

## Abrasive Caps and Abrasive Sleeves

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**321** Mandrel, tapered

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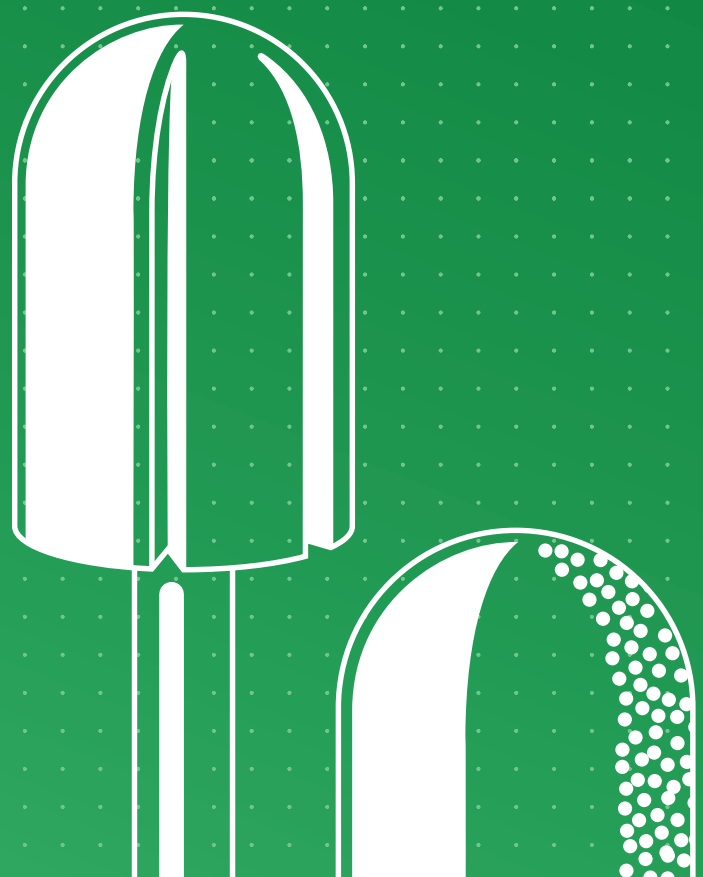
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### Product line marking

Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



## Information

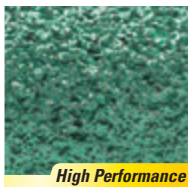
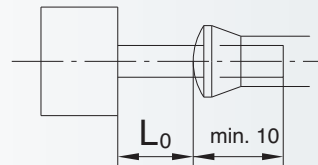
The LUKAS abrasive caps and sleeves are manufactured from high quality coated abrasive material, and are used in conjunction with the appropriate high precision mandrel. We offer a great variety of different tools and mandrels which covers a wide spectrum of applications.

### Examples of application:

- fine and extremely fine machining particularly in areas difficult to access
- tool, mould and model making

## Maximum operating speed

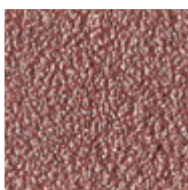
The maximum operating speed for abrasive caps is stated in the respective table of mandrels. The indicated maximum operating speeds are only valid for a maximum overhang length  $L_0$  of 15 mm. Other overhang dimensions must be calculated separately.



High Performance

### Abrasive caps, special, NKS

Special quality for the machining of corrosion and heat-resistant steels for tool and mould making. The top size coating with reactive fillers leads to higher stock removal and increased service life.



### Abrasive caps, universal, NK

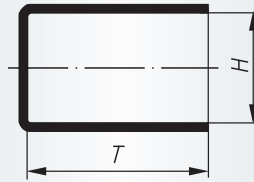
Universal quality for the machining of metal, plastics, wood and many other materials.



**High Performance**

**SKZYS, Abrasive caps special, Cylindrical shape**

Ordering example: A21020051080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 314

NKS = Aluminium Oxide with special coating

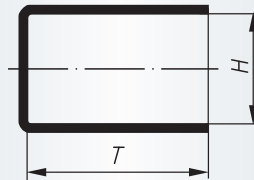
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKZYS 0510	NKS 80	5	10	A21020051080	1 2 3 4 5 6 7 8	■
SKZYS 0510	NKS 150	5	10	A21020051150	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 60	7	12	A21020071060	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 80	7	12	A21020071080	1 2 3 4 5 6 7 8	■
SKZYS 0712	NKS 150	7	12	A21020071150	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 60	10	15	A21020101060	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 80	10	15	A21020101080	1 2 3 4 5 6 7 8	■
SKZYS 1015	NKS 150	10	15	A21020101150	1 2 3 4 5 6 7 8	■



