

## Polishing tools

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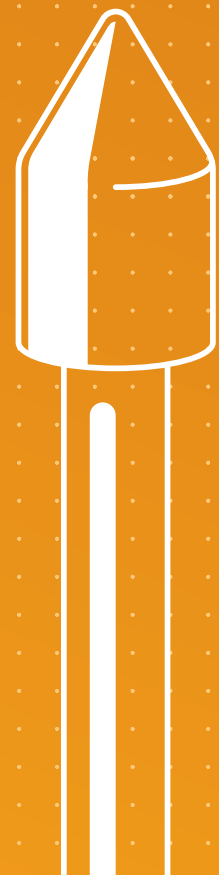
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**373** Power tools

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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**.



## General Information

Should you wish to enhance your product with the desired optical polish or where a defined technical surface finish value must be achieved, there are many good reasons why LUKAS polishing tools can be used on your particular workpiece. Current examples of applications where the highest precision and tolerances must be achieved can be found in the car industry, pump and turbine manufacture and the aerospace industry. Polished surfaces guarantee hygienic and clean working conditions in the food and pharmaceutical industries. The tool and mould manufacturers polish surfaces to a mirror finish in order to achieve a precise replication of the profile to the finished product.

Due to the ever increasing demand for high precision, LUKAS have developed a wide range of polishing tools using different raw materials in various grit sizes and hardnesses.

LUKAS polishing tools are divided into groups – P1 to P7 – to suit specific applications. These tools include polishing wheels, points and sticks to cover a wide variety of applications.

On the following page, you will find an illustration giving a general overview of such applications.

## Safety instructions

LUKAS polishing points under groups P1 and P5 are manufactured according to EN 12413 and are allowed to run at max. 50m/s. However, group P2 is only allowed max. 16m/s. The permissible peripheral speed of the product group P6 depends upon the hardness grade which in the case of MWP is max. 20m/s. The optimal working speed however generally lies below the maximum allowed; this reduces the heat generated and increases tool life. LUKAS polishing mounted points are supplied with a safety ticket which stipulates maximum R.P.M. for different shaft overhang lengths.

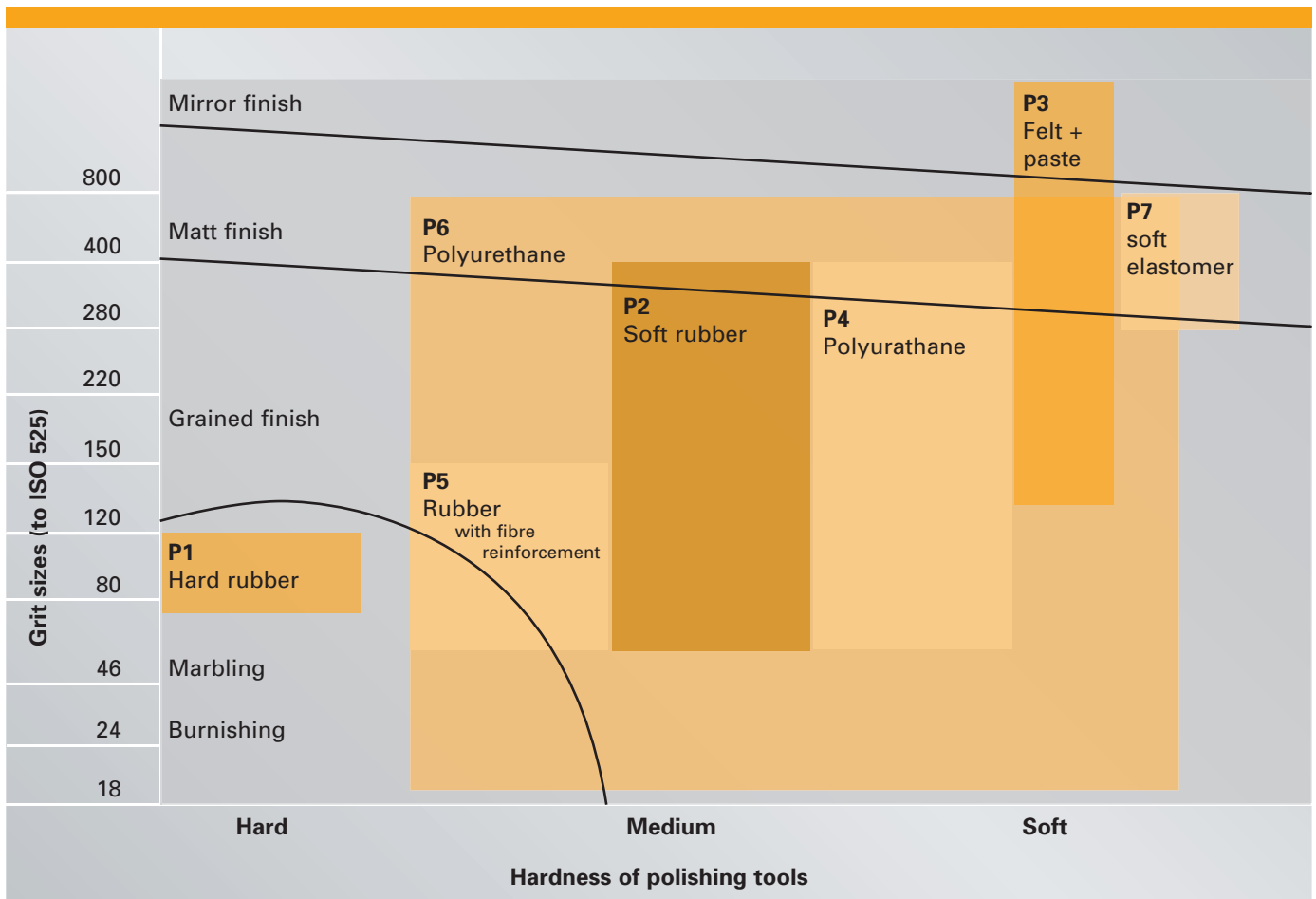
For the safe use of polishing points and wheels, please take note of the following operating instructions:

- FEPA safety recommendations for the correct use of abrasive products
- FEPA safety instructions for bonded abrasives

