531 60777				
	2,485	1	5SG60-IVS	662531 60403	32A80-KVBE	662531 60782				
	2,485	1	5SG60-JVS	662531 60404						
	2,485	1	5SG60-KVS	662531 60405						
12 x 1/2 x 3	2,070	2			32A60-JVBE	662532 62134				
	2,070	2			32A80-KVBE	662532 62110				
12 x 1/2 x 5	2,070	2			32A60-KVBE	662532 62107				
	2,070	2			32A80-KVBE	662532 62111				
12 x 3/4 x 3	2,070	1	5SG46-IVS	662532 62204	32A46-GVBEP	662532 62392	1	38A46-JVBE	662532 62281	
2 / 0/ 1 / 0	2,070	1	00010110	SOLOOLULLUT	32A46-HVBE	662532 62260	•	SOLID OVDE	SOLOOL OLLOI	
	2,070	1			32A46-IVBE	662532 62261				
	2,070	1			32A40-IVBE 32A60-IVBE	662532 62270				
	2 11/11	1			JZAUU-IVDE	002032022/0				
	2,070	1			32A60-KVBE	662532 62273				

B Best Seller; performs well in a variety of applications for many satisfied customers

S Single Wheel Pack

* Indicates wheel max RPM has been tested to 3,600 as explained in the tech tip below

TECH TIP

- * 8" Type 01 and Type 05 Vitrified Toolroom Wheels' Maximum Operating Speeds:
- Stock NorPor VP2 wheels = 3,600 RPMs
- All other 46 grit, J grade and harder = 3,600 RPMs
- All other 54 grit, I grade and harder = 3,600 RPMs
- All other 60 grit and finer, H grade and harder = 3,600 RPMs
- † Exceptions to the rule: speed-tested to 3,600 RPM
- All other specifications = 3,105 RPMs

It is the user's responsibility to refer to and comply with ANSI B7.1



Vitrified Wheels For Steel Applications continued

		TIFR [,]	BEST	C	BETTER			GOOD	6
		TRADENAME:		RTON SG	32A / 48A			38A	
			Ceramic Alumina		Aluminum Oxide		_	Aluminum Oxide	
SIZE (D x T x H)		MIN./STD. PKG.		PART #	SPEC.	PART #	MIN./STD. PKG.		PART #
		_	JFLU.	rani π	JFLU.	ΓANI π	MIN./STD. FKG.	JFEU.	FANT #
Type 01 Straigh	1740608941 1 174060	2010 - 101 - 100 -							
12 x 1 x 3		1	3SGR46-HVP2	662532 20885 *	32A46-GVBEP	662532 62840	1	38A46-HVBE	662532 62700
	2,070	1	5SG46-HVSP	662532 62488	32A46-HVBE	662532 62562	1	38A46-IVBE	662532 62702
	2,070	1	5SG46-IVS	662532 62500	32A46-HVBEP	662532 62842	1	38A46-JVBE	662532 62704
	2,070	1	5SG46-JVS	662532 62501	32A46-IVBE	662532 62564	1	38A60-IVBE	662532 62713
	2,070	1	5SG46-JVS3	662434 95317	32A46-JVBE	662532 62567			
	2,070	1	5SG46-KVS	662532 62502	32A46-KVBE	662532 62572			
	2,070	1			32A60-HVBE	662532 62580			
	2,070	1	5SG60-GVSP	662532 62593	32A60-IVBE	662532 62581			
	2,070	1	5SG60-IVS	662532 62503	32A60-KVBE	662532 62689			
	2,070	1	5SG60-JVS	662532 62504	32A80-KVBE	662532 62532			
	2,070 / 2,710*	1	5SG60-KVS	662532 62505	48A60-HVP2	662532 20891 *			
12 x 1 x 5	2,070	1	5SG46-GVSP	662532 62594	32A46-GVBEP	662532 62841	1	38A46-IVBE	662532 62703
12 X 1 X J	2,070	1	5SG46-IVS	662532 62594	32A46-HVBE	662532 62563	1	38A60-KVBE	662532 62719
				662532 62509 B		662532 62565	I	30A00-NVDE	00203202719
	2,070	1	5SG46-JVS		32A46-IVBE				
	2,070	1	5SG46-KVS	662532 62510	32A46-KVBE	662532 62573			
	2,070	1	5SG60-GVSP	662532 62595	00400 11/05	000500000000			
	2,070	1	5SG60-IVS	662532 62511	32A60-IVBE	662532 62582			
	2,070	1	5SG60-JVS	662532 62512	32A60-JVBE	662532 62686			
	2,070	1	5SG60-KVS	662532 62513	32A60-KVBE	662532 62691 B			
	2,070	1	5SG80-JVS	662532 62515	32A80-JVBE	662532 62696			
	2,070	1			32A80-KVBE	662532 62697			
12 x 1-1/4 x 3	2,070	1			32A46-IVBE	662532 62301			
12 x 1-1/2 x 1-1/4	2,070	1			32A46-KVBE	662532 63146			
12 x 1-1/2 x 3	2,070	1	5SG46-IVS	662532 02820	32A46-HVBE	662532 63143			
-	2,070	1			32A46-IVBE	662532 63144			
	2,070	1			32A60-JVBE	662532 63123			
12 x 1-1/2 x 5	2,070	1	5NQ46-IVS3	690831 59115	32A46-GVBEP	662532 63192	1	38A46-IVBE	662532 14987
	2,070	1			32A46-HVBE	662532 63128	•	OUTTO TYPE	00200211001
	2,070	1	5NQ46-JVS3	690831 59116	32A46-IVBE	662532 63145			
	2,070	1	0110-0100	0000100110	32A46-JVBE	662532 63120			
	2,070	1	5NQ60-GVS3P	690831 59117	32A60-HVBE	662532 63149			
	2,070	1							
			5NQ60-JVS3	690831 59118	32A60-KVBE	662532 63034			
	2,070	1	3SGP60-GVSP	662532 15030					
	2,070	1	5SG46-GVSP	662532 03453					
	2,070	1	5SG46-IVS	662532 02842					
	2,070	1	5SG46-JVS	662532 02926					
	2,070	1	5SG60-GVSP	662532 62596					
12 x 2 x 1-1/4	2,070	1			32A46-KVBE	662532 63461			
	2,070	1			32A46-MVBE	662532 63463			
2 x 2 x 3	2,070	1			32A46-IVBE	662532 63459			
2 x 2 x 5	2,070	1			32A46-HVBE	662532 63403			
	2,070	1			32A46-IVBE	662532 62302			
	2,070	1			32A60-KVBE	662532 63465			
I4 x 1/2 x 5	1,800	1	5SG80-KVS	662533 63814	32A60-KVBE	662533 63761			
14 x 3/4 x 5	1,800	1	20000 100	5020000011	32A60-KVBE	662533 63772			
14 x 1 x 3	1,800	1	5SG46-IVS	662533 63960	SENIOU INIDE	002000 00112			
	1,800	1	00070 100	0020000000000	32A46-IVBE	662533 63914			
	1,000	1			JZM4U-IVDE	00200000014			

* 12" Type 01 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,710; all others = 2,070 B Best Seller; performs well in a variety of applications for many satisfied customers

To maximize the performance of these wheels and finished part quality, refer to the beginning of this section and the "Dressing Solutions" section for truing and dressing products.

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.



Vitrified Wheels For Steel Applications continued

		TIFR	BEST	C	BETTER			G00D	5
		TRADENAME:		RTON SG	32A			38A / 57A	
		ABRASIVE:			Aluminum Oxide			Aluminum Oxide	}
SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straig	ht 💽								
14 x 1/2 x 5	1,800	1	5SG80-KVS	662533 63814	32A60-KVBE	662533 63761			
14 x 3/4 x 5	1,800	1	35000 100	002000014	32A60-KVBE	662533 63772			
14 x 1 x 3	1,800	1	5SG46-IVS	662533 63960	32A46-IVBE	66253363914			
	1,800	1		0020000000	32A60-IVBE	662533 63927			
14 x 1 x 5	1,800	1	5SG46-GVSP	662533 64108	32A46-GVBEP	662533 64074	1	38A46-HVBE	662533 64043
	1,800	1	5SG46-HVSP	662533 13990	32A46-HVBE	662533 63913	1	38A60-IVBE	662533 63947
	1,800	1	5SG46-IVS	662533 63970	32A46-IVBE	662533 63915	1	38A60-JVBE	662533 64051
	1,800	1	5SG46-JVS	662533 63971	32A46-JVBE	662533 63919	1	38A60-KVBE	662533 64053
	1,800	1			32A46-KVBE	662533 63921	1	38A80-KVBE	662533 64058
	1,800	1	5SG60-IVS	662533 63974	32A60-GVBEP	662533 64077	1	57A60-KVBE	662533 64065
	1,800	1	5SG60-IVSP	662533 63871	32A60-HVBE	662533 63926	1	57A60-LVBE	662533 64066
	1,800	1	5SG60-JVS	662533 63975	32A60-JVBE	662533 63930	1	57A80-MVBE	662533 64070
	1,800	1	5SG60-KVS	662533 63976	32A60-KVBE	662533 63932			
	1,800	1	5SG80-JVS	662533 63979	32A60-LVBE	662533 64035			
	1,800	1	5SG80-KVS	662533 64003	32A80-JVBE	662533 64038			
	1,800	1			32A80-KVBE	662533 64039			
14 x 1 x 8	1,800	1			32A60-IVBE	662533 63887			
14 x 1-1/2 x 5	1,800	1	5NQ46-HVS3	662533 87216	32A46-GVBEP	662533 64238	1	38A46-HVBE	662533 13968
	1,800	1			32A46-HVBE	662533 64335 B	1	38A46-HVBEP	662533 13969
	1,800	1	5NQ46-IVS3	690831 59119	32A46-HVBEP	662533 64243	1	38A46-IVBE	662533 64090
	1,800	1	5NQ46-JVS3	690831 59120	32A46-IVBE	662533 64336	1	38A46-JVBE	662533 64240
	1,800	1			32A46-JVBE	662533 64337	1	38A60-IVBE	662533 64247
	1,800	1	5N000 01/005	00000450400	32A46-KVBE	662533 64339			
	1,800	1	5NQ60-GVS3P	690831 59122	32A60-HVBE	662533 64340			
	1,800	1	5NQ60-JVS3	690831 59124	32A60-IVBE	662533 64239			
	1,800	1		CC050000700	32A60-JVBE 32A60-KVBE	662533 64341			
	1,800	1	3SGP46-GVSP 3SGP46-HVSP	662533 06780 662533 07025	32A60-KVBE 32A80-JVBE	662533 64342			
	1,800	1	3SGP46-JVH	662533 13976	JZAOU-JVDE	662533 64246			
	1,800	1	5SG46-GVSP	662533 64320					
	1,800	1	5SG46-HVSP	662533 02625					
	1,800	1	5SG46-IVS	662533 64097					
	1,800	1	5SG46-IVSP	662533 02498					
	1,800	1	5SG46-JVS	662533 64098 B					
	1,800	1	5SG60-IVS	662533 64100					
	1,800	1	5SG60-JVS	662533 64101					
	1,800	1	5SG60-KVS	662533 02160					
	1,800	1	5SG80-KVS	662533 63815					
4 x 2 x 5	1,800	1	5SG60-JVS	662533 64414	32A46-IVBE	662533 64323			
	1,800	1	20000 010	50200000000	32A46-JVBE	662533 64508			
	1,800	1			32A46-KVBE	662533 64509			
	1,800	1			32A60-KVBE	662533 64510			

B Best Seller; performs well in a variety of applications for many satisfied customers

Dressing: Single Point Dressing Tool Starting Recommendations

		Ceramic (NQ, Norto	on SG, TG, etc.), 37C & 39C Wheels	l ini	25A ,
WHEEL SIZES	TOOL SHANK DIAMETER	PRODUCT NO.	PART #		PROL
12" to 14"	3/8"	BCSG5M6	662601 57009		BC5N
	7/16"	BCSG5M7	662601 56907	1.5	BC5N
	standard recommendation; see t ool section for Furioso tools, engi				A

25A, 32A, 38A, 48A, 53A	, 57A, 64A, 86A Wheels
PRODUCT NO.	PART #
BC5M6	662601 95004
BC5M7	662601 95005



Vitrified Wheels For Steel Applications continued

Type 02 Cylinder 6 x 1 x 4 Rim 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound	3,600 3,600 2,865 2,295 1,910	TIER: TRADENAME: ABRASIVE: MIN./STD. PKG. 1/10 1/10	Ceramic Alumina		BETTER 32A / 23A / 48J Aluminum Oxide SPEC. 32A46-KVBE 32A60-JVBE		MIN./STD. PKG.	GOOD 38A / 53A / 5 Aluminum Oxico SPEC.	
Type 02 Cylinder 6 x 1 x 4 film 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" Plate A110170 11 x 5 Rim 1" (ME5245) Plate A10170 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 3,600 2,865 2,295 1,910	<i>TRADENAME:</i> <i>ABRASIVE:</i> MIN./STD. PKG. <u>1/10</u> 1/10	QUANTUM / NO Ceramic Alumina	а	32A / 23A / 48/ Aluminum Oxide SPEC. 32A46-KVBE	PART #		38A / 53A / 5 Aluminum Oxic	de
Type 02 Cylinder 6 x 1 x 4 Rim 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 3,600 2,865 2,295 1,910	ABRASIVE: MIN./STD. PKG. 1/10 1/10	Ceramic Alumina	а	Aluminum Oxide SPEC. 32A46-KVBE	PART #		Aluminum Oxic	de
Type 02 Cylinder 6 x 1 x 4 Rim 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 3,600 2,865 2,295 1,910	MIN./STD. PKG. 1/10 1/10			SPEC. 32A46-KVBE	PART #			
Type 02 Cylinder 6 x 1 x 4 Rim 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 3,600 2,865 2,295 1,910	1/10 1/10	JPEU.		32A46-KVBE			. 3FEG.	FARI#
6 x 1 x 4 Rim 1" Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 3,600 2,865 2,295 1,910	1/10				662528 38308			
Rim 1" Plate A47466 Plate A47466 Rim 1-1/4" Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound Tas 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	3,600 2,865 2,295 1,910	1/10				662528 38308			
Plate A47466 8 x 2 x 5-1/2 Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	2,865 2,295 1,910	·			32A60-JVBE		1/10	38A80-HVBE	662528 38314
Rim 1-1/4" Plate A50831 10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	2,295	1				662528 38309			
10 x 2 x 7-1/2 Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	1,910	1					1/8	53A46-KVBE	662530 44942
Rim 1-1/4" (ME62845) Plate A110170 11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	1,910	1			00454 11/0	00050404007		50400 10/0	00050404504
11 x 5 Rim 1" (ME33437) Tape Wound 11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)					32A54-JVG	662531 61687	1	53A60-KVG	662531 61701
11 x 5 Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)		1			32A30-HVBE	662531 61800			
Rim 1" (ME52726) Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	1,740	1			32A36-EVBEP	662531 61780	1	38A46-GVBE	662531 61807
Tape Wound 18 x 5 Rim 1-1/2" (ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	1,910	1			32A36-GVBEP	662531 61808			
(ME15536) Tape Wound 18 x 5 Rim 1-1/2" (ME52719)	1,910	1			32A46-HVBE	662531 61893			
18 x 5 Rim 1-1/2" (ME52719)	1,065	1			32A30-E19VCP	662534 65142			
Includes Strips	1,170	1			23A30-F19VCP	662534 65235			
Type 05 Recessed Or	Read of the local division of the local divi								
Recess 1/S 3/8 x 3/8	43,290	5/40			32A60-KVBE	662434 27582			
Recess 1/S 1/2 x 1/2	32,470	5/40			32A60-KVBE	662434 27769			
Recess 1/S 1/2 x 1/2	32,470	5/40			32A60-KVBE	662434 27773			
Recess 1/S 5/8 x 1/2	25,975	5/40			32A60-KVBE	662434 27799			
Recess 1/S 5/8 x 1/2	25,975	5/40			32A60-KVBE	662434 27938			
Recess 1/S 3/4 x 1/2	21,645	5/40			32A60-KVBE	662434 27937			
Recess 1/S 3/4 x 1/2	16,235	5/40			32A60-KVBE	662434 28329			
Recess 1/S 1 x 3/4	16,235	10/30			32A60-KVBE	662434 28332			
	3,600	1/10	5SG46-IVS	662529 41976	32A46-HVBE	662529 42209	1/10	38A46-IVBE	662529 42222
	3,600	1/10			32A46-IVBE	662529 42211	1/10	38A60-IVBE	662529 42225
	3,600	1/10			32A46-JVBE	662529 42213			
	3,600	1/10			32A60-IVBE	662529 42217			
	3,600	1/10			32A60-JVBE	662529 42218			
	3,600	1/10			32A60-KVBE	662529 42205			
	3,600	1/10		00050040000	32A46-GVBEP	662529 42826			
	3,600	1/10	3SGR46-HVP2	662529 16228	32A46-HVBE	662529 42688			
	3,600	1/10	5SG46-IVS	662529 42318	32A46-HVBEP	662529 42828			
	0,000	1/10	F0040 11/0	000500 40 407	32A46-IVBE	662529 42691			
	3,600	1/10	5SG46-JVS	662529 42427	32A46-KVBE	662529 42708			
-	3,600								
-	3,600 3,600	1/10		66050040404	32A60-IVBE	662529 42699			
_	3,600		5SG60-JVS	662529 42431					

Continued

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.



Vitrified Wheels For Steel Applications continued

		TIER:	BEST	C	BETTER			GOOD	C
		TRADENAME:	QUANTUM / N	ORTON SG	32A / 48A		_	38A / GEMINI	
		ABRASIVE:	Ceramic Alumin	a	Aluminum Oxid	е		Aluminum Oxio	le
SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 05 Recessed	One Side 🛛 🕅								
7 x 1 x 1-1/4	3,600	1/10	5NQ46-IVS3	662533 50691	32A46-HVBE	662529 42689	1/10	38A46-HVBE	662529 42707
Rec 1/S 3 x 1/2	3,600	1/10	5SG46-IVS	662529 01814	32A46-IVBE	662529 42690	1/10	38A46-IVBE	662529 42809
	3,600	1/10	00010110	00202301014	32A60-IVBE	662529 42686	1/10	38A46-KVBE	662529 42793
	3,600	1/10	5SG60-IVS	662529 06907	JZA00-IVDL	00232342000	1/10	38A60-IVBE	662529 42815
	3,600	1/10	33000-143	00202900907			1/10	38A60-JVBE	662529 42816
	3,600						1/10	38A60-KVBE	662529 42817
	3,600						10/10	Gemini 46-J	662532 42817
7 x 1-1/4 x 1-1/4	3,600	1/5			32A46-HVBE	662529 42833	10/10	Gemini 40-J	00233240033
Rec 1/S 2-3/4 x 5/8	3,600	1/5			32A40-ITVBL	662529 42859			
100 1/0 2-0/4 X 0/0	3,600	1/5			32A00-IVBE	662529 42835			
7 x 1-1/2 x 1-1/4	3,600	1/5			32A00-JVBE	662529 42835			
Rec 1/S 2-3/4 x 3/4	,					662529 42843			
	3,600	1/5			32A60-IVBE				
3 x 3/4 x 1-1/4	3,105	1/10			32A46-IVBE	662530 44213			
Rec 1/S 3-1/4 x 1/4	0.000						10/10	Camini 40 I	00050040050
3 x 1 x 1-1/4	3,600						10/10	Gemini 46-J	662532 46850
Rec 1/S 3 x 1/2	0.405	4.40	500 40 IV/0	00050040540		00050044700			
3 x 1 x 1-1/4 Rec 1/S 3-1/4 x 1/2	3,105	1/10	5SG46-IVS	662530 13543	32A46-IVBE	662530 44790			
	3,600	1/10	500 40 IV/0	0005000000	32A46-JVBE	662530 44382			
	3,600	1/10	5SG46-JVS	662530 03301	00400 11/05				
	3,600	1/10			32A60-IVBE	662530 44753			
	3,600	1/10			32A60-KVBE	662530 44810			
IO x 3/4 x 2 Rec Side A 5 x 3/16 Face Bev Side A 75 Deg From 1/8" Flat	2,485	1			32A60-JVBE	662531 60189			
12 x 1-1/2 x 3 Rec 1/S 6 x 1/2	2,070	1			32A46-IVBE	662532 63186			
12 x 1-1/2 x 5	2,070 / 2,710*	1	3SGR46-HVP2	662532 20904 *	32A46-HVBEP	662532 63180	1	38A46-IVBE	662532 63175
Rec 1/S 7-1/2 x 1/2	2,070	1	5SG46-GVSP	662532 63127	32A46-IVBE	662532 63166			
	2,070	1			32A46-JVBE	662532 63169			
	2,070	1	5SG46-IVS	662532 02883	32A46-KVBE	662532 63170			
	2,070	1			32A60-KVBE	662532 63172			
			5SG60-IVSP	662532 63050					
14 x 1-1/2 x 5	1,800 / 2,320*	1			32A46-HVBE	662533 64359			
Rec 1/S 8 x 1/2	1,800 / 2,320*	1	3SGR46-HVP2	662533 19954 *	32A46-IVBE	662533 64300			
	1,800 / 2,320*	1	3SGR60-HVP2	662533 19956 *	32A46-KVBE	662533 64362			
	1,800	1	5SG46-IVS	662533 64102	32A60-JVBE	662533 64364			
	1,800	1	5SG46-IVS3	662434 94106	32A60-KVBE	662533 64365			
	1,800	1	5SG46-JVS	662533 64103					
	1,800	1	5SG60-IVS	662533 64104					
	1,800	1	5SG60-JVS	662533 64105					
4 x 2 x 5	2,320	1	20000 010		48A46-HVP2	662533 19941	1	25A46-HVP2	662533 19945
Rec 1/S 8 x 1/2	2,320	1	3SGR46-HVP2	662533 19937	10,110 1111 2		1	38A46-HVP2	662533 19949
	2,320		300110 11112	50200013301			1	38A60-HVP2	662533 19951
14 x 2 x 5	1,800	1			32A60-KVBE	662533 64390	1	00/100 1101 2	00200010001
	1,000	•							

* 12" Type 05 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,710; all others = 2,070

* 14" Type 05 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,320; all others = 1,800

To maximize the performance of these wheels and finished part quality, refer to the beginning of this section and the "Dressing Solutions" section for truing and dressing products.

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Vitrified Wheels For Steel Applications continued

			BEST		BETTER		I	GOOD	3
			NORTON SG		32A / 48A		_	38A / 25A / 53	
		-	Ceramic Alumin		Aluminum Oxide			Aluminum Oxid	
SIZE (D x T x H)		M MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 06 Straight Cup	l H								
3-1/2 x 1-1/2 x 1/2 Rim 1/2" Back 1/2"	6,550						1/10	38A60-KVBE	662435 29372
100mm x 50mm x 20mm Rim 10mm, Back 13mm	6,550						1/10	38A80-JVBE	662435 30429
4 x 1-1/2 x 1/2 Rim 1/2" Back 1/2"	5,730	1/10			32A60-KVBE	662435 30218			
4 x 1-1/2 x 1-1/4 Rim 1/2" Back 1/2"	5,730						1/10	38A60-KVBE	662435 30221
4 x 2 x 20mm Rim 3/8" Back 1/2"	5,730						1/10	38A80-JVBE	662435 30523
5 x 1-1/2 x 1-1/4	4,585	1/10			32A46-KVBE	662528 30832	1/10	38A46-KVBE	662528 30842
Rim 3/8" Back 3/8"	4,585	1/10			32A60-JVBE	662528 30837	1/10	38A60-KVBE	662528 30846
Face Y (ME19243)	4,585	1/10			32A60-KVBE	662528 30838			
5 x 2 x 5/8 Rim 1/2" Back 1/2"	4,585	1/10			32A60-JVBE	662528 30987			
6 x 1-1/2 x 1/2 Rim 1" Back 1/2"	3,820	1/10			32A46-KVBE	662528 38458			
6 x 2 x 1-1/4	3,820	1/10			32A46-IVBE	662528 38544	1/10	38A60-KVBE	662528 38486
Rim 1/2" Back 1/2"	3,820	1/10			32A60-JVBE	662528 38538			
7 x 2 x 1-1/4 Rim 1/2" Back 1/2"	3,275	1/8			32A46-JVBE	662529 42856			
9-1/2 x 1-1/2 x 1-1/2 Rim 1-1/2" Back 5/8"	2,415						1	53A46-LVBE	662531 49136
10 x 4 x 1-1/2 Rim 1-1/4" Back 1" Tape Wound	2,295						1	38A46-IVBE	662531 61797
12 x 2-1/2 x 7 Rim 1-1/2" Back 7/8"	1,910	1			32A46-LVBE	662532 63614			
Type 07 Recessed Two	Sides								
12 x 2 x 3 Rec 2/S 5-1/2 x 3/8	2,070	1			32A46-IVBE	662532 63588			
12 x 2 x 3	2,070	1			32A46-HVBE	662532 63590			
Rec 2/S 7-1/4 x 1/2	2,070	1			32A40-HVBE	662532 63348			
12 x 2 x 5 Rec 2/S 7-1/4 x 1/2	2,070	1			32A46-IVBE	662532 63594			
12 x 2 x 5	2.070	1	5SG46-JVS	662532 09930	32A46-HVBE	662532 63591	1	38A46-IVBE	662532 63600
Rec 2/S 7-1/2 x 1/2	2,070	1			32A46-HVBEP	662532 63603	•		
	2,070	1			32A46-JVBE	662532 63483			
	2,070	1			32A46-KVBE	662532 63596			
	2,070	1			32A60-IVBE	662532 63597			





Vitrified Wheels For Steel Applications continued

			BEST		BETTER			GOOD	
		TRADENAME:			32A		_	38A	
017E (D + T + 11)	MAY DD	ABRASIVE:			Aluminum Oxide SPEC.	DADT #		Aluminum Oxide SPEC.	
SIZE (D x T x H)		M MIN./STD. PKG.	SPEG.	PART #	SPEG.	PART #	MIN./STD. PKG.	5PEG.	PART #
Type 11 Flaring Cup		2							
3/2-1/4 x 1-1/4 x 3/4 Rim 1/4" Back 3/8" Face Z (ME21560)	7,640 7,640	1/10 1/10			32A60-JVBE 32A60-KVBE	662435 29183 662435 29187	1/10	38A60-JVBE	662435 29197
3-1/2/2-3/4 x 1-1/2 x 1-1/4 Rim 1/4" Back 3/8" Face Z (ME24327)	7,640	1/10			32A60-KVBE	662435 29358			
4/3 x 1-1/2 x 1-1/4	5,730	1/5	5SG46-IVSP	662435 30127	32A46-IVBE	662435 30240	1/10	38A46-KVBE	662435 30378
Rim 1/4" Back 1/2"	5,730	1/5	5SG46-KVS	662435 03342		662435 30246	1/10	38A60-JVBE	662435 30387
Face Z (ME19237)	5,730	1/5			32A60-JVBE	662435 30256	1/10	38A60-KVBE	662435 30390
	5,730	1/5	5SG60-JVS	662435 30415	32A60-KVBE	662435 30361	1/10	38A80-JVBE	662435 30393
	5,730	1/5	50000 11/0	000 (0500 115	00100 10/05	000 (0500000	1/10	38A80-KVBE	662435 30395
	5,730	1/5	5SG60-LVS	662435 30417	32A80-KVBE	662435 30368			
4-1/2/3-3/4 x 2 x 1-1/4 Rim 1/4"	5,730 5,730	1/5 1/5	5SG80-JVS	662435 30419	32A46-KVBE	662528 30539			
Back 1/2"(ME20115)									
5/3-3/4 x 1-3/4 x 1-1/4	4,585	1/5	5SG46-KVS	662528 03291	32A46-JVBE	662528 30858	1/5	38A46-KVBE	662528 30971
Rim 1/4" Back 1/2"	4,585	1/5	5SG60-KVS	662528 30737	32A46-KVBE	662528 30859	1/5	38A60-JVBE	662528 30973
Face Z (ME21563)	4,585	1/5	50000 11/0	000500000000	00100 11/05	0005000000	1/5	38A60-KVBE	662528 30975
	4,585	1/5	5SG60-LVS	662528 30736	32A60-JVBE	662528 30962			
6/4-1/2 x 2 x 1-1/4	4,585 3,820	1/5 1/5			32A60-KVBE 32A46-JVBE	662528 30964 662528 38491	1/5	38A46-KVBE	662528 38495
Rim 3/8" Back 1/2"	3,820	1/5			32A40-5VBL	662528 38528	1/5	38A60-KVBE	662528 38497
Face Z (ME19241)	3,820	1/5			32A60-JVBE	662528 38492	1/0	OUNCO INVEL	00202000401
7/5 x 2 x 1-1/4 Rim 3/4" Back 1/2" (ME19242)	3,275	1/8			32A46-JVBE	662529 42959	1/8	38A46-HVBE	662529 42963
Type 12 Dish	H								
4 x 1/2 x 3/4 (ME19226)	6,207	1/10			32A60-KVBE	662435 30067			
6 x 1/2 x 1-1/4	4,140	1/10	5SG60-LVS	662528 36574	32A46-JVBE	662528 36860	1/10	38A60-JVBE	662528 36977
(ME19229)	4,140	1/10	50000 1010		32A60-JVBE	662528 36966			
6 x 3/4 x 1-1/4	4,140	1/10	5SG60-KVS	662528 37771	32A46-KVBE	662528 37732			
(ME19230)	4,140	1/10			32A60-JVBE	662528 37734			
7 \(1/0 \(1 1/4)	4,140	1/10			32A60-KVBE	662528 37735 662529 41644			
7 x 1/2 x 1-1/4 (ME13717)	3,600	1/10 1/10			32A46-KVBE 32A60-KVBE	662529 41644			
(ME13717) 8 x 3/4 x 1-1/4 (ME19231)	3,600	1/10			JZAUU-IVDL	00232941047	1/10	38A60-KVBE	662530 44319
10 x 1 x 1 (ME38702)	2,485	1			32A54-JVBE	662531 61196			
10 x 1 x 1-1/4 (ME38702)	2,485	1			32A54-JVBE	662531 61197			
Type 20 Concave One S	ide 🗔								
14 x 1-1/2 x 5 Concave from Periphery	1,800 1,800	1	5SG60-JVS	662533 02265	32A60-JVBE 32A60-KVBE	662533 64250 662533 64332			
1/2" Deep to 8" Flat Spot	Dies 0	5							
Type 35 Plate Mounted						000500 4044 5			
9 x 2 x 4-15/16 Rim 2-1/32" (ME31130)	2,550 2,550	1			32A46-MVBE 32A60-J25VCF2	662530 49115 662530 06557			
Plate A47248	2,550	1			32A00-J25VCF2 32A70-JVBEP	662530 49112			
	2,000				SENIO OVDEN				

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These sharp silicon carbide, vitrified wheels are used for grinding non-ferrous applications.

Applications:

Shapes: Size Range: Grit Range: Abrasive Grain: Use 39C (green silicon carbide) for cemented carbides, titanium, metal matrix composites and plasma sprayed materials. Use 37C (black silicon carbide) on 300 series stainless steels, irons, nonferrous metals (aluminum, brass, bronze and copper) and non-metallic materials (stone, marble, rubber, ceramics and glass). Type 01 Straight, Type 02 Cylinder, and Type 05 Recessed 1 Side 3" – 14" diameter 24 – 120 39C Green Silicon Carbide, 37C Black Silicon Carbide

Vitrified Wheels For Non-Ferrous Applications

			GOOD	
		TRADENAME:	39C / 37C	
		ABRASIVE:	Silicon Carbide	
SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straight		2		
3 x 1/2 x 1/2	10,825	10/50	37C60-MVMT	662435 29041
3 x 1 x 1/2	10,825	10/10	37C60-MVMT	662435 29166
	10,825	10/10	37C80-HVMT	662435 29170
	10,825	10/10	37C80-MVMT	662435 29171
	10,825	10/10	37C100-HVMT	662435 29172
	10,825	10/10	37C100-MVMT	662435 29070
3-1/2 x 1-1/2 x 7/8	7,095	1/10	37C24-SVK	662435 29339
(ME622)	7,095	1/10	37C30-SVK	662435 29338
4 x 1/2 x 1/2	8,120	1/10	37C60-MVMT	662435 29960
	8,120	1/10	39C100-IVMT	662435 30064
6 x 1/2 x 1-1/4	4,140	1/10	39C60-IVMT	662528 36706
	4.140	1/10	39C80-IVMT	66252836816
	4,140	1/10	39C100-IVMT	662528 36827
	4.140	1/10	39C120-IVMT	662528 36836
6 x 3/4 x 1-1/4	4,140	1/10	39C60-IVMT	662528 37584
0 / 0/ 1 / 1 / 1	4,140	1/10	39C80-IVMT	662528 37598
	4,140	1/10	39C100-IVMT	662528 37717
6 x 1 x 1-1/4	4,140	1/10	39C60-IVMT	662528 38161
0.	4,140	1/10	39C80-IVMT	662528 38173
7 x 1/4 x 1-1/4	3,600	1/10	39C80-JVMT	662529 40007
/ x 1/4 x 1-1/4	3,600	1/10	39C100-IVMT	662529 40109
	3,600	1/10	39C120-IVMT	662529 40111
7 x 1/2 x 1-1/4	3,600	1/10	37C46-JVMT	662529 41488
	3,600	1/10	37C60-0VMT	662529 41498
	3,600	1/10	39C60-IVMT	662529 41609
	3,600	1/10	39C60-JVMT	662529 41611
	3.600	1/10	39C60-KVMT	662529 41613
	3,600	1/10	39C80-IVMT	662529 41617
	3,600	1/10	39C80-JVMT	662529 41618
	3.600	1/10	39C100-HVKMT	662529 41622
	3.600	1/10	39C100-IVMT	662529 41624
	3,600	1/10	39C120-IVMT	662529 41632 B
7 x 3/4 x 1-1/4	3.600	1/10	39C80-JVMT	662529 42096
	3,600	1/10	39C100-JVMT	662529 42104
7 x 1 x 1-1/4	3,600	1/10	39C60-IVMT	662529 42666
	3,600	1/10	39C80-IVMT	662529 42413
	3,600	1/10	39C120-IVMT	662529 42416
8 x 1/4 x 1-1/4	3,600	1/10	39C80-IVMT	662530 14526
8 x 3/8 x 1-1/4	3,600	1/10	39C80-IVMT	699366 64144
8 x 1/2 x 1-1/4	3,600	1/10	39C60-IVMT	662530 44013
0 / 1/2 / 1 1/7	3,600	1/10	39C80-IVMT	662530 44015
	3,600	1/10	39C100-IVMT	662530 44017 B
	5,000	1/10	000100-101011	002000 44017 D

		TIER: TRADENAME:	GOOD 39C / 37C	
		ABRASIVE:	Silicon Carbide	
SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straight		MIN./010.1 Ku.	51 20.	
8 x 3/4 x 1-1/4	3.600	1/10	39C60-JVMT	662530 44312
	3,600	1/10	39C80-IVMT	662533 50645
	3.600	1/10	39C100-IVMT	66253044314
8 x 1 x 1-1/4	3,600	1/10	39C60-JVMT	662530 44770
-	3,600	1/10	39C80-IVMT	662530 44425 B
	3,600	1/10	39C100-IVMT	662530 44379
10 x 1 x 3	2,485	1	39C60-JVMT	662531 60348
10 x 1-1/2 x 2	2,485	1	39C60-JVMT	662531 61640
12 x 1 x 3	2,070	1	39C60-IVMT	662532 62985
12 x 1 x 5	2,070	1	39C60-IVMT	662532 62884
	2,070	1	39C80-JVMT	662532 62988
14 x 1 x 5	1,800	1	39C60-JVMT	662533 64206
	1,800	1	39C80-JVMT	662533 64208
14 x 1-1/2 x 5	1,800	1	39C60-JVMT	662533 64242
14 x 2 x 5	1,800	1	39C60-JVMT	662533 64322
Type O2 Cylinder				
6 x 1 x 4	3,600	1/10	39C60-IVMT	662528 38322
Rim 1"	3,600	1/10	39C60-JVMT	662528 38324
Plate A47466	3,600	1/10	39C80-IVMT	662528 38327
	3,600	1/10	39C100-IVMT	662528 38330
	3,600	1/10	39C120-IVMT	662528 38193
6 x 1-1/4 x 4 Rim 1" Plate A47466	3,600	1/10	39C60-IVMT	662528 38345
10 x 2 x 7	2,100	1	39C60-HVMT	662531 61675
Rim 1-1/2" Plate A83831	2,295	1	39C60-JVMT	662531 61678
Type 05 Recessed	l One Side			

14 x 1-1/2 x 5 1,800 1 39C60-IVMT 66253364328 Rec 1/S 8 x 1/2

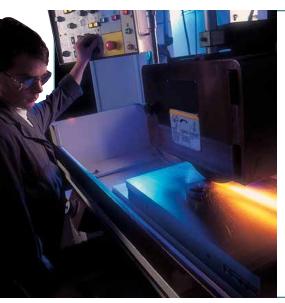
B = Best Seller; performs well in a variety of applications for many satisfied customers



VMT Bond Technology

Lower power draw for reduced cycle time and improved wheel life.





PRECISION GRINDING WHEELS Large Surface Grinding Wheels

Large surface grinding wheels are generally used to grind flat stock or flat surfaces within a workpiece. These wheels are typically used on horizontal spindle machines. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

Applications:

Shape:

Size Range:

Abrasive Grain:

Grinding large molds and dies
 Sharpening knives, blades and cutlery
 Manufacturing broaches
 Type 01 Straight, Type 07 Recessed 2 Sides
 Stock: 20" diameter
 1" - 6" thickness
 Aluminum Oxide

· Producing flat stock

Cross Reference Guide

	GOOD
NORTON	GEMINI
Camel	91A
Cincinnati Milacron	29A, 97A
Radiac	WAA, 97A, 45A



Good choice when a broad range of parts are ground on a few machines

GEMINI ALUMINUM OXIDE BLEND

- Specially blended aluminum oxide abrasive for many surface grinding applications
- · Porous bond is cool cutting on medium to wide contact areas; high chip clearance and stock removal
- Faster grinding rates remove stock, lower rates produce finer finishes; ideal when a broad range of tool steel parts are ground on a few machines

TIER: GOOD

			TRADENAME:	GEMINI	
			ABRASIVE:	Aluminum Oxide	
SIZE (D x T x H)	RECESS	MAX. RPM	STD. PKG.	SPEC.	PART #
Type 01 Straight W	/heels				
20 x 1 x 8	-	1,625	1	Norton Gemini A46-H	662532 46937
20 x 2 x 10	-	1,625	1	Norton Gemini A36-J	662532 46956
Type 07 Recessed	Two Sides				
20 x 2 x 8	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini 59A46-I	662532 46949
	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-G VSP	662532 46953
20 x 3 x 8	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-G VSP	662532 46972
	Recessed 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-H	662532 46969
	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-I	662532 46960
20 x 3 x 10	Recess 2 Sides 12-1/4 x 3/4	1,625	1	Norton Gemini 59A46-1 VSP	662530 58315
	Recess Side A 12-1/2 x 1/2, Side B 12-1/2 x 1	1,625	1	Norton Gemini A36-J VSP	662532 46980
	Recess Side A 12-1/2 x 1/2, Side B 12-1/2 x 1	1,625	1	Norton Gemini A46-D VSP	662532 46988

There are many more sizes and specifications available made-to-your-order. Contact your Norton representative with your custom requirements.



PRECISION GRINDING WHEELS Surface Grinding Segments

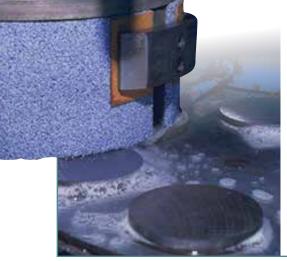
Surface grinding segments are generally used to grind flat stock or flat surfaces within a workpiece. The segment moves over the workpiece in a flat plane or vice versa. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

Applications:

- Vertical spindle surface grinding · Grinding large molds, dies and plates
- Producing flat stock
- **Abrasive Grain:**



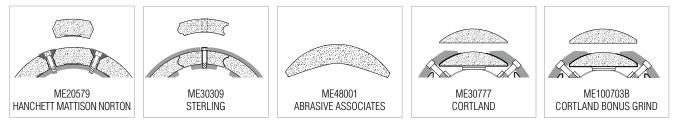
· Sharpening knives, blades, cutlery Ceramic Alumina, Aluminum Oxide



Material-to-Product Recommendation Guide

	HEAVY-DUTY				GENERAL-DUTY		
MATERIAL	QuantumX 20-G	QuantumX 30-F	86A24-G20VTX2	86A30-E20VTX2	Gemini 30-E	Gemini 30-F	Gemini 30-G
Aluminum				•	•		
Bronze (hard)							•
Cast Iron	•						•
Hastalloy			•		•		
Inconel		•			•		
Hardened Steel	•				•		
High Speed Steel	•				•		
Soft Steel			•	•			•
Stainless Steel 300				•	•		
Stainless Steel 400						•	

Segment Blueprints



Troubleshooting Guide

PROBLEM	CORRECTION
Segment acting too hard	Increase rate of downfeed
	Increase table rotation speed (watch amp-meter)
	Dress more frequently
	Consider reducing area of table load
Segment acting too soft	Decrease rate of downfeed
	Decrease table rotation speed
	Check for abnormal machine vibration
Glazing and/or burning	Choose a softer grade
	Increase table speed (watch amp-meter)

TIP FCH

- Choose as coarse a grit size as possible in order to remove stock as quickly as possible (in big chips).
- · To maximize production, choose the hardest grade possible that will not overload the machine.

It is the user's responsibility to refer to and comply with ANSI B7.1



PRECISION GRINDING WHEELS Surface Grinding Segments



Best choice for all low-, medium-, and high-force applications ranging from cast iron, to stainless steel and hard-to-grind alloys

QUANTUM AND QUANTUM X CERAMIC ALUMINA

- Revolutionary, versatile engineered ceramic grain shape and chemistry produce highest productivity with the lowest total grinding costs
- 33% to 100% longer life versus competitive ceramic products, 30% plus higher metal removal rate, with 15% plus lower threshold power
- Excellent performance on both old and new machines

Better choice for versatile, consistent performance

86A ALUMINUM OXIDE

- · Sharper aluminum oxide abrasive grain delivers cooler-cutting, consistent performance
- Segments available for Hanchett, Mattison Norton, Sterling, Abrasive Associates, Cortland, and Cortland Bonus
 Grind machines
- · Better choice with porous vitrified bond for increasesd chip clearance and cool cutting in heat-sensitive applications



Good choice when a broad variety of parts are ground on a few machines

GEMINI ALUMINUM OXIDE BLEND

- · Specially blended aluminum oxide abrasive for many surface grinding applications
- The porous vitrified bond increases chip clearance and maximizes coolant flow, reduces loading, and is cool cutting in heat-sensitive applications
- For use in Hanchett, Mattison, and Norton, and Cortland and Cortland Bonus Grind chucks on surface grinding machines

					-					
				TIER:	BEST		BETTER		GOOD	
				TRADENAME:	QUANTUM/QUAN	TUM X	86A		GEMINI	
				ABRASIVE:	Ceramic Alumina		Aluminum Oxide		Aluminum Oxide	
NIDTH	THICK	HEIGHT	BLUEPRINT NO.		SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
	1-1/2	6	ME20579	8	QUANTUMX 20-G	662533 50603			Gemini 30-E	662530 50295
				8			86A24-H20VTX2	662533 50602	Gemini 30-F	662530 50297
				8			86A30-F12VBEP	614636 50273	Gemini 30-G	662530 50299
-13/16	1-1/2	6	ME30309	8			86A24-G20VTX2	662533 50595		
1-1/4	2-1/4	6	ME30777	5	QUANTUMX 20-G	662533 50607	86A24-E12VBEP	614636 50279	Gemini 30-E	699366 99706
				5	QUANTUMX 20-H	662533 50608	86A24-G20VTX2	662533 50605	Gemini 30-F	699366 99709
				5	3NQP36-G12VSP	662532 51527			Gemini 30-G	699366 99710
				5			86A30-E12VBEP	614636 50285	Gemini 30-H	662434 47588
				5			86A30-F12VBEP	614636 50287		
				5			86A30-G12VBEP	614636 50289		
				5			86A46-D12VBEP	614636 50442		
1-1/4	2-1/4	8	ME30777	5	QUANTUMX 20-G	662533 50612	86A24-G20VTX2	662533 50609	Gemini 30-E	699366 99712
				5	QUANTUMX 20-H	662533 50615			Gemini 30-F	699366 99716
				5	QUANTUMX 30-E	662533 87810	86A30-E20VTX2	662533 87812	Gemini 30-G	699366 99717
				5	QUANTUMX 30-F	662533 87811	86A30-F20VTX2	662533 87813	Gemini 30-H	662434 47591
				5	3NQP30-F12VSP	662532 38276			Gemini 30-I	662434 47592
1-1/4	3	8	ME100703B	4	QUANTUMX 20-G	662533 50623	86A24-G20VTX2	662533 50617	Gemini 30-E	699366 99725
				4	QUANTUMX 20-H	662533 50624			Gemini 30-F	699366 99727
				4	QUANTUMX 30-E	662533 87808			Gemini 30-G	699366 99728
				4	QUANTUMX 30-F	662533 87809			Gemini 30-H	662434 47594
				4	3NQP30-F12VSP	690831 56473			Gemini 30-I	662434 47595
		1-5/8		10	Vitrified Burr Remover	614636 50268 *				

*Minimum Quantity = 2



PRECISION GRINDING WHEELS Cylindrical Wheels

Cylindrical wheels are used most often when the part is held between centers and in chucks. There are three methods of cylindrical grinding: plunge, traverse, and angular.