**Industry**

**SKZY, Abrasive caps universal, Cylindrical shape**

Ordering example: A21000051080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 314

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKZY 0510	NK 80	5	10	A21000051080	1 2 3 4 5 6 7 8	■
SKZY 0510	NK 150	5	10	A21000051150	1 2 3 4 5 6 7 8	■
SKZY 0510	NK 320	5	10	A21000051320	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 60	7	12	A21000071060	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 80	7	12	A21000071080	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 150	7	12	A21000071150	1 2 3 4 5 6 7 8	■
SKZY 0712	NK 320	7	12	A21000071320	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 60	10	15	A21000101060	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 80	10	15	A21000101080	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 150	10	15	A21000101150	1 2 3 4 5 6 7 8	■
SKZY 1015	NK 320	10	15	A21000101320	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 60	13	17	A21000131060	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 80	13	17	A21000131080	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 150	13	17	A21000131150	1 2 3 4 5 6 7 8	■
SKZY 1317	NK 320	13	17	A21000131320	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 60	16	26	A21000161060	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 80	16	26	A21000161080	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 150	16	26	A21000161150	1 2 3 4 5 6 7 8	■
SKZY 1626	NK 320	16	26	A21000161320	1 2 3 4 5 6 7 8	■

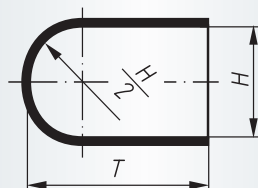




High Performance

**SKWRS, Abrasive caps special, Cylindrical round nose**

Ordering example: A21020052080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 316

Aluminium Oxide with special coating

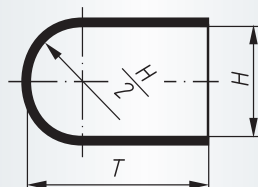
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWRS 0511	NKS 80	5	11	A21020052080	1 2 3 4 5 6 7 8	■
SKWRS 0511	NKS 150	5	11	A21020052150	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 60	7	13	A21020072060	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 80	7	13	A21020072080	1 2 3 4 5 6 7 8	■
SKWRS 0713	NKS 150	7	13	A21020072150	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 60	10	15	A21020102060	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 80	10	15	A21020102080	1 2 3 4 5 6 7 8	■
SKWRS 1015	NKS 150	10	15	A21020102150	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 60	13	19	A21020132060	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 80	13	19	A21020132080	1 2 3 4 5 6 7 8	■
SKWRS 1319	NKS 150	13	19	A21020132150	1 2 3 4 5 6 7 8	■



Industry

**SKWR, Abrasive caps universal, Cylindrical round nose**

Ordering example: A21000052080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 316

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWR 0511	NK 80	5	11	A21000052080	1 2 3 4 5 6 7 8	■
SKWR 0511	NK 150	5	11	A21000052150	1 2 3 4 5 6 7 8	■
SKWR 0511	NK 320	5	11	A21000052320	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 60	7	13	A21000072060	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 80	7	13	A21000072080	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 150	7	13	A21000072150	1 2 3 4 5 6 7 8	■
SKWR 0713	NK 320	7	13	A21000072320	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 60	10	15	A21000102060	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 80	10	15	A21000102080	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 150	10	15	A21000102150	1 2 3 4 5 6 7 8	■
SKWR 1015	NK 320	10	15	A21000102320	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 60	13	19	A21000132060	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 80	13	19	A21000132080	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 150	13	19	A21000132150	1 2 3 4 5 6 7 8	■
SKWR 1319	NK 320	13	19	A21000132320	1 2 3 4 5 6 7 8	■

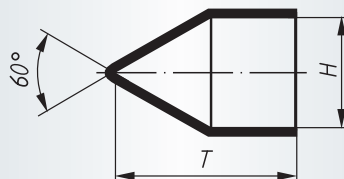
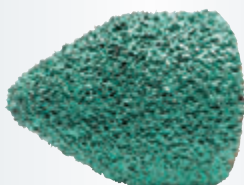




High Performance

**SKWKS, Abrasive caps special, Cylindrical pointed nose**

Ordering example: A21020053080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 318