### Application example of P2



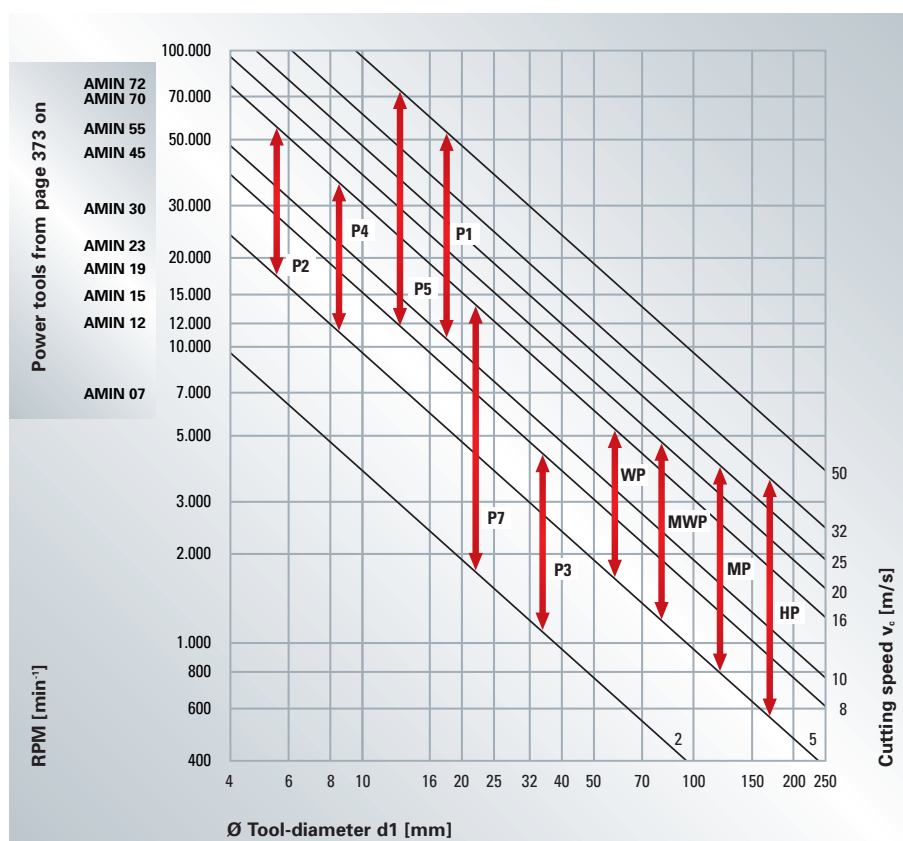
## Areas of application



<b>P1</b>	polishing points consist of a hard rubber bonding with a grit size 100. They are suited for fine finishing applications and for the preparation of surfaces which require further polishing operations
<b>P2</b>	polishig points and wheels are manufactured using a soft rubber bond in grit sizes 46 to 280. Grained and matt finishes on small surface areas can be produced; to achieve the required result, different grit sizes used in sequence should be applied.
<b>P3</b>	felt polishing tools are used in conjunction with a SIC or diamong polishing paste to give the best results even up to a mirror finish.
<b>P4</b>	polishing sticks are manufactured from polyurethane (PU). Areas of application and the results are similar to those detailed in group P2. Polishing sticks are used manually.
<b>P5</b>	polishing points contain a fibre reinforcement to increase tool life. Achievable surface finish lies between group P1 and P2.
<b>P6</b>	polishing tools are available in various forms – mounted points, marbling points, rolls for satin finishes and polishing wheels. The hardness of the polyurethane bonding (PU) can be divided into 4 categories – from soft to hard. Available grit sizes in SIC 24 to 400. These tools give the opportunity of a much wider field of application including larger surfaces. The main application is on stationary polishing machines e.g. centerless polishing of tubes.
<b>P7</b>	polishing mounted points with shaft diameter 2,35 mm using SIC grain in sizes 240 or 400 in a silicon bond. These small tools are very soft and are exceptionally suited for the polishing of jewellery and other small parts.

### A summary of available shapes

Shape	Type	Shape (Lukas)	Available product range
	Cylindrical, Typ 1	<b>ZY</b>	P1, P2, P3, P5, P6
	Cylindrical, Typ 2	<b>ZY2</b>	P1, P2
	Spherical	<b>KE</b>	P1, P2, P3
	Conical	<b>KU</b>	P1, P2, P3, P5
	Arch pointed nose	<b>SP</b>	P2, P3, P5
	Cylindrical round nose	<b>WR</b>	P1, P2
	Wheel	<b>SE1</b>	P3, P6
	Roll	<b>PW</b>	P6
	Stick	<b>SF, SR, SV</b>	P4
	Disc	<b>R</b>	P7
	Lense	<b>L</b>	P7



## Quality and application P1

These polishing points are available in one grit combination only. The surface finish is similar to a finish with grit size 100. The hard-rubber bond makes these points particularly suitable for finishing castings, hard and soft tool steels and also alloyed steel. There is


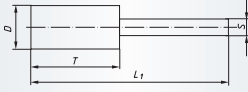

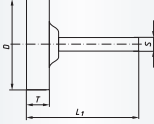
no loading with these points. If applied with low pressure, they have a long and economical tool life.



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2600004083

 <p>Type 1</p>		<p><b>Packing unit:</b> Shank 3 mm = 20 pcs. per type, Shank 6 mm = 10 pcs. per type Further dimensions on request <math>v_{max}</math>: 50 m/s</p>
 <p>Type 2</p>		

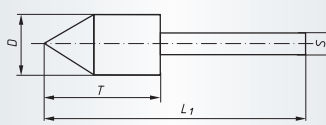
Description	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for								
P1ZY 0408.03	1	4	8	3	38	A2600004083	1	2	3	4	5	7			■
P1ZY 0510.03	1	5	10	3	40	A2600005103	1	2	3	4	5	7			■
P1ZY 0610.03	1	6	10	3	40	A2600006103	1	2	3	4	5	7			■
P1ZY 0710.03	1	7	10	3	40	A2600007103	1	2	3	4	5	7			■
P1ZY 0810.03	1	8	10	3	40	A2600008103	1	2	3	4	5	7			■
P1ZY 0816.06	1	8	16	6	56	A2600008166	1	2	3	4	5	7			■
P1ZY 0820.06	1	8	20	6	60	A2600008206	1	2	3	4	5	7			■
P1ZY 1010.03	1	10	10	3	40	A2600010103	1	2	3	4	5	7			■
P1ZY 1013.03	1	10	13	3	43	A2600010133	1	2	3	4	5	7			■
P1ZY 1016.03	1	10	16	3	46	A2600010163	1	2	3	4	5	7			■
P1ZY 1020.06	1	10	20	6	60	A2600010206	1	2	3	4	5	7			■
P1ZY 1303.03	2	13	3	3	33	A2607013033	1	2	3	4	5	7			■
P1ZY 1313.03	1	13	13	3	43	A2600013133	1	2	3	4	5	7			■
P1ZY 1316.03	1	13	16	3	46	A2600013163	1	2	3	4	5	7			■
P1ZY 1320.06	1	13	20	6	60	A2600013206	1	2	3	4	5	7			■
P1ZY 1604.03	2	16	4	3	34	A2607016043	1	2	3	4	5	7			■
P1ZY 1616.03	1	16	16	3	46	A2600016163	1	2	3	4	5	7			■
P1ZY 1620.06	1	16	20	6	60	A2600016206	1	2	3	4	5	7			■
P1ZY 1632.06	1	16	32	6	72	A2600016326	1	2	3	4	5	7			■
P1ZY 2006.03	2	20	6	3	36	A2607020063	1	2	3	4	5	7			■
P1ZY 2020.06	1	20	20	6	60	A2600020206	1	2	3	4	5	7			■
P1ZY 2032.06	1	20	32	6	72	A2600020326	1	2	3	4	5	7			■
P1ZY 3210.06	2	32	10	6	50	A2607032106	1	2	3	4	5	7			■
P1ZY 3216.06	1	32	16	6	56	A2600032166	1	2	3	4	5	7			■
P1ZY 4020.06	1	40	20	6	60	A2600040206	1	2	3	4	5	7			■



Industry

## Shape KS, conical pointed nose (according to DIN 69170)

Ordering example: A2602016326



**Packing unit:**

10 pcs. per type  
Further dimensions on request  
 $v_{max.}$ : 50 m/s

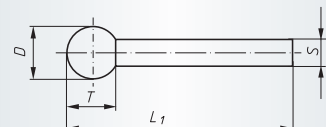
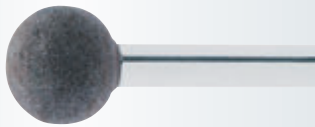
Description	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P1KS 1632.06	16	32	6	72	A2602016326	1 2 3 4 5 7



Industry

## Shape KU, Spherical (according to DIN 69170)

Ordering example: A2605008083



**Packing unit:**

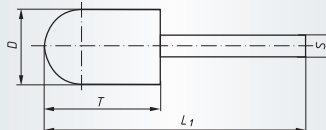
Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type  
Further dimensions on request  
 $v_{max.}$ : 50 m/s

Description	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P1KU 0808.03	8	8	3	38	A2605008083	1 2 3 4 5 7
P1KU 1616.06	16	16	6	55	A2605016166	1 2 3 4 5 7