- Plunge grinding wheel is thrust or plunged into the part
- Traverse grinding wheel moves across the part
- Angular grinding wheel contacts the part at an angle

Typical Industries: Automotive, shipbuilding, engine building, bearing, land- and air-based turbine blades, and toolroom Type 01 Straight, Type 05 Recessed One Side, and Type 07 Recessed 2 Sides Size Range: 16", 18", 20", 24" and 30" diameter Abrasive Grain: Ceramic Alumina and Aluminum Oxide

Stationary Dressing Tool Recommendations for Cylindrical Wheels

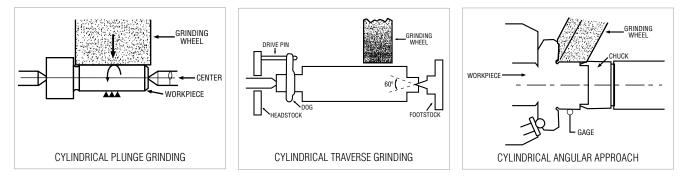
Shape:

		Single Poin	t	Multi-Poir	nt (Grit)				
Grinding Wheel Diameter	Diamond Carat Weight	Tool Product/Par 0° Angle	rt #	Tool Product/P 0° Angle	'art #	Shape	Tool Product/F 15° Angle		Shape
16" - 20"	3/4	BC7M7	662601 95007	BC62	662601 95012	1/4 x 1/2 Rect.	BC63	662601 95013	1/4 x 1/2 Rect.
		NS7M7	662601 95132	2A6D7	662601 95046		2A6E7	662601 95049	
21" +	1	BC10M7	662601 95009	BC61	662601 95011	1/4 x 3/4 Rect.	BC60	662601 95010	1/4 x 3/4 Rect.
		NS10M7	662601 95137	1A6A7	662601 95031		1A6C7	662601 95039	

NS Single Point Diamond Tools are resettable. BC Diamond Tools are not resettable. All tools specified above have 7/16" diameter shanks.

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Burn or cracks on workpiece	Wheel too hard	Try softer wheel or make wheel act softer (see Tech Tip on next page)
	Dress is too fine	Dress faster
	Nozzle not directing coolant properly	Redirect flow
	Work speed too slow or wheel speed too fast	Adjust speeds
	Wheel feed too slow causing excess contact time	Increase feed rate
Chatter marks on workpiece	Loose spindle, end play, bearing failure	Check wheel spindle on assembly
	Work drive faults, out-of-truth plate	Check gear action, truth, drive on pin pressure
	Wheel too hard, poor truing, poor mounting	Use softer grade; dress wheel correctly; secure mounting
Poor quality finish	Poor quality dressing	Reduce final depth of dress on wheel
	Diamond insecurely held	Check and replace diamond and secure properly
	Misalignment of head and tail stocks	Check for properly aligned workpiece
	Dirty coolant	Clean coolant frequently; use efficient filter
	Scored workpiece centers	Check and lap center holes as required





Best choice for highest productivity, lowest total per-part grinding cost

5SG CERAMIC ALUMINA/ALUMINUM OXIDE BLEND

- Exceptionally high-performing seeded gel ceramic alumina and friable aluminum oxide abrasive blend for fast stock removal, cool, superior cutting; 3 5 times more life than aluminum oxide wheels; 2 times stock removal rate vs. conventional abrasives
- · High-performance versatile bond for cylindrical and surface grinding high-speed tool steels, hardened and soft steels, and aerospace alloys: exceptional form holding
- · Self-sharpening abrasive minimizes burn and required dressing, to maximize sharp edge on tools and dies for longer life in production

Better choice for medium to heavy stock removal

32A ALUMINUM OXIDE

- . Exceedingly strong, sharp monocrystalline aluminum oxide grain, for precision production medium to heavy stock removal applications
- · The most versatile vitrified bond, especially recommended for toolroom, cylindrical, and surface grinding
- · Grinds with an exceptional cool; fast cutting action, requires minimum dressing

Better choice for longer wheel life

86A ALUMINUM OXIDE

- · Premium abrasive and superior bond system produce high grinding G-Ratios (metal removal/wheel wear) for increased productivity
- · Hold form for better part geometry; decreased dress frequency and/or dress compensation
- · Engineered for easy use, grind cycles do not need to be altered, no special operator training is needed

Good choice for versatile performance at an economical price

64A ALUMINUM OXIDE BLEND

- · Specially blended aluminum oxide abrasive for production cylindrical applications
- A superior vitrified bond that maintains high grinding rates without wheel breakdown
- Good choice for small job shops grinding numerous materials on a few machines

Good choice for smallest volume, lowest initial price applications

GEMINI 2 ALUMINUM OXIDE

- · Upgraded aluminum oxide abrasive blend delivers an efficient cut rate and improved grinding wheel life to your precision operations
- Made in the USA, these quality, low initial price wheels are ideal for small- to medium-sized manufacturing facilities that perform a variety of jobs
- · Carefully chosen, versatile specifications and sizes meet many cylindrical and surface grinding requirements

FECH TIF

To make a wheel act softer:

- Increase work speed
- Increase traverse speed
- Increase infeed
- Decrease wheel speed
- Increase dresser traverse rate
- Increase depth of dress per traverse
- Dress more often

- To make a wheel act harder:
- Decrease work speed
- Decrease traverse speed
- Decrease infeed
- Increase wheel speed (do not exceed MAX RPM marked on wheel)
- Dress at slower traverse rate
- Decrease depth of dress per traverse

It is the user's responsibility to refer to and comply with ANSI B7.1



NDITTON

NURTUN



PRECISION GRINDING WHEELS Cylindrical Wheels

	TRADENAME:	BEST 5SG		BETTER 32A, 86A		GOOD 64A, GEMINI, O	
	ABRASIVE:		a / Aluminum Oxide	Aluminum Oxide		Aluminum Oxide	K GEMINIZ
	STD.		a / Aluminum Oxide	Aluminum Oxide		Aluminum Oxide	
IZE (D x T x H)	PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
ype 01 Straight							
5x1x5	1	5SG60-JVS	662534 67007	32A60-J8VBE	662534 64836	64A60-K8V127	662534 66722
	1			32A60-K5VBE	662534 64837	Gemini2 60-I	662434 97801
	1					Gemini2 60-K	662434 95077
	1					Gemini2 100-I	662434 97804
	1					Gemini2 100-M	662434 97807
6 x 1 x 8	1			32A60-K5VBE	662534 64826		
6 x 1-1/2 x 5	1	5SG60-KVS	662534 67010	32A46-H8VBE	662534 64925		
6 x 2 x 5	1			32A46-J8VBE	662534 64995	64A60-K8V127	66253466721
	1			32A60-K5VBE	662534 64960	Gemini2 60-I	66243497810
01	1					Gemini2 100-I	662434 97812
8 x 1 x 5	1					Gemini2 60-I	66243483777
	1					Gemini2 60-M	662434 97611
0 v 0 v E	1					Gemini2 100-M	662434 97615
8 x 2 x 5	1					64A60-K8V127 Gemini2 60-I	662534 6671 662434 8377
Dx1x8	1			86A60-J8V127	690786 08982		00243403/13
0 X I X O	1			86A80-J8V127	690786 08983		
	1			00400-301121	09070000303	Gemini2 60-M	662434 9784 1
	1					Gemini2 100-I	662434 97842
0 x 1 x 10	1					Gemini2 60-I	662434 95332
	1					Gemini2 60-K	662434 9778
	1					Gemini2 60-M	66243497791
	1					Gemini2 100-I	66243497793
	1					Gemini2 100-K	6624349779
	1					Gemini2 100-M	66243497798
0 x 1 x 12	1					Gemini2 60-I	662434 8378 7
	1					Gemini2 60-K	662434 9782 7
	1					Gemini2 60-M	66243497831
	1					Gemini2 100-I	6624349783
	1					Gemini2 100-M	662434 97838
0 x 1-1/2 x 5	1			32A46-H8VBE	690786 65382		
0 x 2 x 5	1					64A60-J8V127	690786 66713
0 x 2 x 8	1			32A46-I8VBE	690786 65433	64A60-K8V127	690786 66712
	1			32A60-K5VBE	690786 65490	Gemini2 60-I	662434 8378
	1					Gemini2 60-K	662434 97855
0 x 2 x 10	1					Gemini2 100-I	662434 97849
	1					Gemini2 100-K	662434 97850
0 x 2 x 12	1			32A46-I8VBE	690786 65455		
	1					Gemini2 100-K	662434 97854
0 x 3 x 8	1					64A46-I8V127	690786 66447
	1					64A60-J8V127	690786 08140
	1					Gemini2 100-I	662434 97862
0 x 3 x 10	1					Gemini2 60-I	662434 95333
0 x 3 x 12	1					Gemini2 60-I	662434 83789
4 4 40	1					Gemini2 100-I	66243497860
4 x 1 x 12	1					Gemini2 60-I	66243483790
	1					Gemini2 100-I	66243497866
4010	1					Gemini2 100-M	66243497870
4 x 2 x 12	1					64A60-K8V127	69083166710
4010	1					64A80-K8V127	69083166711
4 x 3 x 12	1					Gemini2 60-I	662434 83793
0 x 2 x 12	1					64A60-J8V127	692104 66704
0 x 3 x 12	1					64A60-J8V127	692104 66697
0 x 4 x 12						64A60-K8V127	692104 66698
0 x 4 x 12	<u>1</u> 1					64A60-J8V127	692104 01774
	500 B					Gemini2 60-J	662434 9798 9
ype 07 Recessed Two Sides							
8 x 2 x 8 Rec 2/S 10-1/2 x 1/2	1			32A46-I8VBE	662534 65110		

18 x 2 x 8 Rec 2/S 10-1/2 x 1/2	1	32A46-I8VBE	662534 65110		
20 x 2 x 8 Rec 2/S 11-1/2 x 1/2	1	32A46-I8VBE	690786 65537		
20 x 3 x 8 Rec 2/S 11-1/4 x 1/2	1	32A46-I8VBE	690786 65686		
20 x 3 x 8 Rec 2/S 11-1/2 x 1/2	1			Gemini 46-H	662532 46969
20 x 3 x 10 Rec 2/S 12-1/4 x 5/8	1	32A46-I8VBE	690786 65575		
20 x 6 x 10 Rec Side A 12-1/4 x 2 Rec Side B 12-1/4 x	11	32A46-I8VBE	690786 65854		
For additional stack aulindrical wheels, and the large of	urface arighting wheel costion of this estalog				

For additional stock cylindrical wheels, see the large surface grinding wheel section of this catalog

Contact your Norton representative with your custom cylindrical wheel requirements. There are many more sizes and specifications available made-to-your-order, including wheels made from Norton 55A and Quantum blank stock. See 55A and Quantum Blank Stock FastTrack Service catalog sections for more details. Ask about wheels made with our revolutionary new premium Quantum Prime ceramic grain and Vitrium3 bond.



PRECISION GRINDING WHEELS Centerless and Feed Wheels

Centerless grinding is a production process that produces extremely close tolerances on metal cylindrical forms or parts. Centerless grinding is used on a wide variety of workpieces. The key components in the process are the grinding wheel, the work rest blade (used to support the work) and the regulating or "feed" wheel (the drive mechanism for the workpiece).

Applications:	 High production operations on large volume continuous grinding
Applications.	
	Parts ranging from miniature roller bearings to train axles and bearings
	 Fastener and tool manufacturing
	Steel mills
	 Automotive related components
	Bearing
	Machine tools
	Aircraft
	 Turbine blades – land- and air-based
Shape:	Centerless wheels: Type 01 Straight
	Feed wheels: Type 01 Straight and Type 07 Recessed 2 Sides
Size Range:	Centerless wheels: 16", 20", and 24" diameter
	Feed wheels: 12" and 14" diameter
Abrasive Grain:	Ceramic Alumina, Aluminum Oxide, Aluminum Oxide/Silicon Carbide Blend

Material-to-Product Recommendation Guide

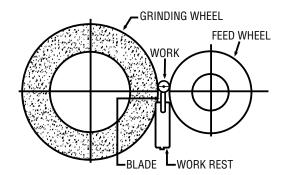
	55A60-KVS3	55A80-LVS3	32AC90-QB	32AC54-QB	2NQMC54-QB45
Alnico	•			•	
Cast Iron	•			•	
Hastalloy	•				
Inconel	•				
Stainless	•				
Stainless Steel 300	•				
Stainless Steel 400	•				
Steel - Hard or Soft					
Less than 1/2" Diameter		•			
5/8" to 2 1/2" Diameter	•				
Over 2 1/2" Diameter	•				•
High Speed (commercial finish)	•				•
High Speed (fine finish)			•		

Stationary Dressing Tool Recommendations for Centerless Wheels

		Single Point	Indexable Single Point	Multi-point (Grit)			
Grinding Wheel Diameter	Diamond Carat Weight	Tool Product # Part # 0° Angle	Tool Product # Part # 0° Angle	Tool Product # Part # 0° Angle	Shape	Tool Product # Part # 15° Angle	Shape
11" - 14"	1/2	BC5M7 66260195005	BCUD5 66260195025	BC65 66260195015	3/8 Round	BC63 66260195013	1/4 x 1/2
		NS5M7 66260195127	NSUD5 66260195163	2R6K7 662601 95096		2A6E7 66260195049	Rectangle
15" - 20"	3/4	BC7M7 66260195007	N/A	BC62 66260195012	1/4 x 1/2	BC63 66260195013	1/4 x 1/2
		NS7M7 66260195132	NSUD7 66260195164	2A6D7 662601 95046	Rectangle	2A6E7 66260195049	Rectangle
21" +	1	BC10M7 66260195009	N/A	BC61 662601 95011	1/4 x 3/4	BC60 662601 95010	1/4 x 3/4
		NS10M7 66260195137	N/A	1A6A7 662601 95031	Rectangle	1A6C7 662601 95039	Rectangle

Stationary Dressing Tool Recommendations for Feed Wheels

			Indexable Si	ngle Point
Feed Wheel	Tool Carat	Tool Shank	Tool	Tool
Diameter	Weight	Diameter	Product #	Part #
Up to 14"	1/2	7/16"	NSUD5	662601 95163





PRECISION GRINDING WHEELS Centerless and Feed Wheels

TECH TIP

Proper Wheel Mounting

- 1. Thoroughly clean spindle and flange bearing area of all dirt and foreign material.
- 2. Inspect for worn, distorted or damaged areas on flanges and spindle.
- If mounting a wide centerless wheel on a spindle (i.e., twin-grip), do not use grease or other petroleum lubricants. Use a silicone spray lubricant on the spindle to ease mounting the wheel, if necessary.
- 4. Ensure mount up arrow is at the top of the wheel. In the case of butted sets, assemble so that the arrow is formed across the top of the wheel face.
- 5. Ensure proper blotters are installed; one on each flange mating surface. Always use new blotters.
- 6. Install blotter flange and snug up the bolts only finger tight.
- 7. Using a torque wrench, tighten all bolts in an alternating pattern from side to side to 15 foot pounds.
- 8. Repeat the same tightening sequence, increasing the torque to 35 foot pounds.

 - » for narrower wheels (2"-12"), a torque of 35 foot pounds is sufficient
- 9. Retorque the flange bolts to specification after the first eight hours of operation.

TECH TIP

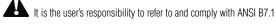
- To make a wheel act softer:
- Increase work speed/regulating wheel speed
- Increase throughput speed/regulating wheel speed
- · Increase infeed
- Decrease wheel speed
- Dress at a faster traverse rate

To make a wheel act harder:

- Decrease work speed/regulating wheel speed
- Decrease throughput speed/regulating wheel speed
- Decrease infeed
- Increase wheel speed (observe safe limits)

TECH TIP

- Use vitrified bond wheels for form holding and plunge grinding
- Use resinoid bond wheels for stock removal, long irregular parts and faster throughfeed grinding
- Vitrified Centerless Wheel Speeds:
 - » 64A46-KVCE wheels: 6,500 SFPM max. operating speed
 - » All other vitrified centerless stock products: 8,500 SFPM max. operating speed
 - » Always check wheel speed markings on wheels before running wheel







Best choice for cast iron to stainless and hard-to-grind materials and alloys (titanium, Inconel...)

QUANTUM (2NQ) CENTURY45 CERAMIC ALUMINA

- · Proprietary 2NQ ceramic abrasive and Century45 (B45) resin bond formulation engineered specifically to maximize productivity of centerless applications
- Achieve over 30% improvement of stock removal, and up to 50% reduction in cycle time
- · Less grinding noise significantly improves operator safety

Better choice for performance to price ratio

55A-VS3 ALUMINUM OXIDE

- Monocrystalline 55A aluminum oxide offers superior performance on centerless plunge and throughfeed surface grinders with 2 plus times the life of competitive aluminum
 oxide wheels
- · Vitrium 3 VS3 bond allows cool cutting, high-speed, and precise form holding
- · Ideal for simple- to complex-shaped components, with increased productivity; more quality parts at low cost per part

Better choice when one wheel is used to grind several different materials

32AC ALUMINUM OXIDE / SILICON CARBIDE BLEND

- Aluminum oxide/silicon carbide abrasive blend in a strong resin bond is ideal when one wheel is used to grind several different materials from high-to-low tensile strength
- · Norton resin bond centerless wheels are the choice for stock removal, long irregular paths, and faster through feed grinding
- Ideal for full range of simple- to complex-shaped components

Good choice for hard-to-grind fasteners

57A ALUMINUM OXIDE WITH FINE / HARD SIDE

- Tough, durable aluminum oxide abrasive for heavy duty work
- · Superior vitrified bond system for longer wheel life and excellent form holding when toolroom and centerless grinding
- 3/16 inch thick fine/hard side provides good form holding while grinding stainless and Inconel fasteners

Good choice for grinding a variety of materials, economically

64A ALUMINUM OXIDE BLEND

- · Good intermediate type aluminum oxide abrasive blend for production centerless applications
- A superior vitrified bond that maintains high grinding rates without wheel breakdown
- Good choice for small job shops grinding numerous materials on a few machines

Good choice for smallest volume, lowest initial price applications

GEMINI 2 ALUMINUM OXIDE

- · Upgraded aluminum oxide abrasive blend delivers an efficient cut rate and improved grinding wheel life to your precision operations
- · Made in the USA, these quality, low initial price wheels are ideal for small- to medium-sized manufacturing facilities that perform a variety of jobs
- · Carefully chosen, versatile specifications and sizes meet many centerless grinding requirements



PRECISION GRINDING WHEELS Centerless and Feed Wheels

Centerless Wheels

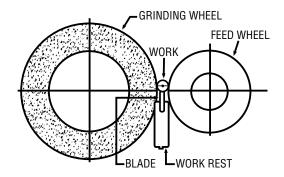
	TIER:	BEST		BETTER		BETTER		GOOD	
TRAD	ENAME:	QUANTUM CENT CENTERLESS RE	IURY45 Sinoid Wheels	32AC / 32AC C Centerless R	ENTURY 45 Esinoid Wheels	55A Centerless V	/ITRIFIED WHEELS	53A, 57A,64A, (CENTERLESS VI	
AE	RASIVE:	Ceramic Alumina		Aluminum Oxide,	/Silicon Carbide	Aluminum Oxide	9	Aluminum Oxide	
	STD.								
SIZE (D x T x H)	PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type 01 Straight									
16 x 4 x 10	1							57A80-L8VCN	662534 65001
20 x 2 x 12	1								
20 x 4 x 12	1							64A60-KVCE	690786 66723
	1							64A80-LVCE	690786 66727
20 x 6 x 12	1	2NQMC54-QB45	662434 96406	32AC80-NB45	662434 96398	55A60-KVS3	662533 87817	64A60-KVCE	690786 66729
	1			32AC54-QB	690786 66545			Gemini 60-L	662532 46994
	1					55A80-MVS	662534 90788		
20 x 8 x 12	1	2NQMC54-QB45	662434 96407	32AC80-NB45	662434 96400	55A60-KVS3	662533 87819	64A60-KVCE	690786 66748
	1			32AC54-QB	690786 66546	55A80-LVS	662534 90783	64A60-LVCE	690786 66749
	1							64A80-KVCE	690786 66751
	1							Gemini 54-J	662532 47001
	1							Gemini2 60-K	662534 51857
24 x 2-1/2 x 12	1							57A A80/120 P/R	662534 91223
24 x 2-1/2 x 12	1								
w/ 3/16" fine/hard layer	1								
24 x 3 x 12	1							64A60-K8V127	690831 66708
24 x 4 x 12	1								
	1							Gemini2 100-L	662534 51861
24 x 6 x 12	1	2NQMC54-QB45	662434 96408	32AC80-NB45	662434 96401	55A80-LVS3	662533 87821	Gemini 60-K	662532 47047
	1			32AC54-QB	690831 66547			Gemini2 60-K	662534 51862
24 x 8 x 12	1	2NQMC54-QB45	662434 96409	32AC80-NB45	662434 96403	55A60-KVS	662534 90791		
	1			32AC54-QB	690831 66548	55A60-LVS	662534 90762		
	1					55A80-LVS3	662533 87825		
	1					55A60-MVS	662534 90782		
24 x 10 x 12	1	2NQMC54-QB45	662434 96410	32AC80-NB45	662434 96404	55A60-KVS3	662533 87830		
	1			32AC54-QB	690831 66549	55A80-LVS3	662533 87828		
24 x 20 x 12	1			32AC54-QB	690831 66552				
Composed of 2 Wheels 10" Thick (ME90362)	1			32AC54-SB	690831 66553				

Rubber Bond Feed Wheels

	TIER:	BETTER	
	ABRASIVE:	Aluminum Oxide	
SIZE (D x T x H)	STD. PKG.	SPEC.	PART #
Type 07 Recessed Two	Sides 📄		
12 x 4 x 5 Rec 2 Sides 7-1/2 x 1/2	1	57A80-RR51	662532 22844
12 x 6 x 5 Rec Side A 7-1/2 x 1-1/2 Rec Side B 7-1/2 x 1/2	1	57A80-RR51	662532 22846
12 x 6 x 5 Rec 2 Sides 7-1/2 x 1-1/2	1	57A80-RR51	662532 22847
12 x 8 x 5 Rec Side A 7-1/2 x 2-1/2 Rec Side B 7-1/2 x 1-1/2	1	57A80-RR51	662532 22850
14 x 8 x 5 Rec Side A 8 x 2 Rec Side B 8 x 1-1/2	1	57A80-RR51	662533 22859
14 x 20 x 6 Rec 2 Sides 8-1/2 x 1-1/2 Butted Feed Wheels Composed of 2 Wheels 10" Thick (ME91512)	1	57A80-RR51	662533 22196

Plastic Bond Feed Wheels

	TIER:	BETTER	
	ABRASIVE:	Aluminum Oxide	
SIZE (D x T x H)	STD. PKG.	SPEC.	PART #
Type 07 Recessed Two	Sides 📄		
12 x 8 x 5 Rec Side A 7-1/2 x 2-1/2 Rec Side B 7-1/2 x 1-1/2	1	57A80-RP4	662532 22199



There are many more sizes and specifications available made-to-your-order, including wheels made from our blank stock FastTrack Service for rush orders. Ask about wheels made with our revolutionary new premium Quantum Prime ceramic grain. Contact your Norton representative with your custom centerless requirements.



NURTUN IDE IN I 1240 HE 24VTX2

PRECISION GRINDING WHEELS Creepfeed Blank Stock

Norton creepfeed wheels are the best performing creepfeed wheels in the industry. These high-performance blank stock wheels can be altered to your dimensional requirements.

Applications: Typical Industries: Size Range:

Grade/Porosity: **Abrasive Grain:**

Heat-sensitive, porous grinding of difficult-to-grind alloys Aerospace, automotive, toolroom, gear, energy Blank Stock: 16" - 25" diameter Finished Wheel: 14" - 25" diameter C28 - F26 Ceramic Alumina, Fused Aluminum Oxide



Best choice for versatility, maximum performance, and highest productivity

QUANTUM X CERAMIC ALUMINA AND VORTEX ALUMINUM OXIDE BLEND

- Leading Norton technologies produce the most free-cutting creepfeed wheel: patented pore-induced construction, a blend of Norton Quantum ceramic and Vortex aluminum oxide abrasives, and the newest, strongest Norton bond: Vitrium
- Excel on large area of contact applications with exceptional form and corner-holding and 20+% less power draw; best MRR vs. all other ceramic creepfeed wheels, with reduced cycle times of up to 50%
- · Versatile; for all low-, medium- and high-force applications on hard-to-grind Inconel, titanium, and aerospace alloys



Better choice for heat-sensitive, porous grinding of difficult-to-grind alloys

VORTEX ENGINEERED ALUMINUM OXIDE

- · High-performance, engineered and optimally spaced fused aluminum oxide abrasive
- · High metal removal rates; able to grind large areas of contact with exceptional part integrity and quality and superior surface finish
- · Long wheel life: dramatically shorter grinding cycles = less wheel changes and more parts/wheel = high productivity

Key Program Features

- · Standard lead-time: 2 weeks
- · Alteration Parameters:
 - » Diameter may be altered to 2" smaller than the original blank stock diameter
- » Thickness may be altered to 1/2 the original blank stock thickness
- » Bore may be altered to these parameters 5" altered up to 8" max. 8" altered up to 12" max.



PRECISION GRINDING WHEELS Creepfeed Blank Stock

	TIER: BEST		BETTER	
TRADE	QUANTUM X 3NQX,	TG	VORTEX	
INADE	CERAMIC UNFINISH	ED BLANK STOCK	A/O UNFINISHED	BLANK STOCK
SIZE (D x T x H)	SPEC.	UF BLANK PART #	SPEC.	UF BLANK PART #
Type 01 Straight				
12 x 1.750 x 3	3NQX60/1-D24VTX2	003105 01586		
12 x 3.500 x 3	3NQX60/1-E24VTX2	003105 01589		
12 x 1 x 3	3NQX60/1-E24VTX2	003105 01590		
12 x 3 x 3	TG2120/1-E24VTX2	003105 01591		
12 x 3.500 x 3	3NQX60/1-C28VTX2	003105 03234		
12 x 1.500 x 3	3NQX60/1-C28VTX2	003105 03235		
16 x 1 x 5	3NQX60-C28VTX2	003104 38575		
	3NQX60-D+28VTX2	003104 79157		
	3NQX60-E24VTX2	003104 25239		
	3NQX80-E+28VTX2	003104 79160		
16 x 3 x 5	3NQX60-C28VTX2	003104 38656		
	3NQX60-D28VTX2	003104 25240		
	3NQX60-E24VTX2	003104 25241		
	3NQX80-E+28VTX2	003104 79161		
16 x 4 x 5			IPA60-D29VTX	003103 12485
			IPA60-E26VTX	003103 12486
16 x 5 x 5	3NQX60-D28VTX2	003104 25242		
	3NQX60-E24VTX2	003104 25243		
16 x 6 x 5	3NQX80-E+28VTX2	003104 79162		
20 x 1 x 8	3NQX60-C28VTX2	003104 38658		
	3NQX60-D28VTX2	003104 25244		
	3NQX60-E24VTX2	003104 25245		
20 x 2-1/2 x 8			IPA60-F17VTX	003103 03131
			IPA80-D29VTX	003103 03132
20 x 3 x 8	3NQX60-C28VTX2	003104 38659		
	3NQX60-D28VTX2	003104 25256		
	3NQX60-E24VTX2	003104 25257		
20 x 4 x 8			IPA60-D29VTX	003103 03133
			IPA60-E26VTX	003103 03134
20 x 5 x 8	3NQX60-D28VTX2	003104 25258		
	3NQX60-E24VTX2	003104 25259		
20 x 6 x 8	3NQX60-C28VTX2	003104 38660	IPA60-C29VTX	003103 25091
24 x 4 x 8			IPA60-D29VTX	003104 06547
			IPA60-F26VTX	003103 03135
25 x 2-1/2 x 8			IPA60-E26VTX	003104 04613
25 x 3-1/2 x 8			IPA60-E26VTX	003104 04678





PRECISION GRINDING WHEELS Quantum Blank Stock

Norton Quantum vitrified wheels deliver the highest productivity of any wheel in the marketplace. They will grind with superior results in many applications. They can be altered to your specific needs within two weeks of receipt of your order.

Applications:

- Centerless plunge and throughfeed grinding
 Surface grinding
- Size Range:

.

Grit Range: Grade Range: Abrasive Grain: Cylindrical grinding
 Cylindrical grinding
 Blank Stock: 18" – 30" diameter
 Finished Wheel: 16" – 30" diameter
 60, 80, and 120
 I – M
 Ceramic Alumina



Best choice for versatility, maximum performance, and cost savings

QUANTUM CERAMIC ALUMINA

- Revolutionary, sharp, durable engineered ceramic alumina grain shape and chemistry; highly-porous
- Perform well on old and new machines with 30%+ higher metal removal rate and 15%+ lower threshold power; achieve highest productivity with lowest total grinding cost
- Versatile; for all low-, medium- and high-force applications ranging from cast iron, to stainless steel and hard-to-grind Inconel and titanium

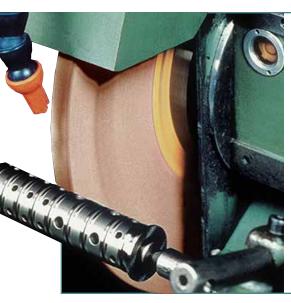
	TIER:	BEST	
	TRADENAME:	QUANTUM Ceramic Unfin	ISHED BLANK STOCK
SIZE (D x T x H)		SPEC.	UNFINISHED BLANK PART #
Type 01 Straight			
18 x 1 x 5		3NQ80-K10VS	00310405993
18 x 2 x 5		3NQ80-K10VS	003104 05994
18 x 3 x 5		3NQ80-K10VS	00310405995
20 x 1 x 8		3NQ80-K10VS	003104 05985
20 x 1 x 12		3NQ80-K10VS	003104 06017
		3NQ120-MVS	003104 05924
20 x 2 x 8		3NQ80-K10VS	00310406036
20 x 3 x 8		3NQ80-K10VS	003104 06037
20 x 6 x 12		3NQ80-L10VS	003104 06018
20 x 8 x 12		3NQ80-L10VS	00310406026
24 x 1 x 8		3NQ80-K10VS	003104 06034
24 x 1 x 12		3NQ80-K10VS	003104 06038
24 x 2 x 8		3NQ80-K10VS	00310406035
24 x 2 x 12		3NQ80-K10VS	003104 06029
24 x 3 x 8		3NQ60-J10VS	003104 25121
		3NQ80-K10VS	003104 06046
24 x 3 x 12		3NQ60-J10VS	003104 25120
		3NQ80-K10VS	003104 06030
24 x 6 x 12		3NQ80-L10VS	003104 06031
24 x 8 x 12		3NQ80-L10VS	003104 06032
24 x 10 x 12		3NQ80-L10VS	003104 06033
30 x 2 x 12		3NQ80-I10VS	003104 27211
		3NQ80-J10VS	003104 06047
		3NQ80-K10VS	003104 06048
30 x 3 x 12		3NQ60-I10VS	003104 27212
30 X 3 X 12		31100-11013	00310421212

There are many finished sizes and specifications available. Contact your local Norton distributor or salesperson with your size and specification requirements for quantity guidelines, quotations and helpful ordering instructions.

Please note "2-week delivery request" if needed, on your order.







55A-VH blank stock wheels are competitively-priced, monocrystalline grain wheels specifically engineered for numerous carbon steel applications requiring moderate to heavy stock removal rates. They can be altered to your specific needs within two weeks of receipt of your order.

Applications:

Size Range:

Grit Range: Grade Range: Abrasive Grain: Centerless plunge and throughfeed grinding Surface grinding Cylindrical grinding Blank Stock: 18" - 42" diameter Finished Wheel: 16" - 42" diameter 60 - 120I - M Aluminum Oxide



Better choice for precision grinding of carbon steel and cast iron

55A-VH ALUMINUM OXIDE

- Advanced combination of monocrystalline 55A aluminum oxide abrasive and superior VH bond
- Superior performance on centerless plunge and throughfeed, surface, and cylindrical grinders with up to 2X the life
 of competitive aluminum oxide wheels
- Ideal for simple- to complex-shaped components with increased productivity, more quality parts, and lowest cost per part

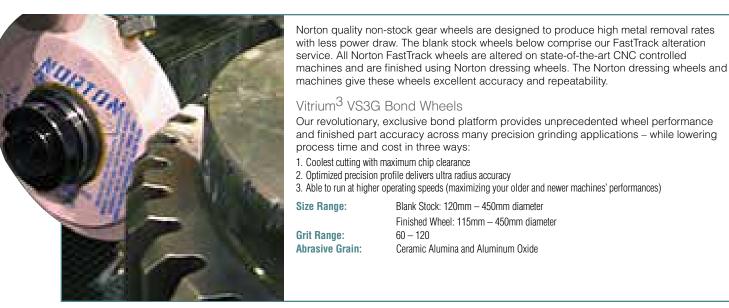
		TIER:	BETTER
		OTHER:	55A-VH Aluminum oxide Unfinished Blank Stock
SIZE (D x T x H)	GRIT	GRADE	UNFINISHED BLANK PART #
Type 01 Straight			
18 x 1 x 5	80	К	003104 04552
18 x 2 x 5	80	К	003104 04554
18 x 3 x 5	80	К	003104 04555
20 x 1 x 8	60	К	003100 20910
20 x 1 x 12	100	К	003103 02177
	120	М	003100 64512
20 x 1-1/2 x 12	80	К	003103 02221
	100	K	003103 02222
20 x 2 x 8	80	K	003100 20918
	100	K	003100 20920
	120	М	003100 64252
20 x 3 x 8	80	K	003104 25116
20 x 3 x 12	80	K	003104 25117
20 x 6 x 12	80	K	003100 20965
24 x 1 x 8	80	K	003100 21884
24 x 1 x 12	60	K	003100 20921
	80	М	003100 20923
24 x 1-1/4 x 12	60	М	003103 02224
24 x 1-1/2 x 8	80	K	003103 02223
24 x 1-1/2 x 12	80	K	003103 02225
	80	Μ	003103 02226
24 x 2 x 8	80	K	003100 21885
24 x 2 x 12	60	К	003100 20924
	80		003100 20926
24 x 3 x 8	80	К	003100 21757
24 x 5 x 12	60	L	003103 02227
24 x 6 x 12	60	К	003100 20968
24 x 10 x 12	80	К	003100 20972
42 x 1-1/2 x 12	60	М	003100 20931

There are many finished sizes and specifications available. Contact your local Norton distributor or salesperson with your size and specification requirements for quantity guidelines, quotations and helpful ordering instructions.

Please note "2-week delivery request" if needed, on your order.



PRECISION GRINDING WHEELS Gear Wheel Blank Stock



Key Program Features

Standard lead time:

- Alteration Parameters:
- » 2 weeks
- Allefalloff Paralifieters:
 Diameter may be altered to 2" s
- » Diameter may be altered to 2" smaller than the original blank stock diameter
 » Thickness may be altered to 1/2 the original blank stock thickness
- Best choice for versatility, highest productivity, and lowest total cost

QUANTUM X CERAMIC ALUMINA AND VORTEX ALUMINUM OXIDE BLEND

- Leading Norton technologies produce the most free-cutting gear wheels: patented pore-induced construction, Norton Quantum X ceramic alumina and Vortex aluminum oxide abrasive blend, and strong Norton bond
- · Best MRR (metal removal rate) versus all other ceramic gear wheels; reduce grinding cycle times up to 50%, best choice for grinding from solid
- Versatile; for all low-, medium- and high-force applications on hard-to-grind Inconel, titanium, and aerospace alloys; excel on large area of contact applications with exceptional form and corner-holding; 20+% less power draw

Excellent choice for the most demanding operations

TARGA TG, 3TG, 5TG CERAMIC ALUMINA

- . The unique elongated shape of our second generation Norton seeded gel ceramic alumina abrasive offers exceptional durability for the most demanding applications and materials
- · Consider Targa (TG) when your requirements for SG have been exceeded
- VS3G Vitrium³ bond is the newest, strongest bond in the Norton portfolio: patented pore-induced construction; for all low-, medium- and high-force applications; excels on hard-to-grind aerospace alloys and large areas of contact; exceptional form and corner-holding

Excellent choice for high productivity, low total per-part grinding cost

SG CERAMIC ALUMINA

- High-performance seeded gel ceramic aluminum oxide abrasive provides fast stock removal, cool, superior cutting, and 3X 5X more life than aluminum oxide wheels, and double
 rough stock removal rate versus conventional abrasives
- · Self-sharpening abrasive for less burn, less dressing; very consistent performing wheel
- 5SG durable Norton SG and aluminum oxide blend blue, for high stock removal rates, excellent productivity, long wheel life, low overall grinding cost; versatile, high-performance VS and VSP bonds provide exceptional form holding

Better choice for versatile, consistent performance

86A ALUMINUM OXIDE

- · Sharper aluminum oxide abrasive for cooler cutting
- VS3G Vitrium3 bond is the newest, strongest bond in the Norton portfolio: patented pore-induced construction; for all low-, medium- and high-force applications
- · Excels on hard-to-grind aerospace alloys and large areas of contact; exceptional form and corner-holding



PRECISION GRINDING WHEELS Gear Wheel Blank Stock

	TIER:	BEST		BEST		BETTER	
	TRADENAME:	NORTON QUANTUM X: Norton quantum: NQN, NQ, 3NQ, 5NQ VS3G = VITRIUM ³ Bo		NORTON SEEDED GEL: 3tgp, Sg, 5sg VS3g = Vitrium ³ Boi	ND	86A, 25A, X25A VS3G = Vitrium ³ Bo	ND
	ABRASIVE:	Ceramic Alumina Unfinished Blank Stock		Ceramic Alumina Unfinished Blank Stock		86A, 25A, X25A – Alum Blank Stock	inum Oxide Unfinished
SIZE (D x T x H)		SPEC.	BLANK PART #	SPEC.	BLANK PART #	SPEC.	BLANK PART #
Type 01 Straight							
Worm Profile Whe							
275mm x 125mm x 1	60mm					86A100/5-I10VTX2	003104 58402
275mm x 160mm x 1						86A90-J10VS3G	003104 86397
300mm x 125mm x 1	60mm	3NQ90-J10VH	003103 94338			86A100/5-J10VTX2	003104 58405
		3NQ90-J10VS3G	003105 17379			86A100/5-I10VTX2	003104 58404
300mm x 160mm x 1	60mm					86A120-J10VS3G	003104 86983
		1NQNR90-J10VS3PN	003105 78192				
		1NQNR120-J10VS3PN	003105 78193				
						86A90-J10VS3PN	003105 78172
						86A120-J10VS3PN	003105 78191
350mm x 125mm x 1						25A90-H10VS3G	003104 48496
Single Rib Wheels							
120mm x 30mm x 20		5NQX100-G20VTX2	003104 90920	3TGP80/3-G12VS3G	003104 48502		
300mm x 30mm x 50		5NQX60-G20VTX2	003104 90863	3TGP80/3-G12VS3G	003104 48501		
300mm x 60mm x 50		5NQX60-G20VTX2	003104 90864	3TGP80/3-G12VS3G	003104 48500		
400mm x 60mm x 12		5NQX60-G20VTX2	003104 90865				
400mm x 75mm x 12				3TGP60-G20VSPF	003104 04597		
400mm x 100mm x 1		5NQX60-G20VTX2	003104 90916	3TGP60-G20VSPF	003104 04598		
400mm x 150mm x 1		5NQX60-G20VTX2	003104 90917				
450mm x 50mm x 12				3TGP80/3-G12VS3G	003104 48499		
450mm x 60mm x 12		5NQX60-G20VTX2	003104 90918				
450mm x 100mm x 1		5NQX60-G20VTX2	003104 90921	3TGP80/3-G12VS3G	003104 48498		
450mm x 150mm x 1	27mm	5NQX60-G20VTX2	003104 90919	3TGP80/3-G12VS3G	003104 48497		

	TIE	R: BEST	
	TRADENAN	E: NORTON SEEDED	GEL: TG, 5TG, 5SG
	ABRASIV	E: Ceramic Alumina U	nfinished Blank Stock
SIZE (D x T x RIM)	PLATE #	SPEC.	BLANK PART #
Type 02 Plate-Mounted	Cylinder		
4.100 x 3.000 x .700	A311220	5SG80-JVS	00310485214
8.400 x 3.500 x 1.050	A311384	5SG80-JVS	003104 85228
		TG280-H12V-X575	003104 85229
8.346 x 3.500 x 1.043	A311384	5TG80-3-J8VH	003104 80245

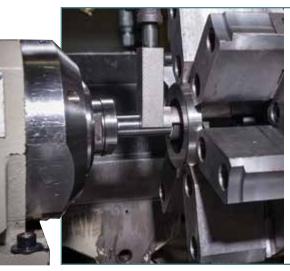
Gear blank stock alteration orders must include complete blueprint information.

Please ask your Norton representative for appropriate blueprint worksheet to fill in:

- Worm wheel blueprint worksheet: ME161508
- Single rib wheel blueprint worksheet: ME161178



PRECISION GRINDING WHEELS ID, Race and Superfinishing Wheels and Sticks



The most extensive line of Pressed-To-Size ID and Race wheels to choose from to maximize performance and cost savings.

In addition to VFL wheels, VS3L-bonded wheels are also available. VS3L is the Vitrium3 high-strength, cool-cutting bond with improved cutting efficiency, productivity, and wheel life. VFL and VS3L wheels are the fastest way to get Make-to-Order Norton ID and Race Grinding wheels. Norton VFL and VS3L wheels are available in both ceramic abrasives and conventional aluminum oxide abrasives in diameters up to 5".

Additional dimensions and grinding faces are available as made-to-order products with 4-week lead-times.

Wheel Types: Abrasive Types: Type 01 and 05 Ceramic Alumina, Aluminum Oxide

ID and Race Wheels

ID and Race Wheel FastTrack Availability

Type 01 Straight		For more program details, ask your
Diameter: 0.172" thru 4.532"	Maximum thickness: 3.75"	Norton sales representative to review
Type 05 Recessed One Side		the FirstLine VFL & VS3L ID and Race
Diameter: 0.407" thru 5"	Maximum thickness: 3.10"	Wheels Brochure #6981 with you.

VFL Availability

ABRASIVE	25A, 32A, 38A, 48A, 53A, 57A, 86A	5TG*	1SG, 3SG, 5SG	32AA	NQN, 1NQN, 3NQN, 5NQN, 1NQNP, 3NQNP, 5NQNP, 1NQNM, 3NQNM, 5NQNM
GRIT	54 - 120	80/1, 120/1	54-120	54-80	54-150
GRADE	J - P	I - M	I – N	I - M	I - N
STRUCTURE	6 (Not Shown)				
BOND	VFL				
WHEEL TYPES	01, 05				
SHAPES	Special faces not available				
SPEED	8,500 SFPM***				
TREAT 22	Not Available				
* 5TG is available in /1	combination, only				

**Speeds up to 12,500 SFPM by request and Safety approval

VS3L Availability

SHAPES

SPEED

ABRASIVE	25A, 32A, 38A, 55A, 86A	5TG*	1SG, 3SG, 5SG	NQN, 1NQN, 3NQN, 5NQN, 1NQNP, 3NQNP, 5NQNP, 1NQNM, 3NQNM, 5NQNM
GRIT	54-120	80/1, 120/1	54-120	54-150
GRADE	H - P	I - K	I - N	I - N
STRUCTURE	8, 10	8	8, 10	8, 10
BOND	VS3L			
WHEEL TYPES	01, 05			

TREAT 22 Not Available

* 5TG is available in /1 combination, only

** Speeds up to 12,500 SFPM by request and Safety approval

Dimensional Tolerances

IF DIAMETER IS:	DIAMETER	THICKNESS	HOLE
0.532" and less	+/003"	+.004"000	+.001" +.006"
> 0.532" - 2.907"	+/005"	+/005"	+.001" +.006"
> 2.907" - 4.407"	+/015"	+/015"	+.001" +.006"

Special faces not available 8,500 SFPM***





PRECISION GRINDING WHEELS ID, Race and Superfinishing Wheels and Sticks

Blank Stock FastTrack Made-to-Order Microabrasive Superfinishing Sticks



Superfinishing blank stock encompasses a wide range of different specifications. These blanks can be finished to your dimensional requirements within two weeks from the date that the order is received at Norton Customer Service. Small lots, for test purposes, can be express shipped.

APPLICATIONS	ABRASIVE TYPE – BOND	GRIT RANGE	TREATMENT TYPE
Superfinishing / Finishing	NLA – V	240 - 1200	Sulfur, Wax
	NMVC – VCA		
	NSA – V		
Honing	SG – VS	54 - 220	
	SGG – VS1		

Rubber Finishing Sticks

These sticks are used for manual or mechanical honing on machines where they are mounted in holders or fixtures. Intended for use where precision dimensional limits and grade controls are required, such as die polishing.

		and the second
STD. PKG./CASE	SPEC.	PART #
Sticks		
5/20	57A120-B2RR	614636 10608
5/20	57A120-B2RR	614636 10609
	Sticks 5/20	5/20 57A120-B2RR

Dressing Solutions

our dressing tools **MAKE THE PERFECT POINT**

The Norton Winter full line of expertly-crafted stationary and rotary dressing tools - whether stock or custom-engineered delivers your every application need. And, our expert resetting and relapping services renew used tools to reduce your "cost per dress".