NKS = Aluminium Oxide with special coating

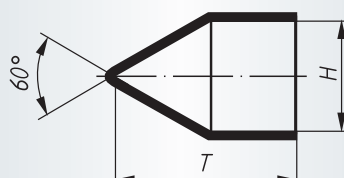
Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWKS 0511	NKS 80	5	11	A21020053080	1 2 3 4 5 6 7 8	■
SKWKS 0511	NKS 150	5	11	A21020053150	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 60	7	13	A21020073060	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 80	7	13	A21020073080	1 2 3 4 5 6 7 8	■
SKWKS 0713	NKS 150	7	13	A21020073150	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 60	10	15	A21020103060	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 80	10	15	A21020103080	1 2 3 4 5 6 7 8	■
SKWKS 1015	NKS 150	10	15	A21020103150	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 60	13	19	A21020133060	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 80	13	19	A21020133080	1 2 3 4 5 6 7 8	■
SKWKS 1319	NKS 150	13	19	A21020133150	1 2 3 4 5 6 7 8	■



Industry

**SKWK, Abrasive caps universal, Cylindrical pointed nose**

Ordering example: A21000053080



**Packing unit:**

100 pcs. per type

n max.: please refer to the corresponding mandrel, page 318

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	Product-Number	recommended for	
SKWK 0511	NK 80	5	11	A21000053080	1 2 3 4 5 6 7 8	■
SKWK 0511	NK 150	5	11	A21000053150	1 2 3 4 5 6 7 8	■
SKWK 0511	NK 320	5	11	A21000053320	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 60	7	13	A21000073060	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 80	7	13	A21000073080	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 150	7	13	A21000073150	1 2 3 4 5 6 7 8	■
SKWK 0713	NK 320	7	13	A21000073320	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 60	10	15	A21000103060	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 80	10	15	A21000103080	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 150	10	15	A21000103150	1 2 3 4 5 6 7 8	■
SKWK 1015	NK 320	10	15	A21000103320	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 60	13	19	A21000133060	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 80	13	19	A21000133080	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 150	13	19	A21000133150	1 2 3 4 5 6 7 8	■
SKWK 1319	NK 320	13	19	A21000133320	1 2 3 4 5 6 7 8	■

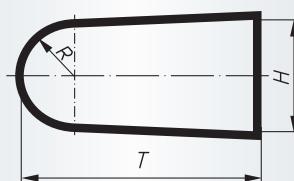




High Performance

**SKKES, Abrasive caps special, Conical round nose**

Ordering example: A2102163060



**Packing unit:**

25 pcs. per type

n max.: please refer to the corresponding mandrel, page 320

NKS = Aluminium Oxide with special coating

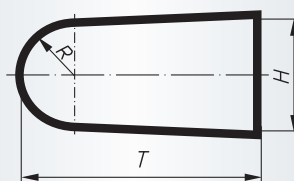
Description	Grits	H mm	T mm	≈R mm	Product-Number	recommended for	
SKKES 1632	NKS 60	16	32	7,5	A2102163060	1 2 3 4 5 6 7 8	■
SKKES 1632	NKS 80	16	32	7,5	A2102163080	1 2 3 4 5 6 7 8	■
SKKES 1632	NKS 150	16	32	7,5	A2102163150	1 2 3 4 5 6 7 8	■



Industry

**SKKE, Abrasive caps universal, Conical round nose**

Ordering example: A2100051080



**Packing unit:**

up to Ø 11 mm = 100 pcs. per type  
from Ø 16 mm = 25 pcs. per type

n max.: please refer to the corresponding mandrel, page 320

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	≈R mm	Product-Number	recommended for	
SKKE 0515	NK 80	5	15	2	A2100051080	1 2 3 4 5 6 7 8	■
SKKE 0515	NK 150	5	15	2	A2100051150	1 2 3 4 5 6 7 8	■
SKKE 0515	NK 280	5	15	2	A2100051280	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 60	11	25	5	A2100112060	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 80	11	25	5	A2100112080	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 150	11	25	5	A2100112150	1 2 3 4 5 6 7 8	■
SKKE 1125	NK 280	11	25	5	A2100112280	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 60	16	32	7,5	A2100163060	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 80	16	32	7,5	A2100163080	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 150	16	32	7,5	A2100163150	1 2 3 4 5 6 7 8	■
SKKE 1632	NK 280	16	32	7,5	A2100163280	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 60	21	40	9,5	A2100224060	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 80	21	40	9,5	A2100224080	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 150	21	40	9,5	A2100224150	1 2 3 4 5 6 7 8	■
SKKE 2140	NK 280	21	40	9,5	A2100224280	1 2 3 4 5 6 7 8	■