Industry

## Shape WR, Cylindrical round nose (according to DIN 69170)



**Packing unit:**

10 pcs. per type  
 $v_{max.}$ : 50 m/s

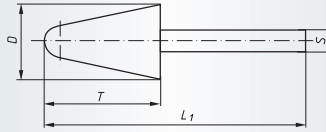
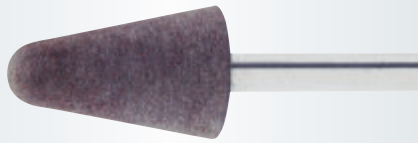
						available on request
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Industry

**Shape KE, Conical round nose (according to DIN 69170)**

Ordering example: A2609020326



**Packing unit:**  
10 pcs. per type  
Further dimensions on request  
 $v_{max.}$ : 50 m/s

Description	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P1KE 2032.06	20	32	6	72	A2609020326	1 2 3 4 5 7



Industry

**Assortment, Polishing points, 114**

Ordering example: A2600114



**Packing unit:**  
1 pc. per type  
Further dimensions on request  
 $v_{max.}$ : 50 m/s

Description	Contents	1 piece each	Product-Number	recommended for
Assortment 114	14-pieces	P1ZY 0408.03; P1ZY 0510.03; P1ZY 0610.03; P1ZY 0710.03; P1ZY 0810.03; P1ZY 1010.03; P1ZY 1013.03; P1ZY 1016.03; P1ZY 1303.03; P1ZY 1313.03; P1ZY 1316.03; P1ZY 1604.03; P1ZY 1616.03; P1ZY 2006.03	A2600114	1 2 3 4 5 7

## Specification and application P2

The polishing mounted points of this group are available in the five grit sizes as detailed below, and are available in a variety of shapes and sizes. They are colour coded to prevent any confusion and to avoid any errors in the polishing process. The soft rubber bonding allows for a very soft grinding effect. Polishing points of this group P2 are mainly used on a pre-machined surface where a fine

polished finish is required. Polishing wheels in this group are also available with a max. diameter 200mm. Exact dimensions and prices are available on request.


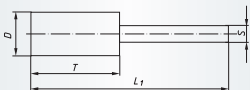

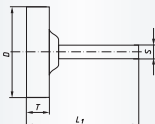
					
<b>Color</b>	black	pale grey	red	brown	green
<b>Grit size</b>	46	80	120	220	280



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610004083080

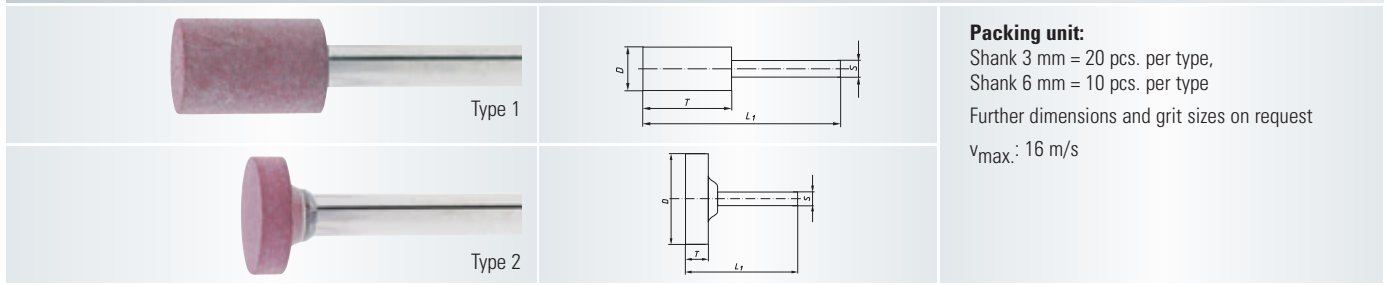
	Type 1		<b>Packing unit:</b> Shank 3 mm = 20 pcs. per type, Shank 6 mm = 10 pcs. per type Further dimensions and grit sizes on request $v_{max.}: 16 \text{ m/s}$
	Type 2		

Description	Grit	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for
P2ZY 0408.03	80	1	4	8	3	38	A2610004083080	1 2 3 4 5 6 7 8
P2ZY 0408.03	120	1	4	8	3	38	A2610004083120	1 2 3 4 5 6 7 8
P2ZY 0408.03	220	1	4	8	3	38	A2610004083220	1 2 3 4 5 6 7 8
P2ZY 0408.03	280	1	4	8	3	38	A2610004083280	1 2 3 4 5 6 7 8
P2ZY 0510.03	80	1	5	10	3	40	A2610005103080	1 2 3 4 5 6 7 8
P2ZY 0510.03	120	1	5	10	3	40	A2610005103120	1 2 3 4 5 6 7 8
P2ZY 0510.03	220	1	5	10	3	40	A2610005103220	1 2 3 4 5 6 7 8
P2ZY 0510.03	280	1	5	10	3	40	A2610005103280	1 2 3 4 5 6 7 8
P2ZY 0610.03	80	1	6	10	3	40	A2610006103080	1 2 3 4 5 6 7 8
P2ZY 0610.03	120	1	6	10	3	40	A2610006103120	1 2 3 4 5 6 7 8
P2ZY 0610.03	220	1	6	10	3	40	A2610006103220	1 2 3 4 5 6 7 8
P2ZY 0610.03	280	1	6	10	3	40	A2610006103280	1 2 3 4 5 6 7 8
P2ZY 0810.03	46	1	8	10	3	40	A2610008103046	1 2 3 4 5 6 7 8



**Shape ZY, Cylindrical (according to DIN 69170)**

Ordering example: A2610008103080



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

v<sub>max.</sub>: 16 m/s

Description	Grit	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for								
P2ZY 0810.03	80	1	8	10	3	40	A2610008103080	1	2	3	4	5	6	7	8	■
P2ZY 0810.03	120	1	8	10	3	40	A2610008103120	1	2	3	4	5	6	7	8	■
P2ZY 0810.03	220	1	8	10	3	40	A2610008103220	1	2	3	4	5	6	7	8	■
P2ZY 0810.03	280	1	8	10	3	40	A2610008103280	1	2	3	4	5	6	7	8	■
P2ZY 0816.06	80	1	8	16	6	56	A2610008166080	1	2	3	4	5	6	7	8	■
P2ZY 0816.06	120	1	8	16	6	56	A2610008166120	1	2	3	4	5	6	7	8	■
P2ZY 0816.06	220	1	8	16	6	56	A2610008166220	1	2	3	4	5	6	7	8	■
P2ZY 0816.06	280	1	8	16	6	56	A2610008166280	1	2	3	4	5	6	7	8	■
P2ZY 1010.03	46	1	10	10	3	40	A2610010103046	1	2	3	4	5	6	7	8	■
P2ZY 1010.03	80	1	10	10	3	40	A2610010103080	1	2	3	4	5	6	7	8	■
P2ZY 1010.03	120	1	10	10	3	40	A2610010103120	1	2	3	4	5	6	7	8	■
P2ZY 1010.03	220	1	10	10	3	40	A2610010103220	1	2	3	4	5	6	7	8	■
P2ZY 1010.03	280	1	10	10	3	40	A2610010103280	1	2	3	4	5	6	7	8	■
P2ZY 1020.06	80	1	10	20	6	60	A2610010206080	1	2	3	4	5	6	7	8	■
P2ZY 1020.06	120	1	10	20	6	60	A2610010206120	1	2	3	4	5	6	7	8	■
P2ZY 1020.06	220	1	10	20	6	60	A2610010206220	1	2	3	4	5	6	7	8	■
P2ZY 1020.06	280	1	10	20	6	60	A2610010206280	1	2	3	4	5	6	7	8	■
P2ZY 1313.03	80	1	13	13	3	43	A2610013133080	1	2	3	4	5	6	7	8	■
P2ZY 1313.03	120	1	13	13	3	43	A2610013133120	1	2	3	4	5	6	7	8	■
P2ZY 1313.03	220	1	13	13	3	43	A2610013133220	1	2	3	4	5	6	7	8	■
P2ZY 1313.03	280	1	13	13	3	43	A2610013133280	1	2	3	4	5	6	7	8	■
P2ZY 1316.03	120	1	13	16	3	46	A2610013163120	1	2	3	4	5	6	7	8	■
P2ZY 1320.06	46	1	13	20	6	60	A2610013206046	1	2	3	4	5	6	7	8	■
P2ZY 1320.06	80	1	13	20	6	60	A2610013206080	1	2	3	4	5	6	7	8	■
P2ZY 1320.06	120	1	13	20	6	60	A2610013206120	1	2	3	4	5	6	7	8	■
P2ZY 1320.06	220	1	13	20	6	60	A2610013206220	1	2	3	4	5	6	7	8	■
P2ZY 1320.06	280	1	13	20	6	60	A2610013206280	1	2	3	4	5	6	7	8	■
P2ZY 1616.03	120	1	16	16	3	46	A2610016163120	1	2	3	4	5	6	7	8	■
P2ZY 1620.06	80	1	16	20	6	60	A2610016206080	1	2	3	4	5	6	7	8	■
P2ZY 1620.06	120	1	16	20	6	60	A2610016206120	1	2	3	4	5	6	7	8	■
P2ZY 1620.06	220	1	16	20	6	60	A2610016206220	1	2	3	4	5	6	7	8	■
P2ZY 1620.06	280	1	16	20	6	60	A2610016206280	1	2	3	4	5	6	7	8	■
P2ZY 1632.06	80	1	16	32	6	72	A2610016326080	1	2	3	4	5	6	7	8	■
P2ZY 1632.06	120	1	16	32	6	72	A2610016326120	1	2	3	4	5	6	7	8	■
P2ZY 1632.06	220	1	16	32	6	72	A2610016326220	1	2	3	4	5	6	7	8	■
P2ZY 2020.06	46	1	20	20	6	60	A2610020206046	1	2	3	4	5	6	7	8	■
P2ZY 2020.06	80	1	20	20	6	60	A2610020206080	1	2	3	4	5	6	7	8	■
P2ZY 2020.06	120	1	20	20	6	60	A2610020206120	1	2	3	4	5	6	7	8	■
P2ZY 2020.06	220	1	20	20	6	60	A2610020206220	1	2	3	4	5	6	7	8	■