NORTON



DRESSING SOLUTIONS **Diamond Stationary Dressing Tools**

Our Norton Winter offering is the industry's most comprehensive line of stock and made-to-order products to true (restore the wheel's profile) and dress (opening - to remove stock - or closing to finish) the face of the wheel. In addition to these catalog stock stationary tools, Norton Winter manufactures a full line of custom stationary tools, rotary diamond dressers and truing/dressing devices to meet all your specific application needs.

Applications: Tool Types:

Truing and dressing conventional and superabrasive wheels, straight, step, radius and form dressing

Stationary: Single Point, Toolroom, Multi-Point, Blade, Form, and Cluster Tools, and Truing Devices

Rotary: Reverse Plated and Infiltrated Form Plunge Diamond Rolls, Diamond CNC Traversing Discs, and Dressing Spindles

Determining the Best Value

Remember that diamonds are a rare commodity-the larger the stone and the better the quality, the higher the initial cost. The key to successful diamond tool productivity and use is based on the "cost per dress." Normally, higher quality diamonds and a proactive resetting program will result in the lowest "cost per dress." In those situations where a resetting program is not feasible or low initial cost is the primary purchasing consideration, Norton Winter offers a complete line of non-resettable tools.

Resetting Your Used Diamond Tools

Resetting - Minimizing Your Cost

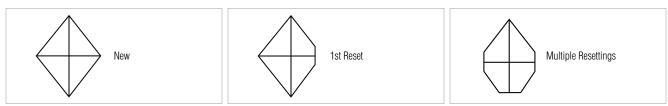
Buving a higher quality diamond is your best value, especially if you participate in a proactive resetting program. Although initial cost may be higher, the payback comes through several factors:

- Diamond durability, providing longer tool life
- Tighter form tolerances
- Consistent finish rates
- · Resetting the diamond lowers the overall tooling cost

Used properly, the overall cost of a higher quality, resettable diamond will compare favorably with that of an inexpensive, non-resettable diamond. Initially, the best diamond point is selected for use. When returned, the next best diamond point is selected for resetting, and so on.

To ensure you get the best value for your diamond:

- · Rotate the diamond tool ¼ turn periodically to maintain a sharp point
- Use proper flow of coolant to protect the diamond from heat which can create fracturing of the diamond
- · Excessive wear on the diamond point may impact the ability to reset the diamond. The widest point of the diamond is referred to as the girth. The diamond girth is buried in a powder metal matrix. Using a diamond into the girth zone might impact the ability to reset other diamond points



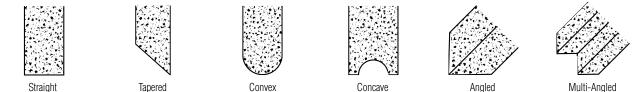
TECH TIP

Selecting the Correct Diamond Tool

To determine the type of dressing tool to use, it is best to think about the desired shape of the wheel face. Finished wheel face shapes are generally categorized into six types, as illustrated below.

Typical Wheel Forms Dressed by Stationary Diamond Tools

Look for the applicable wheel forms beside each product type to help you choose the correct product for your application.



Convex







NDRTDN

SAINT-GOBAIN

Single Point Tools

Our Norton Winter line of single point tools is used in straight and simple form dressing applications. It includes: resettable and non-resettable products, tools for all abrasive types (conventional and advanced ceramic grains) and the technology-leading "Indexable" tool design.

Wheel Forms Dressed by These Tools

TAPERED





SPEC CHECK

Selection Guide

Stock Tools for Ceramic Abrasive Wheels

SG/Ceramic	Engineered for use on ceramic (SG, NQ, Targa, etc.) wheels but may also provide significant benefits when used on conventional abrasive products. These tools are furnished with top quality specially selected diamonds.
BCSG/Ceramic	Economical alternative to an "SG" tool. Best choice when a disposable tool is preferred.

Stock Tools for Conventional Abrasive Wheels

- NS Engineered for use on conventional abrasives. These high quality, value-priced tools can be used for a variety of dressing applications.
- BC Economical alternative to an "NS" tool. Best choice when a disposable tool is preferred.

Selecting the Correct Single Point Tool:

- Identify the wheel abrasive type: aluminum oxide, silicon carbide, or ceramic
- · Determine the wheel diameter to select the optimum carat weight
- · Determine the tool holder size to select appropriate shank diameter

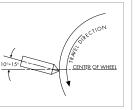
Examples of Single Point Tool Selection

Conventional Wheel Spec:	32A46-IVBE 7" x 1/2" x 1-1/4"			
	Machine has a 7/16	6" tool holder		
Tool Selections:	Resettable:	NS2M7 or NSUD2 (Indexable)		
	Non-Resettable:	BC2M7 or BCUD2 (Indexable)		
Ceramic Wheel Spec:	5SG60-JVS or 5NQ60-IVS 10" x 1" x 3"			
	Machine has a 3/8" tool holder			
Tool Selections:	Resettable:	SG3M6		
	Non-Resettable:	BCSG3M6		

TECH TIP

- Rigidly mount single point tools at a 10° 15° angle to the wheel centerline with a line drawn through the center of the wheel, pointing in the direction of wheel travel
- Point of contact should be slightly below centerline of wheel as shown
- Use coolant whenever possible
- Normal infeed is .001" per pass
- Lead selections range from .002" .010" per wheel revolution
- Rotate the tool 1/4 turn periodically to maintain a sharp point

To optimize applications using ceramic abrasives and/or tools, normal dressing parameters must change. Reduce infeed by 25%. Significant reductions in the amount of infeed and frequency of dress will result in substantially lower cost per part ground.



Single Point Dress Traverse Rate

Select a Lead Value based on desired Surface Finish and run the formula below.

Finish	Lead Value (Per Wheel Revolutions)
For Coarse Finish (approx. 64 RMS)	.008" to .010"
For Medium Finish (approx. 32 RMS)	.005" to .009"
For Fine Finish (approx. 16 RMS)	.002" to .004"

Lead Value x Wheel Speed (RPM) = Traverse Rate in Inches/Minute

- Slower traverse rates result in a closed wheel face and lower surface finish readings on the workpiece.
- Faster traverse rates result in an open wheel face that produces greater stock removal and a rougher workpiece finish.

It is the user's responsibility to refer to and comply with ANSI B7.1



Single Point Tools for Truing/Dressing Ceramic Abrasives



SINGLE POINT TOOLS FOR SG/CERAMIC

- Specially selected broad-shaped, diamond withstands the increased grinding pressures of ceramic abrasives
- · Each diamond is hand selected for stone shape, quality and structural integrity for consistent tool performance
- Multi-purpose can accommodate most straight dressing and simple form dressing applications; stands up to the sharpness of ceramic abrasives (SG, Quantum, Targa, etc.) but can also be used to dress conventional abrasives

Resettable Single Point Tools for SG/Ceramic

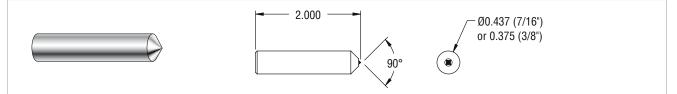
· High quality diamond and a proactive resetting program will result in the lowest dressing cost per part for ceramic abrasives

Non-Resettable Single Point Tools for BCSG/Ceramic

• The best selection for ceramic abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration

			TIER	BEST		GOOD		Wheel Form	e Droccod b	M.
WHEEL DIAMETER	TOOL Carat Weight	TOOL Diameter	TOOL Length	PRODUCT #	3 SETTABLE PTS (2 RESETS) PART #	PRODUCT #	NON-RESETTABLE Part #	These Tools		
Stock Singl	le Point Tools for	Truing/Dress	ing Ceram	ic Abrasives						
Up to 7"	1/4 (.25)	3/8"	2"	SG2M6	662601 95365	BCSG2M6	662601 57007		3.03	
		7/16"	2"	SG2M7	662601 95366	BCSG2M7	662601 56905	-		
8" to 10"	1/3 (.33)	3/8"	2"	SG3M6		BCSG3M6	662601 57008		X.	
		7/16"	2"	SG3M7	662601 95368	BCSG3M7	662601 56906			
11" to 14"	1/2 (.50)	3/8"	2"	SG5M6	662601 95369	BCSG5M6	662601 57009	STRAIGHT	TAPERED	CONVEX
		7/16"	2"	SG5M7	662601 95370	CSG5M7	662601 56907			
15" to 20"	3/4 (.75)	7/16"	2"	SG7M7	662601 95372	BCSG7M	662601 56908			
21"+	1 (1.00)	7/16"	2"			BCSG10M7	662601 57010			

Standard Package = 1 tool



TECH TIP Stock Single Point Tool Marking System **Diamond Quality Diamond Size Shank Diameter** Shank Design SG/Ceramic 1 = 1/5 (.20) carat 6 = 3/8" М BCSG/Ceramic 2 = 1/4 (.25) carat J 7 = 7/16" 3 = 1/3 (.33) carat NS BC 5 = 1/2 (.50) carat 7 = 3/4 (.75) carat 10 = 1 carat Example: NS 2 M 6 SHANK J SHANK M



Single Point Tools for Truing/Dressing Conventional Abrasives



SINGLE POINT TOOLS FOR CONVENTIONAL ABRASIVES

- Consistent diamond structure and shape for repeatable dressing performance on conventional abrasives
- · Well defined, sharp, durable diamond point offers maximum cost effectiveness
- Steeper 60 degree angle head design allows for greater machine and part clearance to produce forms with tighter tolerances

Resettable NS (Norton Standard) Single Point Tools

 Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds

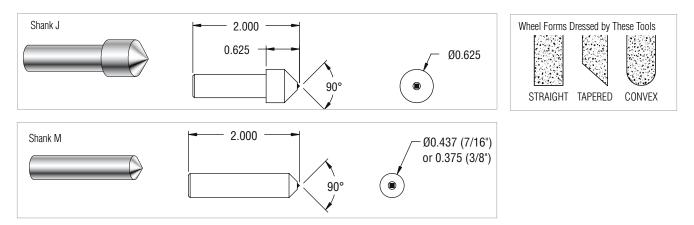
Non-resettable BC Single Point Tools

• The best selection for conventional abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration

		TIER:	BETTER		GOOD	
		TRADENAME:	NS (NORTON STANDARD)		BC	
WHEEL Diameter	TOOL Carat Weight	TOOL DIAMETER	PRODUCT #	2 SETTABLE PTS (1 RESET) PART #	PRODUCT #	NON RESETTABLE PART #
		Pressing Conventional		(1 11-0-1) 1 1111 #		
Internal Wheel	1/5 (.20)	3/8"			BC1M6	662601 95021
		7/16"			BC1M7	662601 95022
Up to 7"	1/4 (.25)	3/8"	NS2M6	662601 95116	BC2M6	662601 95000
		7/16"	NS2M7	662601 95117	BC2M7	662601 95001
8" to 10"	1/3 (.33)	3/8"	NS3M6	662601 95121	BC3M6	662601 95002
		7/16"	NS3M7	662601 95122	BC3M7	662601 95003
11" to 14"	1/2 (.50)	3/8"	NS5M6	662601 95126	BC5M6	662601 95004
		7/16"	NS5M7	662601 95127	BC5M7	662601 95005
15" to 20"	3/4 (.75)	3/8"			BC7M6	662601 95006
		7/16"	NS7M7	662601 95132	BC7M7	662601 95007
		7/16"	NS7J7*	662601 95130 NS		
21" + 1 (1.00)	1 (1.00)	3/8"			BC10M6	662601 95008
		7/16"	NS10M7	662601 95137	BC10M7	662601 95009
		7/16"	NS10J7 *	662601 95135		

* J-shank tools are available in 7/16" diameter with 5/8" head. Standard Package = one tool

NS Non-Stock: Please contact your Norton representative for current lead-times.





DRESSING SOLUTIONS Single Point Tools

Indexable Single Point Tools

Indexable tools are specifically designed to alleviate any misalignment issues and are the tools of choice for CNC grinders. They feature a two-part construction with the head and shank as separate pieces. After the initial installation, operators simply turn the indexable head with a wrench, while the tool shank remains secure (and aligned) in the tool holder.



INDEXABLE SINGLE POINT TOOLS

- These indexable tools are easily turned without having to remove the tool from the holder, making it easier to turn than conventional tools and increasing frequency of beneficial tool turning
- U-Dex-It and Mini-Dex tools have a 60° included angle head design providing additional form versatility through better machine and part clearance
- · Offers an excellent choice for regulating wheels

Indexable Single Point Tools for Truing/Dressing Conventional Abrasives

Resettable NS (Norton Standard) Indexable Single Point Tools

- Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard

Resettable NS (Norton Standard) Mini-Dex Indexable Single Point Tools

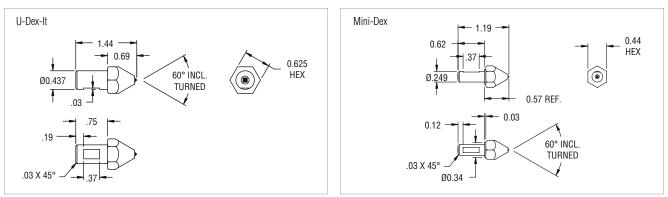
- Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds
- Use a standard 7/16" wrench to turn; designed for internal, bearing race, and twist drill flute machines

Non-Resettable Indexable Single Point Tools

- . The best selection for conventional abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard

		T	<i>IER:</i> BETTER		GOOD	
WHEEL DIAMETER	TOOL CARAT WEIGHT	TOOL SIZE	PRODUCT #	2 SETTABLE PTS (1 RESET) PART #	PRODUCT #	NON-RESETTABLE PART #
Stock Indexable	Single Point Tools for	r Truing/Dressing Conventi	onal Abrasives			
Up to 7"	1/4 (.25)	7/16" x 1-7/16" with 5/8" hea	ıd		BCUD2	662601 95023
		1/4" x 1-3/16" with 7/16" hea	d NSMD2	662601 95171		
8" to 10"	1/3 (.33)	7/16" x 1-7/16" with 5/8" hea	d NSUD3	662601 95162		
11" to 14"	1/2 (.50)	7/16" x 1-7/16" with 5/8" hea	d NSUD5	662601 95163	BCUD5	662601 95025
15" to 20"	3/4 (.75)	7/16" x 1-7/16" with 5/8" hea	d NSUD7	662601 95164		
Ctandard Daakaga	ana taal					

Standard Package = one tool



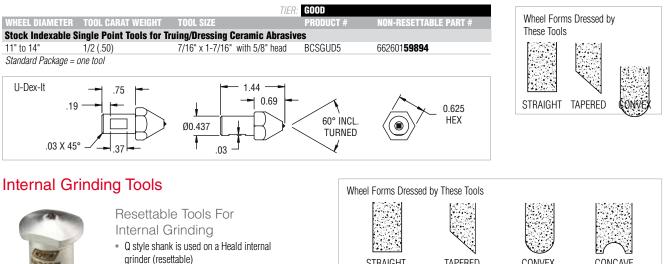


DRESSING SOLUTIONS Single Point Tools

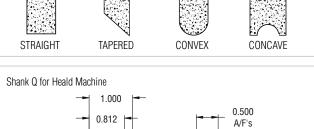
Indexable Single Point Tools for Truing / Dressing Ceramic Abrasives

Non-Resettable Ceramic Indexable Single Point Tools

- U-Dex-It BCSG tool contain specially selected diamonds to withstand increased ceramic (SG, Quantum, Targa, etc.) grinding pressures
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard
- . The best selection when a resetting program is not feasible or low initial cost is the primary purchasing consideration



			TIER:	BEST	
MACHINE Type	CARAT WEIGHT	SHANK Diameter	TOOL Length	PRODUCT #	2 SETTABLE PTS (1 RESET) PART #
Stock Inter	rnal Grindin	ig Tools			
Heald	1/5 (.20)	7/16"	1"	NI21Q7	662601 95180
Standard Pa	ckage = 1 Too	ol			



Thread Grinding Tools



Thread Grinding Tools For SG / Ceramic Abrasives

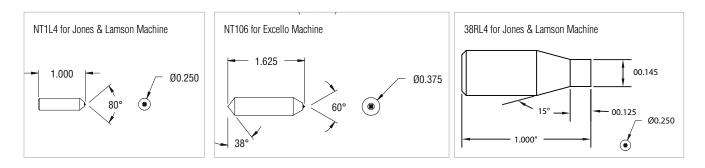
. These wheels are used on J & L and Excello thread grinding machines to accurately dress the grinding wheels that form the desired thread configuration (non-resettable)

20°

Ø0.437

				TIER	BEST		Wheel Forme Dree	ad by
MACHINE Type	SHANK DIAMETER	TOOL Length	INCLUDED ANGLE	MAX. RADIUS ON POINT	S Product #	NON-RESETTABLE Part #	Wheel Forms Dress These Tools	
Stock Threa	d Grinding Tool	s						
J&L	1/4"	1"			38RL4*	662601 95100		
J&L	1/4"	1"	80°	.010"	NT1L4	662601 95187		
EXCELLO	3/8"	1-5/8"	60°	.010"	NT106	662601 95190		×.
	nulti-point (grit) 3 skago – 1 Tool	0 - 40 mesh tool					STRAIGHT	TAPERED

Standard Package = 1 Tool



Ø0.625





Toolroom Tools

Norton Winter Toolroom Dressing Tools are primarily used on surface grinders to form the grinding wheel to an exact concave or convex radius. Although some tools are designed for use on a specific machine, many radius tools can be used on any grinder having the correct set-up.

Used generally on 8" diameter and smaller vitrified toolroom wheels, our Norton Winter offering includes phono-point, conventional radius, and full ball radius tools.

Wheel Forms Dressed by These Tools





Phono-Point Tools



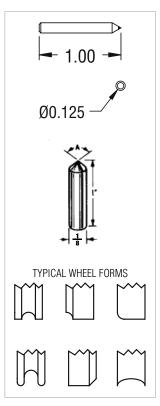
- Non-Resettable Phono-Point Tools
- · For general toolroom concave and convex dressing on small diameter grinding wheels

		TIEF	R: BETTER		GOOD	
INCLUDED Angle	SHANK DIAMETER	TOOL Length	PRODUCT #	NON-RESETTABLE PART #	PRODUCT #	NON-RESETTABLE Part #
Stock Phone	o-Point Tools					
60°	1/8"	1"	NP1M2	662601 95225	BCPP-60	662601 95017
	3/16"	1"	NP1M3	662601 95226		
	1/4"	1"	NP1M4	662601 95227		
75°	1/8"	1"	NP2M2	662601 95228	BCPP-75	662601 95018
	1/4"	1"	NP2M4	662601 95230		
90°	1/8"	1"	NP3M2	662601 95231	BCPP-90	662601 95019
	3/16"	1"	NP3M3	662601 95232		
	1/4"	1"	NP3M4	662601 95233		

Standard Package = one tool

These Tools	Phono-Point Tool Marking System					
	Diamond Type	Included Angle On Diamond	Shank Style	Shank Diameter		
	NP	1 = 60°	Μ	2 = 1/8"		
CONVEX	BCPP	2 = 75°		3 = 3/16"		
\sim	Example: N	p 1 m 3 H TIP				
CONCAVE	 We recomm 	Use Toolroom To nend dressing with coolant e seconds between passes	t. However, if dressing to	otally dry, allow		
	 Use extrem 	nely light cuts from .0002" t	to .001" maximum.			
	 Rotate tool 	if the application and set-u	ip allow.			

• Custom Full Ball Radius Tools should be returned for relap after minimum wear.





Radius Tools

Concave Radius Tools

• This line offers a specially-shaped single point diamond, designed for forming concave radii on small diameter grinding wheels; not resettable.

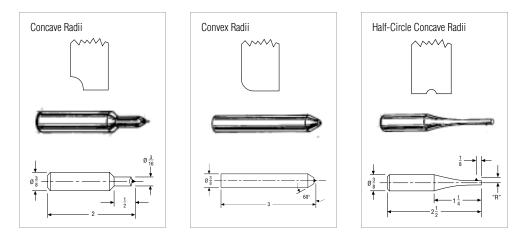
Convex Radius Tools

• This line offers a specially-shaped single point diamond, designed for forming convex radii on small diameter grinding wheels; not resettable.

- Half-Circle Concave Radius Tools (Available as Non-stock Only)
- This line offers a specially-shaped diamond set in the side of the shank for forming half-circle radii on small diameter grinding wheels.
- The tool is rotated to form the radius. Commonly called a "rat tail dresser"; not resettable.

		TIER:	BEST		GOOD	
RADIUS SIZE To be dressed	SHANK Diameter	TOOL LENGTH	PRODUCT #	NON-RESETTABLE Part #	PRODUCT #	NON-RESETTABLE Part #
Stock Concave R	adius Tools					
.010" to .015"	3/8"	2"	NR1P6	662601 95210		
.016" to .020"	3/8"	2"	NR2P6	662601 95211		
.021" to .032"	3/8"	2"	NR3P6	662601 95212		
.033" to .062"	3/8"	2"	NR4P6	662601 95213	BCRD	662601 95016
.063" to .125"	3/8"	2"	NR5P6	662601 95214	BCRD	662601 95016
.126" to .250"	3/8"	2"	NR6P6	662601 95215	BCRD	662601 95016
Stock Convex Ra	dius Tools					
.020" to .125"	3/8"	2"	NR2M6	662601 95216		
.126" to .250"	3/8"	2"	NR12M6	662601 95217		

Standard Package = one tool



Full-Ball Radius Tools for precision plunge form dressing of concave radii in the center of a grinding wheel are available made to your custom requirements. Ask your Norton representative for details.



DRESSING SOLUTIONS Multi-Point (Grit) Tools



Multi-Point (Grit) Tools

Since Norton Winter conventional and high-performance Multi-Point tools never need turning or resetting, they are the most economical way to accomplish a variety of straight, tapered, and step dressing operations on all sizes of cylindrical, centerless, surface, and toolroom grinding wheel applications.

Examples of Multi-Point Tool Selection

Conventional Wheel Spec:

Tool Selection:

Tool Selections:

Ceramic Wheel Spec:

Wheel Forms Dressed by These Tools



STRAIGHT TAPERED

SPEC CHECK

Selection Guide

- Identify the wheel abrasive type: ceramic (SG, Quantum, Targa), aluminum oxide, or silicon carbide
- Determine the wheel diameter and grit size
- · Determine the tool's approach angle to the centerline of the wheel
- Identify the tool holder diameter
- Use 1E shape for angular wheel slide, cylindrical grinding and for shoulder or step truing

TECH TIP

Multi-Point Tools – Straight Face Dressing and Truing

- · Most multi-point tools are used for straight face dressing
- Tool should have full face contact with the wheel
- With new tool, 3–5 passes at .005" per pass should be taken to expose diamonds
- Infeed per pass .001" .002"
- Use coolant whenever possible
- Use appropriate lead (and traverse rate)
- Contact your Norton representative for proper tool selection for Targa wheels

TOP VIEW

Multi-Point Dress Traverse Rate

Select a Lead Value based on desired Surface Finish and run the formula below.

1R6J6

SG1R6J7

FINISH	LEAD VALUE (PER WHEEL REVOLUTIONS)
For Coarse Finish (approx. 64 RMS)	.023" to .030" (.58mm – .76mm)
For Medium Finish (approx. 32 RMS)	.013" to .022" (.33mm – .57mm)
For Fine Finish (approx. 16 RMS)	.006" to .012" (.15mm – .33mm)

32A46-IVBE 7" x 1/2" x 1-1/4"

Machine has a 3/8" tool holder

Machine has a 7/16" tool holder

5SG60-JVS or 5NQ60-IVS 10" x 1" x 3"

Lead Value x Wheel Speed (RPM) = Traverse Rate in Inches/Minute

- Slower traverse rates result in a closed wheel face that produces less stock removal and improved workpiece finish.
- Faster traverse rates result in an open wheel face that produces greater stock removal and a rougher workpiece finish.

It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Optimizing SG Multi-Point Tool Performance

- To optimize applications using ceramic abrasives/tools, normal dressing parameters must change. Significant reductions in the amount of infeed and frequency of dress will
 result in significantly lower cost per part ground.
- While all SG/Ceramic tools have been designed to improve the efficiency of ceramic grinding applications, they can also offer significant benefits in many applications using conventional abrasives.
- When first using a SG/Ceramic tool, make 3 to 5 passes at .005" infeed to ensure full face contact between the dressing tool and wheel face.
- Reduce normal dressing infeed by half. Do not exceed infeed of .002" per pass.
- The lead selection should be between .006"-.030" per wheel revolution. Faster traverse with a SG/Ceramic tool generally provides an open wheel face that can maximize productivity of the ceramic abrasive.



Multi-Point Tool Marking System

Tool Diamond

=

=

Size

4

6

8

12

14

Example: 1A 6 A 7

DRESSING SOLUTIONS Multi-Point (Grit) Tools

TECH TIP

Diamond

Shape

1A

2A

3A

1E

2E

1R

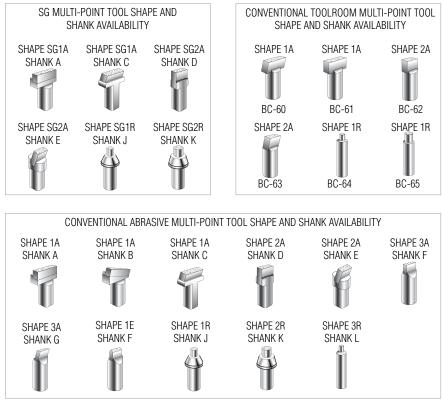
2R

SHAPE	WIDTH	LENGTH	DEPTH	TOOL APPROACH Angle to wheel	FOR WHEEL DIAMETER
1A	1/4"	3/4"	5/16"	0°	Over 20"
2A	1/4"	1/2"	3/8"	0°	15" – 20"
3A	5/32"	3/8"	1/4"	0°	Over 20"
1E	5/32"	3/8"	5/16"	-	
2E	1/4"	1/2"	1/2"	_	20" x 2" and up
1R	1/4" Round		1/4"	0°	Up to 10"
2R	3/8" Round		3/8"	0°	11" – 14"



To Dress Grinding Wheels With Grit Size Of:	Shank Design	Shank Diameter	\square	Shape A is used primarily for straight
46 grit 54 - 100 arit	See the following pages for shank configurations	6 = 3/8" 7 = 7/16"	Ū/	face dressing.
120 - 150 grit 150+ grit Special Applications		8 = 1/2"		Shape E (double angle top face) lis used for standard N-Face wheels, angular wheels, face and side truing of cylindrical wheels, and in step dressing.
			9	Shape R is used for straight face dressing where the tool holder is perpendicular to the wheel face (no drag angle), and on thread grinding machines.

Multi-Point Tools for Straight Dressing



Shapes 3A (F and G Shanks) are used for form, shape, and step truing. Shape 1E is used for angle dressing





MULTI-POINT TOOLS

- · Uniformly distributed diamonds in a tough, durable matrix for consistent performance throughout tool life
- · Fresh, multiple diamond points exposed in truing operation; no turning or resetting required for faster, more consistent straight face dressing and longer tool life than single point tools
- Overall diamond weight exceeds equivalent single point tool making this the most economical way to dress straight and tapered forms

Multi-Point Tools for Truing and Straight Dressing

Multi-Point Tools For SG/Ceramic Abrasives

- · Designed specifically for use on ceramic (SG, Quantum, Targa, etc.) abrasives, SG tools contain a higher diamond concentration to withstand the increased grinding pressures generated by the ceramic abrasives
- These tools have improved life and dress quality; they can also offer significant benefits in many applications when used on conventional abrasives

Standard Multi-Point Tools

· The ideal selection for use on conventional abrasives in high-production applications

BC Multi-Point Tools

· General-purpose tools ideal for conventional toolroom applications with a specially selected diamond size for a broad range of dressing applications

						_			
			TIER:	BEST		BETTER		GOOD	
			TRADENAME:	SG/CERAMI	C	STANDARD		BC	
		TOOL							
WHEEL	WHEEL	APPROACH	TOOL						
DIAMETER	GRIT SIZE	ANGLE	DIAMETER	PRODUCT #	PART #	PRODUCT #	PART #	PRODUCT #	PART #
Multi-Point	Tools for Stra	aight Dressing	3						
Up to 10"	54 to 100	0°	7/16"			1R6J7	662601 95088	BC64	662601 95014
		0°	3/8"			1R6J6	662601 95085		
1" to 14"	54 to 100	0°	7/16"	SG2R6K7	662601 95378	2R6K7	662601 95096	BC65	662601 95015
15" to 20"	54 to 100	0°	7/16"	SG2A6D7	662601 95375	2A6D7	662601 95046	BC62	662601 95012
		15°	7/16"	SG2A6E7	662601 95376	2A6E7	662601 95049	BC63	662601 95013
	120 to 150	0°	7/16"			2A8D7	662601 95047		
		15°	7/16"			2A8E7	662601 95050		
21" +	46	15°	7/16"			1A4C7	662601 95038		
	54 to 100	0°	7/16"	SG1A6A7	662601 95373	1A6A7	662601 95031	BC61	662601 95011
		15°	7/16"			1A6B7	662601 95035		
		15°	7/16"	SG1A6C7	662601 95374	1A6C7	662601 95039	BC60	662601 95010
	120 to 150	15°	7/16"			1A8C7	662601 95040		

Standard Package = one tool

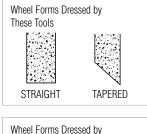
NS Non-Stock: Please contact your Norton representative for current lead-times.

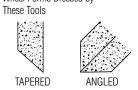
Multi-Point Tools for Form, Shape, or Step Dressing Conventional Abrasives

			TIE	R: BETTER			
WHEEL DIAMETER	WHEEL GRIT SIZE	TOOL Approach angle	TOOL DIAMETER	PRODUCT #	PART #		
Stock Multi-Point Tools for Form, Shape, and Step Dressing							
All	54 to 100	0°	7/16"	3A6F7	662601 95055		
		15°	7/16"	3A6G7	662601 95975		

Standard Package = one tool

			TIE	R: BETTER	
WHEEL DIAMETER	WHEEL GRIT SIZE	TOOL Approach angle	TOOL DIAMETER	PRODUCT #	PART #
Stock Multi-Poi	nt Tools for Ang	ular Dressing Conventio	nal Abrasives		
All	54 to 100	0°	7/16"	1E6F7	662601 95080
Standard Package	= one tool				







DRESSING SOLUTIONS High Performance Grit Tools



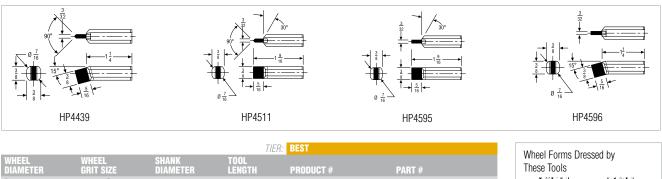
High Performance Grit Tools

Norton Winter High Performance grit tools are used in the same manner as multi-point tools, but are designed to produce a superior finish. They are used on 120 - 150 grit wheels. The traverse rates are equal to or faster than ordinary tools. Mounted on standard shanks, standard High Performance grit tools have a 3/8" wide by .100" thick diamond impregnated blade with a greater number of sharp points than in ordinary multi-point tools.

Since High Performance grit tools contain a higher concentration of diamond than found in standard multi-point tools, they are well suited for ceramic abrasive applications.

Typical Machines and Applications

- HP4439: cylindrical machines, grinding thrust walls, bearing diameters and multi-diameter shafts with radii
- · HP4511: angular machines plunge grinding multi-diameter shafts and plunge grinding on dual-wheel forms
- · HP4595: cylindrical machines grinding main bearing and lobes on camshafts
- HP4596: centerless machines step grinding and machines dual-wheel grinding transmission shafts



DIAMETER	GRIT SIZE	DIAMETER	LENGTH	PRODUCT #	PART #	These Tools
Stock High Pe	erformance Grit To	ols				
Up to 20"	120 to 150	7/16"	1-9/16"	HP4439	662601 95270	
Up to 20"	120 to 150	7/16"	1-9/16"	HP4511	662601 95271	
Up to 20"	120 to 150	7/16"	1-9/16"	HP4595	662601 95272	
Up to 20"	120 to 150	7/16"	1-9/16"	HP4596	662601 95273	
Standard Packa	ne – one tool					STRAIGHT

Standard Package = one tool

TAPERED

DRESSING SOLUTIONS Blade Tools



Blade Tools

With the choice of natural and synthetic diamond in three performance/price tiers, blade tools can meet all your angle, step, and radius dressing requirements for cylindrical, surface, and centerless grinding.

Wheel Forms Dressed by These Tools









Synthetic Blade Tools – For USB and Quantum

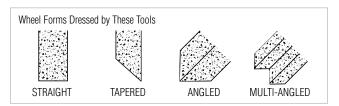
- Synthetic diamond with a controlled diamond shape provides a constant cross section of diamond to the wheel throughout the life of the tool
- Provides consistent wheel conditioning from the first dress to last; economical, long-lasting alternative to chisel-type tools for centerless form grinding
- USB (made-to-order) for dressing aluminum oxide wheels; Quantum (made-to-order) for dressing ceramics and silicon carbide wheels

Multi-Cut Blade Tools (Available in Stock and Made-To-Order)

- · Manufactured with top quality natural or processed elongated diamond
- · Customizable diamond type depending on wheel specification and application requirements
- Durable performing tools in a medium price range

		TIER:	BEST		BETTER	
		TRADENAME:	SYNTHETIC BL	ADE TOOLS	MULTI-CUT TO	OLS
WHEEL DIAMETER (WIDTH < = 9")	TOOL Approach angle	SHANK Diameter	PRODUCT #	PART #	PRODUCT #	PART #
Blade Tools						
12" to 17"	0°	7/16"	NQ20A7	079587 47944 NS		
	15°	7/16"	NQ215A7	079587 47945 NS	MC355	662601 95266
18" to 29"	0°	7/16"	NQ30A7	079587 47946 NS		
	15°	7/16"	NQ315A7	079587 47947 NS		
30" - 36"	0°	7/16"	NQ50A7	079587 47948 NS		
	15°	7/16"	NQ515A7	079587 47950 NS		

These stock tools are composed of 1 layer with 3 diamonds. These tools are not resettable or relappable. NS Non-Stock: Please contact your Norton representative for current lead-times. Standard Package = one tool





DRESSING SOLUTIONS Form Tools



Form Tools

Norton Winter Form Tools have diamond lapped to specific angles and radii required for a particular application, machine, contour dressing system, or CNC operation. Due to the high degree of accuracy necessary, the diamond is of special shape and quality.

Used tools can be relapped - the tip geometry can be restored on worn tools at a reduced cost.

Wheel Forms Dressed by These Tools





ANGLED

Jones & Lamson

• Hoglund

Dia-Form

Moore Pantograph



Ask your Norton representative for information on our

made-to-order form tools for the following machines:

TECH TIP

- How to Use Form Dressing Tools
- Proper centerline and light infeeds are essential to minimize side pressure. Excessive pressure will cause the diamond to fracture.
- Cone point tools should be rotated approximatley 1/4 turn daily.

Cone Point Tools

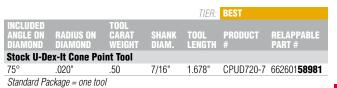


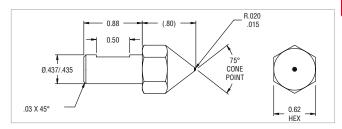
CONE POINT TOOLS

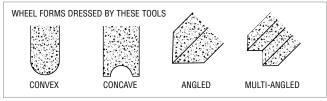
- Norton Winter vacuum braze technology used in the manufacturing surpasses all traditional diamond retention methods
- Absolute diamond retention, diamond pullout prevention during the dressing cycle, and longer tool life through multiple relaps
- Diamond is accurately coned to the specific included angle and radius making these tools ideal when the most intricate, precise forms and radii are required

U-Dex-It Cone Point Tool

- Used for precision dressing of intricate forms and radii
- Specially designed with 5/8" indexable head for easy turning during use
- These tools can be relapped







SPEC CHECK

Cone Point Tool Marking System

Tool Type	Included Angle On Diamond	Radius On Diamond	Carat Weight	Shank Diameter		
CP	6 = 60°	05 = .005"	L = .1015	6 = 3/8"		
	7 = 75°	10 = .010"	M = .2025	7 = 7/16"		
	$9 = 90^{\circ}$	15 = .015"	H = .33			
		20 = .020"	X = .50			
		25 = .025"				
		30 = .030"				
Exampl	Example: CP 6 10 M-6					

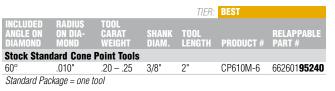


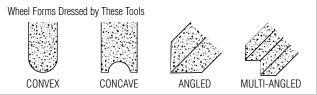
DRESSING SOLUTIONS Form Tools

Cone Point Tools

Standard Cone Point Tool

· These tools are used for precision dressing when the most intricate forms and radii are required; can be relapped





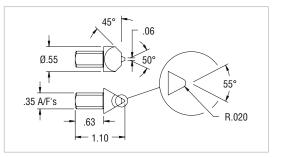


Chisel Point Tools

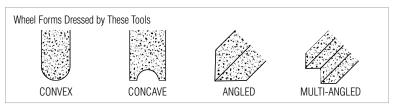
Chisel Point Tool for Toyoda Grinders

- · High-precision chisel point tool designed for forming intricate shapes and radii
- Specifically engineered to fit Toyoda machine series GL32 and GL4, it can also be used on various straight and angle-head grinders - for dressing conventional and ceramic abrasive wheels, sizes 12" to 24"
- · This tool can be reset/relapped

				TIER:	BEST	
INCLUDED ANGLE On Diamond	RADIUS ON Diamond	TOOL CARAT WEIGHT	SHANK Diam.	TOOL Length	PRODUCT #	RELAPPABLE PART #
Stock Chisel Point	t Tool					
55°	.020"	.75	7/16"	1.10"	CHT520-7	662601 03741
Standard Package = 0	one tool					



2



SPEC CHECK

Chisel Point Tool Marking System

Tool Type	Included Angle On Diamond	Radius On Diamond	Carat Weight	Shank Diameter
СН	6 = 60°	05 = .005"	L = .1015	6 = 3/8"
(Natural	7 = 75°	10 = .010"	M = .2025	7 = 7/16"
Diamond)	$9 = 90^{\circ}$	15 = .015"	H = .33	
		20 = .020"	X = .50	
		25 = .025"		
		30 = .030"		
Example: CH	9 5 M-6			

TECH TIP

3 Ø

8

Chisel Point Tools Chisel Point Tools should be rotated 180° when dulling or contour problems occur.





NDRTON

SAINT-GOBAIN

Cluster Tools

Norton Winter Cluster tools are designed specifically for straight face dressing of large diameter, coarse grit grinding wheels on single or double disc, centerless, or surface grinders.

Wheel Forms Dressed by These Tools



STRAIGHT TAPERED

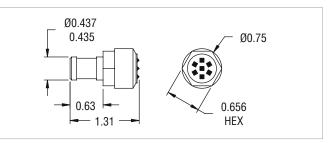
Multi-Point Cluster Tools

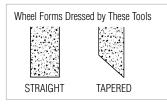
 Multi-Point Cluster tools are typically used for straight face dressing on disc and centerless operations

WINTER

- For greatest efficiency, these tools should be mounted at a 15° angle so that three diamonds are in contact with the wheel face at all times
- The tool should be rotated at frequent intervals; not resettable

		TIER:	BETTER	
DIAMONDS On Face	SHANK	TOOL LENGTH		NON-RESETTABLE Part #
Stock Multi-				
7	7/16"	1-5/16"	NC7K7	662601 95206
Standard Packa	age = 1 Tool			

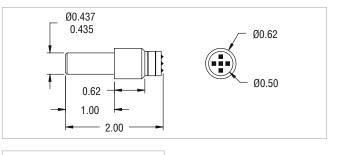




Dia-Pak Tools

- Dia-Pak tools are primarily used in straight face disc grinding, but are extremely versatile and may also be used in centerless and surface operations
- Designed for maximum economy, three layers of diamond are carefully arranged so that a new layer is exposed before the previous layer is completely worn away; not resettable

			TIER:	BETTER	
FOR WHEEL	DIAMONDS	SHANK	TOOL	PRODUCT	NON-RESETTABLE
DIAMETERS	PER LAYER	DIAMETER	LENGTH		PART #
Stock Dia-P	ak Tools				
Up to 14"	5-4-5	7/16"	2"	DP20	662601 95200
Up to 20"	7-6-7	7/16"	2"	DP30	662601 95201
Any	7-6-7	7/16"	2"	DP35	662601 95202
Standard Package = 1 Tool					



Wheel Forms Dressed by These Tools

TECH TIP

Cluster and Dia-Pak Tools - Straight face dressing of hard / coarse wheels:

- Tool should approach the wheel at a 15° angle and be rotated periodically to keep three diamonds in contact with the wheel at all times.
- Tools can also be used at a 90° to the wheel face.
- Multi-Point Cluster tools should be rotated at frequent intervals.
- Infeed per pass should not exceed .0015" (.001" with ceramic Norton SG, Quantum, Targa TG, etc. wheels).
- Use coolant whenever possible.
- These tools permit a faster traverse rate providing a freer cutting wheel than when dressed by a single-point tool.



DRESSING SOLUTIONS Accessories



Tool Holder/Hand Dresser

- Designed for use when offhand truing and dressing on tool and cutter, or benchstand grinders.
- This stock hand dresser will not rust, and is 10-1/2" long, with a hollow shaft that accepts any tool shank length from 3/4" to 9". The 1-3/4" diameter plastic knob ensures a firm grip. The collet accepts a 7/16" diameter tool shank.

DESCRIPTION	PART NUMBER
Hand Dresser	662601 95020
Ø1.75	







Open or Closed Dressing... You Can Count on Fliesen Tools

Whether dressing a wheel OPEN or CLOSED you can count on Fliesen tools. Open wheels (sharp, free-cutting abrasive grains are exposed) are created by increasing the speed a Fliesen tool moves across the wheel when dressing. Generally considered the most favorable wheel conditioning, open wheels avoid workpiece burn while maximizing a wheel's ability to remove metal quickly when grinding.

Slowing a Fliesen tool as it moves across the wheel creates a closed wheel condition (abrasive grains are smoother, less sharp); a very helpful condition when trying to lower part surface finish readings.

- Harder, H-bond metal formulation tools have been specifically engineered to efficiently dress durable silicon carbide and ceramic wheels
- Furioso Fliesen tools have a unique bond system developed for optimal performance when dressing Norton Quantum (NQ) ceramic wheels
- · W-bond Fliesen tools are designed for conventional aluminum oxide wheels

The Benefits of Fliesen Tools

Spend More Time Grinding

Single point, chisel, and cone point tools require operator attention to ensure proper tool rotation at regular intervals. Fliesen tools require no adjustments. Simply install the tool, dress the wheel to break it in, and the tool will do the rest. Operators spend more time grinding – rather than making non-productive dressing adjustments.

Longer Tool Life

Expect long life when using a Fliesen tool. Other stationary tools, made with a single diamond stone, develop flat spots ("wear flats") over time – which create chatter and burn. Fliesen tools use hand-set, fine diamond grit, eliminating the creation of wear flats.

Fliesen Tool Configurations: Plate and Shank

Fliesen tools are available in two basic tool configurations. The most common is a plate configuration, which is somewhat rectangular-shaped with a mounting hole. Fliesen shank tool configurations are plates mounted in shanks of varying sizes and shapes. Most grinding machines accommodate one or the other tool configuration. To find the correct tool configuration for your machine, check the existing dressing tool, or consult your grinding machine manual.

Choosing The Correct Fliesen Tool

Using the chart below, find your desired wheel form – then locate the preferred diamond position. Next, find the correct tool configuration for your machine: plate or shank tool. Follow down that column to find the Fliesen page for your plate or standard shank tool configuration. Go to the appropriate page. Locate the corresponding zone for your wheel diameter and width on the graph. Find that zone number in the part number chart. Next, moving to the right, find your wheel abrasive type and grit size. Locate the part number for your Fliesen tool.