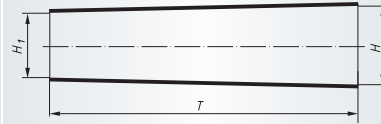




Industry

**SHKE, Abrasive sleeves, Conical shape**

Ordering example: A2101108080



**Packing unit:**

50 pcs. per type

n max.: please refer to the corresponding mandrel, page 321

NK = reg. Aluminium Oxide

Description	Grits	H mm	T mm	H <sub>1</sub> mm	Product-Number	recommended for	
SHKE 0885	NK 80	8	85	4,5	A2101108080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 0885	NK 150	8	85	4,5	A2101108150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1385	NK 80	13	85	9,5	A2101158080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1385	NK 150	13	85	9,5	A2101158150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1885	NK 80	18	85	14,5	A2101208080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 1885	NK 150	18	85	14,5	A2101208150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 2385	NK 80	23	85	19,5	A2101258080	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■
SHKE 2385	NK 150	23	85	19,5	A2101258150	① ② ③ ④ ⑤ ⑥ ⑦ ⑧	■



Industry

**GTKE, Mandrel, Conical shape**

Ordering example: A25001081



**Packing unit:**

5 pcs. per type

Description	D mm	T mm	L mm	≈R mm	Shank Ø x length mm	n max. (1/min)	Product-Number	
GTKE 0885	8	85	40	2	6 X 40	24.000	A25001086	■
GTKE 0885	8	85	40	2	1/4" X 40	24.000	A25001081	■
GTKE 1385	13	85	40	5	6 X 40	17.000	A25001586	■
GTKE 1885	18	85	40	7,5	6 X 40	12.000	A25002086	■
GTKE 2385	23	85	40	9,5	6 X 40	10.000	A25002586	■

For inaccessible areas, use abrasive caps conical shape (see page 319) in conjunction with a mandrel of head length 85 mm.



## Abrasive caps-Assortments

Ordering example: A210000065



**Packing unit:**

1 pc. per type

**Assortment containing:**

640 pcs. Abrasive Caps

23 pcs. Mandrels

Outside dimension of box: 372 x 189 x 46 mm

NK = reg. Aluminium Oxide

Description	pc.	Contents	Product-Number	recommended for	
WS 65	50 pcs. 100 pcs. of 50 pcs. of 20 pcs. of 10 pcs.	<p><b>Abrasive Caps, grit NK 150</b></p> <p>SKKE 0515</p> <p>SKZY 0510, SKWR 0511, SKWK 0511</p> <p>SKZY 0712, SKWR 0713, SKWK 0713</p> <p>SKZY 1015, SKWR 1015</p> <p>SKKE 1125</p> <p><b>Abrasive Caps, grit NK 80</b></p> <p>SKWK 1015</p> <p>SKZY 1317, SKWR 1319, SKWK 1319, SKKE 1632</p> <p>SKWK 1626, SKWR 1626</p> <p><b>Mandrels, Shank 3 mm</b></p> <p>GTZY 0510,GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713</p> <p>GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319</p> <p><b>Mandrels, Shank 6 mm</b></p> <p>GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632</p>	A210000065	<div style="display: flex; justify-content: space-around;"> <span>①</span><span>②</span><span>③</span><span>④</span><span>⑤</span><span>⑥</span><span>⑦</span><span>⑧</span> </div>	■
WS 65 Z	2 pcs. of 1 pc. of 1 pc. of	<p><b>Abrasive Caps, see WS 65</b></p> <p><b>Mandrels, Shank 1/8 inch</b></p> <p>GTZY 0510,GTWR 0511, GTWK 0511, GTZY 0712, GTWR 0713, GTWK 0713</p> <p>GTZY 1015, GTWR 1015, GTWK 1015, GTZY 1317, GTWR 1319, GTWK 1319</p> <p><b>Mandrels, Shank 1/4 inch</b></p> <p>GTKE 0515, GTKE 1125, GTWK 1626, GTWR 1626, GTKE 1632</p>	A210000065Z	<div style="display: flex; justify-content: space-around;"> <span>①</span><span>②</span><span>③</span><span>④</span><span>⑤</span><span>⑥</span><span>⑦</span><span>⑧</span> </div>	■