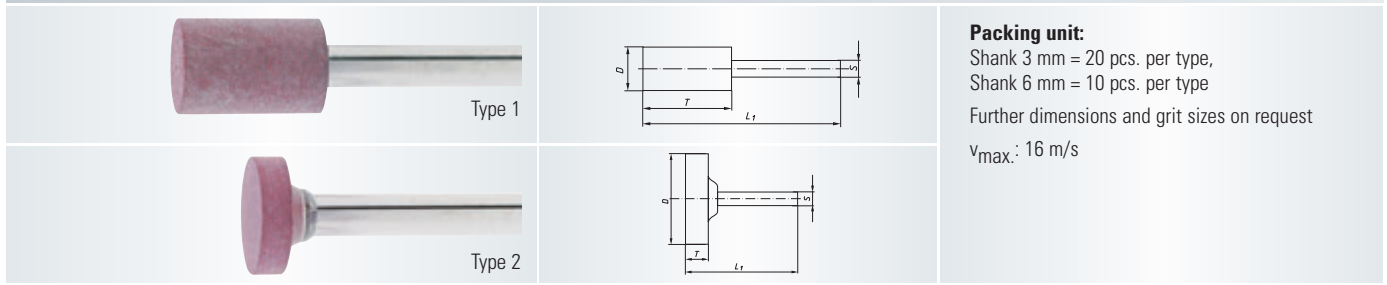
# 142 Polishing points, group P2



Industry

## Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2610020206280



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$ : 16 m/s

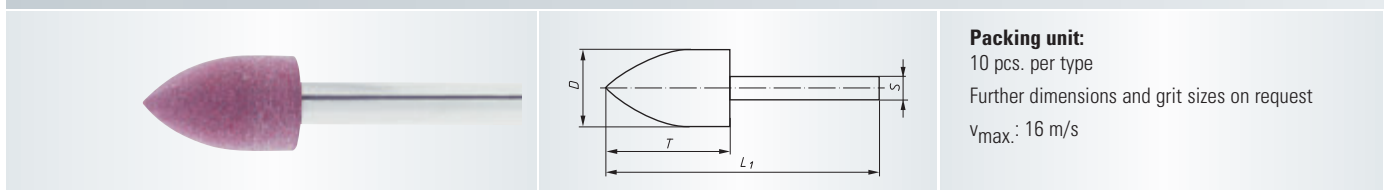
Description	Grit	Type	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2ZY 2020.06	280	1	20	20	6	60	A2610020206280	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	80	1	20	32	6	72	A2610020326080	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	120	1	20	32	6	72	A2610020326120	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	220	1	20	32	6	72	A2610020326220	1 2 3 4 5 6 7 8	■
P2ZY 2032.06	280	1	20	32	6	72	A2610020326280	1 2 3 4 5 6 7 8	■
P2ZY 2510.06	120	2	25	10	6	50	A2617025106120	1 2 3 4 5 6 7 8	■
P2ZY 3210.06	120	2	32	10	6	50	A2617032106120	1 2 3 4 5 6 7 8	■
P2ZY 3210.06	220	2	32	10	6	50	A2617032106220	1 2 3 4 5 6 7 8	■
P2ZY 3220.06	120	1	32	20	6	60	A2610032206120	1 2 3 4 5 6 7 8	■
P2ZY 3232.06	120	1	32	32	6	72	A2610032326120	1 2 3 4 5 6 7 8	■
P2ZY 3232.06	280	1	32	32	6	72	A2610032326280	1 2 3 4 5 6 7 8	■
P2ZY 4010.06	120	2	40	10	6	50	A2617040106120	1 2 3 4 5 6 7 8	■
P2ZY 4020.06	46	1	40	20	6	60	A2610040206046	1 2 3 4 5 6 7 8	■
P2ZY 4020.06	120	1	40	20	6	60	A2610040206120	1 2 3 4 5 6 7 8	■



Industry

## Shape SP, Arch pointed nose (according to DIN 69170)

Ordering example: A2611013206120



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$ : 16 m/s

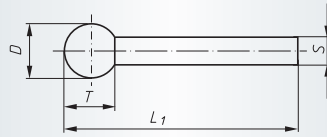
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2SP 1320.06	120	13	20	6	60	A2611013206120	1 2 3 4 5 6 7 8	■
P2SP 2032.06	220	20	32	6	72	A2611020326220	1 2 3 4 5 6 7 8	■



Industry

**Shape KU, Spherical (according to DIN 69170)**

Ordering example: A2615008083120



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

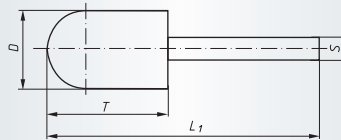
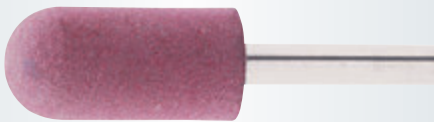
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2KU 0808.03	120	8	8	3	38	A2615008083120	1 2 3 4 5 6 7 8	■
P2KU 1010.03	120	10	10	3	40	A2615010103120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	120	16	16	6	56	A2615016166120	1 2 3 4 5 6 7 8	■
P2KU 1616.06	220	16	16	6	56	A2615016166220	1 2 3 4 5 6 7 8	■



Industry

**Shape WR, Cylindrical round nose (according to DIN 69170)**

Ordering example: A2618016326120



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

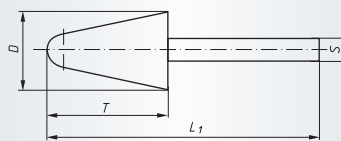
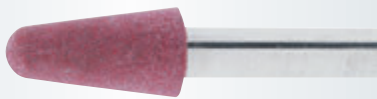
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2WR 1632.06	120	16	32	6	72	A2618016326120	1 2 3 4 5 6 7 8	■