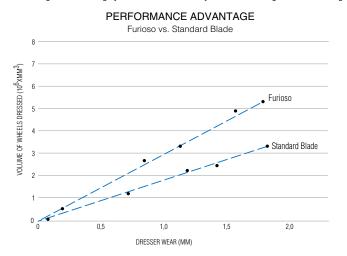
Desired Wheel Form					
Diamond Positions	Blade Only FR	Side-Mounted FRS, FAS, FBS, FCS & FDS	Center-Mounted FAS, FBS, FCS & FDS	Double-Sided FCSD & FDSD	Twin FDST, FSST & 1TFAS
TOOL CONFIGURATI	ON				
Plates	Consult Customer Service	Page 296 – 297	Consult Customer Service	Consult Customer Service	Page 296– 297
Shank Tools	Consult Customer Service	Consult Customer Service	Consult Customer Service	Consult Customer Service	Consult Customer Service



DRESSING SOLUTIONS Diamond Stationary Fliesen Tools

Furioso Tools

The new generation of highly wear-resistant stationary diamond dressing tools for dressing modern ceramic abrasives



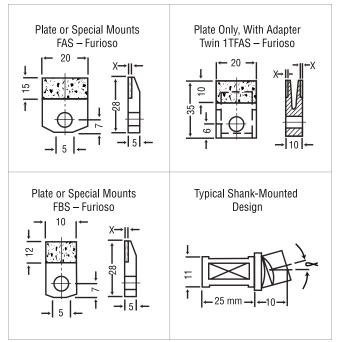




Best choice for optimum performance of Norton Quantum or other ceramic wheels

FLIESEN FURIOSO TOOLS

- The optimized combination of diamond quality, bond and setting pattern when dressing Norton Quantum (NQ) or other ceramic grinding wheels
- · Improved wear-resistance and enhanced tool life; excellent dressing behavior with optimum consistency
- Constant surface roughness





These three pages highlight a small sample of our Fliesen tool offering. Ask your Norton representative for complete product listing and information on these tools.

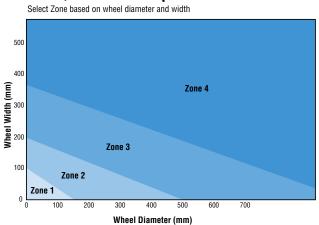
Standard Furioso Plate Drawings



Furioso Plates; Side-Mounted and Twin

Use the Wheel/Tool Graph to identify your grinding wheel's Zone number, and the chart below to find the Furioso tool for your application.

Wheel / Furioso Tool Graph



TIER:	BEST		WHEELS	SP	EC C	HECK
WHEEL GRIT SIZE	TOOL #	PART #	DESCRIPTION			
36 - 54 54 - 80 120 - 180 36 - 54 54 - 80 80 - 120	DT1463 DT1462 DT1460 DT1467 DT1466 DT1465 DT1465	69014122948* 69014122947* 69014122947* 69014122952* 60157690579* 60157693885*	FBS 140 Furioso FBS 115 Furioso FBS 75 Furioso FAS 140 Furioso FAS 115 Furioso FAS 90 Furioso FAS 75 Furioso	1 F 2 F 3 T	BS AS IFAS	DIMENSION 10 mm thick, 15 mm usable length 20 mm thick, 15 mm usable length Twin blade with cooling duct
120 - 180	DT1464	690141 22950 ^	FAS 75 FUIIOSO			
36 - 54 54 - 80 80 - 120 120 - 180	DT1471 DT1470 DT1469 DT1468	690141 22956 * 690141 22955 * 690141 22954 * 690141 22954 *	1TFAS 140 Furioso 1TFAS 115 Furioso 1TFAS 90 Furioso 1TFAS 75 Furioso	140 115 90	PTION	FEPA D1181 D1001 D711 D501
	TO DRESS: WHEEL GRIT SIZE 36 - 54 54 - 80 36 - 54 54 - 80 80 - 120 120 - 180 36 - 54 54 - 80 80 - 120 36 - 54 54 - 80 36 - 54 54 - 80 36 - 54 54 - 80 80 - 120 120	TO DRESS: NORTON QUA WHEEL GRIT SIZE TOOL # 36 - 54 DT1463 54 - 80 DT1462 120 - 180 DT1460 36 - 54 DT1467 54 - 80 DT1466 80 - 120 DT1465 120 - 180 DT1464 36 - 54 DT1465 120 - 180 DT1464 36 - 54 DT1471 54 - 80 DT1470 80 - 120 DT1470	TO DRESS: NORTON QUANTUM NQ CERAMIC WHEEL GRIT SIZE TOOL # PART # 36 - 54 DT1463 69014122948* 54 - 80 DT1462 69014122947* 120 - 180 DT1460 69014122944* 36 - 54 DT1467 69014122952* 54 - 80 DT1466 60157690579* 80 - 120 DT1465 60157693885* 120 - 180 DT1464 69014122950* 36 - 54 DT1464 69014122950* 36 - 54 DT1471 69014122950* 36 - 54 DT1470 69014122955* 80 - 120 DT1469 69014122955*	TO DRESS: NORTON QUANTUM NQ CERAMIC WHEELS WHEEL GRIT SIZE TOOL # PART # DESCRIPTION 36 - 54 DT1463 69014122948* FBS 140 Furioso 54 - 80 DT1462 69014122947* FBS 115 Furioso 120 - 180 DT1460 69014122944* FBS 75 Furioso 36 - 54 DT1467 69014122952* FAS 140 Furioso 54 - 80 DT1466 60157690579* FAS 115 Furioso 80 - 120 DT1465 601576903885* FAS 90 Furioso 120 - 180 DT1464 69014122950* FAS 140 Furioso 120 - 180 DT1465 60157693885* FAS 90 Furioso 36 - 54 DT1471 69014122950* TIFAS 140 Furioso 36 - 54 DT1470 69014122955* 1TFAS 140 Furioso 54 - 80 DT1470 69014122955* 1TFAS 115 Furioso 54 - 80 DT1469 69014122955* 1TFAS 115 Furioso	TO DRESS: NORTON QUANTUM NQ CERAMIC WHEELS WHEEL GRIT SIZE TOOL # PART # DESCRIPTION 36 - 54 DT1463 69014122948* FBS 140 Furioso 54 - 80 DT1462 69014122947* FBS 115 Furioso 120 - 180 DT1466 69014122944* FBS 75 Furioso 36 - 54 DT1466 60157690579* FAS 115 Furioso 54 - 80 DT1465 60157690579* FAS 115 Furioso 80 - 120 DT1464 69014122950* FAS 75 Furioso 36 - 54 DT1464 69014122950* FAS 75 Furioso 30 - 120 DT1464 69014122950* FAS 75 Furioso 36 - 54 DT1471 69014122950* FAS 75 Furioso 36 - 54 DT1470 69014122955* 1TFAS 140 Furioso 36 - 54 DT1470 69014122955* 1TFAS 115 Furioso 54 - 80 DT1470 69014122955* 1TFAS 115 Furioso 140 105 007 105	TO DRESS: NORTON QUANTUM NQ CERAMIC WHEELS WHEEL GRIT SIZE TOOL # PART # DESCRIPTION 36 - 54 DT1463 69014122948* FBS 140 Furioso 1 FBS 120 - 180 DT1460 69014122947* FBS 115 Furioso 2 FAS 36 - 54 DT1466 60157690579* FAS 140 Furioso 2 FAS 120 - 180 DT1465 60157690579* FAS 115 Furioso 3 TFAS 120 - 180 DT1464 69014122950* FAS 75 Furioso 3 TFAS 36 - 54 DT1471 69014122950* TIFAS 140 Furioso 140 120 - 180 DT1469 69014122955* 1TFAS 140 Furioso 140 120 - 180 DT1470 69014122955* 1TFAS 90 Furioso 140 120 - 180 DT1469 60014122954* 1TFAS 90 Furioso 90 90

All Furioso Plates shown ship in 10 business days from receipt of order.

Furioso Shank Tools

Made-to-order Furioso shank tools are also available. Ask your Norton representative for ordering assistance.

Side-Mounted Diamond Sections

Tools are available in different offset positions and angles.

Zero Offset





Offset Left, Specify angle amount

Offset Right, Specify angle amount

Tipping the Diamond Plates on Shank Tools

Diamond sections can be tipped right or left.



Diamond Diamond Tipped Left, Tipped Right, Specify angle Specify angle



There are many different diamonds making up a single plate as this cut-away view shows.



DRESSING SOLUTIONS Diamond Rotary Dressing Tools



Norton Winter diamond rotary truing and dressing tools provide a very efficient way to modify the shape and topography of your grinding wheels.

Products:

- Form Rolls: Plunge Dressing

 Infiltrated diamond form rolls
- Reverse plated diamond form rolls
- Dressing Discs: CNC Traverse Dressing
- Infiltrated dressing discs
- BPR dressing discs (for dressing superabrasive wheels)
- IDW dressing discs (for dressing superabrasive wheels)
- Truing and Dressing Spindles and Devices

Form Roll: Plunge Dressing

- Diamond roll geometry matches geometry of part to be ground
- · Roll is fed into grinding wheel to generate the desired form and wheel surface condition
- Used where lowest cycle time and highest accuracy is required

Dressing Disc: CNC Traverse Dressing

- Diamond dressing disc has a thin diamond section that is traversed across the face of the grinding wheel
- Profile is generated with a CNC program or template
- · Used for simple profiles or where flexibility is necessary



How to Order Rotary Dressing Tools

Provide the following information to your local sales representative or customer service representative

Legible blueprint of roll, wheel, or part with the following geometry:

- Overall diameter
- Overall length
- Bore size and tolerances required
- Mounting pattern
- Any feature with tolerances less than 0.0002" (5 um) must be clearly defined for engineering review
- If designing from a part, a fully dimensioned part drawing is required
- Abrasive type (natural diamond, synthetic diamond, CVD stones, etc.)
- · Specification of wheel to be dressed (need at least the grit type and size)
- Dressing type (Plunge or CNC Profiling)



Request the "Rotary Truing and Dressing" brochure, form # 8535, and contact your Norton representative for more information and expert assistance with your dressing operation.



DRESSING SOLUTIONS Truing Devices



Brake Controlled Truing Devices

Designed for truing diamond and cBN wheels rapidly, effectively, and with a minimum of superabrasive loss. Recommended for wheels up to 12" in diameter.

Applications:

- Truing straight, cup and cylinder wheels:
- Straight wheels, used on chip breaker, tool and cutter, surface, and cylindrical grinding machines
- · Cup wheels, used on vertical spindle surface grinders
- Internal grinding wheels
- · Cut-off wheels



Norton Abrasives: True to Form, Dress To Cut

𝒫 nortonsga.us/qnfx2

Non-Stock 4597 Brake Controlled Truing Device

The 4597 is engineered for heavier and more frequent truing applications. The adjustable speeds allow for varying conditions (between 1050 and 1500 SFPM). It comes complete with a reusable case, two 3" 38A60-M8VBE* vitrified wheels, Truing Device Tips book and a dressing stick. It can be rebuilt using the 4597RK Rebuild Kit.

Worn #4597 Brake Controlled Truing Devices (UPC 662601**95350**) in need of reconditioning (beyond new shoes and springs) may be returned to be rebuilt. Contact Customer Service for return instructions and quote.

Stock 3597 Pacesetter Brake Controlled Truing Device

The Pacesetter model is ideal for light-duty use. The pre-set brake speed requires no adjusting. This model includes one 3" 38A60-M8VBE* vitrified wheel and can be rebuilt using the 3597RK Rebuild Kit.

Stock 4597RK and 3597RK Rebuild Kits

The truing devices can be rebuilt with these kits, consisting of 3 brake shoes, 3 springs, and 3 screws.

TIED	BETTER		0000			
TIER:			GOOD		SPEC CHE	-CK
ITEM	PRODUCT NO.	PART #	PRODUCT NO.	PART #		
Truing Devices					Truing Diamond a	nd
4597 Brake Controlled Truing Device	4597	662601 95350 NS			Ŭ	
3597 Pacesetter Brake-Controlled	3597	662601 35578			cBN Wheels	
Truing Device						TRUING WHE
Truing Device Rebuild Kits					SUPERABRASIVE WHEEL	SPECIFICATI
4597 Rebuild Kit	4597RK	662601 95351			Resin and Vitrified Bond	
3597 Pacesetter Rebuild Kit	3597RK	662601 35595			80, 100, and 120 grits	38A60-MVBE
Replacement Wheels					-	37C60-MVK
3 x 1 x 1/2			38A60-MVBE	662435 29145	150, 180, and 220 grits	38A80-MVBE
			38A80-MVBE	662435 29146		37C80-MVK
			37C60-MVK	662435 29166	320 and finer grits	37C100-HVK
			37C80-HVK	662435 29170	Metal Bond	
			37C80-MVK	662435 29171	80, 100, and 120 grits	38A60-MVBE
			37C100-HVK	662435 29172	150, 180, and 220 grits	38A80-MVBE
			37C100-MVK	662435 29070	240 and finer grits	37C80-HVK

NS Non-Stock: Please contact your Norton representative for current lead-times.

TECH TIP

- Prior to truing the wheel, run a wax crayon over the wheel face. Important: do NOT use any liquid-based ink on superabrasive wheels.
- Any crayon left on the wheel face after truing will reveal untrued areas.
- Indicate the superabrasive wheel runout before starting... usually within .001" to .002", to minimize wheel loss.
- Mount the device spindle parallel to the wheel spindle to ensure proper straight face truing.
- For cup-shaped wheels, the device spindle will be mounted perpendicular to the wheel spindle.
- · Always use the brake-controlled truing device dry.
- Bring the diamond/cBN wheel and the truing wheel together until they almost touch.

- Start the diamond/cBN wheel to normal speed; spin the truing wheel in the same direction at point of contact.
- Bring the two wheels together until they touch.
- · Make sure the truing wheel is spinning at time of contact.
- Traverse the wheel back and forth at 30 to 60 inches/minute.
- Downfeed .0005" to .001" at the end of each traverse.
- At the end of truing, the diamond/cBN wheel should be smooth and in truth.
- · Apply a dressing stick to sharpen the wheel.



It is the user's responsibility to refer to and comply with ANSI B7.1





Regular use of properly selected dressing sticks will help you achieve maximum performance from your grinding wheels.

Applications: Grit Range: Abrasive Grain: Shape: Machine Used: Truing, cleaning, and dressing diamond, cBN, and conventional abrasive grinding wheels 16 – 1200 Aluminum Oxide, Boron Nitride, Silicon Carbide Square, rectangular, and round

DRESSING SOLUTIONS

Dressing Sticks

HAND	DRESSING

Grinding Wheel-to-Product Recommendation Guide

Selecting the appropriate dressing stick for each application depends on the wheel size, type, speed, specification, and grit size, as well as the workpiece material. Initial starting specifications are listed below. We recommend testing several sticks to find the best one for your application.



	Product	Specification
Superabrasive Wheels - Resin and Vitrified Bo	nd	
- 80, 100, and 120 grits	Dressing Stick	38A150-HVBE
- 150, 180, and 220 grits	Dressing Stick	38A220-HVBE
- 320 and finer grits	Superfine Stick	NMVC400-J5VCA
Superabrasive Wheels - Metal Bond		
- 80, 100, and 120 grits	Dressing Stick	37C80-NV
- 150, 180, and 220 grits	Dressing Stick	37C150-KV
- 240 and finer grits	Dressing Stick	37C220-KV
Conventional Vitrified Wheels - Vitrified Bond		
- 46 grit and finer and M grade and softer	High Performance Dressing Stick	Norbide
	Conventional Dressing Stick	37C24-SVK

TECH TIP

Dressing Diamond and cBN Wheels

- Resin and Vitrified Bond Diamond, and cBN Wheels: choose a dressing stick one or two grit sizes finer than the abrasive in the wheel in a soft grade (H or I)
- Metal Bond Diamond, and cBN Wheels: choose a stick the same grit size or one grit size coarser than the abrasive in the wheel in a medium grade (K-M)

It is the user's responsibility to refer to and comply with ANSI B7.1

Offhand Grinding Wheel Dressing Stick and Holder

This convenient metal holder is widely used by mechanics and foundry-men for truing, dressing and changing the face of the wheel. The JT246 dressing stick – an extra coarse grit silicon carbide for dressing conventional vitrified wheels – is firmly held and adjusted by the knurled control.



		TIER	BETTER	
SIZE (D x L)	SPEC.	STD. PKG.	PRODUCT #	PART #
Offhand Grind	ing Wheel Dressing Stick and Holder			
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5	JT246	614636 87900
10 Overall	Dressing Stick Holder	5	H6	614636 87895

Norbide High-Performance Sticks

For offhand truing and dressing of medium grit, soft- and medium-grade conventional vitrified grinding wheels. Norton Norbide sticks are the hardest sticks you can buy. Made from boron carbide, they are well suited for dressing tool and cutter wheels 10" and smaller, especially cup and saucer shapes.

	TIE	R: BETTER	
SIZE (T x W x L*)	STD. PKG.	SPEC.	PART #
High Performance	Long Life Stick		
1/4 x 1/2 x 3	5	Norbide	614636 10148
* Thickness x Width x	Length		



Vitrified Dressing Sticks

Aluminum Oxide (White)

For dressing and cleaning diamond and cBN superabrasive wheels.

Silicon Carbide (Black)

Coarse grit (16 - 46) and hard-grade (R and harder) sticks are used for dressing conventional vitrified wheels. Finer grit and softer grades are used for dressing diamond wheels.

	TIER	BETTER			TIER	BETTER	
SIZE (T x W x L)	STD. PKG.	SPEC.	PART #	SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
Vitrified Dressing	Sticks – Alumi	num Oxide		Vitrified Dressing S	Sticks – Silicon	Carbide	
3/8 x 3/4 x 4	5	38A150-IVBE	614636 39635	1/2 x 1/2 x 6	5	37C24-SVK	614636 10285
1/2 x 1/2 x 4	5	38A220-HVBE	614636 10555		5	37C100-LV	614636 10201
1/2 x 1/2 x 6	5	38A150-IVBE	614636 10303		5	37C150-KV	614636 10205
	5	38A220-HVBE	614636 10103		5	37C150-MV	614636 10207
1/2 x 3/4 x 4	5	38A60-LVBE	614636 10415		5	37C220-KV	614636 10214
1/2 x 1 x 4	5	38A180-IVBE	614636 99705	3/4 x 3/4 x 6	5	37C150-LV	614636 10375
3/4 x 3/4 x 4	5	38A60-LVBE	614636 10440	1x1x6	5	37C20-SVK	614636 10459
	5	38A80-MVBE	614636 10362		5	37C24-SVK	614636 10462
	5	38A90-LV	614636 39632		5	37C24-TVK	614636 10354
	5	38A150-HVBE	614636 10291	_	5	37C46-RVK	614636 10466
	5	38A150-IVBE	614636 10368		5	37C80-NV	614636 10393
	5	38A220-HVBE	614636 10290		5	37C150-KV	614636 10438
3/4 x 3/4 x 8	5	38A220-HVBE	614636 10280		5	37C220-KV	614636 10398
1 x 1 x 6	5	38A150-HVBE	614636 10405	1 x 1 x 8	5	37C24-SVK	614636 10471
	5	38A150-IVBE	614636 10453	1 x 2 x 8	5	37C16-TVK	614636 10482
	5	38A220-HVBE	614636 10406		5	37C24-TVK	614636 10485
1 x 1 x 8	5	38A120-IVBE	614636 10390	2 x 2 x 8	5	37C24-SVK	614636 10490
	5	38A150-IVBE	614636 10455	Vitrified Round Dre	essing Sticks –	Silicon Carbide	
				1/2 x 6	5	37C24-SVK	614636 10371
				1 x 6	5	S/C Ex-C (JT276)	614636 87905

Vitrified Superfine Sticks

For dressing diamond and cBN superabrasive wheels.

	TIER.	BETTER	
SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
Vitrified Superfine	e Sticks – Alumi	num Oxide	
1 x 1 x 6	5	PCD Coarse - 400 grit	614636 47865
	5	PCD Fine - 800 grit	614636 47867
1x1x8	5	NSA320-H8V	614636 10597
Vitrified Superfine	e Sticks – Silico	n Carbide	
1/2 x 1/2 x 6	5	NMVC320-J5VCA	614636 10599
	5	NMVC400-J5VCA	614636 50324
1 x 1 x 6	5	NMVC320-J5VCA	614636 10605
	5	NMVC400-J5VCA	614636 50450

Organic Silicon Carbide Micro Dressing Wheel

Type 01 straight dressing wheels with sharp high-purity green silicon carbide abrasive. For micro-dressing fine grit polyimide superabrasive diamond wheels.

			IIE	R: BEST
			ABRASIV	E: Silicon Carbide
SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straight				
200mm x 10mm x 31.75mm	2,870	5	320 Silicon Carbide Organic Micro Dressing Wheels	662532 96349 *
* For fine grit diamond Polymide w	heels			







Diamond and cBN Wheel Mounting, Truing and Dressing Guide

To achieve the best results using Norton Winter diamond and cBN products, the following steps for mounting, truing and dressing should be practiced:

MOUNTING - Putting Wheel on Machine Spindle

- Examine wheel flanges and spindle carefully.
- Be sure flanges' surfaces are clean and free of damage.
- Ensure that the mounting flanges are flat and of equal diameter, especially on wheels with rigid centers, such as vitrified bond wheels.
- Paper or plastic blotters should only be used when mounting superabrasive wheels with vitrified cores. Using paper or plastic blotters on any other core material might result in the wheel loosening during grinding.
- Inspect machine spindle for excessive runout.
 - » TIR (Total Indicated Runout) should be no greater than 0.0002".
- Mount wheel between hand-tightened flanges.
- Using a dial indicator, tap the wheel lightly with a rubber or wooden block to minimize runout to less than .0010".

TRUING - Making Wheel Round and Concentric with the Spindle Axis

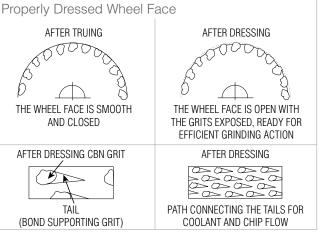
- Prior to truing the wheel, run a wax crayon over the wheel face. Important: do not use any liquid-based ink on superabrasive wheels.
- Any crayon left on the wheel face after truing will reveal untrued areas.
- Indicate the superabrasive wheel runout before starting... usually within .001" to .002", to minimize wheel loss.
- Brake controlled truing devices are most commonly used to true Diamond and cBN straight, cup and cylinder wheels.
- » Mount the device spindle parallel to the wheel spindle to ensure proper straight face truing.
- » For cup wheels, the device spindle will be mounted perpendicular to the wheel spindle.
- » Always use brake controlled truing device dry.

DRESSING - Opening the Face of a Trued Wheel

- Dressing the abrasive a cleaning/sharpening process to expose sharp, free-cutting grit:
- » For resinoid and vitrified bond wheels, the dressing stick should be one or two grit sizes finer than the abrasive in the diamond/cBN wheel – in a soft grade such as H or I.
- » For metal bond wheels, choose a stick with the same grit or one grit coarser than the wheel abrasive in a medium grade (K N).
- » See the "Dressing Stick" section for recommendations.



- · Tighten flange securely and recheck with indicator.
- Allow a newly mounted wheel to operate for one full minute before grinding.
- The use of one permanent mounting for the life of the wheel is recommended whenever possible:
- » If the grinding machine has a tapered spindle, mount each straight, flaring cup or dish wheel on a separate collet or adapter.
- » When changing wheels the entire unit is removed, keeping the wheel in running truth.
- » When needed again, the entire unit can be placed directly on the spindle or arbor, thereby eliminating the time and abrasive lost in retruing.
- » Bring the diamond/cBN wheel and the truing wheel together until they almost touch.
- $\,\,{}^{\,\,}$ Start the diamond/cBN wheel to normal speed; start the truing wheel in the same direction.
- » Bring the two wheels together until they touch.
- » Make sure the truing wheel is spinning at time of contact.
- » Traverse the wheel back and forth at 30 to 60 inches per minute.
- » Downfeed .0005" to .001" at the end of each traverse.
- » At the end of truing, the diamond/cBN wheel should be smooth and in truth.
- » Apply a dressing stick to sharpen the truing wheel.
- Dressing the core The core material (the part of the wheel that holds and supports the abrasive-bearing section) should never contact the work piece during grinding; rubbing will generate excessive heat. As the abrasive section of a cup wheel wears, the core material might become exposed, necessitating dressing.
- » Use a single-point carbide or steel tool to dress an exposed resaloy core.
- » Clamp the tool in a vise.
- » Direct the cutting edge accurately to leave a 1/16" of abrasive section exposed.



Diamond & cBN Abrasives

setting a new industry standard **FOR PRODUCTIVITY**

From the most comprehensive stock offering to the industry's largest custom-manufactured availability, our Norton Winter superabrasive product portfolio gives you the most options with uncompromising performance.

- Diamond / cBN Stock Wheels
- B99 Express Made-to-Order Resin Wheels
- CNC Wheels
- Electroplated Products
- Lapping Compound



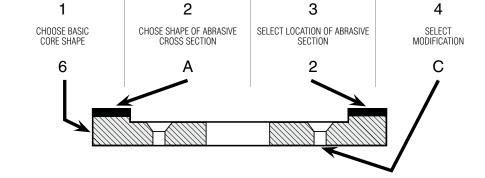
The American Standard Code employs a series of numbers and letters to designate the shape of a diamond wheel. Its use involves four simple steps shown at right.

In this example, the complete wheel shape number would read:

6A2C

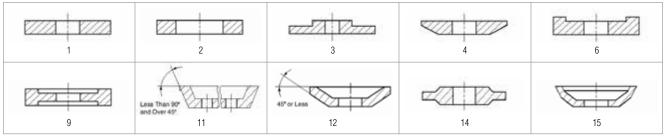
COURTESY OF ANSI

1. Basic Core Shapes and Marks

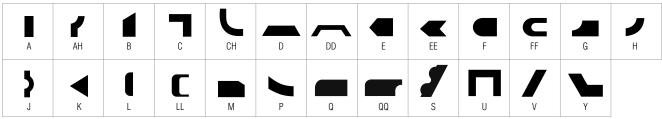


DIAMOND & cBN ABRASIVES

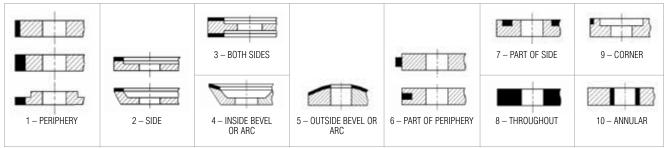
Diamond / cBN Basics



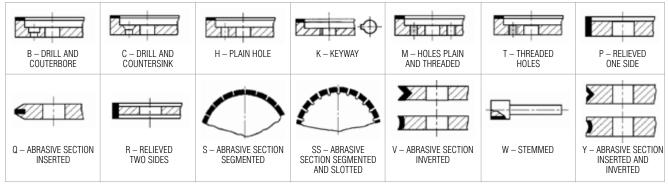
2. Abrasive Cross Sections and Marks



3. Location of Abrasive Section and Marks



4. Popular Modifications and Marks







Norton Winter Diamond Product Identification System / Usage Information

		-		-
ASD	120 –	R 75	B99	1/8
	~ /	- 1	~	

Abrasive Type	Grit Size	Grade	Concentration	Bond	Abrasive Depth
ASD • Used with B99 and B105 bonds • Armored • Durable • Versatile • Use wet or dry • Carbide/steel operations CD • Used with B99 bond • Used with B99 bond • Used with B99 bond • M3D • Used with M99 bond M4D • Used with M99 bond M4D • Used with M99 bond M4D • Used with M99 bond SD • Used with V99 bond SD • Used with B99 and V99 bonds	Grit Size • 100S – Roughing • 120 – Roughing/cutting-off • 150 – Combined roughing and finishing • 180 – Improving finish • 220, 320 & 400 – Finishing only • 10/20 mic • 6/12 mic	Grade Resin Bond R – Norton standard N – Free cutting Metal Bond N – Norton standard Vitrified Bond P – Norton standard R – Most durable	Concentration 50 • Most economical • For broad area of contact 75 • Norton standard • Freer cutting than 100 • Dry grinding with ASD 100 • Very durable • For flood coolants • Use with 220 grit or finer • Use for cutting-off 115 • For CNC grinding machines 125 • Form holding • For high volume, high pressure coolant, precision applications on high-speed tool steels	 B99 Resin bond Use wet or dry Tool making; resharpening B105 Premium resin bond Advanced heat-reducing bond Use dry; reconditioning B610 and B80 For CNC grinding machines M99 Metal bond 1A1R cut-off Glass and ceramics MSL Metal single layer Type 6A2C only Use dry Offhand reconditioning/ finishing carbide V99 Vitrified bond Offhand finishing of carbide tools 	Abrasive Depth 1/16" 1/8" 1/4" 9/32" 3/8" 1/2" 3/4" Solid
 Durable; for non-metallics RMD Used with V99 bond SD Used with B99 and V99 			applications on high-speed	 Use dry Offhand reconditioning/ finishing carbide V99 Vitrified bond Offhand finishing of 	

Abrasive Type	Grit Size	Grade	Bond	Abrasive Depth
CB – cubic Boron Nitride	• 100 - Roughing	Q	B99	1/16"
Used with B99 bond	 120 — Roughing/cutting-off 	 Approx. 50 concentration 	 Resin bond 	1/8"
Armored	 150 — Combined roughing and 	 Type 6A2 	 Use wet or dry 	1/4"
Use wet or dry	finishing	 Broad area of contact 	Aztec III	1/2"
	 180 — Improving finish 	Т	 Premium resin bond 	Solid
	 220, 320, 400 – For finishing only 	 Approx. 75 concentration 	 Use dry 	
	Ully	 Norton standard 	 Tool resharpening 	
		 First choice 	Aztec .007	
		 Lower horsepower 	 Premium resin bond 	
		 Broad area of contact 	 Use dry 	
		 Dry grinding 	 Increased feed rates 	
		 Resharpening applications 	 Heavy stock removal 	
		W	 Heavier cuts 	
		 Approx. 100 concentration 		
		 Most durable 		
		 High volume coolant 		
		 Flute polishing 		
		 Curtoss grinding 		

- Surface grinding
- Cylindrical grinding



DIAMOND & CBN ABRASIVES Diamond / CBN Basics

Application-to-Product Recommendation Guide – Diamond Wheels

		COMMON WHEEL SIZE, TYPE & BLUEPRINT	APPLICATION VARIABLES		RECOMMENDED SPECIFICATION
	ng – Toolroom Productio				
Blanchard Grinding Vertical Spindle Surface Grinding		10", 11", 16" & 18" diameters Type 2A2T	Wet – solid carbide	1" or larger pieces – roughing	SD100-R75B99E*
				Small pieces	ASD100-R75B99E*
			Carbide & steel (combin	ation)	ASD100-R75B99E*
Hand Burr Grinding		6" x 3/32" x 1-1/4" Type 1V1P V – 20° ME89562	Dry		ASDC320B-R125B99
Centerless (wet)	Throughfeed Grinding	12", 14", 16", 18" & 20" diameters Type 1A1	Roughing		ASD100-R75B99E*
	Unison Dedtru Grinder	7" x 1" x 1-1/4" Type 1A1			ASD150-R75B99E*
Cutting Off (wet	t)	6" x .035" x 1-1/4"	Most durable		ASD100S-R100B99
		Type 1A1R ME43572	Free cutting		SD100-R75B99
		10" x .050" x 1-1/4" Type 1A1R ME43565			SD120-R100B99
Cylindrical Grin	ding (wet)	10", 12", 14", 16" & 20" diameters	Wet, rough grinding of cemented		ASD180-R100B99
		Type 1A1	carbides, hard (55 Rc+) plasma and ceramic spray coatings		ASD180-R75B99E*
					ASD150-R75B99
					ASD120-R75B99
			Wet, finish grinding of all carbides, plasma and ceramic spray coatings		SD220-R100B99E*
Tool Sharpener	Bench Grinder (wet)	5" x 1" x 1-1/4" Type 6A2H ME27084 Rim Width (W) = 1-1/16	Tool sharpening		SD320-R50B99
Hand Honing (d	dry)	Various sizes			ASD100-R100B99
		Type HH1 or HH2			SD320-100V99
Lamination Dies	s (wet)	Various sizes Type 1A1	Surface grinding of carb	ide	ASD120-R75B99
Surface Grindin		Various sizes	Roughing	Durable	ASD100S-R100B99E*
Straight Wheels	6	Type 1A1		Free cutting	SD100S-R100B99
			Finishing only		SD220-R100B99
			General purpose		ASD150-R75B99
Tool & Cutter G	rinding	Various sizes Type 11V9, 12V9 or 15V9	Wet or dry		ASD120-R7599
Carbide Grindi	ng – Offhand				
Single-Point Ca	rbide Tools	6" x 3/4" x 1-1/4"	Wet roughing	Durable	RMD150-P50V99*
		Type 6A2C ME27853		Free cutting	SD150-P50V99
			Wet finishing	Durable	RMD220-P50V99*
			-	Free cutting	SD220-P50V99
			Wet or dry grinding	Roughing	ASD120-R75B99
			where free-cutting and self-dressing wheels	Finishing	SD220-R50B99E*
			are required		

Note: Diamond depths are not indicated in above listings. When ordering, be sure to include Diamond depth (1/16, 1/8, etc.). *Express Made-To-Order; Refer to the B99E Express Made-to-Order Wheel section.

Application-to-Product Recommendation Guide - cBN Wheels

APPLICATION OR COMMON MACHINE TYPE	COMMON WHEEL SIZE, TYPE & BLUEPRINT	APPLICATION VARIABLES	RECOMMENDED SPECIFICATION
Toolroom Grinding			
Cutter Sharpening	3-3/4" x 1-1/2" x 1-1/4"	Dry	Aztec III 120T
Milling Cutters, Broaches,	Type 11V9 ME92192	Wet	CB120-TB99
Reamers, etc.	6" x 1" x 1-1/4" Type 12A2 ME27758	Wet or dry	CB120-TB99
	6" x 3/4" x 1-1/4" Type 12V9 ME48666	Wet or dry	CB120-TB99
	6" x 3/4" x 1-1/4" Type 15V9 ME40633	Wet or dry	CB100-WB99E*
Surface Grinding	10" x 1/2" x 3" Type 1A1	Wet or dry	CB100-TB99E*
Cylindrical Grinding	12" x 1/2" x 3" Type 1A1	Wet or dry	CB150-WB99E*
Internal Grinding Tools	Thinner than 1/2" Type DW	Wet or dry	CB100-WB99
	1/2" or thicker Type 1A1	Wet or dry	CB120-TB99E*
Slotting	7" x .040" x 1-1/4" Type 1A1R	Water-base coolant	CB120-WB99E*

Note: cBN depths are not indicated in above listings. When ordering, be sure to include cBN depth (1/16, 1/8, etc.) *Express Made-To-Order; Refer to the B99E Express Made-to-Order Wheel section.



DIAMOND & CBN ABRASIVES Diamond / CBN Basics

Troubleshooting Guide – Dry Grinding

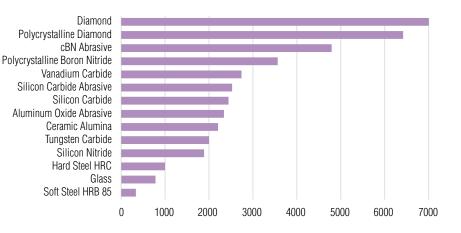
Problem	Possible Causes	Suggested Correction
Burning (excessive heat)	Wheel loaded or glazed	Dress wheel with a dressing stick
	Excessive feed rate	Reduce infeed of wheel or workpiece
	Wheel too durable	Use freer cutting specification or slow down wheel speed
Poor finish	Grit size too coarse	Select a finer grit size
	Excessive feed rate	Reduce infeed of wheel or workpiece
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount (See "Mounting, Truing and Dressing Guide")

Troubleshooting Guide - Wet Grinding

Problem	Possible Causes	Suggested Correction	
Burning (excessive heat)	Wheel glazed or loaded	Re-dress wheel	
	Poor coolant placement	Apply coolant directly to wheel/workpiece interface	
	Excessive material removal rate	Reduce downfeed and/or crossfeed	
Poor finish	Excessive dressing	Use lighter dressing pressure	
		Stop dressing as soon as wheel starts to consume stick rapidly	
	Grit size too coarse	Select a finer grit size	
	Poor coolant flow or location	Apply heavy flood so it reaches wheel/work interface	
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount	
Wheel will not cut	Glazed by truing	Dress lightly until wheel opens up	
	Wheel loaded	Dress lightly until wheel opens up	
		Increase coolant flow to keep wheel surface clean	
		Never run wheel with coolant turned off	
Slow cutting	Low feeds and speeds	Increase feed rate; increase wheel speed (Do not exceed wheel MOS)	
Short wheel life	Incorrect coolant flow	Apply coolant to flood wheel/work surface	
	Low wheel speed	Increase wheel speed (observe maximum operating speed)	
	Excessive dressing	Use lighter dressing pressure	
	Wheel too soft or too hard	Change grit or grade; use higher concentration	

Material Hardness Scale

Superabrasives is a term used to describe those abrasives of extreme hardness which produce outstanding results when properly used on specific applications. This graph provides a hardness comparison (Knoop Hardness Scale) between diamond and cBN superabrasives, aluminum oxide and silicon carbide standard abrasives, and some common materials these abrasives are used to grind.



TECH TIP

Avoid Grinding Steel

- Avoid steel when grinding with diamond wheels. Keep the amount of steel ground to an absolute minimum.
- On brazed tools, use aluminum oxide wheel to back off the steel shank.
- A high lubricity grinding fluid should be used.
- For some steels, an armored (AMD) diamond wheel might prove most economical.

Use Rigid Work Support

- All workpieces should be supported firmly during the grinding process. Any amount of vibration will cause wheel wear and produce chatter or wave marks on the ground surface.
- On work ground between centers, centerholds should be properly prepared.
- Minimize work overhang.
- If the ground work is supported by a work finger, ensure the finger is strong enough to provide vibrationfree support.

Coolant - Grind Wet

- Diamond wheels should be used with a full flood coolant properly directed toward the grinding zone. Water with a rust inhibitor is recommended.
- Vitrified diamond wheels should be used only with a coolant.
- When flood application can't be used, try mist or spray application.
- » Use compressed air to "atomize" water or soluble oil.
- » Direct the spray at the grinding zone to help dissipate heat and prevent heat damage to the work.

Avoid Excessive Feeds

- Excessive feeds will result in premature wheel wear. Excessive feed rates are characterized by:
 - » A hard grinding sound
 - » Chatter
 - » Burn
 - » High wheel wear rate
 - » Vibration



WINTER

DIAMOND & CBN ABRASIVES Diamond / CBN Basics

Decimal and Metric Equivalents of Common Fractions

FRACTI	ONS		
OF AN I	1/64	OF AN INCH .0156	MILLIMETERS 0.397
1/32	1/04	.0313	0.794
1/32	3/64	.0313	1.191
1/16	3/04	.0403	1.588
1/10	5/64	.0023	1.985
3/32	J/04	.0938	2.381
3/32	7/64	.10938	2.778
1/8	7/04	.1094	3.175
1/0	9/64	.1230	3.572
5/32	9/04	.1400	3.969
5/52	11/64	.1719	4.366
3/16	11/04	.1875	4.762
3/10	13/64	.2031	5.159
7/32	10/04	.2188	5.556
1752	15/64	.2344	5.953
1/4	10/04	.2500	6.350
1/ 7	17/64	.2656	6.747
9/32	17/04	.2813	7.144
5102	19/64	.2013	7.541
5/16	13/04	.3135	7.937
0/10	21/64	.3281	8.334
11/32	21/07	.3438	8.731
11/02	23/64	.3594	9.128
3/8	20/04	.3750	9.525
5/0	25/64	.3906	9.922
13/32	20/04	.4063	10.319
10/02	27/64	.4219	10.716
7/16	21/04	.4375	11.112
1/10	29/64	.4531	11.509
15/32	23/04	.4688	11.906
10/02	31/64	.4844	12.303
1/2	51/04	.5000	12.700
1/2	33/64	.5156	13.097
17/32	00/01	.5313	13.494
11/52	35/64	.5469	13.891
9/16	00/01	.5625	14.287
5/10	37/64	.5781	14.684
19/32	01/01	.5938	15.081
10/02	39/64	.6094	15.478
5/8	03/01	.6250	15.875
0/0	41/64	.6406	16.272
21/32	11/01	.6563	16.688
21,02	43/64	.6719	17.085
11/16	10/01	.6875	17.462
11,10	45/64	.7031	17.859
23/32	.0,01	.7188	18.256
	47/64	.7344	18.653
3/4	,01	.7500	19.050
-, -	49/64	.7645	19.447
25/32		.7813	19.843
	51/64	.7969	20.240
13/16	, • !	.8125	20.637
,	53/64	.8281	21.034
27/32	, • ·	.8438	21.430
, .	55/64	.8594	21.827
7/8	, • ·	.8750	22.224
.,-	57/64	.8906	22.621
29/32	0.701	.9063	23.018
20,02	59/64	.9219	23.415
15/16	55/01	.9375	23.812
, 10	61/64	.9531	24.209
31/32	01/01	.9688	24.606
01/02	63/64	.9844	25.003
1	33/01	1.0000	25.400
		1.0000	20.100

Expected Surface Finish by Grit Size

Use these charts as guides only. Surface finish is affected by several variables: machine type and condition, type of material ground, coolant, wheel speed, bond system, etc.

DIAMOND

Grit Size	Expected Finish Micro Inch AA	Maximum Depth of Cut per Pass for Grit Size
100	24 to 32	0.001" to 0.002"
120	16 to 18	0.001" to 0.002"
150	14 to 16	0.001" to 0.002"
180	12 to 14	0.0007" to 0.001"
220	10 to 12	0.0007" to 0.001"
320	8	0.0004" to 0.0006"
400	7 to 8	0.0003" to 0.0005"

cBN

CDIN		
Grit Size	Expected Finish With Oscillation	Expected Finish Plunge
100	35 – 40	40 - 45
120	30 - 35	35 - 40
150	25 – 30	30 – 35
180	20 – 25	25 - 30
220	15 – 20	20 – 25
320 400	10 – 15	15 – 20
400	4 – 8	5 – 10

Recommended Wheel Speeds for Diamond and cBN Wheels

WET GRINDING	Cup Wheels 11V9, 12V9, 15V9, etc.	Peripheral Wheels 1A1, 1V1, 1A1R, etc.
Diamond Grinding Wheels		
Resin Bond Wheels	4921 to 7874 SFPM	4921 to 7874 SFPM
	25 to 40 m/s	25 to 40 m/s
Metal Bond Wheels		3937 to 5906 SFPM
		20 to 30 m/s
Vitrified Bond Wheels	2953 to 5906 SFPM	2953 to 5906 SFPM
	15 to 30 m/s	15 to 30 m/s
cBN Grinding Wheels		
Resin Bond Wheels	5906 to 9843 SFPM	5906 to 9843 SFPM
	30 to 50 m/s	30 to 50 m/s
DRY GRINDING	Cup Wheels 11V9, 12V9, 15V9, etc.	Peripheral Wheels 1A1, 1V1, 1A1R, etc.
Diamond Grinding Wheels		
Resin Bond Wheels	2756 to 3543 SFPM	2756 to 3543 SFPM
	14 to 18 m/s	14 to 18 m/s
cBN Grinding Wheels		
Resin Bond Wheels	2953 to 5906 SFPM	2953 to 5906 SFPM
	15 to 30 m/s	15 to 30 m/s
Note: These are not the maximum operating.	sneeds (MOS)	

Note: These are not the maximum operating speeds (MUS). Consult ANSI B7.1 or contact your Norton representative for MOS.

Wheel Speed Calculation

To convert M/S to S	SFPM:	Multiply M/S x 196.85 = SFPM
To convert SFPM to	o M/S:	Divide SFPM by 196.85 = M/S
To convert RPM to	SFPM:	Multiply wheel diameter in inches x RPM x 0.262
M/S = meters/second	RPM = Revolutions	s Per Minute SFPM = Surface Feet Per Minute



DIAMOND & CBN ABRASIVES Diamond / CBN Wheels

Norton Winter offers an extensive line of stock Diamond and cBN (cubic Boron Nitride) grinding products, including resin, vitrified, metal and MSL (metal single layer) bond offerings, under the "99" quality line. Premium, high-performance stock resin bond options are also available.