Industry

**Shape KE, Conical round nose (according to DIN 69170)**

Ordering example: A2619010206080



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 16 m/s

Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P2KE 1020.06	80	10	20	6	60	A2619010206080	1 2 3 4 5 6 7 8	■
P2KE 1020.06	120	10	20	6	60	A2619010206120	1 2 3 4 5 6 7 8	■

## Specification and application P3

**LUKAS felt polishing points are available in two specifications:**

- H3 as per DIN 61200
- H3S super hard and particularly effective when used in conjunction with diamond paste

**The optimal peripheral speed for LUKAS felt polishing points is 2–8 m/s.**

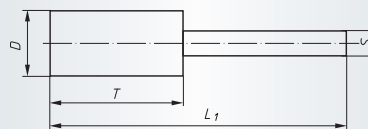
The LUKAS assortment of felt polishing tools reflects years of experience in this field and encompasses the most common shapes and sizes. Due to the extreme flexibility, felt polishing points together with LUKAS diamond paste are ideally suited for polishing exceptionally complex shapes e.g. pressure and injection moulds, drawing- press- and cutting tools, dies, bearings, spindles, rolls, gauges etc.



**Industry**

### Shape ZY, Cylindrical

Ordering example: A3700006103



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type  
Further dimensions on request

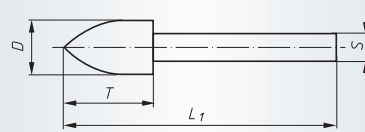
Description	Quality	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P3ZY 0610.03	H3	6	10	3	50	A3700006103	1 2 3 4 5 6 7 9	■
P3ZY 0610.03	H3-S	6	10	3	50	A37000061030001	1 2 3 4 5 6 7 9	■
P3ZY 0810.03	H3	8	10	3	50	A3700008103	1 2 3 4 5 6 7 9	■
P3ZY 0810.03	H3-S	8	10	3	50	A37000081030001	1 2 3 4 5 6 7 9	■
P3ZY 1012.03	H3	10	12	3	50	A3700010123	1 2 3 4 5 6 7 9	■
P3ZY 1012.03	H3-S	10	12	3	50	A37000101230001	1 2 3 4 5 6 7 9	■
P3ZY 1015.06	H3	10	15	6	55	A3700010156	1 2 3 4 5 6 7 9	■
P3ZY 1015.06	H3-S	10	15	6	55	A37000101560001	1 2 3 4 5 6 7 9	■
P3ZY 1215.03	H3	12	15	3	55	A3700012153	1 2 3 4 5 6 7 9	■
P3ZY 1215.03	H3-S	12	15	3	55	A37000121530001	1 2 3 4 5 6 7 9	■
P3ZY 1220.06	H3	12	20	6	60	A3700012206	1 2 3 4 5 6 7 9	■
P3ZY 1220.06	H3-S	12	20	6	60	A37000122060001	1 2 3 4 5 6 7 9	■
P3ZY 1620.06	H3	16	20	6	60	A3700016206	1 2 3 4 5 6 7 9	■
P3ZY 2025.06	H3	20	25	6	65	A3700020256	1 2 3 4 5 6 7 9	■
P3ZY 2025.06	H3-S	20	25	6	65	A37000202560001	1 2 3 4 5 6 7 9	■
P3ZY 2530.06	H3	25	30	6	70	A3700025306	1 2 3 4 5 6 7 9	■
P3ZY 3040.06	H3	30	40	6	80	A3700030406	1 2 3 4 5 6 7 9	■



Industry

**Shape SP, Arch pointed nose**

Ordering example: A3701006103



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type  
Further dimensions on request

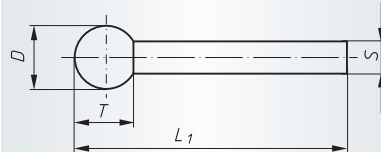
Description	Quality	D mm	T mm	S mm	L1 mm	Product-Number	recommended for	
P3SP 0610.03	H3	6	10	3	50	A3701006103	1 2 3 4 5 6 7 9	■
P3SP 0810.03	H3	8	10	3	50	A3701008103	1 2 3 4 5 6 7 9	■
P3SP 1012.03	H3	10	12	3	52	A3701010123	1 2 3 4 5 6 7 9	■
P3SP 1015.06	H3	10	15	6	55	A3701010156	1 2 3 4 5 6 7 9	■
P3SP 1220.06	H3	12	20	6	60	A3701012206	1 2 3 4 5 6 7 9	■
P3SP 2025.06	H3	20	25	6	65	A3701020256	1 2 3 4 5 6 7 9	■
P3SP 2530.06	H3	25	30	6	70	A3701025306	1 2 3 4 5 6 7 9	■
P3SP 3040.06	H3	30	40	6	80	A3701030406	1 2 3 4 5 6 7 9	■



Industry

**Shape KU, Spherical**

Ordering example: A3703006063



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type  
Further dimensions on request

Description	Quality	D mm	T mm	S mm	L1 mm	Product-Number	recommended for	
P3KU 0605.03	H3	6	5,5	3	45	A3703006063	1 2 3 4 5 6 7 9	■
P3KU 0807.03	H3	8	7,5	3	50	A3703008083	1 2 3 4 5 6 7 9	■
P3KU 1009.03	H3	10	9	3	50	A3703010103	1 2 3 4 5 6 7 9	■
P3KU 1009.06	H3	10	9	6	50	A3703010106	1 2 3 4 5 6 7 9	■
P3KU 1211.06	H3	12	11	6	50	A3703012126	1 2 3 4 5 6 7 9	■
P3KU 2019.06	H3	20	19	6	60	A3703020206	1 2 3 4 5 6 7 9	■

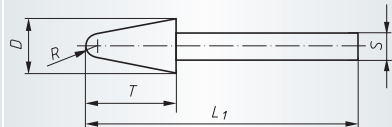
# 146 Felt polishing points, group P3



Industry

## Shape KE, Conical round nose

Ordering example: A3705010123



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions on request

Description	Quality	D mm	T mm	S mm	L <sub>1</sub> mm	R mm	Product-Number	recommended for								
P3KE 1012.03	H3	10	12	3	50	2,5	A3705010123	1	2	3	4	5	6	7	9	■
P3KE 1015.06	H3	10	15	6	55	2,5	A3705010156	1	2	3	4	5	6	7	9	■
P3KE 1015.06	H3-S	10	15	6	55	2,5	A37050101560001	1	2	3	4	5	6	7	9	■
P3KE 1620.06	H3	16	20	6	60	3	A3705016206	1	2	3	4	5	6	7	9	■
P3KE 2025.06	H3	20	25	6	65	3,5	A3705020256	1	2	3	4	5	6	7	9	■
P3KE 2530.06	H3	25	30	6	70	4,5	A3705025306	1	2	3	4	5	6	7	9	■
P3KE 3040.06	H3	30	40	6	80	6,5	A3705030406	1	2	3	4	5	6	7	9	■

### Application example P3

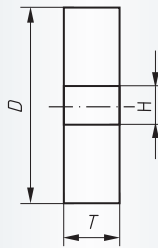




Industry

Shape S1, Wheels

Ordering example: A3750040106



**Packing unit:**  
10 pcs. per type  
Further dimensions on request

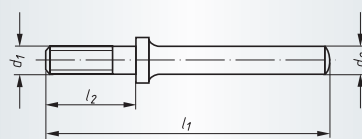
Description	Quality	D mm	T mm	H mm	Product-Number	recommended for	
P3S1 4010.06	H3	40	10	6	A3750040106	1 2 3 4 5 6 7 9	■
P3S1 5010.06	H3	50	10	6	A3750050106	1 2 3 4 5 6 7 9	■
P3S1 5020.06	H3	50	20	6	A3750050206	1 2 3 4 5 6 7 9	■
P3S1 6010.06	H3	60	10	6	A3750060106	1 2 3 4 5 6 7 9	■
P3S1 6020.06	H3	60	20	6	A3750060206	1 2 3 4 5 6 7 9	■



Industry

Arbors for felt polishing wheels

Ordering example: A1630780



**Packing unit:**  
5 pcs. per type  
2 washers and a nut are supplied per arbor.

Description	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n max. (1/min)	Product-Number	
ASB 780	M6	20	6	63	7.000	A1630780	■
ASB 781	M6	30	6	73	7.000	A1630781	■

### Specification and application of diamond paste

Type	Quality	Recommended applications
Super-M	oil/alcohol soluble, medium concentration, HP diamond grit	for the occasional use as first and second polishing stages on hard materials
Super-W	oil/alcohol soluble, higher concentration, HP diamond grit	for the more frequent polishing operations on hard materials – from the second polishing stage
Super-F	oil/alcohol soluble, high concentration, HP diamond grit, high percentage of the same mesh size	for regular polishing on hard materials – where a reduction in the polishing cycle time is required – on extremely hard surface coatings – from the second polishing stage

### List of grit sizes

Grit Size	Application	Tool material	Cutting speed
30 μ 23 μ 15 μ	Fine polish	Steel, cast iron, bronze, brass, copper, safety glass, laminated wood, plywood	v = 1–3 m/s
9 μ	Pre-polish	Cast iron, bronze, brass, copper, safety glass, laminated wood, plywood, hardwood	v = 1–3 m/s
6 μ 3 μ 1 μ 0,25 μ	Mirror polish	Soft wood, felt (hard or soft), paper, cotton wool	v = 5–20 m/s

Examples of diamond pastes and diamond sprays





Industry

Grinding compound

Ordering example: A3760120



**Packing unit:**  
1 pc. per type  
Contents: 250 g

Description	Quality	Grit	µm	Product-Number	recommended for	
SP-1	medium	120	88 – 125	A3760120	1 2 3 4 5 6 7	■
SP-2	fine	180	55 – 88	A3760180	1 2 3 4 5 6 7	■
SP-3	very fine	320	20 – 40	A3760320	1 2 3 4 5 6 7	■

**Ingredient:** silicon carbide paste, oil-soluble, can be used with thinners, cleaned with oil, spirit or petrol.

**Application:** For polishing pre-ground surfaces; particularly suited for hard metallic surfaces e.g. steel, iron, cast iron, bronze, brass and copper



Industry

Diamond pastes

Ordering example: A34105062



**Packing unit:**  
1 pc. per type  
Contents: 5 g

Description	Quality	Grit µ	Color of paste	Product-Number	recommended for	
M-062	Super-M	3	green	A34105062	1 2 3 4 5 6 7 9	■
M-063	Super-M	6	yellow	A34105063	1 2 3 4 5 6 7 9	■
M-064	Super-M	9	red	A34105064	1 2 3 4 5 6 7 9	■
M-065	Super-M	15	pale brown	A34105065	1 2 3 4 5 6 7 9	■
M-066	Super-M	30	dark brown	A34105066	1 2 3 4 5 6 7 9	■
W-082	Super-W	3	green	A34103082	1 2 3 4 5 6 7 9	■
W-083	Super-W	6	yellow	A34103083	1 2 3 4 5 6 7 9	■
W-084	Super-W	9	red	A34103084	1 2 3 4 5 6 7 9	■
W-085	Super-W	15	pale brown	A34103085	1 2 3 4 5 6 7 9	■
F-091	Super-F	1	blue	A34101091	1 2 3 4 5 6 7 9	■
F-092	Super-F	3	green	A34101092	1 2 3 4 5 6 7 9	■
F-093	Super-F	6	yellow	A34101093	1 2 3 4 5 6 7 9	■
F-094	Super-F	9	red	A34101094	1 2 3 4 5 6 7 9	■
F-095	Super-F	15	pale brown	A34101095	1 2 3 4 5 6 7 9	■

# 150 Diamond sprays and thinner



Industry

## Diamond sprays

Ordering example: A34104070



**Packing unit:**  
1 pc. per type  
Contents: 150 ml = 126 g

Description	Grit μ	Color	Product-Number	recommended for	
GS-070	0,25	pale grey	A34104070	1 2 3 4 5 6 7 9	■
GS-071	1	blue	A34104071	1 2 3 4 5 6 7 9	■
GS-072	3	green	A34104072	1 2 3 4 5 6 7 9	■
GS-073	6	yellow	A34104073	1 2 3 4 5 6 7 9	■
GS-074	9	red	A34104074	1 2 3 4 5 6 7 9	■



Industry

## Thinner

Ordering example: A341063003



**Packing unit:**  
1 pc. per type  
Contents: 100 ml

Description	Color	Product-Number	recommended for	
MWF 3003	green	A341063003	1 2 3 4 5 6 7 9	■

## Specification and application P4

Tools within this group are bonded with polyurethane (PU) and are manufactured in various hardnesses. They contain a mixture of abrasive grain (aluminium oxide, silicon carbide) and fillers. To optically differentiate between qualities, these tools are colour coded. Products in this group have a relatively dense structure.

Pores resulting from the manufacturing process are of no detriment. A range of flexibility from soft to hard relating to the cross section are available. These polishing sticks are mainly used manually for mould manufacture.

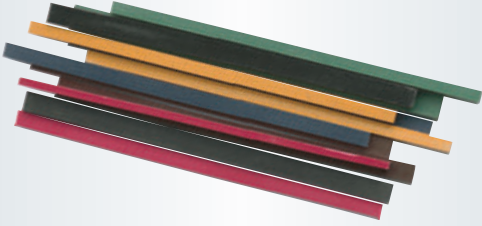
Color	Qualities	Color	Qualities	Color	Qualities
pale grey	SIC 80 soft	pale green	SIC 240 soft	pale red	EKW 150 soft
grey	SIC 80 hard	green	SIC 240 hard	red	EKW 150 hard
pale blue	SIC 150 soft	beige	EKW 80 soft	pale brown	EKW 240 soft
blue	SIC 150 hard	dark beige	EKW 80 hard	brown	EKW 240 hard




Industry

### Polishing sticks, flat

Ordering example: P4SF 0612.070 SIC 80 soft





**Packing unit:**  
10 pcs. per type  
Further dimensions on request  
All items are available within a few days  
ex-intermediate stock.

Description	H mm	B mm	L mm			recommended for							▲			
						1	2	3	4	5	6	7				
P4SF 0612.070	6	12	70			1	2	3	4	5	6	7				▲
P4SF 0612.140	6	12	140			1	2	3	4	5	6	7				▲
P4SF 0816.070	8	16	70			1	2	3	4	5	6	7				▲
P4SF 0816.140	8	16	140			1	2	3	4	5	6	7				▲
P4SF 0816.210	8	16	210			1	2	3	4	5	6	7				▲
P4SF 1020.070	10	20	70			1	2	3	4	5	6	7				▲
P4SF 1020.140	10	20	140			1	2	3	4	5	6	7				▲
P4SF 1020.210	10	20	210			1	2	3	4	5	6	7				▲
P4SF 1020.280	10	20	280			1	2	3	4	5	6	7				▲

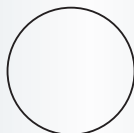
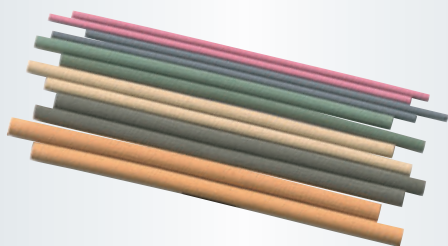
# 152 Polishing sticks, group P4



Industry

## Polishing sticks, round

Ordering example: P4SR 0006.070 EKW 80 hard



**Packing unit:**

10 pcs. per type

Further dimensions on request

All items are available within a few days ex-intermediate stock.