Applications:

- · Sharpening cemented carbide cutting tools
- Cutting off carbide rod

B99 Diamond Wheels

- Grinding or cutting off non-ferrous materials such as ceramics or glass
- Surface grinding dies
- 0.D. grinding spray coatings
- B99 cBN Wheels
- Sharpening high-speed (M2, D2, T15, etc.) steel cutting tools
- · Surface and ID grinding hardened steel die components
- Precision grinding steel parts Rc 50 or harder

Stock Shapes:

Abrasive Grain: Abrasive Bonds: DW Mounted Points, HH1 and HH2 Hand Hones, and 1A1, 1A1R, 1V1P, 4A2P, 6A2C, 6A2H, 11V9, 12A2, 12V9, and 15V9 Wheels

e Grain: Diamond and cBN (cubic Boron Nitride) e Bonds: Resin, Metal, Metal Single Layer, and Vitrified



Superior performance for grinding non-ferrous materials

DIAMOND WHEELS

- · High quality synthetic diamond
- · High material removal rates with longer wheel life vs. conventional green silicon carbide wheels
- · Wide variety of stock wheel shapes and bond options available

Diamond Bond Types

BONDS	DESCRIPTION
Diamond Wheel Bonds	
Pre-engineered resin bond – B99	Free cutting; superior form holding; efficient wet or dry
Premium, heavy-duty resin bond – B105	Ideal for dry toolroom reconditioning applications
Metal bond – M99	Ideal for 1A1R cut-off applications and grinding glass or ceramic materials
MSL (metal single layer) diamond tools; no wheel dressing required	Fast stock removal, cool cutting; excellent for dry offhand finishing of carbide
Vitrified bond – V99	Most durable under high grinding forces; excellent for wet, offhand finishing of carbide tools



Superior performance for grinding ferrous materials

cBN WHEELS

- · cBN (cubic Boron Nitride) abrasive material is second in hardness to diamond
- · Easily cuts difficult-to-grind steel parts Rc 50 or harder
- · Highly wear resistant and thermally stable

cBN Bond Types

BONDS	DESCRIPTION
cBN Wheel Bonds	
Pre-engineered resin bond – B99	Free cutting, superior form holding
Premium Aztec III resin bond	Most efficient for dry tool resharpening
Premium Aztec .007 resin bond	Most efficient for dry tool resharpening where heavy stock removal is desired



DIAMOND & CBN ABRASIVES Diamond / CBN Wheels

How to Select Diamond Wheels

SELECT:

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS	· · · · · · · · · · · · · · · · · · ·	DxTxH	Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.
ABRASIVE	Select the abrasive based	Resin Bon	
	on horsepower, grinding wet or dry, and contact	ASD	Armored diamond, durable. Versatile: can be used wet or dry. Also should be used when carbide and steel are ground in the same operation.
	with steel.	D	Micron-sized diamond. Used for finishing and polishing operations.
		SD	Free cutting standard. Used wet or dry; should be used on low horsepower (3/4 hp or less) machines.
		Metal Bond	d Wheels:
		M4D	Armored, durable standard. A strong, blocky crystal designed for high performance on glas ceramics, refractories and other non-metallics.
		Vitrified Bo	ond Wheels:
		RMD	Medium strength. Specifically designed for use with vitrified bonds.
		SD	Free cutting standard.
GRIT SIZE	Select the abrasive grit	100	Roughing. The most common grit size for roughing operations.
	size based on finish	120	For roughing where 100 is too coarse. Also for cut-off applications.
	and material removal	150	Medium stock removal plus good finish. For combined roughing and finishing applications.
	rate required.	180	Medium stock removal plus good finish. To improve finish.
		220	Finishing
		320	Finishing
		400	Fine Finishing
		10/20 Mic	Super Fine Finishing
		6/12Mic	Super Fine Finishing
GRADE	The hardness of	Resin Bon	d Wheels:
	the wheel	R	Norton standard
		Ν	Free cutting
		Metal Bond	d Wheels:
		Ν	Norton standard
		Vitrified Bo	ond Wheels:
		Р	Norton standard
		R	Most durable
CONCENTRATION	Select the abrasive	50	Most economical. For broad area of contact grinding.
	concentration based on grinding wet or dry,	75	Norton standard. Freer cutting than 100 and the most economical for dry grinding with ASD diamond.
	material removal rates and form-holding	100	Very durable. Recommended under flood coolant conditions; for use with 220 grit or finer, when durability is required, and for cut-off applications.
	requirements.	125	Form holding. Used in high volume, high pressure coolant, precision applications on high-speed tool steels.
BOND	Select the bond	Resin Bon	
	based on the material being ground and	B99	Norton standard. Versatile enough to be used wet or dry on most tool making or resharpening applications.
	grinding application.	B105	Premium, heat-reducing bond. For dry toolroom reconditioning applications.
		Metal Bond	
		M99	Best suited for 1A1R cut-off applications as well as grinding glass or ceramic materials.
		MSL	Metal Single Layer. Available in shape 6A2C for dry, offhand reconditioning of carbide tools
		Vitrified Bo	
		V99	Best for wet offhand finishing of carbide tools as well as plunge grinding of carbide tools.
ABRASIVE DEPTH	Usable abrasive	1/16	
		1/8	
		1/4	
		9/32	
		Solid	



How to Select Stock cBN Wheels

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS		DxTxH	Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.
ABRASIVE	Select cBN abrasive	Resin Bond	1 Wheels:
	to grind hard tool steels such as A2, D2, T15, etc., and tough alloy steels.	CB	Norton standard coated cBN (cubic Boron Nitride). Optimized for high performance in resin bond systems.
GRIT SIZE	Select the grit size	100	Roughing. The most common grit size for roughing operations.
	based on finish and	120	For roughing where 100 is too coarse. Also for cut-off applications.
	material removal rate required.	150	Medium stock removal plus good finish. For combined roughing and finishing applications.
GRADE	The hardness of	Q	Approximately 50 concentration. Used on wide area of contact applications.
	the wheel	Т	Norton standard. Approximately 75 concentration. T is the first choice for lower horsepower equipment or large area of contact between the wheel and the work piece. Ideal for resharpening applications with 11V9, 12A2, 4A2P, and 15V9 wheel shapes when dry grinding.
		W	Most durable. Approximately 100 concentration, W is recommended for high volume coolant operations: flute grinding from solid, flute polishing, surface, and cylindrical grinding.
BOND	Select the bond depending on the type	B99	Norton standard. Pre-engineered for optimal performance with cBN abrasive. Available in all shapes.
	of grinding application.	Aztec III	The advanced heat-reducing, lubricating resin bond. Used for dry grinding tool steels.
		Aztec .007	The premium resin bond for increased feed rates, high stock removal and heavier cuts – when dry grinding tool steels.
ABRASIVE DEPTH	Usable abrasive	1/16	
		1/8	
		1/4	
		Solid	

Competitive Cross Reference Guides

Abrasives				Bonds						
Resin Diamond	Resin Diamond	Metal Diamond	Resin/ Vitrified cBN	Resin Diamond	Resin Diamond	Metal Diamond	Vitrified Diamond	Resin cBN	Resin cBN	Resin cB
ASD	SD	M4D	СВ	B99/ B99E	B105	M99	V99	B99/ B99E	B99EF	AZTEC
CGD, ND	GD, D, MD		CB	PS			V		BC	
SN	S		cBN	В		Μ		В		
NCD	D, MD		BN	В		Μ				
5SD, 6SD	SD	MD	CB	B43, B52		Μ		B26	C3	
NMD	D, MD		cBN, CB							
			CBC		BX4			BD/B38		BX4
NCD, WD, 1WD, MDC	D, MD	MD4C	B, CB, BZ	B7Z, BB, B5, B56,BN		M, MF	V	BZ, BN		
			B, BB	BJ						
MDN	D, MD		В					B82	B5	
SDM, XDL, XDN, D, 7D, CMD	SD, D, 6D, MD	1D	5B,1BN, BN, BM	BD, BC, BX33, B52, B6	Amigo	MI, MSS, MB		B72, B56, BG, B7	BXU8	Amigo
SDK			B, BXW					RN	RR	
		=		BONDS		RN				
			1				F			
D		CB	•	BP		BPP	-			
	Resin Diamond ASD CGD, ND SN NCD 5SD, 6SD NMD NCD, WD, 1WD, MDC MDN SDM, XDL, XDN, D, 7D, CMD SDK ABRASIV UNIVEL DIAMOR	Resin Diamond Resin Diamond ASD SD CGD, ND GD, D, MD SN S NCD D, MD 5SD, 6SD SD NMD D, MD NCD, WD, MDC D, MD MDN D, MD SDM, XDL, 7D, CMD SD, D, XDN, D, 7D, CMD SDK ABRASIVES UNIVEL/G-FORCE DIAMOND AD	Resin Diamond Resin Diamond Metal Diamond ASD SD M4D CGD, ND GD, D, MD MD SN S NCD SN S MD SSD, 6SD SD MD NMD D, MD MD NMD D, MD MD4C NMD D, MD MD4C NCD, WD, D, MD MD4C MDN D, MD SDM, SD, D, XDL, 6D, MD 1D SDK SDK	Resin DiamondResin DiamondMetal DiamondResin/ Vitrified cBNASDSDM4DCBCGD, NDGD, D, MDCBCBSNSCBNNCDD, MDBN5SD, 6SDSDMDCBNMDD, MDCBN, CBNMDD, MDCBN, CBNMDD, MDCBCNMDD, MDBN5SD, 6SDSDMDMDCB, CB, BZNCD, WD, D, MDMD4CB, BBBDM, SDM, SD, D, TDL, SDK1DSDKSD, MDSB, BNABRASIVESB, BNWABRASIVESJAMOND ADCBN ADCBN BX	Resin DiamondResin DiamondMetal DiamondResin/Vitrified CBNResin DiamondASDSDM4DCBB99/ B99ECGD, NDGD, D, MDCBBSNSCBNBNCDD, MDBNB5SD, 6SDSDMDCBMDD, MDBNB5SD, 6SDSDMDCBNMDD, MDCBN, CBCBCCBCNCD, WD, 1WD, XDL, 6D, MDMD4CB, CB, BS, BS, BS6,BNMDND, MDBSDM, XDL, 6D, MD1D5B, 1BN, BN, BMSDKB, BXWABRASIVESBONDSUNIVEL/G-FORCEDIAMONDDIAMOND ADcBN BX	Resin DiamondResin DiamondMetal DiamondResin/Vitrified CBNResin DiamondResin DiamondASDSDM4DCBB99/ B99EB105CGD, NDGD, D, MDCBPSB105SNSCBNBNCDD, MDBNB5SD, 6SDSDMDCBMDDD, MDCBN, CBB43, B52NMDD, MDCBN, CBBX4NCD, WD, D, MDMD4CB, CB, B7Z, B5, B56, BNMDCBBB56, BNMDCBBSDM, SD, D, NDNDBSDM, SD, D, TD, CMDBBD, BC, AmigoSDKB, BXWBX33, B52, B6ABRASIVESBONDSUNIVEL/G-FORCEDIAMOND AND cEDIAMOND ADcBN BX	Resin DiamondResin DiamondMetal DiamondResin/Vitrified CBNResin DiamondResin DiamondMetal DiamondASDSDM4DCBB99/ B99EB105M99CGD, NDGD, D, MDCBCBPSM10SNSCBNBMNCDD, MDBNBMSSD, 6SDSDMDCBB43, B52MNMDD, MDCBN, CBBX4MSCD, WD, D, MDMD4CB, CB, BZB7Z, B56,BNBX4NCD, WD, D, MDMD4CB, CB, BSB56,BNMI, MFMDCBBBMMDND, MDBBBJMDND, MDBBBJMDND, MDBBBJMDND, MDBBBJMDND, MDBBD, BC, BN, BMAmigoSDKB, BXWB, BXWBONDSABRASIVESBONDSDIAMOND AND cBNUNIVEL/G-FORCEDIAMOND AND cBNDIAMOND ADcBN BXUNIVELG-FORCDIAMOND AND cBN	Resin DiamondResin DiamondMetal DiamondResin Vitrified cBNResin DiamondResin DiamondMetal DiamondVitrified DiamondASDSDM4DCBB99/ B99EB105M99V99CGD, NDGD, D, MDCBPSVSNSCBNBMNCDD, MDBNBMSSD, 6SDSDMDCBB43, B52MNMDD, MDCBN, CBBZBZB56, BNMDCCBCBZB7Z, B56, BNM, MFVNCD, WD, D, MDMD4CB, CB, 	Resin DiamondResin DiamondMetal DiamondResin/ Vitrified cBNResin DiamondResin DiamondMetal DiamondVitrified DiamondResin DiamondASDSDM4DCBB99/ B99EB105M99V99B99/ B99ECGD, NDGD, D, MDCBCBPSVVSNScBNBMBNCDD, MDBNBMBSSD, 6SDSDMDCBB43, B52MB26NMDD, MDcBN, CBB7Z, B5, B56, BNM, MFVB2, BNNCD, WD, D, MDMD4CB, CB, BZB7Z, BB, B5, B56, BNM, MFVBZ, BNMDND, MDBBB3B42, B52B13B14, B52MDND, MDB, CB, BZB7Z, B56, B56, BNB7Z, B56, B56, BNB7Z, B56, B56, BNB7Z, B56, B3, B3, BB, B3B13MDND, MDBBB3B14, MSS, B72, B56, B6, B73, B52, B6B14, MSS, B72, B56, B6, B73, B52, B6B14, MSS, B72, B56, B6, B73, B52, B6B14, MSS, B72, B56, B6, B73, B52, B6MBB12, BNSDKB, BXWB, BXWB, BXWRNRNRNABRASIVESB, BXWB, BXWBNDSB14MOND AND cBN UNIVEL/G-FORCERN	Resin DiamondResin DiamondMetal DiamondResin Vitrified cBNResin DiamondMetal DiamondVitrified DiamondResin cBNResin cBNASDSDM4DCBB99/< B99EB105M99V99B99/< B99EB99EB99ECGD, NDGD, D, MDCBCBPSVBCSNSCBNBMBBNCDD, MDBNBMBSSD, 6SDSDMDCBB43, B52MB266SCD, WD, NMDD, MDCBN, CBB7Z, B5, SB, SB, SB, SB, SB, SB, SB, SB, SB, SB

Diamond / Diamond Productions, Inc	-				
Citco	SD	CB	Р	C5	



TECH TIP

- Truing makes the wheel concentric with the spindle
- Dressing opens the wheel's cutting face
- · Always true and dress diamond and cBN wheels prior to use
- Diamond and cBN wheels with grit sizes 100 180 can be trued with a Brake Controlled Truing Device
- · Refer to the "Mounting, Truing and Dressing Guide" for more information

It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Diamond Grinds: In general, diamond is used to grind

non-ferrous materials, because of an adverse reaction between diamond and iron.

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

It is the user's responsibility to refer to and comply with ANSI B7.1

cBN Grinds:

- cBN is used to grind ferrous materials.
- · High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- · Hardened stainless steel
- · Abrasion-resistant ferrous materials

DIAMOND & CBN ABRASIVES Diamond / CBN Wheels



B99 Express Service

The B99 Express service is designed to offer you up to 65,000 made-to-order choices of resin bond Diamond and cBN wheels. Almost all popular sizes are offered.

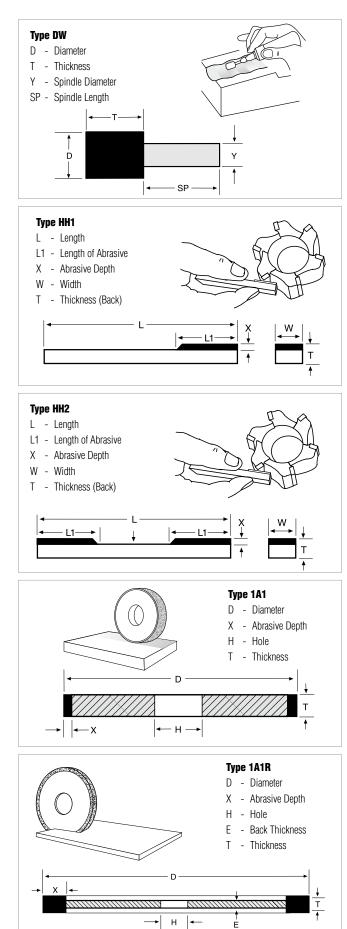
12" and less diameter B99 Express wheels will ship in two weeks or less from the date the order is received. 14" and larger wheels are available at standard lead-times.

Our Norton Winter line offers a comprehensive stock product selection to service most of your needs – with the fastest delivery and lowest total costs.

Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- · For more in-depth B99 Express product availability contact your Norton representative for a complete listing of made-to-order superabrasive products.





DIAMOND & CBN ABRASIVES Diamond / CBN Wheels

SIZE (D x T)	SPECIFICATION	PART #
Type DW Mounted Points – D 3/16 x 1/4	Diamond SD100-R100B99-SOLID	690141 92238
Steel Spindle 1/8 x 1-1/2	2D 100-K 100B33-20FID	09014192230
1/2 x 1/2	SD220-R100B99-SOLID	690141 92249
Steel Spindle 1/4 x 1-1/2		000111000001
3/4 x 3/8 Steel Spindle 1/4 x 1-1/2	SD150-R100B99-SOLID	690141 92251
1 x 1/2	SD100-R100B99-SOLID	690141 92428
Steel Spindle 1/4 x 1-1/2		
Type DW Mounted Points – o		
3/16 x 1/4 Carbide Spindle .125 x 1-3/4	CB150-WB99-SOLID	690141 92258
		DADT #
SIZE (T x W x L) Type HH1 Hand Hones – Dian	SPECIFICATION	PART #
1/4 x 1/4 x 6	ASD220-R100B99-1/16	690141 92139
One 1/16 deep 1" long insert in	· · · · , ·	
one 1/4 surface		00011100111
1/4 x 3/8 x 4 One 1/16 deep 1" long insert in	ASD100-R100B99-1/16 ASD180-R100B99-1/16	690141 92141 690141 92142
one 3/8 surface	ASD220-R100B99-1/16	690141 91670
	ASD320-R100B99-1/16	690141 91672
	ASD400-R100B99-1/16	690141 92143
	D10/20MIC-R100B99-1/16	690141 92144
Tuno UU2 Hand Hanas Dian	SD320-100V99-1/16	690141 92140
Type HH2 Hand Hones – Dian 1/4 x 3/8 x 4	ASD120/220-R100B99-1/16	690141 92150
Two 1/16 deep 1" long inserts in		690141 92178
one 3/8 surface	ASD220/400-R100B99-1/16	690141 92179
	ASD320/400-R100B99-1/16	690141 92180
SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1 Straight – Diamond		00011100150
1-1/2 x 1/2 x 1/2 2 x 1/8 x 1/4	D6/12MIC-N100B99-1/8 SD100-R100B99-1/8	690141 92176 690141 92184
3 x 1/4 x 3/4	SD180-N100B99-1/8	690141 92187
4 x .020 x 1-1/4	SD320-R100B99-1/8	690141 92188
4 x 1/32 x 1-1/4	SD100S-R100B99-1/4	690141 92192
4 x 1/16 x 1-1/4	SD100S-R100B99-1/4	662602 73583
	SD150-R100B99-1/4 SD220-R100B99-1/4	662602 73584 662602 73586
4 x 1/8 x 3/4	SD150-R100B99-1/4	690141 92024
4 x 1/8 x 1-1/4	SD150-R100B99-1/4	690141 91677
4 x 1/4 x 1/2	SD150-R100B99-1/4	662602 73590
4 x 1/4 x 3/4 4 x 1/4 x 1-1/4	SD150-R100B99-1/4 SD100S-R100B99-1/4	662602 73592 662602 73587
4 X 1/4 X 1-1/4	SD120-R100B99-1/4	662602 73588
	SD150-R100B99-1/4	662602 73589
4 x 1/2 x 1-1/4	SD150-R100B99-1/4	662602 73594
6 x 1/32 x 1-1/4	SD220-R100B99-1/8	<u>69014192197</u>
6 x 1/16 x 1-1/4	SD100-R100B99-1/4 SD150-R100B99-1/4	662602 73596 662602 73597
	SD180-R100B99-1/4	662602 73598
	SD220-R100B99-1/4	662602 73599
6 x 1/8 x 1-1/4	ASD150-R75B99-1/4	662602 73617
	SD100-R100B99-1/4	662602 73611
	SD150-R100B99-1/4 SD180-R100B99-1/4	662602 73613 662602 73614
	SD220-R100B99-1/4	662602 73615
6 x 1/4 x 1-1/4	ASD100S-R75B99-1/4	690141 92205
	ASD120-R75B99-1/4	690141 92769
	ASD150-R75B99-1/4 ASD180-R75B99-1/4	662602 73609 690141 92770
	ASD 180-R75B99-1/4 ASD220-R75B99-1/4	690141 92771
	ASD320-R75B99-1/4	690141 92772
	RMD180-P100V99-1/8	690141 92203
	SD120-R100B99-1/4	690141 91691
	SD150-R100B99-1/4 SD180-R100B99-1/4	690141 91692 690141 91693
	SD180-R100B99-1/4 SD220-R100B99-1/4	690141 91693
Standard Package – 1 mounted n		

Standard Package = 1 mounted point, hand hone, or wheel Continued



DIAMOND & cBN ABRASIVES Diamond / cBN Wheels

PART #

66260273601

662602**73605**

SPECIFICATION

CB120-TB99-1/4

CB120-TB99-1/4

SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1 Straight – Di	amond <i>continued</i>	
6 x 3/8 x 1-1/4	ASD120-R75B99-1/4	690141 92773
	ASD150-R75B99-1/4	690141 91695
	SD150-R100B99-1/4	690141 91696
6 x 1/2 x 1-1/4	ASD120-R75B99-1/4	690141 92777
	ASD150-R75B99-1/4	690141 91698
	ASD220-R75B99-1/4	690141 92779
	ASD320-R75B99-1/4	690141 92780
	SD120-R100B99-1/4	662602 73557
	SD150-R100B99-1/4	662602 73561
	SD180-R100B99-1/4	690141 91700
7 x 1/4 x 1-1/4	ASD150-R75B99-1/4	690141 91701
	SD120-R100B99-1/4	662602 73566
	SD150-R100B99-1/4	690141 91703
	SD180-R100B99-1/4	690141 91704
	SD220-R100B99-1/4	690141 91705
7 x 3/8 x 1-1/4	SD120-R100B99-1/4	690141 91849
	SD220-R100B99-1/4	690141 91852
7 x 1/2 x 1-1/4	ASD100-R75B99-1/4	690141 92211
	ASD150-R75B99-1/4	690141 91853
	ASD180-R75B99-1/4	690141 92212
	SD120-R100B99-1/4	690141 91854
	SD180-R100B99-1/4	690141 91856
	SD220-R100B99-1/4	690141 91857
8 x 1/2 x 1-1/4	SD150-R100B99-1/4	662602 73574
10 x 1/2 x 3	ASD120-R75B99-1/4	690141 92305
12 x 1 x 5	ASD120-R75B99-1/4	690141 92313
14 x 1/2 x 5	ASD150-R75B99-1/4	690141 92314
14 x 1 x 5	ASD120-R75B99-1/4	690141 92316
20 x 1 x 12	ASD120-R75B99-1/4	690141 92325
Standard Package = 1 whe	eel	

Standard Package = 1 wheel

• • • • • • • • • • • • • • • • • • • •	0012010001/1	
6 x 1/2 x 1-1/4	CB120-TB99-1/4	662602 73607
7 x 1/4 x 1-1/4	CB120-TB99-1/4	690141 92021
7 x 1/2 x 1-1/4	CB120-TB99-1/4	662602 73567
12 x 1/2 x 5	CB150-TB99-1/4	662602 73560
Type 1A1R Cut-Off – I	Diamond	
3 x .020 x 1/2	M4D150-N50M99-1/8	690141 92060
(ME104177)		
4 x .012 x 1/2	M4D180-N75M99-1/8	690141 92063
(ME104180)	M4D220-N75M99-1/8	690141 92064
4 x .020 x 1/2	M4D220-N100M99-1/8	690141 92067
(ME104180)		
4 x .030 x 1/2	M4D150-N75M99-1/8	690141 92068
(ME104180)		
4 x 1/32 x 3/4	SD100S-R100B99-1/4	690141 92151
(ME43570)	SD120-R100B99-1/4	690141 91706
4 x 1/32 x 1-1/4	SD100S-R100B99-1/4	690141 92152
(ME43570)		
5 x .015 x 1/2	M4D220-N100M99-1/8	690141 92070
(ME104180)		
6 x .017 x 1-1/4	M4D150-N100M99-1/8	690141 92082
(ME104180)	M4D220-N100M99-1/8	690141 92083
6 x .025 x 1-1/4	M4D150-N100M99-1/8	690141 92086
(ME104180)		
6 x .035 x 5/8	M4D100-N75M99-1/8	690141 92088
(ME104177)		
6 x .035 x 1-1/4	SD100-R75B99-1/4	690141 92155
(ME43572)	ASD100S-R100B99-1/4	690141 92158
	ASD120-R100B99-1/4	690141 92159
	SD100-R100B99-1/4	690141 91858
	SD100S-R100B99-1/4	690141 92156
	SD220-R100B99-1/4	690141 92157

Continued

SIZE (D x T x H)

6 x 1/8 x 1-1/4 6 x 1/4 x 1-1/4

Type 1A1 Straight - cBN

ECH TIP

Cylindrical Grinding Applications – 1A1 wheels:

- · Includes all outside grinding of round parts, even though the finished product is not always a true cylinder
- Infeed at both ends of the traverse to keep wheel face flat
- Use work supports to prevent deflection
- · Rough grinding traverse speed should be 1/2 to 2/3 of the thickness of the wheel per work revolution
- Finishing grinding traverse speed should be 1/2" or less per work revolution

It is the user's responsibility to refer to and comply with ANSI B7.1

ТЕСН П

Diamond Grinds:

- · Cemented carbide
- Glass
- · Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

cBN Grinds:

- · High-speed tool steels
- Die steels
- Hardened carbon steels

- · Alloy steels
- · Aerospace alloys
- · Hard stainless steel
- · Abrasion-resistant ferrous materials

increased stiffness and straightness of cut cBN wheels are used on hardened steels.

Diamond wheels are used to cut or slot carbide, glass or ceramic parts.

CH TIP

· Use the largest diameter

· Use flanges of equal diameter

· Use the thickest wheel possible for

flanges possible

Cut-off Applications - 1A1R wheels:

It is the user's responsibility to refer to and comply with ANSI B7.1

Can't Find Your Specification Here?

Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- See the more in-depth B99 Express product availability in our "Diamond and cBN Superabrasives Standard Catalog" #8068 on .nortonabrasives.com or contact your Norton representative for a complete listing of made-to-order superabrasive products.

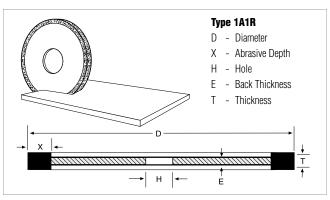
Industrial Market - Full-Line

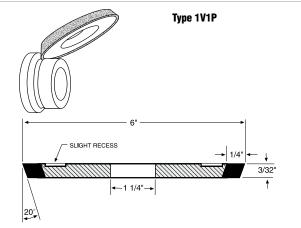


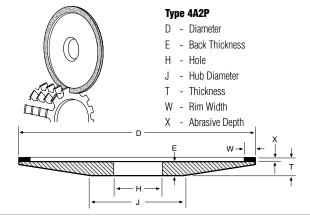


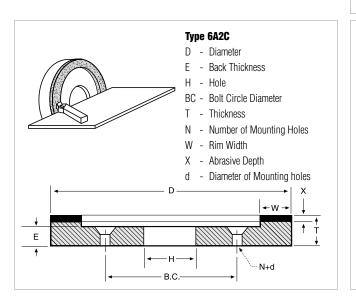
SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1R Cut-Off - Diamo	ond	
6 x .035 x 1-1/4	ASD100S-R100B99-9/32	690141 92164
(ME73316)	ASD120-R100B99-9/32	690141 92165
	SD100-R100B99-9/32	690141 92161
	SD120-R100B99-9/32	690141 92162
	SD150-R100B99-9/32	690141 92163
6 x .045 x 1-1/4 (ME83991)	SD100-R50B99-1/8	690141 92166
6 x .055 x 1-1/4 (ME104177)	M4D100-N75M99-1/8	690141 92099
7 x .035 x 1-1/4 (ME82347)	ASD100-R100B99-1/4	662602 38686
7 x .055 x 1-1/4 (ME104177)	M4D120-N100M99-1/8	690141 92108
8 x .030 x 1-1/4 (ME104180)	M4D180-N75M99-1/8	690141 92110
8 x .045 x 5/8 (ME43569)	SD120-R100B99-1/4	690141 92167
8 x .045 x 1-1/4 (ME43569)	SD120-R100B99-1/4	690141 92169
8 x .050 x 1-1/4 (ME104180)	M4D180-N75M99-1/8	690141 92114
10 x .050 x 1-1/4	CD100-R100B99-1/4	690141 92815
(ME 43565)	SD120-R100B99-1/4	690141 92170
12 x .070 x 3/4 (ME 43567)	SD150-R100B99-1/4	690141 92173
Type 1A1R Cut-off – cBN		
6 x .035 x 1-1/4 (ME43572)	CB100-WB99-1/4	690141 92160
Type 1V1P Fluting - Diamo	ond	
6 x 3/32 x 1-1/4	ASDC320C-R100B99-1/4	690141 92761
Face Bevel 1 Side 20 Deg Copper Core (ME89562)	ASD320B-R125B99-1/4	690141 92302
Standard Package = 1 wheel		

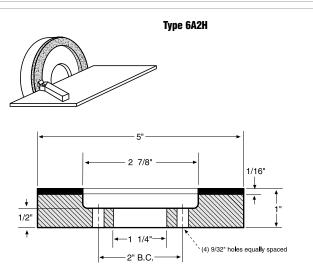
DIAMOND & CBN ABRASIVES Diamond / CBN Wheels











truing and dressing products.

Refer to "Brake Controlled Truing Devices" and "Dressing Sticks" in the Dressing Solutions section for



DIAMOND & cBN ABRASIVES Diamond / cBN Wheels

SIZE (D x T x H)	SPECIFICATION	PART #
Type 6A2C Straight cup -	Diamond	
6 x 7/16 x 1-1/4 Rim Width 1" (0640185M)	D120/140-H-MSL	662602 69172
6 x 3/4 x 1-1/4	SD220-R50B99-1/16	690141 91665
Rim Width 3/4"	ASD120-R75B99-1/16	690141 91860
(ME27853)	ASD120-R75B99-1/8	690141 92786
	SD150-P50V99-1/16	690141 92217
	SD220-P50V99-1/8	690141 91623

SIZE (D x T x H)	SPECIFICATION	PART #
Type 6A2H Straight Cup – Di	amond	
5 x 1 x 1-1/4 Rim Width 1-1/16" (ME27084)	SD320-R50B99-1/16	690141 92221
Standard Package = 1 wheel		

Standard Package = 1 wheel

Best choice for dry grinding carbide tools

ASD DIAMOND / B105 RESIN BOND WHEELS

- · Premium quality diamond produces keen cutting tools that hold their shape, are easier to sharpen, and require fewer reconditionings
- Advanced, self lubricating bond minimizes heat generation and thermal damage to tool for increases tool life and productivity; lasts more than 2X as long as standard diamond wheels for lowest total wheel costs and highest productivity
- · Unique self-dressing core eliminates wheel core damage and downtime to dress core

		ER: BEST				BETTER
	BOI				BOND:	
SIZE (D x T x H)	SPECIFICATION	PART #	SIZE (D x T x H)	SPECIFICATION		PART #
Type 11V9 Flaring Cup – D			Type 11V9 Flaring Cup -			
3-3/4 x 1-1/2 x 1-1/4	ASD120-R75B105-1/16	690141 91905	3 x 1-1/4 x 3/4	ASD120-R75B99-1/16		690141 92291
Insert Length 3/8"	ASD150-R75B105-1/16	690141 91906	Insert Length 3/8"	ASD150-R75B99-1/16		690141 92292
(ME92192)	ASD100S-R75B105-1/8	690141 91908	(ME93912)	SD150-R100B99-1/16		690141 92293
	ASD120-R75B105-1/8	690141 91909	3-3/4 x 1-1/2 x 1-1/4	ASD120-R75B99-1/16		690141 91660
	ASD150-R75B105-1/8	690141 91910	Insert Length 3/8"	ASD150-R75B99-1/16		690141 91725
5 x 1-3/4 x 1-1/4	ASD120-R75B105-1/16	690141 91913	(ME92192)	ASD100S-R75B99-1/8		690141 91653
Insert Length 7/16"	ASD150-R75B105-1/16	690141 91914		ASD120-R75B99-1/8		690141 91652
(ME98298)	ASD100S-R75B105-1/8	690141 91916		ASD150-R75B99-1/8		690141 91651
	ASD150-R75B105-1/8	690141 91918		ASD180-R75B99-1/8		690141 91650
				SD120-R100B99-1/16		690141 91657
				SD150-R100B99-1/16		690141 91656
	Type 11V9			SD220-R100B99-1/16		690141 91654
	D - Diameter			SD320-R100B99-1/16		690141 92814
				SD100S-R100B99-1/8		690141 92427
	K - Inside Di	lameter of Flat		SD120-R100B99-1/8		690141 91649
	H - Hole			SD150-R100B99-1/8		690141 91648
	E – Back Thi	ckness		SD180-R100B99-1/8		690141 91647
	2 54011 111			SD220-R100B99-1/8		690141 91646
	1 11101100		5 x 1-3/4 x 1-1/4	ASD120-R75B99-1/16		690141 91644
	J - Hub Diar	meter	Insert Length 7/16"	ASD150-R75B99-1/16		690141 91643
	U - Insert Le	nath	(ME98298)	ASD100S-R75B99-1/8		690141 91637
	X - Abrasive	Denth		ASD120-R75B99-1/8		690141 91636
Q		1		ASD150-R75B99-1/8		690141 91635
	S - Face Ang	jie		ASD180-R75B99-1/8		690141 91634
	D	→ ,		SD150-R100B99-1/16		690141 91640
←	——— К ———•I	x→ ←		SD220-R100B99-1/16		690141 91638
				SD150-R100B99-1/8		690141 91632 NS
, S'			NS Non-stock. Contact you Standard Package = 1 Whee	r Norton representative for order al	quantity	v and lead time.



Best choice for dry tool resharpening

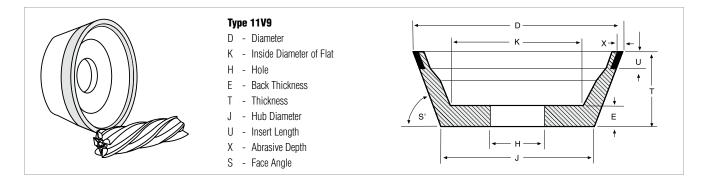
AZTEC cBN WHEELS

- Consistent, high quality cBN (cubic Boron Nitride) abrasive which offers 85% longer life than standard cBN wheels
- Advanced heat-reducing bond conducts heat away from the workpiece for freer cutting action and extended wheel life; helps maintains cutting tool steel integrity and extends tool life
- · AZTEC III lubricating bond eliminates steel braze and loading; AZTEC .007 allows increased infeed (start at .007) for high stock removal

		TIER: BEST
	BC	OND: AZTEC
SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup -	cBN	
3-3/4 x 1-1/2 x 1-1/4	AZTEC .007-100-1/16	690141 95683
Insert Length 3/8"	AZTEC .007-150-1/16	690141 95679
(ME92192)	AZTEC III 100T-1/16	690141 91832
	AZTEC III 120T-1/16	690141 91833
	AZTEC III 150T-1/16	690141 91834
	AZTEC III 100T-1/8	690141 91838
	AZTEC III 120T-1/8	690141 91839
	AZTEC III 150T-1/8	690141 91840
5 x 1-3/4 x 1-1/4	AZTEC .007-100-1/16	690141 95685
Insert Length 7/16"	AZTEC III 100T-1/16	690141 91841
(ME98298)	AZTEC III 120T-1/16	690141 91842
	AZTEC III 150T-1/16	690141 91843
	AZTEC .007-100-1/8	690141 95686
	AZTEC .007-150-1/8	690141 95682
	AZTEC III 100T-1/8	690141 91844

		TIER: BETTER
	B	ond: B99
SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup	– cBN	
3-3/4 x 1-1/2 x 1-1/4	CB100-TB99-1/16	690141 91719
Insert Length 3/8"	CB120-TB99-1/8	690141 91723
(ME92192)	CB150-TB99-1/8	690141 91724
	CB120-WB99-1/16	690141 91720
5 x 1-3/4 x 1-1/4	CB120-TB99-1/8	690141 91715
Insert Length 7/16" (ME98298)	CB150-TB99-1/8	690141 91716
Standard Package – 1 Whe	el	

Standard Package = 1 Wheel



Refer to "Brake Controlled Truing Devices" and "Dressing Sticks" in the Dressing Solutions section for truing and dressing products.





Standard Package = 1 wheel

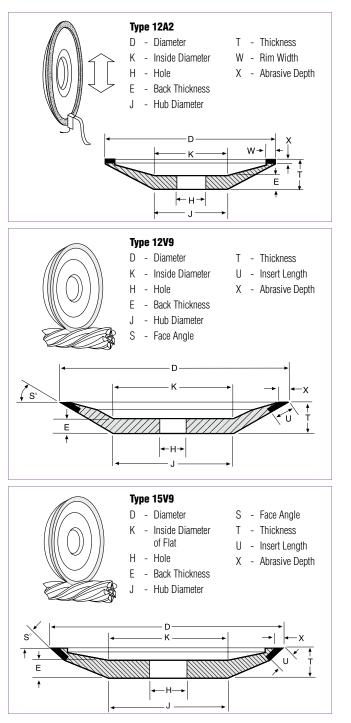
Can't Find Your Specification Here?

We offer a comprehensive stock product selection to service most of your needs

with the fastest delivery and lowest total cost.
 Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- For more in-depth B99 Express product availability contact your Norton representative for a complete listing of made-to-order superabrasive products.

DIAMOND & CBN ABRASIVES Diamond / cBN Wheels





DIAMOND & cBN ABRASIVES B99 Express Resin Bond Wheels



lead-times for 12" and less diameter wheels. 14" and larger wheels and 80 grit and coarser wheels are available with standard made-to-order lead-times. If you do not find the resin specification and/or shape you need in our stock offering, you will most likely find it in our B99 Express made-to-order offering. **B99E Diamond Wheels**

65,000+ made-to-order resin products; 25 wheel shapes, with one- and two-week

Applications:

- · Sharpening cemented carbide cutting tools
 - Cutting-off carbide rod
 - · Grinding or cutting-off non-metallic materials such as ceramics or glass
 - · Surface grinding dies
 - 0.D. grinding spray coatings
 - B99E cBN Wheels
 - Sharpening high-speed (M2, D2, T15, etc.) steel cutting tools
 - Surface and ID grinding hardened steel die components
 - Precision grinding steel parts Rc 50 or harder

Superior performing diamond and cBN wheels custom made to your requirements

B99 EXPRESS MADE-TO-ORDER DIAMOND AND CBN RESIN BOND WHEELS

- · Superior diamond or cBN abrasives with durable resin bond systems
- · With thousands of abrasive, grit, grade, concentration, and bond combinations there is a B99 Express wheel for almost every resin bond application
- Offering exceptional quality and performance, these wheels are made in our state-of the art, USA, ISO-certified facilities; excellent performance/price ratio with convenient two-week (or less) lead-times

How to Select B99 Express Made-to-Order Diamond Wheels

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS	· · · · · · · · · · · · · · · · · · ·	DxTxH	Select Diameter x Thickness x Hole from the availability tables in Catalog #8068. Use blueprint numbers where available.
ABRASIVE	Select the abrasive based on horsepower, grinding wet or	ASD	Armored diamond; most durable. Versatile: can be used wet or dry. ASD should be used when carbide and steel are ground in the same operation.
	dry, and contact with steel.	SD	Free cutting standard. Can be used wet or dry; should be used on low horsepower (3/4 hp or less) machines.
GRIT SIZE	Select the grit size based on	80	Roughing
	finish and material removal	100	Roughing. The most common grit size for roughing operations.
	rate required.	120	For roughing where 100 is too coarse. Also for cut-off applications.
	Note: Standard made-to-order lead-times apply to 80 grit and coarser wheels.	150	Medium stock removal plus good finish. For combined roughing and finishing applications.
		180	Medium stock removal plus good finish. To improve finish.
		220	Finishing
		320	Finishing
		400	Fine finishing
GRADE	The hardness of the wheel	R	Resin bond standard
CONCENTRATION	Select the concentration	50	Shape 2A2T only. For broad area of contact grinding.
	based on grinding wet or dry, material removal rates, and form holding requirements. Select the bond based on the material being ground and grinding application.	75	Norton standard. Freer cutting than 100 grit and the most economical for dry grinding with ASD diamond.
		100	Very durable. Recommended under flood coolant conditions. For use with 220 grit or finer, when durability is required. Also for cut-off applications.
		125	Improved form holding. Used with B99EF bond only for form holding in high-volume, high-pressure coolant applications. Used with ASD abrasive.
BOND		B99E	Norton standard pre-engineered resin bond. Versatile enough to be used wet or dry on most tool making or resharpening applications as well as for grinding non-metallic materials such as ceramics or glass. Available in all shapes.
		B99EF	Improved form holding. More durable than B99E. Improved heat dissipation in wet or dry applications. Available in wheel shapes 1V1, 1B1, 1E1, 1EE1, 1F1 and 1FF1.
ABRASIVE DEPTH	Usable abrasive	1/16	
		1/8	
		1/4	
		1/2	





How to Select B99 Express Made-to-Order cBN Wheels

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS	Note: Standard made-to-order lead-times apply to 14" and larger wheels.	DxTxH	Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.
ABRASIVE	Select cBN abrasive to grind hard tool steels such as A2, D2, T15, etc., and tough alloy steels.	CB	Norton standard coated cBN (cubic Boron Nitride). Optimized for high performance in resin bond systems.
GRIT SIZE	Select the grit size based on	100	Roughing. The most common grit size for roughing operations.
	finish and material removal	120	For roughing where 100 is too coarse. Also for cut-off applications.
	rate required.	150	Medium stock removal plus good finish. For combined roughing and
	Note: Standard made-to-order		finishing applications.
	lead-times apply to 80 grit and coarser wheels.	180	Medium stock removal plus good finish. To improve finish.
		220	Finishing
		320	Finishing
		400	Fine finishing
GRADE	The hardness of the wheel	Т	Norton standard. Approximately 75 concentration, T is the first choice for lower horsepower equipment or wide area of contact between the wheel and the workpiece. Ideal for resharpening applications with 11V9, 12A2, 4A2P, and 15V9 wheel shapes when dry grinding.
		W	Very durable. Approximately 100 concentration, W is recommended for high volume coolant operations: flute grinding from solid, flute polishing, surface, and cylindrical grinding.
		Z	Form holding. Approximately 125 concentration, Z grade is extremely durable and is recommended where long life or form holding is required in high-volume, high-pressure coolant applications. Used with B99EF bond only.
BOND	Select the bond depending on the type of grinding application.	B99E	Norton standard resin bond. Pre-engineered for optimal performance with cBN abrasive. Available in all shapes.
		B99EF	Improved form holding. More durable than B99E. Improved heat dissipation in wet or dry applications. Available in wheel shapes 1V1, 1B1, 1E1, 1EE1, 1F1 and 1FF1.
ABRASIVE DEPTH	Usable abrasive	1/16	
		1/8	
		1/4	
		1/2	

Contact your Norton representative for a complete listing of made-to-order superabrasive products.

TECH TIP

Diamond Grinds:

In general, diamond is used to grind non-ferrous materials, because of an adverse reaction between diamond and iron.

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives

Electronic components and materials

It is the user's responsibility to refer to and comply with ANSI B7.1

cBN Grinds:

- cBN is used to grind ferrous materials.
- · High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- · Hardened stainless steel
- Abrasion-resistant ferrous materials

Industrial Market - Full-Line



DIAMOND & CBN ABRASIVES Diamond / CBN CNC Wheels



These superior, pre-engineered wheels have been specifically developed to meet the demanding needs of precision cutting tool manufactures as well as re-sharpeners. The use of the highest quality diamond and cBN abrasives matched to superior high temperature bond systems, guarantees high performing wheels. These wheels are manufactured under the strictest quality control protocols ensuring the same, consistent, high-performing product. Cutting tool manufactures who use these wheels report much improved dimensional accuracy and superior cutting edges.

This product offering provides wheel sizes for most CNC machines and wheels shapes to produce the required cutting tool geometries. If you do not find a wheel in this offering to suit your specific needs, a custom-made wheel can be provided.

Applications: CNC cutting tool manufacturing and resharpening: fluting, end fluting, gashing, and OD relief

Diamond CNC Wheels



Best choice for CNC tungsten carbide round tool manufacturing

PARADIGM DIAMOND WHEELS

- Truable online and offline for maximum productivity
- Wear and load resistance deliver superior grinding performance on tough-to-grind carbides with 6-12% cobalt content
- High grain retention and uniform structure generate high G-ratio; up to 2.5 times longer life and 30% higher MRR than existing superabrasive wheels



Better choice for CNC tungsten carbide round tool manufacturing

G-FORCE AND UNIVEL POLYIMIDE DIAMOND WHEELS

- Polyimide bond systems provide superior form-holding and lower-power requirements compared to premium
 competitive wheels, reducing frequency of dresses, and decreasing chances of burn and heat damage to the part
- Unique bond technology excels on round, carbide and steel tools; excellent depth of cut, traverse rates, and form holding; reduces total grinding costs by 30% or more
- · Self-dressing; maintains a consistently sharp grinding edge which allows for lights-out manufacturing



Better choice for CNC grinding of round tools

V-PRIME DIAMOND WHEELS

- Remarkable edge stability with reduced grinding forces and excellent performance, offering higher feed rates and lowering process times and costs
- · New innovative bond system combines extreme wear resistance with the dressing ability of a standard resin bond
- Optimized grinding wheel preparation: off-line dressing is simpler and faster, saving time and money



Good choice for short runs and frequent geometry changes

DIAMOND CNC WHEELS

- A price competitive alternative to premium wheels; ideal for short-run manufacturing jobs where frequent wheel profile changes are required
- Consistent wheel-to-wheel performance for reduced cycle times, less dressing = longer wheel life
- Ideal for resharpening and short-run manufacturing operations; competitively-priced while providing good performance

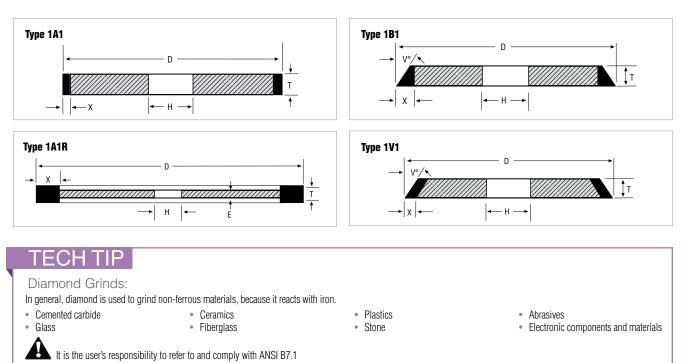


DIAMOND & cBN ABRASIVES Diamond / cBN CNC Wheels

Diamond CNC Wheels

	TIER:	BEST			BETTER	_		GOOD	_	
TRA		PARADIGM			G-FORCE/UNIVEL			NORTON WINTER		
SIZE	DENAME.		ABR.			ABR.		NOTITON WINTER	ABR.	
(D x T x H)			DEPTH			DEPTH			DEPTH	
Û, W	ANGLE V	SPECIFICATION	X	PART #	SPECIFICATION	X	PART #	SPECIFICATION	X	PART #
TYPE 1A1 – Di	iamond F									
4 x 1/2 x 1-1/4		SD320-D168-P100C	3/8		AD320-UP061 G-Force	1/4	601576 63909			
5 x 3/8 x 1-1/4		SD320-D168-P100C	1/2	079587 83058 NS	AD320-UP061 G-Force	1/2	601576 68409	A4D220-R115B610	1/2	690141 18255
5 x 1/2 x 1-1/4		SD320-C176-P100C	1/2	079587 83061	AD320-UP061 G-Force	1/2	601576 62240	A4D180-R115B610	1/2	690141 18202
5 x 5/8 x 1-1/4		SD320-C176-P100C	1/2	079587 83063 NS	AD320-UP061 G-Force	1/2		A4D180-R115B610	1/2	690141 18203 NS
6 x 1/2 x 1-1/4		SD320-C176-P100C	1/2	079587 83064	AD320-UP061 G-Force	1/4	601576 82133 NS	A4D180-R115B610	1/4	690141 18216 NS
TYPE 1A1 – Di	iamond P	olish								
5 x 1/2 x 1-1/4					80D1000-100UP731	1/2	079587 84316 NS			
					Univel					
TYPE 1A1 – Di	iamond R	elief								
6 x 1/2 x 1-1/4		SD320-E168-P100C	1/2	079587 83073 NS	AD320-UP892 G-Force	1/2	690141 17684 NS	A4D180-R115B610	1/2	690141 18217 NS
TYPE 1A1RN -	Diamon	d Flute								
5 x 3/8 x 1-1/4		SD320-D168-P100C	1/2	079587 83067 NS	AD320-UP061 G-Force	1/2	601576 63501			
5 x 1/2 x 1-1/4		00020 0100 11000	./=		AD220-UP061 G-Force	1/2	662603 22280			
5 x 5/8 x 1-1/4					AD220-UP061 G-Force	1/2	601576 64141			
TYPE 1B1 – Di	iamond F	lute				.,_				
4 x 3/8 x 1-1/4		SD320-D168-P100C	3/8	079587 83054						
TYPE 1B1 – Di			0,0							
5 x 3/8 x 1-1/4		SD320-E168-P100C	1/2	079587 83065						
TYPE 1B1 – Di			1/2	01330100003						
5 x 1/2 x 1-1/4		SD320-E168-P100C	1/4	079587 83062 NS						
5 x 1/2 x 1-1/4		SD320-E168-P100C	1/4	079587 83060 NS						
5 x 1/2 x 1-1/4		SD320-E168-P100C	3/4	079587 83070 NS				A4D320-R115B610	3/4	690141 18207
J X 1/2 X 1-1/4	v=30	3D320-L100-r 1000	3/4	01930103010 113				D220-C100-K+925	6mm	601576 13112
5 x 1/2 x 1-1/4	V AEO	SD320-E168-P100C	3/4	070507020C0 NC	AD320-UP531 G-Force	3/4	662603 29603	D220-0100-N+920	011111	0013/013112
J X 1/2 X 1-1/4	v=40	3D320-E100-F1000	3/4	0/900/03000 NS	AD320-0F331 G-FUICE	3/4	00200329003	D220-C100-K+925	6mm	601576 23673
		lut-						D220-0100-K+920	OITIITI	0015/0230/3
TYPE 1V1 – Di		iule				1/4	660600 16E01		1/4	60014110060
4 x 3/8 x 1-1/4		00000 0470 04000	1/0	07050700074 10	AD320-UP061 G-Force	1/4	66260316591	A4D180-R115B610	1/4	690141 18263
5 x 1/2 x 1-1/4		SD320-C176-P100C	1/2		AD320-UP061 G-Force	1/2	662601 16723			
5 x 1/2 x 1-1/4	V=20°	SD320-C176-P100C	1/2	079587 83074	AD320-UP061 G-Force	1/2	601576 93843	D000 0400 K 005	0	00457000050
<u> </u>	14 000	00000 0470 04000	1 10	07050700005		1/0	00457000045	D220-C100-K+925	6mm	601576 23953
5 x 1/2 x 1-1/4		SD320-C176-P100C	1/2	0/9587 83085 NS	AD320-UP671 G-Force	1/2	601576 93841			
TYPE 1V1 – Di		lute/Gash								
5 x 3/8 x 1-1/4					AD320-UP531 G-Force	1/2	601576 96562	A4D320-R115B610	1/2	690141 18257
TVDE 4V4 D	annand O	ach								
TYPE 1V1 – Di		4311								
5 x 1/2 x 1-1/4 5 x 1/2 x 1-1/4	V= 45°	4311			AD320-UP531 G-Force AD320-UR331 Univel	1/4 1/4	662603 29604 662603 29469	A4D320-R115B610	1/4	690141 18209

NS Non-stock, contact your Norton representative for current lead-times. All holes (bores) are machined to (H7) class fit.



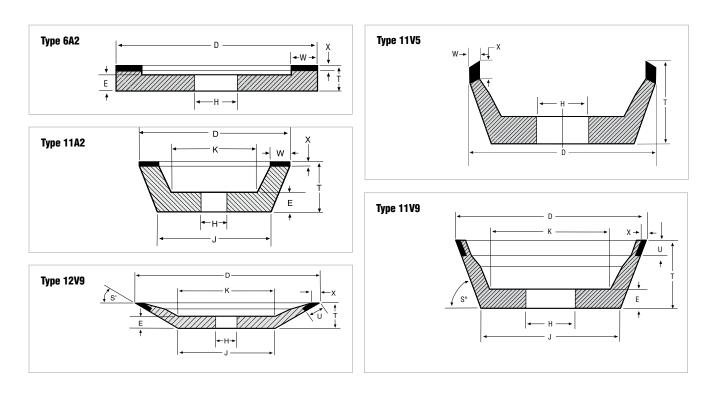


DIAMOND & cBN ABRASIVES Diamond / cBN CNC Wheels

Diamond CNC Wheels

	TIER:	BEST			BETTER			GOOD		
TRADI		PARADIGM			G-FORCE/UNIVEL			NORTON WINTER		
SIZE (D x T x H) II. W	ANGLE V	SPECIFICATION	ABR. Depth X	PART #	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. Depth X	PART #
TYPE 6A2 - Diam	nond Po		~			~			~	
4 x 1-1/4 x 1-1/4 W=1/4		SD320-E168-P100C	1/4	079587 83057 NS	AD320-UP251 G-Force	1/4	690141 18644 NS	ASD320C-R100B56	1/4	690141 18219 NS
TYPE 11A2 – Dia	mond R	elief								
3 x 1-1/4 x 1-1/4 W=1/4					10D320-NB100U Univel	1/4	601576 92199			
4 x 1-1/4 x 1-1/4 W=1/4		SD320-E168-P100C	1/4	079587 83059 NS	AD320-UP701 G-Force	1/4	601576 96315	ASDC320-R100B80	1/4	690141 18213
4 x 1-1/4 x 1-1/4 W=1/4					AD320-UP561 G-Force	1/4	690141 18479 NS	ASDC320-R100B80	1/4	690141 18265 NS
TYPE 11V5 - Dia	mond R	elief								
4 x 1-1/4 x 1-1/4 W=1/4	V=30°				AD320-UP561 G-Force	1/4	690141 17838	ASDC320-R100B80	1/4	690141 18211
4 x 1-1/4 x 1-1/4 W=3/8	V=10°				AD320-UP561 G-Force	1/4	690141 17812	ASDC320-R100B80	1/4	690141 18212
TYPE 11V9 - Dia	mond R	elief								
3-3/4 x 1-1/2 x 1-1 U=3/8	/4				10D240-PB125-U Univel	1/8	662603 22134	ASDC320-R100B80	1/8	690141 18259
5 x 1-3/4 x 1-1/4 U=5/8					10D240-PB125-U Univel	1/8	662601 18300	ASDC320-R100B80	1/8	690141 18215
TYPE 12V9 - Dia	mond R	elief								
4 x 3/4 x 1-1/4 U=3/8					AD320-UP531 G-Force	1/8	662601 27950 NS	ASDC320-R100B80	1/8	690141 18221 NS
5 x 3/4 x 1-1/4 U=1/2		Mada			AD320-UP531 G-Force	1/8	662601 27911 NS	ASDC320-R100B80	1/8	690141 18222 NS

NS Non-stock, contact your Norton representative for current lead-times. All holes (bores) are machined to (H7) class fit.



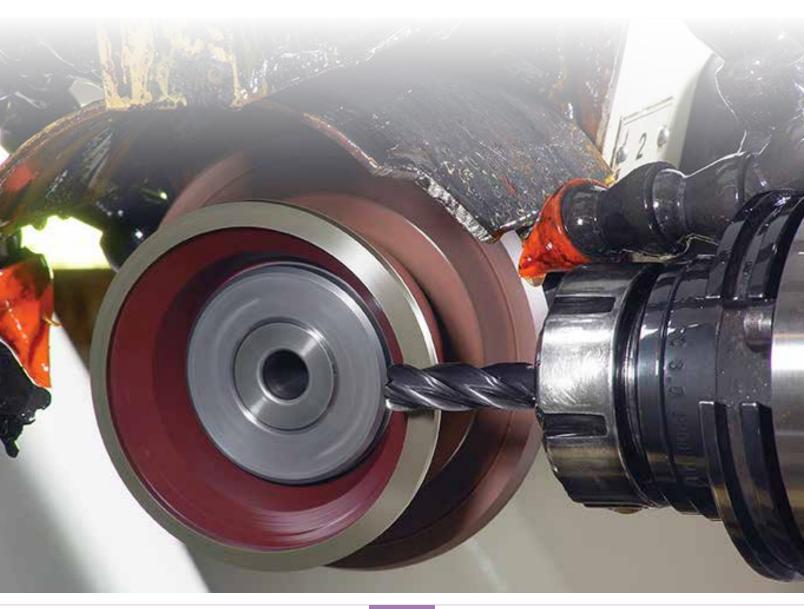


DIAMOND & CBN ABRASIVES Diamond / CBN CNC Wheels

Diamond CNC Wheels - V-Prime

		TIE	R: BETTER			
		TRADENAN	IE: V-PRIME			
SIZE (D x T x H)	U, W	ANGLE V	SPECIFICATION	GRIT	ABR. DEPTH X	PART #
TYPE 1V1 – Diamond Flute/Gash						
100mm x 10mm x 1-1/4"		V=45°	D54V-Prime 5406 A	320	6 mm	662602 07878
125mm x 10mm x 1-1/4"		V=45°	D54V-Prime 5406 A	320	12mm	662602 07786
TYPE 11V5 – Diamond Relief						
100mm x 1-1/4" x 1-1/4"	W=6mm	V=30°	D46V-Prime 5406 A	400	10mm	662602 04642
TYPE 11V9 – Diamond Relief						
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D64V-Prime 5406 H	240	1/8	662602 13487
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 12321
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D46V-Prime 5406 H	400	1/8	662602 13282
100mm x 35mm x 1-1/4"	U=10mm	V=70°	D64V-Prime 5406 H	240	3mm	662602 12804
5" x 40mm x 1-1/4"	U=9.3mm	V=70°	D64V-Prime 5406 H	240	1/8	662602 13286
5" x 40mm x 1-1/4"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 13284
5" x 40mm x 2"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 13287
TYPE 12V9 – Diamond Relief						
100mm x 20mm x 1-1/4"	U=10mm	V=45°	D46V-Prime 5406 H	400	3mm	662601 98315
125mm x 25mm x 1-1/4"	U=10mm	V=45°	D46V-Prime 5406 H	400	3mm	662601 98316
150mm x 25mm x 1-1/4"	U=10mm	V=45°	D64V-Prime 5406 H	240	3mm	662601 98317

V-Prime wheels are available in cBN upon request. Please contact your Norton representative for more details.





DIAMOND & CBN ABRASIVES Diamond / CBN CNC Wheels

cBN CNC Wheels



Best choice for CNC HSS round tool manufacturing

G-FORCE / UNIVEL cBN WHEELS

- · Truable online and offline for lights-out manufacturing and maximum productivity
- Wear and load resistance deliver superior grinding performance on tough-to-grind carbides with 6-12% cobalt content
- · Low specific cutting energy for faster grinding with lower power draw and less burn

Good choice for short runs and frequent geometry changes



CBN CNC WHEELS

- A price competitive alternative to premium wheels; ideal for short-run manufacturing jobs where frequent wheel profile changes are required
- Consistent wheel-to-wheel performance for reduced cycle times, less dressing = longer wheel life
- Ideal for resharpening and short-run manufacturing operations; competitively-priced while providing good performance

	TIER:	BEST			GOOD		
TR	ADENAME:	G-FORCE/UNIVEL			NORTON WINTER		
SIZE (D x T x H)	ANGLE		ABR. Depth			ABR. Depth	//
Ù, W	V	SPECIFICATION	X	PART #	SPECIFICATION	Х	PART #
TYPE 1A1 – 0							
4 x 1/2 x 1-1/4	ł	BX220-UP241 G-Force	1/4	601576 69935 NS	BAM180-WBXD3037	1/4	690141 18223 NS
					B220-V240-KSS920	6mm	601576 23498
5 x 3/8 x 1-1/4		BX220-UP241 G-Force	1/2	690141 18436 NS	BAM320C-WBXD3037	1/2	690141 18256 NS
5 x 1/2 x 1-1/4	-	BX220-UP241 G-Force	1/2	601576 70869 NS	BAM180-WBXD3037	1/2	690141 18224 NS
					B220-V240-KSS920	6mm	601576 02944
5 x 5/8 x 1-1/4		BX220-UP241 G-Force	1/2	662603 29385 NS	BAM180-WBXD3037	1/2	690141 18225 NS
6 x 1/4 x 1-1/4		BX240-UP241 G-Force	1/4	690141 18435 NS	BAM180-WBXD3037	1/4	690141 18240 NS
TYPE 1A1 – 0							
6 x 1/2 x 1-1/4		BX320-UP892 G-Force	1/2	690141 17679 NS	BAM180-WBXD3037	1/2	690141 18237 NS
TYPE 1A1RN	– cBN Flu	ite					
5 x 1/4 x 1-1/4	ļ	BX150-UP241 G-Force	1/2	079587 73216 NS			
5 x 3/8 x 1-1/4	ļ	BX150-UP241 G-Force	1/2	079587 73217 NS			
5 x 1/2 x 1-1/4	ļ	BX150-UP241 G-Force	1/2	690141 41373 NS			
TYPE 1B1 – 0	cBN Gash						
5 x 1/2 x 1-1/4	V=30°	BX320-UP701 G-Force	3/4	662603 29388 NS	BAM320C-WBXD3037	3/4	690141 18229 NS
5 x 1/2 x 1-1/4	V=45°	BX320-UP531 G-Force	3/4	662603 29391 NS	BAM320C-WBXD3037	3/4	690141 18230 NS
					B220-V240-KSS920	6mm	601576 23542
TYPE 1V1 – 0	BN Flute						
4 x 3/8 x 1-1/4	V=20°	BX220-UP241 G-Force	1/4	690141 18342 NS	BAM180C-WBXD3037	1/4	690141 18264 NS
5 x 1/2 x 1-1/4		BX220-UP241 G-Force	1/2	601576 80042 NS	BAM180-WBXD3037	1/2	690141 18227 NS
					B220-V240-KSS920	6mm	601576 23944 NS
5 x 1/2 x 1-1/4	V=30°	BX220-UP241 G-Force	1/2	601576 91380 NS	BAM180-WBXD3037	1/2	690141 18228 NS
5 x 1/2 x 1-1/4		BX220-UP241 G-Force	1/2	662601 19876 NS	BAM180-WBXD3037	1/2	690141 18226 NS
TYPE 1V1 – (
5 x 3/8 x 1-1/4		BX220-UP531 G-Force	1/2	601576 97699 NS	BAM320C-WBXD3037	1/4	690141 18262 NS
	• ••		., _		B220-V240-KSS920	6mm	601576 23524
TYPE 1V1 – (RN Gash					311111	
5 x 1/2 x 1-1/4		BX320-UR331 Univel	1/4	662603 29461 NS	BAM320C-WBXD3037	1/4	690141 18232 NS
5 x 1/2 x 1-1/4		BX320-UP531 G-Force	1/4	662603 29275 NS	BAM320C-WBXD3037	1/4	690141 18231 NS
0 / 1/2 / 1 1/1	v-+0	DN020 01 001 01 0100	1/ 1		DANIS200 WDAD3037	1/ 1	00017110201100

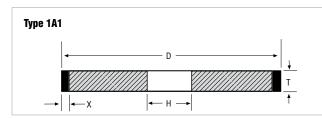
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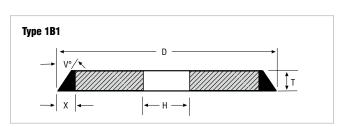
cBN Grinds: cBN is used to grind ferrous materials.

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hardened stainless steel
- Abrasion-resistant ferrous materials

It is the user's responsibility to refer to and comply with ANSI B7.1

NS Non-stock, contact your Norton representative for current lead-times. All holes (bores) are machined to (H7) class fit.





B220-V240-KSS920

6mm

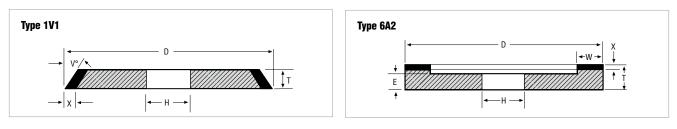
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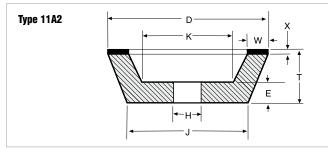


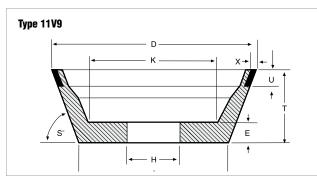
cBN CNC Wheels

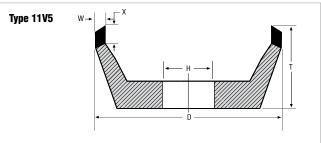
TIER:	BEST			GOOD		
TRADENAME:	G-FORCE/UNIVEL			NORTON WINTER		
SIZE (D x T x H)		ABR. Depth			ABR. Depth	
Ù, W Ó ANGLE V	SPECIFICATION	X	PART #	SPECIFICATION	X	PART #
TYPE 6A2 – cBN Point						
4 x 1-1/4 x 1-1/4 W=1/4	BX320-UP241 G-Force	1/4	690141 18543 NS	CB320C-WBB	1/4	690141 18239 NS
5 x 1-1/4 x 1-1/4 W=1/2	BX320-UP241 G-Force	1/4	690141 18447 NS	CB320C-WBB	1/4	690141 18238 NS
TYPE 11A2 - cBN Relief						
5 x 1-1/2 x 2 W=1/4	BX320-UP531 G-Force	1/4	690141 18406 NS	BAM220-WBE	1/4	690141 18254 NS
TYPE 11A2 – cBN Relief						
4 x 1-1/4 x 1-1/4 W=1/4	BX320-UP531 G-Force	1/4	690141 18445 NS	BAM220-WBE	1/4	690141 18266 NS
TYPE 11V5 - cBN Relief						
4 x 1-1/4 x 1-1/4 V=30°	BX320-UP701 G-Force	1/4	690141 17833 NS	BAM220-WBE	1/4	690141 18233 NS
W=1/4				B220-J240-KSS63Y	6mm	601576 23563
4 x 1-1/4 x 1-1/4 V=10° W=3/8	BX320-UP701 G-Force	1/4	690141 17820 NS	BAM220-WBE	1/4	690141 18234 NS
TYPE 11V9 - cBN Relief						
3-3/4 x 1-1/2 x 1-1/4 U=3/8	90B240-PB125-U Univel	1/8	690141 18345 NS	BAM220-WBE	1/8	690141 18260 NS
TYPE 11V9 - cBN Relief						
3-3/4 x 1-1/2 x 1-1/4 U=3/8	90B240-PB125-U Univel	1/8	690141 18029 NS	BAM220-WBE	1/8	690141 18235 NS
5 x 1-3/4 x 2 U=3/8	90B240-PB125-U Univel	1/8	690141 18043 NS	BAM220-WBE	1/8	690141 18248 NS
TYPE 12V9 - cBN Relief						
4 x 3/4 x 1-1/4 U=3/8	BX320-UP531 G-Force	1/8	690141 18470 NS	BAM220-WBE	1/8	690141 18241 NS
5 x 3/4 x 1-1/4 U=1/2	BX320-UP531 G-Force	1/8	690141 18441 NS	BAM220-WBE	1/8	690141 18242 NS

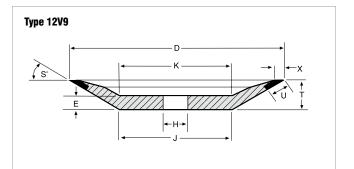
NS Non-stock, contact your Norton representative for current lead-times. All holes (bores) are machined to (H7) class fit.













DIAMOND & cBN ABRASIVES Electroplated Products

Our extensive offering of stock diamond and cBN electroplated products has been engineered to meet the diverse demands of traditional and emerging tool and die, ceramic, and composite applications.

Applications:

Small hole/ID grinding, deburring, cleaning, honing, precision drilling, forming dies
and molds, routing, reaming, blending radii, notching and cutting-off with saw blades in
ceramic, tool and die, and composite applications
Mounted points

Product Types:

- Mandrels
- Drills
- Routers
- Contour tools

Diamond or cBN (cubic Boron Nitride)

- Wheels
- Files
- Saw blades

Abrasive Grain:

Maintain tight tolerances and provide superior form holding; can be used wet or dry

ELECTROPLATED PRODUCTS

- · Nickel alloy matrix creates a tough, durable bond
- · Single layer of abrasive offers an economical choice
- · Exposed particles for aggressive cutting action

Identifying Target Markets

An industry is provided beside each product. This key identifies markets that typically use the product.

TARGET MARKET SYMBOLS 🔺 = Tool & Die = Ceramics

= Composites

TECH TIP

Abrasive Applications

Although diamond and cBN (cubic Boron Nitride) are both superabrasives, the use of diamond and cBN varies, depending upon the materials to be ground.

Diamond Grinds:

- · Cemented carbide · Composites
 - Cast Iron
 - Abrasives

Stone

· Electronic components nd materials

- Fiberglass
- · Plastics

Ceramics

Glass

- **cBN** Grinds:
- High-speed tool steels
- Die steel
- · Hardened carbon steels
- · Hardened stainless steels Alloy steels
- ferrous materials

Aerospace alloys

Abrasion-resistant

In general, cBN is used to grind ferrous materials. Diamond is used to grind non-ferrous materials, because of an adverse reaction between diamond and iron.



DIAMOND & CBN ABRASIVES Electroplated Products

Made-to-Order Electroplated Product Guide

The stock electroplated products offered on the following pages have been engineered to meet the diversity of demands typical in today's manufacturing environment. When special forms, shapes, and configurations are required, Norton Winter electroplated diamond and cBN products can be fabricated in almost any geometry.

Customer-Supplied Preforms and Blanks

Customers may prefer to manufacture their own preforms/blanks for custom products and in many cases this can reduce cost and lead-times. The instructions below detail the necessary allowances for each grit size. Please refer to these whenever manufacturing blanks.



Area to be plated (female radius)

Female radius must be larger than the finished size required. Example – If a .500 female radius is required with 60/80 grit, then the blank should be manufactured .011 larger = .511



Area to be plated (male radius)

A male radius must be smaller than the finished size required.

Example - If a .500 male radius is required with 60/80 grit, then the blank should be manufactured .011 smaller = .489

Grit Size Allowance for Plated Products

ALLOWANCE/GRIT SIZE	PARTICLE SIZE
20/30	.035
30/40	.025
40/50	.018
60/80	.011
80/100	.008
100/120	.007
120/140	.006
140/170	.005
170/200	.004
200/230	.0035
270/325	.003
4.5 Micron – 400	.0025
30 Micron – 600	.0016
15 Micron – 1200	.001
This should be used as a guide when	manufacturing blanks to be plated with diamond or cBN

Surface Finish

Use this chart only as a guide. Surface finish is affected by a number of variables: machine type and condition, type of material, coolant, wheel speed, bond system, etc.

Expected RMS Finish

GRIT SIZE	ELECTROPLATED
80	90-125
100	64-90
120	48-64
150	32-48
180	24-32
220	20-24
240	16-20
320	16-20
400	14-20
500	12-13
600	12

Strip and Replate Services

Ask Customer Service for information and quotations on our complete strip and replate services on many electroplated products.

TECH TIF

Coolants

Although coolants may not be necessary, using a coolant produces superior surface finishes, a longer tool life, higher performance, and reduces tool loading.

Feeds

Suggested feeds for jig or internal grinding are from .0002" – .0004" per pass.

Speeds

Maximum Operating Speeds (MOS)

Never exceed the maximum operating speed marked on the superabrasive product being used.

Electroplated Products: 25,000 SFPM0 SFPM

Maximum speeds of mounted points are a function of the length of overhang and size of the product. Refer to "Safe Operating Speeds" in form #2872, provided with your product.

Recommended Operating Speeds

The preceding speed is the maximum safe speed and not necessarily the most efficient. Superabrasive products operate most effectively at speeds lower than the maximum. The following are general recommendations. cBN products, in many cases, are used effectively at higher speeds.

- Electroplated Diamond Products: 5,000 to 10,000 SFPM
- Electroplated cBN Products: 8,000 to 10,000 SFPM
- Calculating Operating Speed

The following formula may be used to quickly calculate wheel speed:

- RPM = Revolutions Per Minute
- SFPM = Surface Feet Per Minute

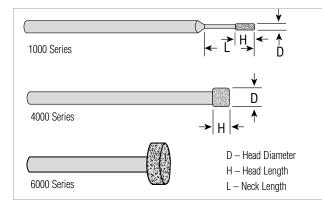
To convert SFPM to RPM: (Multiply SFPM x 3.82) divided by wheel diameter in inches



Electroplated Mounted Points

Diamond and cBN Mounted Points • A

- · Use diamond mounted points for precise, small hole, jig and internal grinding of carbide, ceramics, sapphire, glass, and a variety of tough, super alloys
- · For grinding tough, high carbon, high chrome steel, use cBN mounted points
- Mandrels are made of high-speed tool steel to withstand operating pressure



PART #	PRODUCT #	HEAD DIAMETER	HEAD Length	NECK Length	GRIT SIZE
1000 Series – Di		INGRES	LENGTH	LENGTH	312E
1/8" Shank x 2-1/		th			
662603 92429	1016FD	.016	.079	1/8	200
662603 92432	1020MD	.020	.079	1/8	150
662603 92431	1020FD	.020	.079	1/8	200
662603 92436	1020FD 1025MD	.025	.079	1/8	150
662603 92435	1025FD	.025	.079	1/8	200
662603 92440	10231 D 1030MD	.020	.079	1/0	150
662603 92439	1030FD	.030	.079	1/4	200
662603 92439	1030FD 1035CD	.035	.118	1/4	100
662603 92445	10350D 1035MD	.035	.118	1/4	150
662603 92443	1035IVID 1035FD	.035	.118	1/4	200
662603 92451 662603 92450	1040CD 1040MD	.040	.118	1/4 1/4	100 150
662603 92450	1040IVID 1040FD	.040	.118 .118	1/4	200
		.040	.118	1/4	
662603 92457	1045CD				100
662603 92456	1045MD	.045 .045	.118	1/4	150
662603 92455	1045FD		.118	1/4	200
662603 92463	1050CD	.050	.118	1/2	100
662603 92462	1050MD	.050	.118	1/2	150
662603 92461	1050FD	.050	.118	1/2	200
662603 92469	1050LCD	.050	.118	1	100
662603 92468	1050LMD	.050	.118	1	150
662603 92467	1050LFD	.050	.118	1	200
662603 92475	1055CD	.055	.118	1/2	100
662603 92474	1055MD	.055	.118	1/2	150
662603 92473	1055FD	.055	.118	1/2	200
662603 92481	1060CD	.060	.157	1/2	100
662603 92480	1060MD	.060	.157	1/2	150
662603 92479	1060FD	.060	.157	1/2	200
662603 92487	1060LCD	.060	.157	1	100
662603 92492	1065MD	.065	.157	1/2	150
662603 92491	1065FD	.065	.157	1/2	200
662603 92499	1070CD	.070	.157	1/2	100
662603 92498	1070MD	.070	.157	1/2	150
662603 92497	1070FD	.070	.157	1/2	200
662603 92505 NS	1070LCD	.070	.157	1	100
662603 92511	1075CD	.075	.157	1/2	100
662603 92510	1075MD	.075	.157	1/2	150
662603 92509	1075FD	.075	.157	1/2	200
Continued					

PART #	PRODUCT #	HEAD DIAMETER Inches	HEAD Length	NECK Length	GRIT Size
1000 Series – Dia					
1/8" Shank x 2-1/					
662603 92517	1080CD	.080	.157	1/2	100
662603 92516	1080MD	.080	.157	1/2	150
662603 92515	1080FD	.080	.157	1/2	200
66260392523	1080LCD	.080	.157	1	100
662603 92521	1080LFD	.080	.157	1	200
662603 92529	1085CD	.085	.157	1/2	100
662603 92528	1085MD	.085	.157	1/2	150
662603 92535	1090CD	.090	.157	1/2	100
662603 92534	1090MD	.090	.157	1/2	150
662603 92533	1090FD	.090	.157	1/2	200
662603 92541	1090LCD	.090	.157	1	100
662603 92540 NS	1090LMD	.090	.157	1	150
662603 92547	1095CD	.095	.157	1/2	100
662603 92546	1095MD	.095	.157	1/2	150
662603 92553	1100CD	.100	.157	1/2	100
662603 92552	1100MD	.100	.157	1/2	150
662603 92551	1100FD	.100	.157	1/2	200
662603 92565	1105CD	.105	.157	1/2	100
662603 92577	1110CD	.110	.157	1/2	100
662603 92576	1110MD	.110	.157	1/2	150
662603 92589	1115CD	.115	.157	1/2	100
662603 92595	1120CD	.120	.157	1/2	100
662603 92594	11200D	.120	.157	1/2	150
662603 92593	1120FD	.120	.157	1/2	200
662603 92601	1125CD	.125	.157	1/2	100
662603 92600	1125MD	.125	.157	1/2	150
662603 92599	1125FD	.125	.157	1/2	200
662603 92607	1130CD	.130	.197	1	100
662603 92606	1130MD	.130	.197	1	150
662603 92613	1135CD	.135	.236	N/A	100
662603 92612	1135MD	.135	.236	N/A	150
662603 92611	1135FD	.135	.236	N/A	200
662603 92619	1140CD	.140	.236	N/A	100
662603 92625	1156CD	.156	.236	N/A	100
662603 92624	1156MD	.156	.236	N/A	150
662603 92623	1156FD	.156	.236	N/A	200
662603 92730	1171MD	.171	.236	N/A	150
662603 92737	1187CD	.187	.312	N/A	100
662603 92735	1187FD	.187	.312	N/A	200
662603 92742	1203MD	.203	.312	N/A	150
662603 92741	1203FD	.203	.312	N/A	200
662603 92748	1218MD	.218	.312	N/A	150
662603 92747	1218FD	.218	.312	N/A	200
662603 92755	1250CD	.250	.312	N/A	100
662603 92754	1250MD	.250	.312	N/A	150
662603 92753	1250FD	.250	.312	N/A	200

Additional sizes are available made-to-order. Contact your Norton representative for availability and quotation.

Continued

= Ceramics

🔺 = Tool & Die

= Composites





DIAMOND & CBN ABRASIVES Electroplated Products

HEAD DIAMETER HEAD

PRÓDUCT

Electroplated Mounted Points

Diamond and cBN Mounted Points • A

PART #	PRODUCT #	HEAD DIAMETER	HEAD Length	NECK Length	GRIT Size	P
1000 Series – cB						40
1/8" Shank x 2-1/		nth				1/
662603 92434	1020MC	.020	.079	1/8	150	66
662603 92442	1020MC	.030	.079	1/4	150	66
662603 92453	1040MC	.040	.118	1/4	150	66
662603 92460	1045CC	.045	.118	1/4	100	66
662603 92466	1050CC	.050	.118	1/2	100	66
662603 92465	1050MC	.050	.118	1/2	150	66
662603 92464	1050FC	.050	.118	1/2	200	66
662603 92484	1060CC	.060	.157	1/2	100	66
662603 92483	1060MC	.060	.157	1/2	150	66
66260392482	1060FC	.060	.157	1/2	200	66
662603 92496	1065CC	.065	.157	1/2	100	66
662603 92502	1070CC	.070	.157	1/2	100	66
662603 92501	1070MC	.070	.157	1/2	150	66
662603 92500	1070FC	.070	.157	1/2	200	66
66260392514	1075CC	.075	.157	1/2	100	66
66260392520	1080CC	.080	.157	1/2	100	66
662603 92532	1085CC	.085	.157	1/2	100	66
662603 92538	1090CC	.090	.157	1/2	100	66
662603 92537 NS	1090MC	.090	.157	1/2	150	66
66260392536	1090FC	.090	.157	1/2	200	66
662603 92543	1090LMC	.090	.157	1	150	66
662603 92556	1100CC	.100	.157	1/2	100	66
662603 92554	1100FC	.100	.157	1/2	200	66
662603 92561	1100LMC	.100	.157	1	150	66
662603 92568	1105CC	.105	.157	1/2	100	66
662603 92567	1105MC	.105	.157	1/2	150	40
662603 92580	1110CC	.110	.157	1/2	100	1/4
662603 92578	1110FC	.110	.157	1/2	200	66
662603 92598	1120CC	.120	.157	1/2	100	66
662603 92604	1125CC	.125	.157	1/2	100	66
662603 92603	1125MC	.125	.157	1/2	150	66
662603 92602	1125FC	.125	.157	1/2	200	66
662603 92610	1130CC	.130	.197	1	100	66
662603 92608	1130FC	.130	.197	1	200	66
662603 92616	1135CC	.135	.236	N/A	100	66
662603 92615	1135MC	.135	.236	N/A	150	66
662603 92622	1140CC	.140	.236	N/A	100	66
662603 92628	1156CC	.156	.236	N/A	100	66
662603 92627	1156MC	.156	.236	N/A	150	66
662603 92626	1156FC	.156	.236	N/A	200	66
662603 92734	1171CC	.171	.236	N/A	100	66
662603 92733	1171MC	.171	.236	N/A	150	66
662603 92740	1187CC	.187	.312	N/A	100	66
662603 92739	1187MC	.187	.312	N/A	150	66
662603 92738	1187FC	.187	.312	N/A	200	66
662603 92745	1203MC	.203	.312	N/A	150	66
662603 92751	1218MC	.218	.312	N/A	150	66
662603 92758	1250CC	.250	.312	N/A	100	66
662603 92757	1250MC	.250	.312	N/A	150	66

FANI#	FRUDUCI#	INCHES	LENGIN	LENUIN	SIZE
4000 Series - D	iamond				
1/4" Shank x 3"	Overall Length				
662603 92630	4156CD	.156	.250	1	100
662603 92629	4156FD	.156	.250	1	200
662603 92634	4187CD	.187	.250	1	100
662603 92633	4187FD	.187	.250	1	200
662603 92638	4203CD	.203	.250	1	100
662603 92642	4218CD	.218	.250	1	100
662603 92641	4218FD	.218	.250	1	200
662603 92646	4236CD	.236	.250	1	100
662603 92645	4236FD	.236	.250	1	200
662603 92650	4250CD	.250	.250	1	100
662603 92649	4250FD	.250	.250	1	200
662603 92654	4282CD	.282	.250	N/A	100
662603 92653	4282FD	.282	.250	N/A	200
662603 92658	4312CD	.312	.375	N/A	100
662603 92657	4312FD	.312	.375	N/A	200
662603 92662	4375CD	.375	.375	N/A	100
662603 92661	4375FD	.375	.375	N/A	200
662603 92666	4390CD	.390	.375	N/A	100
662603 92670	4406CD	.406	.375	N/A	100
662603 92674	4437CD	.437	.375	N/A	100
662603 92678	4500CD	.500	.375	N/A	100
662603 92677	4500FD	.500	.375	N/A	200
662603 92682	4730CD	.730	.375	N/A	100
662603 92690	41000CD	1.000	.375	N/A	100
662603 92689	41000FD	1.000	.375	N/A	200
4000 Series - c					
1/4" Shank x 3"		150	050	4	100
662603 92632 662603 92631	4156CC 4156FC	.156 .156	.250	1	100 200
662603 92636	4130FC 4187CC	.130	.250	1	100
662603 92635	418700 4187FC	.187	.250	1	200
662603 92640	4187FC 4203CC	.187	.250	1	100
662603 92639	420300 4203FC	.203	.250	1	200
662603 92644	4203FC 4218CC	.203	.230	1	
662603 92643			250	1	100
662603 92648			.250	1	200
	4218FC	.218	.250	1	200
	4218FC 4236CC	.218 .236	.250 .250	1	200 100
662603 92647	4218FC 4236CC 4236FC	.218 .236 .236	.250 .250 .250	1 1 1	200 100 200
662603 92647 662603 92652	4218FC 4236CC 4236FC 4250CC	.218 .236 .236 .250	.250 .250 .250 .250	1 1 1 1	200 100 200 100
662603 92647 662603 92652 662603 92651	4218FC 4236CC 4236FC 4250CC 4250FC	.218 .236 .236 .250 .250	.250 .250 .250 .250 .250 .250	1 1 1 1 1	200 100 200 100 200
662603 92647 662603 92652 662603 92651 662603 92656	4218FC 4236CC 4236FC 4250CC 4250FC 4250FC 4282CC	.218 .236 .236 .250 .250 .250 .282	.250 .250 .250 .250 .250 .250 .250	1 1 1 1 1 N/A	200 100 200 100 200 100
66260392647 66260392652 66260392651 66260392656 66260392655	4218FC 4236CC 4236FC 4250CC 4250FC 4250FC 4282CC 4282FC	.218 .236 .250 .250 .250 .282 .282	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 1 N/A N/A	200 100 200 100 200 100 200
66260392647 66260392652 66260392651 66260392655 66260392655 66260392655 66260392655	4218FC 4236CC 4236FC 4250CC 4250FC 4282CC 4282FC 4312CC	.218 .236 .236 .250 .250 .250 .282 .282 .282 .312	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 N/A N/A N/A	200 100 200 100 200 100 200 100
66260392647 66260392652 66260392651 66260392655 66260392655 66260392655 66260392660 66260392659	4218FC 4236CC 4236FC 4250CC 4250FC 4282CC 4282FC 4312CC 4312FC	.218 .236 .236 .250 .250 .282 .282 .282 .312 .312	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200
662603 92647 662603 92652 662603 92651 662603 92655 662603 92655 662603 92660 662603 92659 662603 92664	4218FC 4236CC 4236FC 4250FC 4250FC 4282CC 4282FC 4312CC 4312FC 4375CC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .375	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100
662603 92647 662603 92652 662603 92651 662603 92655 662603 92655 662603 92660 662603 92659 662603 92664 662603 92663	4218FC 4236CC 4236FC 4250CC 4250FC 4250FC 4282CC 4282FC 4312CC 4312FC 4312FC 4375FC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .312 .375 .375	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 N/A N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100 200
662603 92647 662603 92652 662603 92651 662603 92655 662603 92655 662603 92660 662603 92659 662603 92664	4218FC 4236CC 4236FC 4250FC 4250FC 4282CC 4282FC 4312CC 4312FC 4375CC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .375	.250 .250 .250 .250 .250 .250 .250 .375 .375 .375 .375 .375 .375 .375	1 1 1 1 N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100
66260392647 66260392652 66260392651 66260392656 66260392656 66260392660 66260392669 66260392664 66260392663 66260392668	4218FC 4236CC 4236FC 4250CC 4250FC 4250FC 4282FC 4312CC 4312FC 4375FC 4390CC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .375 .375 .390	.250 .250 .250 .250 .250 .250 .250 .250	1 1 1 1 N/A N/A N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100 200 100 200 100
66260392647 66260392652 66260392656 66260392655 66260392655 66260392659 66260392659 66260392664 66260392663 66260392668 66260392668	4218FC 4236CC 4236FC 4250CC 4250FC 4282CC 4282FC 4312FC 4312FC 4375FC 4375FC 4390CC 4406CC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .375 .375 .375 .390 .406	.250 .250 .250 .250 .250 .250 .250 .375 .375 .375 .375 .375 .375 .375 .375	1 1 1 1 N/A N/A N/A N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100 200 100 1
66260392647 66260392652 66260392656 66260392655 66260392655 66260392660 66260392664 66260392663 66260392663 66260392668 66260392672 66260392676	4218FC 4236CC 4236FC 4250CC 4250FC 4282CC 4282FC 4312CC 4312FC 4375CC 4375FC 4390CC 4406CC 4437CC	.218 .236 .236 .250 .250 .282 .312 .312 .375 .375 .375 .390 .406 .437	.250 .250 .250 .250 .250 .250 .250 .375 .375 .375 .375 .375 .375 .375 .375	1 1 1 1 N/A N/A N/A N/A N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100 200 100 1
66260392647 66260392652 66260392655 66260392655 66260392660 66260392660 66260392664 66260392663 66260392668 66260392672 66260392675	4218FC 4236CC 4236FC 4250FC 4250FC 4282CC 4282FC 4312CC 4312FC 4375FC 4375FC 4375FC 4390CC 4406CC 4437FC	.218 .236 .236 .250 .250 .282 .312 .312 .375 .375 .375 .390 .406 .437 .437	.250 .250 .250 .250 .250 .250 .250 .375 .375 .375 .375 .375 .375 .375 .375	1 1 1 1 N/A N/A N/A N/A N/A N/A N/A N/A N/A	200 100 200 100 200 100 200 100 200 100 200 100 1
66260392647 66260392652 66260392655 66260392655 66260392660 66260392660 66260392664 66260392664 66260392668 66260392672 66260392675 66260392675 66260392680	4218FC 4236CC 4236FC 4250FC 4250FC 4282CC 4282FC 4312CC 4312FC 4375FC 4375FC 4390CC 4406CC 4437FC 437FC	.218 .236 .236 .250 .250 .282 .282 .312 .312 .375 .375 .375 .390 .406 .437 .437 .500	.250 .250 .250 .250 .250 .250 .250 .375 .375 .375 .375 .375 .375 .375 .375	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	200 100 200 100 200 100 200 100 200 100 1

Additional sizes are available made-to-order. Contact your Norton representative for availability and quotation.