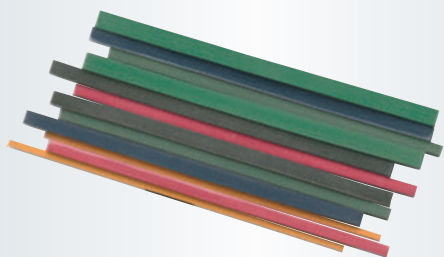
Description	Ø mm	L mm	recommended for							
P4SR 0006.070	6	70								▲
P4SR 0006.140	6	140								▲
P4SR 0010.070	10	70								▲
P4SR 0010.140	10	140								▲
P4SR 0010.210	10	210								▲
P4SR 0012.070	12	70								▲
P4SR 0012.140	12	140								▲
P4SR 0012.210	12	210								▲
P4SR 0012.280	12	280								▲
P4SR 0015.070	15	70								▲
P4SR 0015.140	15	140								▲
P4SR 0015.210	15	210								▲
P4SR 0015.280	15	280								▲



Industry

## Polishing sticks, square

Ordering example: P4SV 0606.070 SIC 80 hard



**Packing unit:**

10 pcs. per type

Further dimensions on request

All items are available within a few days ex-intermediate stock.

Description	H mm	B mm	L mm	recommended for							
P4SV 0606.070	6	6	70								▲
P4SV 0606.140	6	6	140								▲
P4SV 1010.070	10	10	70								▲
P4SV 1010.140	10	10	140								▲
P4SV 1010.210	10	10	210								▲
P4SV 1212.140	12	12	140								▲
P4SV 1212.210	12	12	210								▲
P4SV 1515.070	15	15	70								▲
P4SV 1515.140	15	15	140								▲
P4SV 1515.210	15	15	210								▲
P4SV 1515.280	15	15	280								▲

## Specification and application P5

The polishing points of this group are characterized by their special structure and bonding i.e. fibre reinforced. This makes them ideally suited for fine finishing of aluminium and associated alloys, non-ferrous metals and low and high alloyed steels.

Due to the fibre reinforcement, these tools have exceptional edge-retention capabilities and resilience. Polishing points in group P5 are available in grit sizes detailed below; they are identified with a red marking.

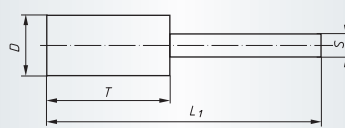
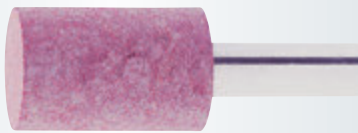
			
<b>Color</b>	black	pale grey	red
<b>Grit</b>	46	80	120



Industry

### Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620004083080



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

$v_{max}$ : 50 m/s

Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5ZY 0408.03	80	4	8	3	38	A2620004083080	1 2 3 4 5 6 7	■
P5ZY 0408.03	120	4	8	3	38	A2620004083120	1 2 3 4 5 6 7	■
P5ZY 0510.03	80	5	10	3	40	A2620005103080	1 2 3 4 5 6 7	■
P5ZY 0510.03	120	5	10	3	40	A2620005103120	1 2 3 4 5 6 7	■
P5ZY 0610.03	80	6	10	3	40	A2620006103080	1 2 3 4 5 6 7	■
P5ZY 0610.03	120	6	10	3	40	A2620006103120	1 2 3 4 5 6 7	■
P5ZY 0810.03	80	8	10	3	40	A2620008103080	1 2 3 4 5 6 7	■
P5ZY 0810.03	120	8	10	3	40	A2620008103120	1 2 3 4 5 6 7	■
P5ZY 0816.06	46	8	16	6	56	A2620008166046	1 2 3 4 5 6 7	■
P5ZY 0816.06	80	8	16	6	56	A2620008166080	1 2 3 4 5 6 7	■
P5ZY 0816.06	120	8	16	6	56	A2620008166120	1 2 3 4 5 6 7	■
P5ZY 1010.03	80	10	10	3	40	A2620010103080	1 2 3 4 5 6 7	■
P5ZY 1010.03	120	10	10	3	40	A2620010103120	1 2 3 4 5 6 7	■
P5ZY 1020.06	46	10	20	6	60	A2620010206046	1 2 3 4 5 6 7	■
P5ZY 1020.06	80	10	20	6	60	A2620010206080	1 2 3 4 5 6 7	■
P5ZY 1020.06	120	10	20	6	60	A2620010206120	1 2 3 4 5 6 7	■
P5ZY 1313.03	120	13	13	3	43	A2620013133120	1 2 3 4 5 6 7	■
P5ZY 1316.03	80	13	16	3	46	A2620013163080	1 2 3 4 5 6 7	■
P5ZY 1320.06	80	13	20	6	60	A2620013206080	1 2 3 4 5 6 7	■

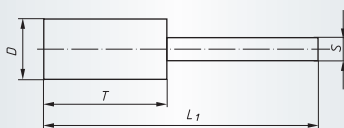
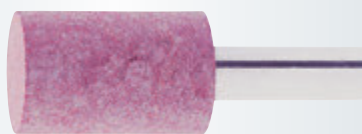
# 154 Polishing points, group P5



Industry

## Shape ZY, Cylindrical (according to DIN 69170)

Ordering example: A2620013206080



**Packing unit:**

Shank 3 mm = 20 pcs. per type,  
Shank 6 mm = 10 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$ : 50 m/s

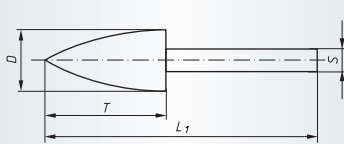
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5ZY 1320.06	120	13	20	6	60	A2620013206120	1 2 3 4 5 6 7	■
P5ZY 1620.06	80	16	20	6	60	A2620016206080	1 2 3 4 5 6 7	■
P5ZY 1620.06	120	16	20	6	60	A2620016206120	1 2 3 4 5 6 7	■
P5ZY 1632.06	46	16	32	6	72	A2620016326046	1 2 3 4 5 6 7	■
P5ZY 1632.06	80	16	32	6	72	A2620016326080	1 2 3 4 5 6 7	■
P5ZY 2020.06	80	20	20	6	60	A2620020206080	1 2 3 4 5 6 7	■
P5ZY 2032.06	46	20	32	6	72	A2620020326046	1 2 3 4 5 6 7	■
P5ZY 2032.06	120	20	32	6	72	A2620020326120	1 2 3 4 5 6 7	■
P5ZY 3232.06	80	32	32	6	72	A2620032326080	1 2 3 4 5 6 7	■
P5ZY 4016.06	120	40	16	6	56	A2620040166120	1 2 3 4 5 6 7	■



Industry

## Shape SP, Arch pointed nose (according to DIN 69170)

Ordering example: A2621020326080



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$ : 50 m/s

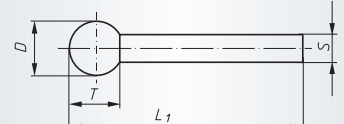
Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5SP 2032.06	80	20	32	6	72	A2621020326080	1 2 3 4 5 6 7	■



Industry

## Shape KU, Spherical (according to DIN 69170)

Ordering example: A2625008083080



**Packing unit:**

20 pcs. per type

Further dimensions and grit sizes on request

$v_{max.}$ : 50 m/s

Description	Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P5KU 0808.03	80	8	8	3	38	A2625008083080	1 2 3 4 5 6 7	■

## Specification and application P6

Products in group 6 are manufactured with a polyurethane bond (PU) in different hardnesses.