🔺 = Tool & Die

= Ceramics

= Composites





UVERAL LENGTH

3

3

3-1/2

3-1/2

3-1/2

60

60

60

60

60

150

150

OVERA Length

Electroplated Mounted Points, Mandrels, Tapered Hones and Micro Drills

Diamond and cBN Mounted Points • A

PART #	PRODUCT #	HEAD DIAMETER	HEAD Length	GRIT SIZE
6000 Series – D		INGILS	LENGTH	unit Size
3/8" Shank x 3-		nath		
662603 92694	6406CD	.406	.375	80
662603 92693	6406MD	.406	.375	150
662603 92698	6437CD	.437	.375	80
662603 92697	6437MD	.437	.375	150
662603 92702	6500CD	.500	.375	80
662603 92701	6500MD	.500	.375	150
662603 92706	6562CD	.562	.375	80
662603 92710	6625CD	.625	.375	80
662603 92709	6625MD	.625	.375	150
662603 92718	6750CD	.750	.375	80
662603 92717	6750MD	.750	.375	150
662603 92721	6875MD	.875	.400	150
662603 92726	61000CD	1.000	.500	80

		HEAD DIAMETER	HEAD	
PART #	PRODUCT #	INCHES	LENGTH	GRIT SIZE
6000 Series - (cBN			
3/8" Shank x 3-	-3/4" Overall Len	gth		
662603 92696	6406CC	.406	.375	80
662603 92695	6406MC	.406	.375	150
662603 92700	6437CC	.437	.375	80
662603 92699	6437MC	.437	.375	150
662603 92704	6500CC	.500	.375	80
662603 92703	6500MC	.500	.375	150
662603 92708	6562CC	.562	.375	80
662603 92712	6625CC	.625	.375	80
662603 92716	6687CC	.687	.375	80
662603 92715	6687MC	.687	.375	150
662603 92720	6750CC	.750	.375	80
662603 92719	6750MC	.750	.375	150
662603 92724	6875CC	.875	.400	80
662603 92728	61000CC	1.000	.500	80
662603 92727	61000MC	1.000	.500	150

PRODUCT

HSR-1/4

HSR-3/8

HSR-1/2

HSR-3/4

TH25-14MD

TH25-16MD

M-Series Micro Drills – Diamond

HSR-1

PART #

HSR Series - cBN

662603**95426**

662603**95428**

662603**95429**

662603**95431**

662603**95432**

66260395544

662603**95545**

DIAMETER

1/4

3/8

1/2

3/4

1

LENGTH

1/4

3/8

3/8

3/8

3/8

3/8

3/8

3/8

3/8

3/8

1/4

1/4

HEAD Length

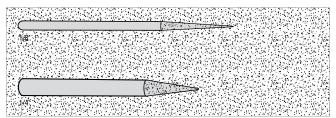
cBN Heavy Stock Removal Mandrels

 For heavy stock removal on jig, internal, and offhand operations on tool steels and hardened aerospace alloys. Made with super coarse abrasive grit for long tool life



Diamond Tapered Hones for Drawing Dies • 🔺 🔳

 Used primarily for forming carbide drawing dies, but also can be used for small hole honing in ceramics, fiberglass, plastics, and composite materials



PART #	PRODUCT #	INCLUDED Angle	SHANK Diameter	GRIT SIZE
Tapered Hone	s for Drawing Die	es – Diamond		
3" Overall Len	gth			
662603 95540	TH12-6MD	6°	1/8	150
662603 95541	TH12-8MD	8°	1/8	150
662603 63371	TH25-12CD	12°	1/4	100
662603 95542	TH12-12MD	12°	1/8	150
662603 95543	TH25-12MD	12°	1/4	150

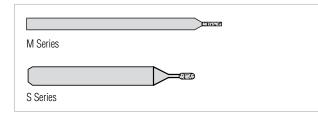
14°

16°

DIAMETER

Diamond Micro Drills • 🔺 **•**

- A modification of mounted points, these tools are specifically designed for drilling holes in the .007" to .065" diameter range
- Perfect for drilling sapphire and high density alumina ceramics for hybrid micro-circuit substrates
- M-Series Carefully-sized, uniformly-shaped diamond particles are used on all M-Series drills
- · S-Series Recommended for adapting to ultrasonic drill heads



Shank Diamet	er .040" (1mm)				
662603 95516	M7	.007	.028	11/16	600
662603 95517	M10	.010	.049	11/16	400
662603 95518	M12	.012	.056	13/16	325
662603 95519	M15	.015	.077	13/16	325
		DIAMETER	HEAD	OVERALL	GRIT
PART #	PRODUCT #	INCHES	LENGTH	LENGTH	SIZE
S-Series Micro	o Drills – Diamo	nd			
1/8" Shank x 1	" Overall Length	1			
662603 95520	S16FD	.016	.062	.093	200
662603 92841	S18FD	.018	.062	.125	200
662603 95521	S20FD	.020	.062	.125	200
662603 95522	S25FD	.025	.093	.156	200
662603 95523	S30MD	.030	.093	.156	150
662603 95524	S35MD	.035	.093	.187	150
662603 95525	S40MD	.040	.125	.218	150
662603 95526	S45CD	.045	.125	.218	100
662603 95527	S50CD	.050	.125	.250	100
662603 95528	S60CD	.060	.125	.312	100
	S65CD	.065	.125	.312	100

TARGET MARKET SYMBOLS • = Ceramics

▲ = Tool & Die = Composites

Industrial Market - Full-Line

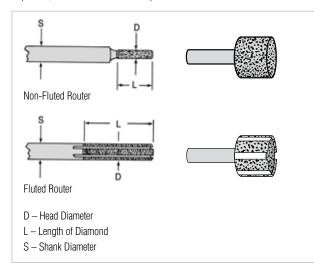


DIAMOND & CBN ABRASIVES Electroplated Products

Electroplated Routers and Mounted Contour Tools

Diamond Routers •

- · Used with hand operated tools, drill presses, and milling machines
- Ideal for routing and reaming the highly-abrasive materials of alumina, fiberglass, plastics, and other nonmetallic composite materials.



PART #	PRODUCT #	HEAD Diameter	LENGTH OF Diamond	SHANK DIAMETER	OVERALL Length	GRIT SIZE
Non-Fluted Ro	outers – Diamo	ond				
662603 64302	RNF1410CD	1/4	1	1/4	2-1/2	40
Fluted Router	s – Diamond					
662603 64310	RSF1812CD	1/8	1/2	1/4	2-1/2	60
662603 64309	RSF1810CD	1/8	1	1/4	2-1/2	60
662603 64308	RSF1412CD	1/4	1/2	1/4	2-1/2	40
662603 64307	RSF1410CD	1/4	1	1/4	2-1/2	40
662603 02715	RSF3412CD	3/4	1/2	1/2	2-1/2	40

Type 6A2C cup and Type 01 straight bench and pedestal electroplated wheels are available as madeto order products. Contact your Norton representative for availability and quotation.

Diamond and cBN Mounted Contour Tools • 🔺 🔳

- For contour grinding applications on carbide, ceramics, glass, ferrites, and many tough alloys and cements. Best suited for blending radii and deburring operations
- Operating speeds: 15,000-20,000 RPM range
- Variety of tool shapes available as stock to satisfy most tool and die and deburring requirements

Cones	
Ball Ends (Spherical)	
(
Round End Tapers	
Round End Cylinders	ويونين مر

		CONE BASE	INCLUDED	CONE	
PART #	PRODUCT #	DIAMETER	ANGLE	LENGTH	GRIT SIZE
Cones – Diamond					
1/8" Shank x 2" 0	verall Length				
662603 95484	C14CD	1/8	14°	1/2	100
662603 95488	C35CD	5/32	35°	1/4	100
662603 95490	C60CD	11/64	60°	5/32	100
662603 95492	C90CD	3/16	90°	3/32	100
Cones – cBN					
1/8" Shank x 2" 0	verall Length				
662603 95483	C14CC	1/8	14°	1/2	100
662603 95485	C26CC	3/16	26°	13/32	100
662603 95487	C35CC	5/32	35°	1/4	100
662603 95489	C60CC	11/64	60°	5/32	100
662603 95491	C90CC	3/16	90°	3/32	100

			BALL			
PART #	PRODU	CT #	DIAMETER	G	RIT SIZE	
Ball Ends (Sph	erical) – Dia	mond				
1/8" Shank x 2	" Overall Len	gth				
662603 95434	BE1CD		3/64	1(00	
662603 95436	BE2CD		1/16	1(00	
662603 95438	BE3CD		5/64	1(00	
662603 95440	BE4CD		3/32	1(00	
662603 95442	BE5CD		1/8	1()0	
662603 95444	BE6CD		3/16	1(00	
662603 95448	BE8CD		3/8	1(00	
662603 95450	BE9CD		1/2	1()0	
Ball Ends (Sph	erical) – cBN	1				
1/8" Shank x 2						
662603 95437	BE3CC	-	5/64	1(00	
662603 95439	BE4CC		3/32	1(00	
662603 95441	BE5CC		1/8	1(00	
662603 95443	BE6CC		3/16	1()0	
662603 95445	BE7CC		1/4	1(00	
	PRODUCT	SMALL HEAD	LARGE HEAD	HEAD	INC.	GRIT
PART #	#	DIAMETER	DIAMETER	LENGTH	ANGLE	SIZE
Round End Tap						
1/8" Shank x 2						
662603 95506	RT44CD	.044	.066	5/16	4°	100
662603 95510	RT78CD	.078	.110	5/16	6°	100
Round End Tap	oers – cBN					
1/8" Shank x 2	" Overall Len	gth				
662603 95509	RT78CC	.078	.110	5/16	6°	100
DADT #	DDODU	HEA	D Meter	HEAD Lengt		GRIT Size
PART #	PRODU		VIEIEK	LENGI	1	512E
Round End Cyl						
1/8" Shank x 2			<u>^</u>	1/4		100
662603 95494	RE1CD	1/16		1/4		100
662603 95496	RE2CD	5/64		1/4		100
662603 95498	RE3CD	3/32	2	1/4		100
00000000000000000000000000000000000000						
662603 95500	RE4CD	1/8	•	1/4		100
662603 95500 662603 95502 662603 95504		1/8 3/10 1/4	6	1/4 5/16 5/16		100 100 100

TARGET MARKET SYMBOLS

● = Ceramics ▲ = Tool & Die

= Composites



DIAMOND & CBN ABRASIVES Electroplated Products

Electroplated Files

Diamond Machine Files • A

- For use in reciprocating hand profiling machines
- Ideal for reworking and finishing carbide dies and molds, blending radii, and deburring and cleaning slots and grooves

DADT #		DIMENCIONO	ABRASIVE	
PART # Machine Files	PRODUCT #	DIMENSIONS	LOCATION	GRIT SIZE
			-	
5/8" Diamond L	ength, 1/8" Shan	k, 2" Overall Lengt	h	
662603 95585	1ECD	.020 x .125		100
662603 95586	2ECD	.030 x .125	:	100
662603 95587	3ECD	.040 x .125	ê n s ê	100
662603 95589	3FCD	.120 x .040	·····	100
662603 95590	4FCD	.157 x .040		100
662603 95591	5FCD	.203 x .078	•••••	100
662603 95592	6FCD	.120 x .040		100
662603 95593	1CCD	.098 x .196	Ö	100
662603 95594	2CCD	.120 x .250	\odot	100
662603 95596	3TCD	.127 side		100
662603 95599	2RCD	.080 diam.	Ö	100
662603 95600	3RCD	.127 diam.	Ö	100

Diamond Hand Files • A

- Indispensable aid for the toolroom
- All purpose hand-held tool useful for deburring, notching, dressing, and honing hard, brittle materials

PART #	PRODUCT #	DIMENSIONS	LOCATION	GRIT SIZE
Hand Files - Diam	ond			
6" Overall Length,	1-1/2" Diamond	l Length		
662603 95605 NS	DF1CD	1/8 x 1/8		100
662603 95606	DF2CD	1/8 x 1/4	·····	100
662603 95607	DF2WCD	1/8 x 1/4		100
662603 95608	DF3CD	1/8 x 3/8	·····	100
662603 92844	DF3FD	1/8 x 3/8	·····	200
662603 95609	DF3WCD	1/8 x 3/8		100
662603 64241	DF3SCD	1/8 x 1/2		100
662603 95611	DF4CD	1/8	Ö:	100
662603 00134	DF4WCD	1/4	Ö	100
662603 95613	DF5CD	1/8	. <u>.</u>	100
662603 92846	DF5FD	1/8	. <u>.</u>	200
662603 95614	DF5WCD	1/4		100
662603 95615	DF6CD	1/8	Ö	100

ABRASIVE

= Ceramics

- Tool & Die

▲ = Tool & Die = Composites



Electroplated Files and Drills

Diamond Needle Files • A

- · Indispensable aid for the toolroom
- · An all-purpose hand-held tool, useful for deburring, notching, dressing, and honing hard, brittle materials

Ove	erall Length 🗕 🗕
	← Diamond Length →

PART #	PRODUCT #	GRIT SIZE
NFK-6 Needle File Kit	– Diamond	
662603 64008	NFK-6	
Contains one each of	the following:	
	NF1FD	200
	NF2FD	200
	NF3FD	200
	NF4FD	200
	NF5FD	200
	NF6FD	200
DFS-6 Die File Kit – D	iamond	
662603 91830	DFS-6	
Contains one each of	the following:	
	1571	100
	1572	100
	1573	100
	1574	100
	1575	100
	1576	100

DIAMOND & cBN ABRASIVES
Electroplated Products

PART #	PRODUCT #	DIMENSIONS	ABRASIVE Location	SHAPE	GRIT Size
leedle Files –		DIMENSIONS	LUGATION	SHAFE	312E
		2" Overall Leng	gth		
62603 02432	LNF2CD	.400 x .100		Equaling	100
62603 05611	LNF2FD	.400 x .100		Equaling	200
62603 02898	LNF3CD	.450 x .150	ä	Half Round	100
62603 05612	LNF3FD	.485 x .150	ä	Half Round	200
2-3/4" Diamon	d Length, 5-3/	4" Overall Leng	gth, With Han	dle	
62603 91729	1571	.055 x .190		Flat	100
62603 91730	1572	.075 x .210	Ä	Half Round	100
62603 91731	1573	.145 x .145	. <u>Å</u> .	Triangle	100
62603 91732	1574	.100 x .100		Square	100
62603 91733	1575	.120	ö	Round	100
62603 91734	1576	.055 x .190		Pointed Flat	100
3" Diamond Le	ngth, 5-1/2" O	verall Length,	With Handle		
62603 95575	NF1FD	.150 x .105	Ö	Oval	200
62603 95576	NF2FD	.218 x .072	ä	Half Round	200
62603 95577	NF3FD	.205 x .058		Equaling	200
62603 95578	NF4FD	.096 x .096		Square	200
62603 95579	NF5FD	.138 x .138	. <u>.</u> .	Triangle	200
62603 95580	NF6FD	.118	Ö	Round	200
62603 95578 662603 95579	NF4FD NF5FD	.096 x .096 .138 x .138		Square Triangle	20 20

Needle File	e Shape and Application Key:
Barrette:	A triangle with diamond on the bottom side only
Crossing:	Elongated oval, with more pointed ends than an oval file; has diamonds all around
Equaling:	A rectangle with diamond on all four sides; ideal for filing both sides of an ID simultaneously
Pointed Flat:	A cone with a flat top with diamond on the sides of the cone

Diamond Core Drills •

- · High performance on glass and ceramic applications while providing fast, reliable cutting
- · Submersed drilling is highly recommended for optimum operating performance



PART #	PRODUCT #	OUTER Diameter	INNER Diameter	GRIT SIZE
Core Drills -	Diamond			
Straight Tub	e Type, 2" Overall L	ength		
662603 95530	A1MD	1/16	.023	150
662603 95531	A2MD	3/32	.048	150
662603 95532	A3MD	1/8	.075	150
662603 95533	A4MD	5/32	.110	150
662603 95534	A5CD	3/16	.140	100
662603 95535	i A6CD	1/4	.195	100
662603 95536	A7CD	5/16	.255	100

Diamond Twist Drills •

- · Recommended for precision drilling on circuit boards containing fiberglass, nylon, and similar tough, abrasive materials
- · Diamond twist drills are also useful for drilling plastics and resin composites and have been successful in drilling soft ductile materials as well as "green" carbide
- · Operating procedures are similar to those of standard twist drills



PART #	PRODUCT #	DRILL DIAMETEI	R DRILL LENGTH	GRIT SIZE
Twist Drills –	Diamond			
662603 95549	TW-1/16	1/16	1-3/4	100
662603 95550	TW-1/8	1/8	2-3/4	100
662603 95551	TW-1/4	1/4	4	100
Diameter toleran	nce equals + or – 1/64	1		

ameter tolerance equals + or 1/64.

TARGET MARKET SYMBOLS • = Ceramics 🔺 = Tool & Die

= Composites

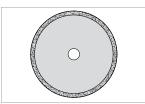


DIAMOND & CBN ABRASIVES Electroplated Products

Electroplated Saw Blades

Diamond Continuous Rim Cut-off Saw Blades

 Ideal for cutting-off highly-abrasive materials such as alumina, fiberglass, plastics, and other nonmetallic composite materials

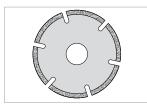


Additional diamond continuous rim and slotted cut-off saw blades, with extended wraps to avoid binding, are available as made-to-order products. Please contact your Norton representative.

PART #	PRODUCT #	DIAM.	OVERALL Thickness	HOLE Size	GRIT Size
Continuous Rin	n Cut-off Saw Blac	des – Diamo	nd		
662603 01990	DS2062-250	2	1/16	1/4	40
662603 91474	DS2094-250	2	3/32	1/4	40
662603 91473	DS3094-250	3	3/32	1/4	40
662603 63036	DS3094-375	3	3/32	3/8	40
662603 95554	DS4094-500	4	3/32	1/2	40
662603 00197	DS4094-750	4	3/32	3/4	40
662603 95557	DS8094-625	8	3/32	5/8	40

Diamond Slotted Cut-off Saw Blades

 3/4" wrap: additional 3/4" of electroplated diamond on the blade core increases life of blade on deep cuts, and reduces binding and grinding on the core



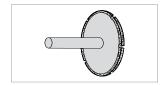
Additional diamond continuous rim and slotted cut-off saw blades, with extended wraps to avoid binding, are available as made-to-order products. Please contact your Norton representative.

			OVERALL	HOLE	GRIT
PART #	PRODUCT #	DIAM.	THICKNESS	SIZE	SIZE
Slotted Cut-off	Saw Blades - Diam	ond			
662603 01989	DSS2062-250	2	1/16	1/4	40
662603 64258	DSS3094-250	3	3/32	1/4	40
662603 95559	DSS4094-500	4	3/32	1/2	40
662603 95560	DSS6094-500	6	3/32	1/2	40
662603 62981	DSS10125-625	10	1/8	5/8	40
662603 64253	DSS14156-500	14	5/32	1/2	40
662603 62989	DSS14156-1	14	5/32	1	40
662603 95565	DSS16156-1	16	5/32	1	40
662603 95566	DSS18156-1	18	5/32	1	40
Slotted Cut-off	Saw Blades with 3/	/4" Wrap –	Diamond		
662603 13423	DSSW4094-750	4	3/32	3/4	40

Diamond Mounted Saw Blades

- Ideal for cutting-off highly-abrasive materials such as alumina, fiberglass, plastics, and other nonmetallic composite materials
- 3/4" wrap additional 3/4" of electroplated diamond on the blade core increases life of blade on deep cuts, andreduces binding and grinding on the core

PART #	PRODUCT #	DIAM.	OVERALL Thickness	HOLE Size	GRIT Size
Mounted Saw B	lades – Diamond				
2" Overall Leng	th				
662603 95422	MDS1CD	1	3/32	1/4	40
662603 95423	MDS1-1/2CD	1-1/2	3/32	1/4	40
662603 95424	MDS2CD	2	3/32	3/8	40



TARGET MARKET SYMBOLS

= Ceramics

= Composites

🔺 = Tool & Die

Industrial Market - Full-Line

DIAMOND & cBN ABRASIVES Diamond Lapping Compound

Norton Winter diamond lapping compound polishes all materials - hard and soft. Diamond powders are uniformly distributed in a liquid vehicle for aggressive polishing and consistent part quality. Easy-to-use plastic syringe for quick clean-up.

Applications:

Syringe Size: Type:

Machine Used:

For mold, die, and tool polishing, polishing to final tolerance of ceramic parts, initial charging of lapping plates and discs, and other processes that require mirror finish and close tolerance performance. 5 and 18 gram syringes

Water soluble - when soap/water is used for clean-up Oil soluble - when solvent is used for clean-up



PRODUCT #	MICRO	N GRADE	COLOR	PART #
Diamond Compou	und – Wa	ter Soluble		
5 Gram Syringes				
5PS1/4WSSTD	1/4	Ultra Fine	Gray	662603 00362
5PS1/2WSSTD	1/2	Ultra Fine	Lt. Gray	662603 00417
5PS1WSSTD	1	Ultra Fine	lvory	662603 00368
5PS3WSSTD	3	Super Fine	Yellow	662603 00667
5PS6WSSTD	6	Super Fine	Orange	662603 00372
5PS9WSSTD	9	Super Fine	Green	662603 00375
5PS12WSSTD	12	Super Fine	Aqua	662603 00376
5PS15WSSTD	15	Fine	Blue	662603 00379
5PS30WSSTD	30	Fine	Red	662603 00383
5PS45WSSTD	45	Fine	Brown	662603 00384
5PS60WSSTD	60	Fine	Purple	662603 00388
5PS90WSSTD	90	Fine	Black	662603 00389 NS
18 Gram Syringes	S			
18PS1/4WSSTD	1/4	Ultra Fine	Gray	662603 00392
18PS1/2WSSTD	1/2	Ultra Fine	Lt. Gray	662603 00394
18PS1WSSTD	1	Ultra Fine	lvory	662603 00396
18PS3WSSTD	3	Super Fine	Yellow	662603 00398
18PS6WSSTD	6	Super Fine	Orange	662603 00400
18PS9WSSTD	9	Super Fine	Green	662603 00402
18PS15WSSTD	15	Fine	Blue	662603 00406
18PS20WSSTD	20	Fine	Auburn	662603 00408

NORTON

SAINT-GOBAIN

STD .0

PRODUCT #	MICRO	N GRADE	COLOR	PART #
Diamond Compo	und – Oil	Soluble		
5 Gram Syringes				
5PS1/40SSTD	1/4	UltraFine	Gray	614636 91123 NS
5PS1/20SSTD	1/2	UltraFine	Lt. Gray	662603 00363
5PS10SSTD	1	UltraFine	lvory	614636 91133
5PS30SSTD	3	Super Fine	Yellow	614636 91138
5PS60SSTD	6	Super Fine	Orange	614636 91143
5PS90SSTD	9	Super Fine	Green	614636 91148
5PS150SSTD	15	Fine	Blue	614636 91153
5PS300SSTD	30	Fine	Red	614636 91158
5PS450SSTD	45	Fine	Brown	614636 91163
5PS600SSTD	60	Fine	Purple	662603 00386
5PS900SSTD	90	Fine	Black	662603 00390
18 Gram Syringe	s			
18PS1/40SSTD	1/4	UltraFine	Gray	662603 00391
18PS10SSTD	1	UltraFine	lvory	614636 91134 NS
18PS30SSTD	3	Super Fine	Yellow	614636 91139
18PS60SSTD	6	Super Fine	Orange	662603 00399
18PS90SSTD	9	Super Fine	Green	614636 91149 NS
18PS150SSTD	15	Fine	Blue	614636 91154
18PS200SSTD	20	Fine	Auburn	662603 00407
18PS300SSTD	30	Fine	Red	662603 00409
18PS450SSTD	45	Fine	Brown	614636 91164 NS
18PS600SSTD	60	Fine	Purple	662603 00413
18PS900SSTD	90	Fine	Black	662603 00415

Non-stock; contact your Norton representative for current lead-time.

Marking System

		5 PS 1/4 C	S STD	*
SYRINGE Size	CARTRIDGE Type	MICRON GRADE	VEHICLE Type	CONCENTRATION
5 Gram 18 gram	PS (Plastic Syringe)	1/4 - Gray $1/2 - Light Gray$ $1 - Ivory$ $3 - Yellow$ $6 - Orange$ $9 - Green$ $12 - Aqua$ $15 - Blue$ $20 - Auburn$ $30 - Red$ $45 - Brown$ $60 - Purple$ $90 - Black$	OS (Oil Soluble) WS (Water Soluble)	Standard

TECH TIP

Diamond Compound Application Guide

APPLICATION	MICRON Grade	MICRON Range	MESH Size Equiv.	COLOR	CONC.
ULTRA FINE	1/4	(0-1/2)	100,000	Gray	Std.
Applying finest finishes	1/2	(0-1)	60,000	Lt. Gray	Std.
on metals and ceramics	1	(0-2)	14,000	lvory	Std.
SUPER FINE	3	(2-4)	8,000	Yellow	Std.
Final finishing of dies,	6	(4-8)	3,000	Orange	Std.
molds, seals, most	9	(8-12)	1,800	Green	Std.
applications (RMS 4-12)	12	(9-15)	1,500	Aqua	Std.
FINE FINISH	15	(12-22)	1,200	Blue	Std.
Preparatory lapping	20	(15-25)	800	Auburn	Std.
(RMS 12-20)	30	(22-36)	600	Red	Std.
	45	(36-45)	325	Brown	Std.
	60	(54-80)	230	Purple	Std.
	90	(80-100)	170	Black	Std.

Construction Products

GIGE

the Norton Clipper brand **HITS THE PAVEMENT**

The leader for diamond blades, tools, and light machines for construction and cutting materials is "Redefining Jobsite Muscle – Rugged. Reliable. Affordable."



CONSTRUCTION PRODUCTS **Diamond Blades**



With faster cut rates, constant depth of cut, and less downtime, Norton Clipper diamond blades are the choice of professionals versus conventional abrasive blades. Norton Clipper diamond blades are available for high-speed saws, portable hand-held saws, and walk-behind saws. For the full offering of diamond blades, see the Norton Clipper Construction Products Catalog #7719.

Applications: Size Range: **Thickness Range: Segment Height: Range: Abrasive Grain: Mounting Options:** Shape: **Machines Used:**

Cutting concrete, stone, tile, and other building materials 4" - 18" .080" - .375"

.210" - .550"

Diamond 1"/20mm universal arbor, 7/8"-5/8"-20mm, DM-7/8"-5/8", 5/8"-11 Type 01







HIGH-SPEED GAS CIRCUI OR ELECTRIC SAW SAW

RIGHT-ANGLE GRINDER

WALK-BEHIND SAW



Diamond Blade Rim Types

There are three main diamond blade rim types: segmented, turbo, and continuous rim.



Most aggressive cutting action for general-purpose and

· Use when cutting speed and productivity are more

masonry applications

important than finish

· Best life, best cut rate, good finish

Turbo

- Aggressive cutting action with a smoother quality of cut than segmented rim blades
- For use on harder materials, such as granite, marble, and stone to reduce chipping
- · Better life and cut rate, better finish

Continuous

- · Provides the smoothest of cuts
- · Best performance when used wet
- · Use on porcelain, tile, marble, and other hard materials requiring a high-quality cut
- · Good life, good cut rate, best finish

Material / Application-to-Product Recommendation Guide

lcon	Description	Application
	Multi-Purpose, All Materials	Concrete, reinforced concrete, granite, building materials, thin steel sections, angle iron up to 1/2" material thickness, rebar up to no. 5.
	Natural Stone and Tiles	Ceramic and stone tiles, granite, marble, very hard bricks and other very hard and dense materials.
	Reinforced Concrete and Harder Building Materials	Reinforced concrete, hard bricks, limestone, terrazzo, and other hard materials.
	General Purpose and Masonry Building Materials	Blocks, medium-hard building bricks, paving slabs, concrete roof tiles and other medium-hard materials.
	Asphalt	Asphalt, green concrete, asphalt over concrete, abrasive blocks, mortar and other abrasive materials.

Diamond Performance Tiers

Best Best Performance Better High Performance

Good Good Performance

Value

Consistent Performance

$\bigcirc \bigcirc \oslash \oslash \oslash \oslash \bigcirc \bigcirc$	ł
2	

TECH TIP

•	Never twist or turn a segmented blade in the cut because it may result in segment breakage
	Never use wet blades dry
•	Remove dry blades from cut for 10 seconds of each minute of cut to air cool

- · Never operate any saw, wet or dry, without the blade guard

It is the user's responsibility to refer to and comply with ANSI B7.1



CONSTRUCTION PRODUCTS – DIAMOND BLADES High-Speed Saw Blades

For Reinforced Concrete and Harder Building Materials

DRY – Segmented Rim ()+()

DUO EVO

The unique shape of the DUO EVO segments optimizes the angle of attack while enhancing the evacuation of the debris. With a new manufacturing process, the DUO EVO segments provide an exceptional cutting speed for optimum performance and increased life up to 20% over the original DUO EVO design.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
12 x .110 x 1"/20mm	.590"	6,300	DU0EV012110	701846 84217	
14 x .118 x 1"/20mm	.590"	5,460	DU0EV014118	701846 84218	
16 x .130 x 1"/20mm	.590"	4,500	DU0EV016130	701846 93356	

DUO

Our exclusive design has become a dominant name in the market. The unique dual segment per land technology provides excellent cutting speed with low vibration and high comfort of cut. The exclusive arrow shape gullets not only indicate blade direction, but also assist in fast removal of cutting debris. Maximum general purpose performance when cutting medium to low reinforcement, hard materials.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
12 x .110 x 1"/20mm	.393"	6,300	DU012110	701846 83611	
14 x .110 x 1"/20mm	.393"	5,460	DU014110	701846 83612	
14 x .125 x 1"/20mm	.393"	5,460	DU014125	701846 83613	
16 x .125 x 1"/20mm	.393"	4,500	DU016125	701846 83798	

For Asphalt and Abrasive Materials

DRY – Segmented Rim

DUO ASPHALT Constraints and green concrete. The laser-welded, wear-retardant drop segments extend blade life. Scoop gullets for faster swarf removal increases cut speed. Stroboscopic indicators to control cut depth and show rotation direction.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
14 x .125 x 1"/20mm	.590"	5,460	DU0ASP14125	701846 84315
16 x .125 x 1"/20mm	.590"	4,500	DUOASP16125	701846 84544

DUO ABRASIVE

Utilizes the basic characteristics of the original DUO blade and adds a unique segment shape that optimizes the angle of attack while enhancing the evacuation of the particles. The result is an exceptional cutting speed allied with very good performance and life in abrasive materials and concrete block. The bond specification lends additional life when high-speed cutting.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
14 x .110 x 1"/20mm	.327"	5,460	DUOAB14110	701846 84291
14 x .125 x 1"/20mm	.327"	5,460	DUOAB14125	701846 84292

For General-Purpose and Masonry Building Materials

DRY – Segmented Rim

CLASSIC				$\otimes \otimes \otimes$		
The improved bond provides longer life at an economical price in medium-hard materials such as concrete with light to medium reinforcement.						
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #		
12 x .110 x 1"/20mm	.256"	6,300	COHSGP1220	701846 81383		
14 x .110 x 1"/20mm	.256"	5,460	COHSGP1420	701846 81309		
14 x .125 x 1"/20mm	.256"	5,460	COHSGP1420P	701846 84268		
16 x .125 x 1"/20mm	.256"	4,500	COHSGP1620	701846 40356		

VALUPLUS

	For value and performance on s	small- to medium-size jobs.	The sintered blade cuts unr	einforced soft-to-medium con	crete fast on saws up to 13 HP.
	SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
	12 x .110 x 1"/20mm	.393"	6,300	VPHSGP1220	701846 84180
	14 x .110 x 1"/20mm	.393"	5,460	VPHSGP1420	701846 84181
	14 x .110 x 1"/20mm	.393"	5,460	VPHSGP1420 20PK	701846 84428

















CONSTRUCTION PRODUCTS – DIAMOND BLADES High-Speed Saw Blades

Multi-Fulpose, Fol All Materia

Dry – Segmented Rim ()+()

4X4 MAX CUT

Taking high-speed cutting versatility to an all new level. The same standard features as the 4X4 with its anti-crack gullets and patented depth indicators that not only cool the blade, but also allow the operator to know how deep they are cutting. An all-new bond and diamond specification improves blade life in a wide range of materials while excelling in steel. New segment wear indicators give the operator an idea of remaining blade life.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
12 x .118 x 1"/20mm	.472"	6,300	4X4MC12118	701846 45927	
14 x .125 x 1"/20mm	.472"	5,460	4X4MC14125	701846 45926	

Multi-purpose laser welded blade for dry cutting a range of construction materials without sacrificing performance or price. Depth of cut is easily controlled with the patented depth-of-cut indicators cut into the steel core. Anti-crack gullets for enhanced safety cutting steel and metal (up to 5mm thick).

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
12 x .110 x 1"/20mm	.393"	6,300	4X412110	701846 84548	
14 x .118 x 1"/20mm	.393"	5,460	4X414118	701846 84547	
16 x .125 x 1"/20mm	.393"	4,500	4X416125	701846 45306	

MULTI-CUT				$\otimes \otimes \otimes$	
The perfect combination of performance and price on high-speed, masonry, and floor saws. The laser welded segments are designed for cutting					
speed and long life, while a precise 1"/20mm laser cut dual arbor hole provides consistently secure mounting on the saw. Premium features combined with low pricing make for a reliable, fast cutting, long life blade for a variety of common construction materials.					
1 0	,	0, 0	,		
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
14 x .125 x 1"/20mm	.472"	5,460	MULTICUT14125	701846 09680	
16 x .125 x 1"/20mm	.472"	4,500	MULTICUT16125	701846 31788	







TECH TIP

High-Speed Hand Saw Blades – Maximum Blade Cutting Depths and Recommended Operating Speeds

Note: Diamond blade cutting depths listed are approximate. Actual cutting depth will vary with the exact blade diameter or saw type, or the exact diameter of the blade flanges. Cutting depth will also be reduced if saw components extend below the blade flanges.

BLADE DIAMETER	CUTTING DEPTH	MAXIMUM SPEED (RPM)
12"	4"	6,300
14"	5"	5,460
16"	6"	4,500
•		

It is the user's responsibility to refer to and comply with ANSI B7.1



CONSTRUCTION PRODUCTS – DIAMOND BLADES Hand-Held Saw Blades

For Reinforced Concrete and Harder Building Materials

DRY – Crack Chasing ()+()

0 0	
CHARGER	
A heavy V-shaped segment designed with a special bond and diamond content for maxi	mum removal of grout, mortar jointing, crack chasing and
crack widening. East cutting and long life in abrasive materials using portable tools. His	the the text the text of t

crack widening. Fast cutting and long life in abrasive materials using portable tools. Highly competitive to others of its kind in the market.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x .375 x 7/8-5/8-20mm	.550"	15,000	CGCC0400	701846 83856	
7 x .375 x 7/8-5/8-20mm	.550"	8,730	CGCC0700	70184683859	

For Asphalt and Abrasive Materials

Dry – Tuck Pointing 🚺 + 🔏

CLASSIC

An economical solution for small to medium tuck pointing jobs. High-quality performance for heavy grout removal or mortar jointing. The heavy-duty wide segment reduces wear in abrasive materials.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x .250 x 7/8-5/8	.275"	15,000	CHTUCK0400	701846 81776	
4-1/2 x .250 x 7/8-5/8	.275"	13,300	CHTUCK0450	701846 81777	
5 x .250 x 7/8-5/8	.275"	12,000	CHTUCK0500	701846 81778	
7 x .250 x 7/8-5/8	.275"	8,730	CHTUCK0700	701846 81779	

For General-Purpose and Masonry Building Materials

Dry – Segmented Rim ()+

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x .080 x 7/8-5/8-20mm	.393"	15,000	CGDSEG0400	701846 81505	
4-1/2 x .080 x 7/8-5/8-20mm	.393"	13,300	CGDSEG0450	076607 04021	
5 x .080 x 7/8-5/8-20mm	.393"	12,000	CGDSEG0500	701846 82851	
6 x .080 x 7/8-5/8-20mm	.393"	10,185	CGDSEG0600	701846 83820	
7 x .090 x DM-7/8-5/8	.393"	8,730	CGDSEG0700	076607 04020	

VALUPLUS

For value and performance on small- to medium-size jobs cutting soft abrasive materials like brick and tile. The sintered rim delivers a quality cut and good life.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.315"	15,000	VPSEG0400	701846 84098
4-1/2 x .080 x 7/8-5/8-20mm	.315"	13,300	VPSEG0450	701846 84099
7 x .090 x DM-7/8-5/8	.315"	8,730	VPSEG0700	701846 84100

Dry – Turbo Rim

CHARGER

Combines the characteristics of a standard Charger blade with a turbo rim configuration for cutting hard, dense materials with minimal effort. A better bond and diamond concentration for maximum cutting speed, life and quality of cut.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #		
4 x .080 x 7/8-5/8-20mm	.393"	15,000	CGTURB0400	076607 05475		
4-1/2 x .080 x 7/8-5/8-20mm	.393"	13,300	CGTURB0450	076607 04023		
5 x .080 x 7/8-5/8-20mm	.393"	12,000	CGTURB0500	701846 82853		
7 x .090 x DM-7/8-5/8	.393"	8,730	CGTURB0700	076607 04022		

For Natural Stone and Tiles

Dry – Continuous Rim 💧+🎸

CLASSIC	
An economical solution for small- to medium-size jobs cutting softer ceramic tile and stone materials with efficient cutting ability.	

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.275"	15,000	CON4DT	076607 02793
4-1/2 x .080 x 7/8-5/8-20mm	.275"	13,300	CON45DT	076607 01194
7 x .090 x DM-7/8-5/8	.275"	8,730	CON7DT	076607 02788



















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CONSTRUCTION PRODUCTS – DIAMOND BLADES Walk-Behind Saw Blades

For Reinforced Concrete and Harder Building Materials

WET – Medium Aggregates

CHARGER

The steel core is designed to keep the cut straight while the .41)" segment height prolongs cutting wear	. Suitable for cutting medium aggregates
with up to 35 HP walk-behind saws.		

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.413"	4,365	35hp	CGWCMD1412	701846 81366
18 x .125 x 1	.413"	3,395	35hp	CGWCMD1812	701846 81368

CLASSIC

Laser welded blade at an economical price for general purpose cutting of cured concrete, medium-hard aggregate and no steel reinforcement. The bond and diamond combination allow fast cutting action on limited horse powered walk-behind saws.

		0			
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
16 x .125 x 1	.315"	3,820	35hp	CHWCGP1612	701846 81360
18 x .125 x 1	.327"	3,395	35hp	CHWCGP1812	701846 81361

For Asphalt and Abrasive Materials

(**)**+(**)**

DRY – Green Concrete

GMAX – MULTI-PURPOSE Designed specifically for our GC55 down-cut green concrete push saw, the GMAX Multi-Purpose blade is excellent in green concrete. The unique segment specification and anchor slot gullet allows this blade to be used in green concrete applications with outstanding results.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
8 x .095 x 1-5/8	.393"	7,640	6hp	NXDGRN0895	701846 83758
9 x .110 x 1-5/8	.275"	6,600	6hp	EE9110	701846 75125
10 x .110 x 1-5/8	.275"	6,115	6hp	EE10110	701846 84508

WET – Asphalt

CHARGER

For large road and construction jobs with saws up to 35 HP. Higher diamond content increases productivity and offers faster cutting and longer life in asphalt and green concrete applications.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.327"	4,365	35hp	CGWASP1412	701846 81478
18 x .125 x 1	.307"	3,395	35hp	CGWASP1812	701846 81479

CLASSIC

An economical choice for fast cutting and good life when performing jobs in a variety of abrasive materials such as green concrete and asphalt on saws up to 35 HP.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.326"	4,365	35hp	CHWASP1412	701846 81375
18 x .125 x 1	.326"	3,395	35hp	CHWASP1812	701846 81376















Walk-Behind Saw Blades – Maximum Blade Cutting Depths and Recommended Operating Speeds

Note: Diamond blade cutting depths listed are approximate. Actual cutting depth will vary with the exact blade diameter or saw type, or the exact diameter of the blade flanges. Cutting depth will also be reduced if saw components extend below the blade flanges.

BLADE DIAMETER	CUTTING DEPTH	IDEAL SPEED (RPM)	MAXIMUM SPEED (RPM)
8"	2"	4,536	7,640
9"	2-1/2"	2,640	6,600
10" 14"	3"	2,446	6,115
14"	4-5/8"	2,592	4,365
18"	6-5/8"	2,016	3,395

It is the user's responsibility to refer to and comply with ANSI B7.1



CONSTRUCTION PRODUCTS **Diamond Cup Grinders**



Norton Clipper cup grinders are available in a range of specifications and diameters providing a solution for a number of applications in the building and construction industry. There are many benefits to diamond grinding. It's very fast, low-cost and creates little noise compared to other concrete cutting options. It has become a very popular choice in the commercial construction and DIY home improvement industries.

Applications: Size Range: Segment Height: **Range:**

Used on right angle grinders to grind concrete, stone and masonry materials. 4" - 7"

Abrasive Grain: **Mounting Options: Options:**

.177", .210"

Diamond 5/8"-11 attachment optimized for all popular angle grinders, 7/8-5/8"-20mm

Standard - single row or double row available

iHD (Infiltrated High-Density) has thicker body, larger ventilation holes for better cooling RIGHT-ANGLE

GRINDER

General-Purpose and Masonry Building Materials

Dry – Cup Grinder ()+

3X3 WITH IHD TECHNOLOGY

The 3X3 cup grinder ensures very high material removal rate, extreme comfort while working without vibrations and a self-sharpening feature. These new iHD cups offer the best finishing and longest life even on softer, more abrasive materials.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x 5/8"-11	.177"	15,000	3X3CG0400	701846 01763	
5 x 5/8"-11	.177"	12,000	3X3CG0500	701846 01766	
7 x 5/8"-11	.177"	8,730	3X3CG0700	701846 01769	

RGER WITH IHD TECHNOLOGY

The Charger cup grinder ensures a high material removal rate and more comfortable work. These new iHD cups provide a better finish and long life on a wide range of materials.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x 5/8"-11	.177"	15,000	CGCG0400	701846 01762	
5 x 5/8"-11	.177"	12,000	CGCG0500	701846 01765	
7 x 5/8"-11	.177"	8,730	CGCG0700	701846 01768	

CLASSIC WITH IHD TECHNOLOGY

The Classic cup grinder provides efficient material removal rate thanks to the small contact surfaces of the segments. The cups also have flat sides to avoid damaging walls or ceilings during flush grinding.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
4 x 5/8"-11	.177"	15,000	CCCG0400	701846 01761	
5 x 5/8"-11	.177"	12,000	CCCG0500	701846 01764	
7 x 5/8"-11	.177"	8,730	CCCG0700	701846 01767	

CLASSIC

Available in a range of sizes and segment designs for optimum performance by life or by speed. Ideal for leveling all types of masonry materials, brick, block, concrete and stone. Strategically placed hole designs help ventilate dust from the surface to extend the life of the cups.

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SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #	
Single Row for Fast S	tock Removal				
4 x 7/8-5/8-20mm	.210"	15,000	CHSCPH0400	701846 82585	
5 x 7/8-5/8-20mm	.210"	12,225	CHSCPH0500	701846 84035	
7 x 7/8-5/8-20mm	.210"	8,730	CHSCPH0700	701846 82594	
4 x 5/8"-11	.210"	15,000	CHSCPT0400	701846 82555	
5 x 5/8"-11	.210"	12,000	CHSCPT0500	701846 84036	
7 x 5/8"-11	.210"	8,730	CHSCPT0700	701846 82593	
Double Row for Long	Life, Smooth Finish				
4 x 7/8-5/8-20mm	.210"	15,000	CHDCPH0400	701846 82588	
5 x 7/8-5/8-20mm	.210"	12,225	CHDCPH0500	701846 84037	
7 x 7/8-5/8-20mm	.210"	8,730	CHDCPH0700	701846 82596	
4 x 5/8"-11	.210"	15,000	CHDCPT0400	701846 82586	
5 x 5/8"-11	.210"	12,000	CHDCPT0500	701846 84038	
7 x 5/8"-11	.210"	8,730	CHDCPT0700	701846 82595	

Accessories

VACUUM SHROUD KIT

Industrial Market - Full-Line

The Vacuum Shroud's design creates a cyclonic affect extracting dust and debris from the work surface into the support vacuum. This prolongs the life of the grinding cup and grinder and provides a smoother surface while decreasing the chance of dust particle inhalation.

DESCRIPTION

5" vacuum shroud kit - includes one shroud, five different adapter rings to fit most popular right angle grinders, 701846**94059** and one 5" x 5/8-11 Norton Clipper cup wheel.











IPC #



CONSTRUCTION PRODUCTS **Diamond Core Bits**



Core bits are cutting tools used to remove a cylindrically shaped piece of material. A core drill is designed to cut a hole and remove a core sample or to drill a hole without leaving material behind. Diamond core bits have diamond cutting tips and are frequently used for drilling in materials such as concrete, stone, and asphalt.

Applications: Size Range: Segment Height Range: .254", .393" Abrasive Grain: **Mounting Options:** Machines Used:

Used on core drills in materials such as concrete, stone and other hard materials 2" - 10"

Diamond 1-1/4"-7 threads



Reinforced Concrete and Harder Building Materials

WET – Hard Aggregates

FANADIQIN	
Premium diamond in the turbo segment permits the core to penetrate quickly and efficiently into the toughest cured concrete	e, for significantly
increased performance. The 14" tube length with 1-1/4"-7 threads fits a wide range of core drill mounting arbors.	

increased perioriti	ance. The 14 lube	1611yuli wilii 1-1/4 -7 ulii	saus nis a wide range	or core unit mounting and	JI 3.
SIZE IN INCHES	SIZE IN MM	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
2	51mm	.490"	2,000	PDBIT0200	701846 01410
2-1/2	64mm	.490"	1,300	PDBIT0250	701846 01411
3	76mm	.490"	1,300	PDBIT 0300	701846 01412
3-1/2	89mm	.490"	1,300	PDBIT0350	701846 01413
4	102mm	.490"	1,000	PDBIT0400	701846 01414
4-1/2	114mm	.490"	800	PDBIT0450	701846 01415
5	127mm	.490"	800	PDBIT0500	701846 01416
6	152mm	.490"	665	PDBIT0600	701846 01417
7	178mm	.490"	600	PDBIT0700	701846 01418
8	203mm	.490"	500	PDBIT0800	701846 01419
10	254mm	.490"	400	PDBIT1000	701846 01706





CLASSIC

DADADICM

Economical choic	e for use in harder	concrete with heavy reinf	orcement and maso	nry materials with good perfo	ormance.
SIZE IN INCHES	SIZE IN MM	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
2	51mm	.350"	2,000	CHBIT0200	701846 82762
3	76mm	.350"	1,300	CHBIT0300	701846 82765
4	102mm	.350"	1,000	CHBIT0400	701846 82767
6	152mm	.350"	665	CHBIT0600	701846 82771
8	203mm	.350"	500	CHBIT0800	701846 82773
10	254mm	.350"	400	CHBIT1000	701846 82774





TECH TIP

Core Bits - Minimum and Maximum **Recommended Operating Speeds**

BIT DIAMET	FER MINIMUM RPM	IDEAL SPEED (RPM)	MAXIMUM RPM
1	2,400	3,200	4,000
2	1,200	1,600	2,000
3	800	1,050	1,300
4	600	800	1,000
5	475	640	800
6	400	530	665
7	340	450	600
8	300	400	500
10	240	320	400

Note: For half inch increments, go to the next larger bit diameter.

It is the user's responsibility to refer to and comply with ANSI B7.1





CONSTRUCTION PRODUCTS Equipment



High-Speed Gas Saws

No more pre-mixing oil and fuel - the patented iLube option automatically controls mixing for maximum efficiency, and the saw drops to idle speed when the oil is low - eliminating possible machine damage

Walk-Behind Saws

Proven, robust and functional for ideal user comfort. The professionals' choice for outstanding walk-behind cutting performance, wet or dry.

Masonry Saws

Norton introduced the first masonry saw over 85 years ago and they have become the industry standard for masons worldwide.

For the full line of quality Norton Clipper equipment, please contact your local Norton sales representative

High-Speed Gas Saws

CP500 SERIES HIGH-SPEED SAWS

The Norton Clipper CP500 high-speed cut-off saw might be new to the market, but it's destined to be an asset on any crew. It's fully designed with the user in mind to not only cut a smooth, fast track, but it's also fully equipped to handle the everyday performance of any jobsite with unrelenting durability and reliability. Select a standard model or upgrade to the world's first patented automatic lubrication system, Norton Clipper Lube. The patented iLube option automatically controls mixing of oil and fuel for maximum efficiency. An electronic sensor will

indicate a low oil level and adjust the engine to idle to prevent engine damage.

		-	
DESCRIPTION	SHAFT RPM	PART #	UPC #
14" Standard High-Speed Cut-Off Saw	4,500	CP514-350	701846 47563
14" iLube High-Speed Cut-Off Saw	4,500	CP514-350i iLube	701846 47565
ACCESSORIES			
High-Speed Saw Wheel Kit			005101 09845
High-Speed Saw Tool Kit			005101 09846













CONSTRUCTION PRODUCTS Equipment



GC55 EARLY ENTRY/GREEN SAW

UPC # 701846**30005**

With a compact, light-weight design backed by the reliable Honda 5HP gasoline engine, the GC55 early entry saw is intended for a variety of applications. From green, cured or decorative concrete cutting to expansion joints, the features of this small push saw are hard to beat in a single saw. The low, wide profile of the frame, along with the front mount blade, contribute to producing a more disciplined cut.

Honda GX160 115 lbs

10"

UPC 70184642453



C1318P GASOLINE SAW

The next generation of 13HP saws. The C1318P features shock-absorbing handle bars. The new sleek design of the water tank, with increased capacity and improved securing, adds an additional 1.5 gallons of water over the cut. And, a newly-designed belt tensioning system helps keep the saw cutting tried and true. All these features, coupled with the Honda 13HP engine, make the C1318P the premiere choice for rental and service work

Honda GX390 220 lbs

18"



C13PE GASOLINE SAW

Rental equipment has to withstand any and all conditions by user and application. For that reason, the Norton Clipper C13PE suits any rental fleet that both the novice and expert will appreciate to hold-up through tough situations. The 18" blade guard, ride-on water system and guick-release blade guard lock all keep safety in mind while the rugged frame, powerful engine and easy-to-use console makes cutting a breeze.

UPC #	MOTOR	WEIGHT	GUARD
70184647524	Honda GX390	220 lbs	18"





Large Masonry Saws

BBL BLOCKBUSTER LARGE MASONRY SAWS

Having introduced the first masonry saw over 70 years ago, the Norton Clipper BBL heavy-duty block saws have become the industry standard for masons worldwide. These models are equipped with single-phase electric motors and come with a blade capacity of 14" or 20". Extended water pan and open back frame allow cutting of larger materials. The balanced cutting head makes for effortless cutting depth positioning. Having a rugged all-steel frame design with forklift brackets allows these saws to resist twisting and damage during transport around a job site.

For other sizes and horsepower machines, or for gasoline-powerered versions, contact your Norton sales representative.

DESCRIPTION	HP	PART #	UPC #
BBL547 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	5	BBL547	701846 83211
BBL527 Blockbuster Saw with Baldor electric motor; 20" blade guard capacity	5	BBL527	701846 83150
ACCESSORIES			
Electric Water Pump – PE-1			701846 68392
Conveyor Cart Replacement for BBL			003100 07390

Electric Water Pump

CONSTRUCTION PRODUCTS Equipment



Compact Masonry Saws

BBC BLOCKBUSTER COMPACT MASONRY SAW

Combines the performance of a full size masonry saw with the convenience of portability. Also available in gas or electric versions, the BBC saws have a rugged jig-welded frame, durable enough for even the heaviest work load. Standard rear wheel dolly design and removable legs make transport and set-up easy.

For other sizes and horsepower machines, or for gasoline-powered versions, contact your Norton sales representative.

DESCRIPTION	HP	PART #	UPC #
BBC157 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	1.5	BBC157	701846 82488
BBC207 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	2	BBC207	701846 82501
BBC307 Blockbuster Saw with Baldor electric motor; 20" blade guard capacity	3	BBC307	701846 30011
BBC547 Blockbuster Saw with Honda gasoline motor; 14" blade guard capacity	5.5	BBC547	701846 82175
BBC507 Blockbuster Saw with Honda gasoline motor; 20" blade guard capacity	5.5	BBC507	701846 30012
ACCESSORIES			
Electric Water Pump – PE-1			701846 68392
Conveyor Cart Replacement for BBC			003100 07367
Mechanical Water Pump Assembly (water pump not included)			003100 04237
Water Pump Pulley			003100 04669





BBC Water Pump Pulley

BBC Conveyor Cart Replacement



CONSTRUCTION PRODUCTS Equipment

Mini Masonry Saws

BBM BLOCKBUSTER MINI MASONRY SAWS

The innovative design of these small masonry saws has been copied many times due to its compact, all-steel unibody construction, giving the best weight-to-strength distribution. A 14" blade capacity and ergonomically-designed, three-position locking, cutting head provides a safe, clear view of the work area. Whether your choice is the 3HP brush motor or the 1.5HP induction motor for heavier commercial use, both come with features such as overload protection, garden hose connection and a channeled-flow water pan to direct dust and slurry away from the operator.

DESCRIPTION	HP	PART #	UPC #
Blockbuster Mini Masonry Saw with AC universal motor; gear drive	3	BBM307	701846 00684
Blockbuster Mini Masonry Saw with Induction motor; belt drive	2	BBM158	701846 26327
ACCESSORIES			
Conveyor Cart with Vacuum Attachment			701846 02862
Wet Kit			701846 00704
Stand			701846 00691







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shine on EVERY STEP OF THE WAY

Finishing and masking products to help you finish the job right. Our polishing compounds and surface finishing products along with application accessories are designed to provide the highest level of shine.





FINISHING PRODUCTS Buffing Compounds



The Farécla system of compounds and waxes is designed to achieve a perfect finish on painted and gel coat surfaces. A full line of cutting and polishing compounds, along with application accessories, will enhance the highest-level shine. Farécla compounds contain a unique abrasive technology that removes sanding marks permanently, avoiding costly reworks.

Farécla polishing compounds and surface finishing products are used on a wide variety of substrates and have been used by automotive bodyshops, detailers, boat builders, woodworkers, composite manufacturers and other industrial applications since 1952.

Products: Markets: Surface Types: Machine Used: Liquid Compound, Paste Compound, Wax, Applicator Pads, Microfiber Cloths Marine, Prime Automotive, General Transportation, Solid Surfaces, Instruments and more Paint/Laquer, Gel Coat, Composite

HAND



PNEUMATIC OR VARIABLE SPEED BUFFER



Step One – Compounding



For use on all wood lacquers, clear coats and paints

PROFILE ADVANCED PLUS 400 LIQUID COMPOUND

- · Offers the highest level of cut and gloss on painted surfaces and wood lacquers
- Unique abrasive technology which contains no fillers or silicones allow operators to see sanding marks from up to P1500 grit permanently removed
- · Provides a high shine finish with good depth and clarity

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored liquid	Medium	152 g/L	0.95	8 - 9	All wood lacquers, clear coats and paints



For use on any gel coat surfaces

PROFILE SELECT 200 LIQUID COMPOUND

- A great value, swirl-free, versatile, cutting compound aimed at OEM applications removes P800 grit or finer sanding
 marks from tooling or production gel coats in a single step
- Used with a wool pad, quickly removes sanding marks up to P1500 on painted surfaces, performs best on a twisted wool compounding pad at high speeds of 2,000-3,500 rpm
- Clean in use, and loads application pads evenly for a fine shine

Technical Inform	nation				
APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored liquid	Medium	152 g/L	0.95	8 - 9	Any painted or industrial surface

For use on marine gel coats, wood, aerospace, caravans, and mo	torhomes etc.
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PROFILE PREMIUM PASTE

- · Ideal for removing sanding marks of P1200 and finer or restoring oxidized and weathered gel coat surfaces
- · Works great as a single step on dark colors delivering a high gloss finish
- · Use as the first stage of a two-part process where higher gloss and lower swirl is desired

Technical Inform	nation		
APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENS
White thick liquid	High	266g/L	1.15

PAINT TYPE COMPLIANCE
Marine gel coats, wood, aerospace, caravans, and motorhomes etc.

7 - 8



Step One – Compounding continued

	ung continueu		
	For use on mar	rine gel coats, wood, aeros	pace, caravans, and motorhomes etc.
	Removes sanding rEasy to apply; with	marks up to P800 while leaving you	Y CUT PASTE COMPOUND vith a high gloss finish It in hot conditions or on large working surfaces
Technical Information APPEARANCE VISCOSITY White thick liquid High	VOC CONTENT RELATIVE DEN KG 1.65		PE COMPLIANCE el coats, wood, aerospace, caravans, and motorhomes etc.
	For use on har	d tooling and production g	el coats, and solid surfaces
	Coarse, water-baseRemoves up to P60	ed cutting compound designed for ag	SE CUT PASTE COMPOUND gressive compounding on tough resins and gel coats shine in comparison to other compounds
Technical InformationAPPEARANCEVISCOSITYWhite colored pasteHigh	VOC CONTENT RELATIVE DEN Og/L 1.57		PE COMPLIANCE ling and production gel coats, and solid surfaces
	For use on poly	yester, acrylic and epoxy r and solid surfaces	esins and gel coats, industrial paint finishes,
Technical Information	Versatile, mid-rangRestores gloss and	ge, high gloss, water-based compoun d color to virtually any gel coated or p	ASTE COMPOUND d capable of removing P1000 or P1200 dry abrasive marks ainted surface a first stage or as a finishing compound
APPEARANCE VISCOSITY White colored paste High	voc content relative den 119g/L 1.45	9.8 Pol	IT TYPE COMPLIANCE rester, acrylic and epoxy resins and gel coats, industrial paint hes, wood lacquers and solid surfaces
Liquid		PROFILE 350	PREMIUM
TRADENAME: PROFILE ADV SIZE ORD. QTY. PRODUCT #	ANCE PLUS PROFILE SELEC Part # Product #	T LIQUID GRP I Part # Product #	AST MEDIUM CUT PART #
1 Litre61 Gallon2PRA118	PRS101 780727 15148 PRS106	780727 00168 PRL112 780727 00169 PRL118	780727 63911 780727 64005
5 Gallon 1 PRA518 Paste PD0ELLE 100	780727 29474 PRS506	780727 29473	
TRADENAME: PROFILE 100 EXTRA HEAVY SIZE ORD. QTY. PRODUCT #	PART # PRODUCT #	ASTE RAPID CUT C Part # Product #	OMPOUND PART #
3 kg 24 PRE306	780727 63866 PRP306	780727 64019 PR0300-3000	780727 64012



FINISHING PRODUCTS Buffing / Finishing Compounds

Step Two – Finishing



For use on all paint types

PROFILE FINISH LIQUID COMPOUND

- Fine abrasive formulation quickly and permanently removes swirls and holograms
- · Restores dull surfaces and enhances color for a high shine finish with good depth clarity
- Ideal economical solution to compounding with low viscosity

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE	
White colored liquid	Medium	152 g/L	0.95	8 - 9	All paint types	

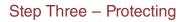


	TRADENAME:	PROFILE FINISH		
SIZE	ORD. QTY.	PRODUCT #	PART #	
1 Litre	6	PRF101	780727 00164	





FINISHING PRODUCTS Buffing / Protecting Compounds





For use on any painted or industrial surface

PROFILE POLYMER WAX

- · Quick and easy to use making short work of large surfaces, perfect for use on boats, vans, trucks and planes
- Creates a durable, highly water resistant protective coating which repels many common contaminants; high-gloss finish has excellent evenness and real transparency on dark colors
- · Sprayable formulation is perfect for ultra-fast applications due to its low viscosity and drying resistance

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
Pink colored liquid	Low / Medium	131 g/L	0.960	7	Any painted or industrial surface



For use on all paint types

PROFILE UV WAX

- Carnauba based wax incorporating special UV absorbers to give up to 3 month's protection to gel coats and paints
 exposed to external weathering
- High Carnauba content ensures long-lasting protection against rain and salt water while the UV absorbers protect
 against exposure to sunlight
- Gives a high-gloss, long-lasting finish on most surfaces; well suited for use on boats, caravans, trains, planes, lacquered wood and UPVC surfaces

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	РН	PAINT TYPE COMPLIANCE
Pale purple liquid	Medium viscosity	167g/L	0.970	7 (approx.)	All paint types



For use on all paint types and surfaces

PROFILE RAPID DETAILER CLEANER & WAX

- Fast liquid spray wax for that "just waxed" look or a quick clean leaving a high-gloss finish
- · Perfect for paintwork, rubber, vinyl, plastic, glass, and chrome
- · Won't remove previously applied polishes or waxes aiding continuous protection

Technical Information

APPEARANO	CE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANC	E
Colorless th	nin liquid	Low viscosity	27g/L	0.990	8 - 9	All paint and surface type	S
			8				
	TRADENAME:	PROFILE POLYM	ER WAX	PROFILE UV W	AX	PROFILE RAPI	D DETAILER CLEANER & WAX
SIZE	ORD. QTY.	PRODUCT #	PART #	PRODUCT #	PART #	PRODUCT #	PART #
1 Litre	6	PRW101	780727 00171	PRU101	780727 00170		
1 Gallon	2					PRD106	780727 17216



Farécla

FINISHING PRODUCTS Applicator Pads & Accessories



Having the right applicator pad, whether it's a wool, waffle or dimple configuration will help others see the perfection in your work. Multiple choices in size and face to evenly distribute the Farécla compounds and create a reflection others will envy.

Products: Application: Machine Used: Foam Pads, Waffle Pads, Wool Pads, Buffing Pads, Spot Repair Pads, Micro-Fiber Cloths Even distribution of compounds and waxes; polishing



HAND APPLICATION

PNEUMATIC OR VARIABLE SPEED BUFFER

Single-Sided Pads



Single-Sided Pads have a beveled edge design to allow access under trim and improve user control. The recessed back provides accurate alignment for balance and protects against backing plate contact.

SIZE/DESCRIPTION	STD. PKG.	PART #
CCS Dimple Foam Pad - Single-Sided		
3.25" Cutting and Polishing - Orange	6	662610 85302
3.5" Cutting- White	6	666233 91319
3.5" Polishing - Black	6	666233 91320
3.5" Finishing - Blue	6	666233 91321
Cutting Wool Pads – Single-Sided		
3.5" Cutting Wool	6	666233 91318
CCS Waffle Foam Pads - Single-Sided		
8" Cutting- White	6	666233 91306
8" Polishing - Black	6	666233 91307
8" Finishing - Blue	6	666233 91308
Finishing Wool Pads		
8" Single-Sided Wool Pad	6	666233 91315
8" Single-Sided Blended Yellow Wool Pad	6	780727 59561
8" Double-Sided Blended Yellow Wool Pad	6	780727 59563

Double-Sided Pads



Double-Sided Pads have a highly engineered center plate designed to minimize pad hop or chatter with the perfect amount of flexibility when buffing contours.

SIZE/DESCRIPTION	STD. PKG.	PART #
CCS Waffle Foam Pads - Double-Sided		
8" Cutting - White	6	666233 91310
8" Polishing - Black	6	666233 91311
8" Finishing - Blue	6	666233 91312



FINISHING PRODUCTS Applicator Pads & Accessories

Spot Repair Pads for Buffing/Polishing

SIZE/DESCRIPTION	STD. PKG.	PART #
Spot Repair Foam Pads		
3" Super Cut Wool Pad	40	636425 43832
3" Blue Cutting Foam Pad	40	636425 05459
3" White Finishing Foam Pad	40	636425 05460
Back-up Pad		
3" Back-up Pad	40	636425 06128

Hook and loop polishing pads for small spot repair

Buffing Pads and Accessories



Wool pads give a high cut and great finish. Our polish applicator pads are available in sizes to suit a range of rotary polishers, including 3" and 8" with backing plates also available.

SIZE/DESCRIPTION	STD. PKG.	PRODUCT #	PART #	
G Mop Series Buffing Pads				
8" G Mop Single-Sided Red Waffle Pad	6	PRF801	780727 44634	
Buffing Pads				
8" Single-Sided Lambswool Pad	6	LPS801	780727 45650	
8" Double-Sided Wool Pad	6	10045	780727 45643	
8" US Advanced Wool Compounding Pad	6	40012	780727 45649	
Accessories for G Mop Series Buffing Pads				
3" and 6" Rotary Extension	6		666233 91317	
3.5" Back-up Plate	6		666233 91316	
8" Double-Sided Pad Adapter	6		666233 91313	
8" Double-Sided Quick-Change Pad Adapter	6		666233 91330	
8" Back-up Plate	6		666233 91314	
Pad Conditioning Brush	6		666233 91489	



FINISHING PRODUCTS Micro-Fiber Cloths

Micro-Fiber Performance Cloths



Cleaning Cloth – Blue: Used for general-purpose wet or dry applications. Works best when sprayed with a light water mist to deep clean.

Dry Tack Cloth – Red: This woven terry cloth has a low profile to resist snagging and help pick up embedded debris.

Polishing Cloth – Yellow: Streak-free cleaning of mirrors, optical lens and highly-polished items.

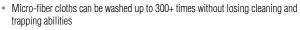
SIZE	COLOR	STD. PKG.	PART #
Micro-Fiber Clear	ing Cloth		
16" x 16"	Dark Blue (thick)	20	636425 04402
16" x 16"	Light Blue	20	076607 05300
Micro-Fiber Dry Ta	ack Cloth		
16" x 16"	Red	20	076607 04025
Micro-Fiber Polis	hing Cloth		
16" x 16"	Yellow	20	07660705301

TECH TIP

- Use these micro-fiber cloths dry for general cleaning
- To remove spills, stains or grime, lightly dampen the cloth for best results

It is the user's responsibility to refer to and comply with all safety regulations.

• All micro-fiber cloths can be used with or without chemicals



· Clean often for best results



FINISHING PRODUCTS Masking Products

Norton masking tapes feature a special solvent-based, rubber adhesive system and strong holding properties. These tapes adhere and release cleanly while providing clean edges on a variety of flat, contoured, and irregular surfaces. Norton sheetings provides superior solvent, paint, and contaminant penetration resistance. Use them during paint preparation and anywhere you need work area protection. Tear-resistant properties allow movement without ripping.

Products: Machine Used:

Attachment Tape, Masking Tape, Sheeting

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HAND
APPLICATION
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NDRTDN

SAINT-GOBAIN



Best choice for dynamic bus, truck and trailer bonding applications

NORBOND A7600 DOUBLE-SIDED ACRYLIC FOAM TAPE

- High performance, double-sided acrylic foam tape with outstanding viscoelastic and adhesion properties and great conformability to dynamic stress loads
- · Offers ideal bonding performance for many interior and exterior industrial and automotive applications
- Formulated for durable, long-lasting adhesion, exceeds industry standards for shear strength and bonding to high surface energy substrates, even at elevated temperatures

Good choice for bonding performance for many interior and exterior commercial applications

PREMIUM ATTACHMENT TAPE

- · Double sided, gray foam tape used in bonding performance for many interior and exterior commercial applications
- · Good conformability and stretching
- Resistance to weathering degradation (UV and high temperature)

DESCRIPTION	THICKNESS	3/8" x 108'	1/2" x 108'	3/4" x 108'	1" x 108'	1-1/2" x 108'
Norbond A7600						
Double-Sided Acrylic Foam Tape	.043" (1.1mm)	780727 59979 NS	780727 64821	780727 02902	780727 02903	780727 02904 NS
	.063" (1.6mm)		780727 75703	780727 59947	780727 64819	780727 59983 NS
Rolls/Case		25/1	20/1	10/1	10/1	8/1
DESCRIPTION	THICKNESS	1/4" X 20 YDS	1/2" X 20 YDS	7/8" X 20 YDS		
Premium Attachment Tape						
Gray Double-Sided Acrylic Foam Tape	.043" (1.1mm)	636425 05620	636425 05621	636425 05622		
Rolls/Case		12/1	12/1	12/1		
Adhesion Promoter						
Dauber - 4 oz.		666233 91030				
Qty/Case		6				

NS Non-Stock: Please contact your Norton representative for current lead-times.

Technical Data

Performance tests are run using standard test procedures. The values presented are typical values and should not be used for specification purposes.

	90° PEEL ADHESION¹ (3-DAY DWELL) Ib/in² (N/cm²)	T-BLOCK ² Ib/in ² (N/cm ²)	DYNAMIC SHEAR ³ lb/in ² (N/cm ²)	STATIC SHEAR ⁴ 7 Days /1 kg	SERVICE TEMPERATURE		
WITHOUT LINER	ALUMINUM	ALUMINUM	S/S	S/S			
Norbond A7600	22 (39)	83 (57)	79 (54)	Pass and Exceed	-30°F to 200°F (-35°C to 93°C)		
Premium Attachment Tape	33 (57)	100 (69)	48 (33)	Pass and Exceed	-30°F to 200°F (-35°C to 93°C)		
¹ Based on ASTM D3330 ² Based on ASTM D897 ³ Based on ASTM D1002 ⁴ Based on ASTM D3654							





It delivers very sharp, clean edges on smooth- to moderately-textured surfaces

BLUE CORE 14-DAY TAPE

- Our paint masking tape has a specially formulated adhesive system that provides optimum low- to medium-tack
 adhesion and clean removal from a variety of surfaces, for up to 14 days
- Blue Core masking tape can be used indoors or out
- The crepe paper backing is designed to enable easy unrolling and to minimize slivering

		TIER:	GOOD
		TRADENAME:	BLUECORE 14 DAY TAPE
		BACKING	Fine Crepe Paper
		ADHESIVE	Synthetic Rubber
		TENSILE STRENGTH	23 lbs/in (101 N/25mm)
		ELONGATION AT BREAK	11%
		TOTAL THICKNESS	5.5 mils (0.14mm)
METRIC	IMPERIAL	ROLLS/CASE	PART #
Blue Core 14-Day Tape			
36mm x 54.8m	1-1/2" x 60 yards	24	076607 21954
48mm x 54.8m	2" x 60 yards	24	076607 21955

Bulk packed as individual rolls



Good multi-purpose choice provides durability and excellent protection

HIGH DENSITY SHEETING (HDPE)

Our multi-purpose painters' plastic sheeting protects virtually any area from sanding dust and paint overspray with ease – even after repositioning. Our High Density Plastic Sheeting (HDPE) is designed to be one of the strongest most durable products on the market.

- · Resists tearing and solvent bleed-through with light weight .31 mil High Density Polyethylene plastic (HDPE)
- · Holds in place as it clings to horizontal or vertical surfaces during taping with its natural electrostatic properties
- · Attracts and holds sanding debris for a dust-free finish
- Drapes easily over furniture

SIZE	THICKNESS	COLOR	QTY/PACK	PACKS/CASE	PART #
9' x 400'	.31 mil	Clear	1	1	076607 68142
12' x 400'	.31 mil	Clear	1	1	076607 68143

Also available by the pallet.

DON'T LEARN **SAFETY GUIDES** BY ACCIDENT!

SAFETY IS EVERYONE'S JOB

Make the safety of yourself and your team a priority on every job site and learn the proper use and function of all your Norton products and equipment.



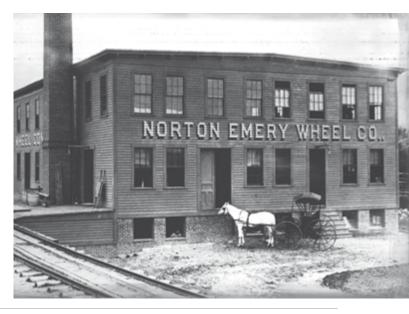
Safety Leadership / References

100 Years of Safety Leadership

The year 2016 marked the 100-year anniversary of the leadership of the former Norton Company in the creation of the first ever safety code for abrasives.

In 1916, following more than a decade of safety research, advocacy, and leadership by the Norton Company (now Norton | Saint-Gobain Abrasives), "The Safety Code for the Use and Care of Abrasive Wheels" was published. This 13-page booklet, containing an unprecedented set of safety device recommendations and procedures, was the spark that changed the entire future of the abrasives industry.

In the 1970s, this code received the ultimate endorsement when selected by OSHA as the basis of new federal regulations concerning abrasive wheel machinery. Today, the ever-evolving "Safety Requirements for the Use, Care and Protection of Abrasive Wheels" (commonly known as the ANSI B7.1 standard) continues to mirror the latest technologies and remains the global authoritative abrasives safety standard.



Breakages/Personal Injury

In the event of on-machine breakage of Norton abrasive products, call your local Norton distributor immediately. Whether involving personal injury or not, the abrasive user should leave the equipment and other evidence undisturbed until a Norton sales representative has been notified and conducts an investigation. Prompt action on the part of abrasive users, distributor, and Norton sales personnel is important to ensure swift determination of the breakage cause and to guard against recurrence.





It is the user's responsibility to refer to and comply with ANSI B7.1 and B7.7 - Contact us for a free copy.



Safety Poster (Form # 7868-English, 7868-French, 7868-Spanish)

To order this poster for your shop, mailto:nortonliterature@saint-gobain.com

Abrasive Safety References



Safety Information on the Web

Visit our newly updated safety website for safety guides, safety data sheets, videos and lots of additional safety resources. <u>nortonsga.us/safety</u>

UAMA (United Abrasives Manufacturers Association) website at <u>safety.uama.org</u>

Safety Videos



Watch our Safety Videos **& YouTube.com/NortonAbrasives**

- Safety, It's The Smart Thing To Do (Safety information for portable grinding and cutting wheels)
- Foundry Safety
- First in Precision Grinding Safety
- Proper Grinding Wheel Mounting
- Railroad Abrasive Safety
- Coated Abrasive Belt and Disc Safety



UAMA Approved Safety Icons

The UAMA has approved a new set of standardized icons to be used throughout the Abrasive industry to convey safety information to the users. Below are the approved icon types and their definitions.

ICON TYPES	EXAMPLE
Safety Icon: A pictorial whose purpose is to relay safety related information to the user.	
Hazard Alert Icon: This type of safety icon conveys information primarily related to the nature of a hazard. It contains a graphical depiction of the hazard drawn within a yellow equilateral triangle.	
Prohibition Icon: This type of safety icon conveys actions that should not be taken. It consists of a red circular band with a 45° diagonal red band from upper left to lower right. The icon contains a black depiction of what should not be done within the red band on a white background.	
Mandatory Action Icon: This type of safety icon conveys actions that should be taken to avoid hazards. It consists of a white image within a solid blue or black circular surround shape.	
Proper Machine Use Icon: This type of icon is designed to show the use of the wheel on a proper machine. The icon can be a bit more realistic to show components such as a safety guard and an auxiliary handle. The recommended angle of use may also be depicted.	

ICON	MEANING	ICON	MEANING
	Improper use may break wheel and cause serious injury or death.		Always use wheel guard for angle grinder.
	No side grinding. Cutting only.	GUARD	Always use wheel guard for non-portable machine.
	No side grinding. Cutting only		Protect your eyes.
	No cutting. Side grinding only.		Protect your face.
	No cutting. Side grinding only, grouped icon.		Protect your lungs against dust.



SAFETY Safety Icon Meanings

UAMA Approved Safety Icons continued

ICON	MEANING	ICON	MEANING	
	Do not use a damaged wheel.		Protect your hearing.	
	Do not use on high-speed gas saws.	T	Protect your eyes and face.	
	Do not use on angle grinders.		Protect your eyes and hearing. Combined icon.	
	Do not use on die grinders		Protect your eyes, ears and lungs.	
	Warning alert symbol.	M2	Protect your hands.	-
C	Read OSHA and ANSI B7.1.		Use matched diameter, relieved flanges.	
safety.uama.org)	Read OSHA and ANSI B7.1. Visit the industry safety page: <u>safety.UAMA.org</u>			



Coated Abrasive Disc and Wheel Safety Do's and Don'ts

Warning

Improper use may cause wheel breakage and serious injury. Comply with ANSI B7.7, OSHA and safety guide provided with the package. Always follow all manufacturer's recommended procedures and safety instructions. Never exceed tool manufacturer's maximum operating speed.

Exposure to DUST generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury. Use dust capture or local exhaust as stated in the SDS. Wear government–approved respiratory protection and eye and skin protection. Failure to follow this warning can result in serious lung damage and/or physical injury.

Lead Poisoning can develop as a result of inhalation and/or ingestion of the dust generated from sanding any product containing lead, including lead based paint. Lead Poisoning is an illness which can permanently damage the body's physical, neurological and/or reproductive systems. Care must be taken to avoid the inhalation and/or ingestion of dust containing lead

	DO'S	DON'TS
INSPECT / STORAGE / SPEED	 D0 read all manuals, operating instructions and warnings D0 read SDS for the disc/wheel and the work-piece material. D0 check all products for damage before mounting. D0 make sure the machine speed does not exceed the speed marked on the package or back up pad. D0 store products prior to use at 35 – 50% relative humidity and 60 – 80°F. 	 DON'T use products that have been dropped or damaged. DON'T use on machines that do not show a MAX RPM speed.
MOUNT / GUARD	 D0 use the wheel guard provided with machine. Position it so it protects the operator and covers the wheel. D0 use recommended back up pad or mandrel for the product. D0 run wheels ONLY in direction of directional arrow stenciled on wheel and in core (except Unified Wheels, which can be run in either direction). D0 run discs/wheels in a protected area for one minute before grinding. 	 DON'T remove or modify any guard. ALWAYS use a proper guard. DON'T use excessive pressure when mounting a wheel. Tighten enough only to hold wheel firmly.
PROTECT	 D0 wear ANSI Z87+ safety glasses and face protection, if required. D0 wear safety shoes, arm guards, leather gloves and aprons. D0 employ dust controls and/or protective measures appropriate to the material being ground. 	 DON'T use products near bystanders if they are not wearing protective equipment.
OPERATE	 D0 support work-piece firmly. D0 hold machine firmly in two hands. D0 stop the equipment at once if chattering or vibration occurs during use. Determine cause of the problem and correct before remounting. D0 ease the disc into the work piece at a 5-10° angle to the work piece surface. 	 DON'T allow untrained people to handle, store, mount or use discs/wheels. DON'T twist, jam or bend any wheel. DON'T force or bump wheel so that the tool motor stalls. DON'T use discs/wheels in the presence of combustible materials. DON'T use disc/wheel for applications other than for which they were designed. Refer to ANSI B7.7.



SAFETY Portable Grinding Safety

Portable Grinding Safety Do's and Don'ts

	DO'S	DON'TS
INSPECT / SPEED	 D0 read all manuals, operating instructions and warnings. D0 read SDS for the wheel and workpiece material. D0 check all wheels for cracks or other damage before mounting. D0 make sure the machine does not exceed the maximum operating speed marked on the wheel. D0 store according to ANSI B7.1. 	 DON'T use wheels that have been dropped or damaged. DON'T use on grinders that do not show a MAX RPM.
MOUNT / GUARD	 DO use an ANSI B7.1 wheel guard. Position it so it protects the operator. DO be sure wheel hole or threads fit machine properly and that the flanges are clean, flat, undamaged and the proper type. DO run wheel in a protected area for one minute before grinding. 	 DON'T remove or modify any guard. ALWAYS use a proper guard. DON'T alter a wheel or force it on to the spindle. DON'T mount more than one wheel on an arbor. DON'T use excessive pressure when mounting a wheel. Tighten enough only to hold wheel firmly.
PROTECT	 D0 wear ANSI Z87+ safety glasses and face protection, if required. D0 wear gloves, hearing and body protection. D0 employ dust controls and/or protective measures appropriate to the material being ground. D0 comply with OSHA regulations 29 CFR 1926.1153 when working on materials containing crystalline silica such as concrete. 	• DON'T use wheels near bystanders if they are not wearing protective equipment.
OPERATE	 DO support work-piece firmly. DO hold grinder firmly with two hands. 	 DON'T allow untrained people to handle, store, mount or use wheels. DON'T use grinding wheels or cutting wheels on pistol grip air sanders. DON'T use any cutting wheel for grinding nor apply side pressure on a cutting wheel. Use for CUTTING ONLY. DON'T use a cutting wheel to cut curves. Cut in straight lines only. DON'T twist, bend or jam any wheel. DON'T force or bump wheel so that the tool motor slows or stalls. DON'T use wheels in the presence of combustible materials. DON'T use wheels for applications other than for which they were designed.



Portable Grinding Safety

Dangerous Pairing: Die Grinders and Cut-off Wheels

While die grinders and portable cut-off tools may look similar, they are by no means interchangeable. Several crucial differences exist between the two handheld machines.

GUARD

Cut-off wheels must be used on guarded machines for the safety of the operator and bystanders.

SPEED

Cut-off wheels must be used at or below their maximum operating speed, marked clearly on the side of the wheel. Excessive speed can result in breakage and serious personal injury.

Die grinders often operate above 25,000 rpm and therefore are too fast for abrasive wheels. The speed hazard is increased by the absence of a guard. Portable cut-off tools, however, rotate at speeds compatible with the abrasive wheels for which they are designed. And, their guards prevent use of an oversize wheel.

MOUNTING

Cut-off wheels must be mounted between proper flanges, as described in the national safety standard for abrasive wheels, ANSI B7.1. Die grinders make use of a collet for mounting

Portable cut-off tools use flanges for mounting, flanges designed according to the ANSI B7.1 safety standard.

Now that you have learned the three crucial differences between die grinders and portable cut-off tools – GUARD, SPEED and MOUNTING – be on watch for the dangerous pairing of cut-off wheels and die grinders, and warn your friends and colleagues of the same.

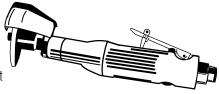
A Deadly Equation

Pistol Grip Air Sander + Grinding Wheel = Certain Injury!

- Never use a high-speed air sander as a portable grinder
- Use only sanding discs specifically designed for sanders
- Because the speed of these sanders far exceeds the maximum rated speeds for grinding wheels, a potentially lethal wheel breakage might occur



Die Grinder



Portable Cut-off Tool



Starting a Grinding Wheel / Ring Test

Starting a Grinding Wheel

ANSI's Procedure for Starting an Abrasive Wheel

This article is designed to remind users of the proper procedure when starting a machine with a new abrasive wheel mounted on it, starting a machine after the machine and wheel have been stored for a period of time, or remounting a wheel. ANSI B7.1 requires the following procedure when starting a newly mounted grinding wheel.

9.8 Starting the Wheel (Requirements)

All abrasive wheels shall be run at operating speeds with the safety guard in place or in a protected enclosure for at least one minute before applying work. During this time no one shall stand in front of or in line with the wheel. (See section 4, for safety guard requirements.) This provision shall apply each time one of the following conditions occur: a) a new wheel has been mounted; or b) a used wheel has been remounted.

E 9.8 Starting the Wheel (Explanatory Information)

An abrasive wheel may be damaged in shipment or storage, or the wheel may be subjected to improper, excessive stresses during mounting. Wheels which have been damaged or are under excessive stress, are likely to fracture within the first minute of rotation at operating speed. While this procedure is most important at the time when an abrasive wheel is mounted or remounted, damage may also occur to a wheel during a shut down of the machine on which it is mounted. The user should evaluate the circumstances and length of machine shut down to determine additional times that the operating rule should be followed.

Improper wheel mounting is a major cause of wheel breakages. Always use proper mounting procedures as outlined in ANSI B7.1, machine manufacturer's instructions and those supplied with the abrasive wheel. Be safe, know and follow the rules!



How to Perform a Ring Test on a Grinding Wheel

One method of grinding wheel inspection is called ring testing. OSHA, ANSI and the grinding wheel manufacturers require this method of grinding wheel inspection. It must be performed BEFORE the wheel is mounted on a grinding machine. Ring testing depends on the damping characteristics of a cracked wheel to alter the sound emitted when the wheel is tapped lightly. It is subject to interpretation by the inspector and is primarily applicable to vitrified bonded wheels. To perform the ring test, wheels should be tapped gently with a light nonmetallic implement, such as the handle of a screw driver for light wheels, or a wooden mallet for heavier wheels.

- Tap wheels about 45 degrees each side of the vertical line and about 1" or 2" from the periphery. Rotate the wheel 45 degrees and repeat the test.
- Large and thick wheels may be given the ring test by striking the wheel on the periphery rather than the side of the wheel.
- A sound and undamaged wheel will give a clear tone. If cracked, there will be a dead sound and not a clear ring and the wheel should not be used.
- Wheels must be dry and free of sawdust when applying the ring test, otherwise the sound may be deadened. The ring test is not applicable to certain wheels because of their size, shape or composition.

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(FOR WHEEL MARKING PURPOSES THE CALCULATED RPM FIGURES LISTED BELOW ARE ROUNDED OFF TO THE NEXT 5) REVOLUTIONS PER MINUTE FOR VARIOUS DIAMETERS OF

20,000		76,395	38,195	25,465	19,100	15,280	12,730	10,915	9,550	8,490	7,640	6,365	5,455	4,775	4,245	20	02:	3,185	2,940	2,730	2,545	2,385	2,245	2,120	2.010	1,910	1,820]
												6,3	5,4	4,7	4,2	3,820	3,470	3,1	2,9	2,7	2,5		2,2	2,1				-
19,685	-	75,190	37,595	25,065	18,800	15,040	12,530	10,740	9,400	8,355	7,520	6,265	5,370	4,700	4,175	3,760	3,420	3,135	2,890	2,685	2,505	2,350	2,210	2,090	1,980	1,880	1,790	_
17,000	_	64,935	32,465	21,645	16,235	12,985	10,820	9,275	8,115	7,215	6,495	5,410	4,640	4,060	3,605	3,245	2,950	2,705	2,495	2,320	2,165	2,030	1,910	1,085	1,710	1,625	1,545	_
16,500	_	63,025	31,510	21,010	15,755	12,605	10,505	9,005	7,880	7,000	6,300	5,250	4,500	3,940	3,500	3,150	2,865	2,625	2,425	2,250	2,100	1,970	1,855	1,750	1,660	1,575	1,500	_
16,000		61,116	30,558	20,372	15,278	12,224	10,186	8,732	7,640	6,792	6,112	5,092	4,366	3,820	3,396	3,056	2,776	2,546	2,352	2,182	2,056	1,910	1,796	1,698	1,608	1,528	1,464	_
14,200		54,240	27,120	18,080	13,560	10,850	9,040	7,750	6,780	6,030	5,425	4,520	3,875	3,390	3,015	2,715	2,465	2,260	2,090	1,940	1,810	1,695	1,595	1,510	1,430	1,355	1,295	
12,500		47,745	23,875	15,915	11,940	9,550	7,960	6,820	5,970	5,305	4,775	3,980	3,410	2,985	2,655	2,390	2,170	1,990	1,840	1,705	1,595	1,495	1,405	1,330	1,260	1,195	1,140	
0 9,500 10,000 12,000 12,500	ute (RPM)	45,836	22,918	15,278	11,459	9,168	7,639	6,548	5,729	5,092	4,584	3,820	3,274	2,865	2,546	2,292	2,084	1,910	1,762	1,637	1,528	1,432	1,348	1,273	1,206	1,146	1,090	VSI B7.1
10,000	Revolutions Per Minute (RPM)	38,196	19,098	12,732	9,549	7,640	6,366	5,456	4,775	4,244	3,820	3,183	2,728	2,387	2,122	1,910	1,736	1,591	1,468	1,364	1,274	1,194	1,124	1,061	1,006	956	908	2.10 of AI
9,500	Revolu	36,287	18,143	12,096	9,072	7,258	6,048	5,183	4,535	4,032	3,629	3,023	2,592	2,268	2,016	1,814	1,649	1,512	1,395	1,296	1,210	1,134	1,067	1,007	955	908	863	ted in Section 1.2.10 of ANSI B7.1
9,000		34,377	17,188	11,459	8,595	6,876	5,729		4,297	3,820	3,438	2,864	2,455	2,149	1,910	1,719	1,562	1,433	1,322		1,146	1,074	1,011	954	904	860	818	listed in S
8,500		32,467	16,238	10,822	8,116	6,494	5,411	4,638	4,058	3,606	3,247	2,705	2,319	2,029	1,803	1,623	1,476	1,353	1,248	1,159	1,082	1,014	955	902	854	812	775	formula
8,000		30,558	15,278	10,186	7,640	6,112	5,092	4,366	3,820	3,396	3,056	2,546	2,182	1,910	1,698	1,528	1,388	1,274	1,176	1,092	1,018	954	898	848	804	764	732	d use the
7,500		28,647	14,328	9,549	7,162	5,730 (4,775	4,092	3,580	3,182	2,865	2,386	2,046	1,791	1,591	1,432	1,302	1,194	1,101	1,023	955 1	895 5	843 843	795 8	754 8	716	682	s not liste
7,000		26,737 2	13,368 1	8,913 5	6 685 7	5,348 5	4,456 4	3,820 4	3,342 3	2,970 3	2,674 2	2,228 2	1,910 2	1,672 1	1,485 1	1,337 1	1,215 1	1,115 1	1,028 1	955 1	891 (836 8	786 8	742 7	704	669 7	636 6	For intermediate diameters not listed use the formula list
6,500 7		24,828 2	12,414 1	8,276 8	6,207 6	4,966 5	4,138 4	3,547 3	3,103 3	2,758 2	2,483 2	2,069 2	1,773 1	1,552 1	1,379 1	1,241 1	1,128 1	1,034 1	955 1,	887 91	828 8	776 8	730 7	690 7	653 7	620 6	591 6	mediate
Diameter of Wheel 6		1 2.	2 12	3 8,	4 6,	5 4,	6 4,	7 3,	8 3,	9 2,	10 2,	12 2,	14 1,	16 1,	18 1,	20 1,	22 1,	24 1,	26 95	28 86	30 82	32 77	34 73	36 65	38 65	40 62	42 59	For intermediate diameters not listed use the for



SAFETY Wheel Speed Conversion Table

Industrial Market - Full-Line

To convert meters per second (m/s) to SFPM: m/s x 196.85 = SFPM

To convert SFPM to m/s: SFPM/196.85 = m/s. To convert RPM to SFPM: Wheel Diameter x RPM \times 0.262 = SFPM



Silica and What You Need to Know

Background and Health impacts

Silica (SiO2) is one of the most common minerals in the earth's crust. Glass, beach sand, silicone and granite are all "silica" materials. Products containing silica have been used for thousands of years in building and is a key ingredient in many products we use every day. There are two forms of silica; crystalline and non-crystalline. Crystalline silica is a mineral that occurs in several forms. Quartz, the most common form, is a component of sand, stone, rock concrete, brick, block and mortar. Non-crystalline silica is found in glass, silicon carbide and silicone.

When rocks containing crystalline silica are cut, crushed, ground, drill or used in similar industrial processes, dust particles are produced. These particles are very fine, at least 100 times smaller than ordinary beach sand – known as respirable crystalline silica or RCS. Inhaling very small or respirable crystalline silica particles is most hazardous and may cause multiple diseases such as silicosis, followed in severe cases by lung cancer.

Who is at risk from exposure to crystalline silica?

It is estimated that 2.3 million workers are exposed to crystalline silica on the job. The majority of the workers, about 2 million, are in the construction industry. The hazard exists when specific activities create respirable dust that is released into the air.

The New OSHA Standard

OSHA's recently implemented silica standards for Construction "29 CFR 1926.1153" and General Industry "29 CFR 1910.1053" suggests procedures applicable for work in these environments. This new standard affects all activities that generate silica dust on a jobsite. Trades involving brick, stone, concrete and other materials that are difficult to replace must comply with the standard. This is a change around "process", not specific products.

Impacts on Industry

Industries affected by this regulation include Construction, Glass manufacturing, Pottery products, Structural clay products, Concrete products, Foundries, Cut stone and Stone products, Railroads, Refractory products and Asphalt products manufacturing to name a few. Always read the Safety Data Sheet for the workpiece and abrasive before use.

The Occupational Safety and Health Administration (OSHA) has a number of available resources to help companies understand the general information and requirements to explain the new regulations including:

OSHA's Crystalline Silica Rule: Construction <u>osha.gov/Publications/OSHA3681.pdf</u>

OSHA Fact Sheet osha.gov/publications/OSHA3682.pdf

Small Entity Compliance Guide for Respirable Crystalline Silica Standard for Construction <u>osha.gov/publications/OSHA3902.pdf</u>

Small Entity Compliance Guide for Respirable Crystalline Silica Standard for General Industry and Maritime osha.gov/publications/OSHA3911.pdf





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