These tools

- can be easily profiled
- quickly generate an excellent surface finish
- produce little heat during the polishing process
- do not load
- require no dressing
- contain no softener
- do not increase in hardness after long storage
- are ideal for both stationary and manual application

These polishing tools are used to improve surface finish and geometry. The main applications are the polishing and finishing of steel, brass, precious metals, sintered metals and plastic. The product range includes polishing points, marbling wheels, rolls for satin finishes, and wheels from 60 mm to 300 mm diameter. They can be used with or without coolant.

When wet polishing, the coolant must be maintained at a neutral (ph) value. For dressing, a dressing stick (page 124) or diamond dressing tool can be used.

Due to long tool life and a good edge retention, the tools are ideally suited for automated processes e.g. centerless polishing of tubes or marbling of high alloyed steel plates.

The following grades are available:

**WP** = soft, very flexible

**MWP** = medium to soft

**MP** = medium for general application

**HP** = hard, resilient for flat surfaces

**SHP** = super hard, for stationary applications

The bonding is mixed with silicon carbide „SIC“ or aluminium oxide „A“ grain in the FEPA grit sizes 24 to 400.

### Application examples marbling points P6



Application recommendations polishing tools P6

	Removing rust, cleaning, tarnish removal	Cylindrical and surface grinding	Sharpening, dressing	Marbling, matt finishing		Deburring, cleaning up and rounding off				Burnishing				Pre-finishing				Polishing	
	MWP	SHP	SHP	WP	MWP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP
Gold, silver Nickel, aluminium Copper Brass																		400	400
														240	240				
												150		150					
												120	120						
						80			80	80		80							
					46	46				46		46							
Constructional steel	46																		
Stainless steel, titanium			400															400	400
			240												240	240			240
									150			150			150	150			
			120								120	120			120				
			80		80	80	80	80	80	80	80	80	80						
					46		46				46	46	46	46					
				24					24										
Hardened steel, Carbide		240															240		
		150											150						
		120											120						
		80					80												
							46												
Glass															400				
															240				
															150				
							80												
Rubber																			
Wood																			
Paint	46																		
Solder	240																		
Tin																			
													80						
													46						

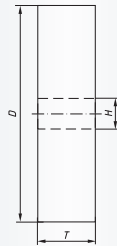
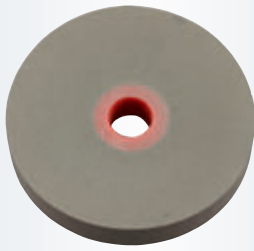
Grit sizes



Industry

**Polierscheiben, Form SE1**

Ordering example: A29100600060041



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

$v_{max}$ : MWP = 20 m/s

WP = 16 m/s

SHP = 32 m/s

Description	Quality/ Grit	D mm	T mm	H mm	Product-Number	recommended for									
P6SE1 06006 B.06	SC 80 MWP	60	6	6	A29100600060041	1	2	3	4	5	6	7	9	■	
P6SE1 06006 B.06	SC 150 MWP	60	6	6	A29100600060061	1	2	3	4	5	6	7	9	■	
P6SE1 10010 B.25	SC 80 MWP	100	10	25	A29101000100041	1	2	3	4	5	6	7	9	■	
P6SE1 10010 B.25	SC 150 MWP	100	10	25	A29101000100061	1	2	3	4	5	6	7	9	■	
P6SE1 10020 B.25	SC 46 MWP	100	20	25	A29101000200021	1	2	3	4	5	6	7	9	■ <b>NEW</b>	
P6SE1 10020 B.25	SC 80 MWP	100	20	25	A29101000200041	1	2	3	4	5	6	7	9	■	
P6SE1 10020 B.25	SC 150 MWP	100	20	25	A29101000200061	1	2	3	4	5	6	7	9	■	
P6SE1 10020 B.25	SC 400 MWP	100	20	25	A29101000200091	1	2	3	4	5	6	7	9	■ <b>NEW</b>	
P6SE1 12510 B.25	SC 80 MWP	125	10	25	A29101250100041	1	2	3	4	5	6	7	9	■	
P6SE1 12510 B.25	SC 150 MWP	125	10	25	A29101250100061	1	2	3	4	5	6	7	9	■	
P6SE1 12520 B.25	SC 80 MWP	125	20	25	A29101250200041	1	2	3	4	5	6	7	9	■	
P6SE1 12520 B.25	SC 150 MWP	125	20	25	A29101250200061	1	2	3	4	5	6	7	9	■	
P6SE1 15010 B.25	SC 150 MWP	150	20	25	A29101500100061	1	2	3	4	5	6	7	9	■	
P6SE1 15010 B.25	SC 150 SHP	150	10	25	A29101500100069	1	2	3	4	5	6	7	9	■ <b>NEW</b>	
P6SE1 15015 B.20	SC 120 SHP	150	15	20	A29101500150059	1	2	3	4	5	6	7	9	■ <b>NEW</b>	
P6SE1 15020 B.25	SC 80 MWP	150	20	25	A29101500200041	1	2	3	4	5	6	7	9	■	
P6SE1 15020 B.25	SC 150 MWP	150	20	25	A29101500200061	1	2	3	4	5	6	7	9	■	
P6SE1 15020 B.25	SC 80 WP	150	20	25	A29101500200040	1	2	3	4	5	6	7	9	■ <b>NEW</b>	
P6SE1 15025 B.20	SC 46 MWP	150	25	20	A29101500250021	1	2	3	4	5	6	7	9	■	
P6SE1 15025 B.25	SC 150 MWP	150	25	25	A29101500250061	1	2	3	4	5	6	7	9	■	
P6SE1 15025 B.25	SC 80 WP	150	25	25	A29101500250040	1	2	3	4	5	6	7	9	■	
P6SE1 17520 B.25	SC 80 MWP	175	20	25	A29101750200041	1	2	3	4	5	6	7	9	■	
P6SE1 17520 B.25	SC 150 MWP	175	20	25	A29101750200061	1	2	3	4	5	6	7	9	■	
P6SE1 20025 B.25	SC 80 MWP	200	25	25	A29102000250041	1	2	3	4	5	6	7	9	■	
P6SE1 20025 B.25	SC 150 MWP	200	25	25	A29102000250061	1	2	3	4	5	6	7	9	■	
P6SE1 20025 B.32	SC 46 MP	200	25	32	A29102000250024	1	2	3	4	5	6	7	9	■ <b>NEW</b>	

These polishing wheels are supplied in a medium bond in the two grit sizes 80 and 150. Upon request these polishing wheels can also be delivered with the bonding HP ( $v_{max}$  32 m/s) or MP ( $v_{max}$  25 m/s).

**Safety instructions:**

Grinding and polishing wheels on stationary machines are to be used only from both sides with the appropriate flanges. The diameter of flange must be 2/3 of the wheel diameter. The flanges are provided with a recess (1–2 mm depth) up to 5–10 mm from the outer edge.

# 158 Mounting system for polishing wheels



Industry

## Mounting system for polishing wheels

Ordering example: A6981008000



**Packing unit:**  
1 pc. per type

Description	Product-Number		
Mounting system MCA + K25	A6981008000		■

The mounting system for polishing wheels consists of a plastic sleeve (MCA) and a mounting arbor with 8 mm diameter shaft (K25) which is solely applicable to shape SE1 in the dimensions 10010 B 25 and 10020 B 25. It is not permitted to use this

mounting system for polishing wheels with larger diameters. Maximum peripheral wheel speed using this mounting method is 10m/s; this means a maximum spindle speed of 1900 R.P.M. with a wheel diameter of 100 mm.



## Always the right tool



**Assortment of mounted points:**  
I am delighted that LUKAS now offers a special line of products for retailers. Amazing packaging with most of fast moving tools to work steel and stainless steel.

**Andrea Bittner**  
Sales Department

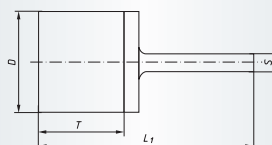
[www.lukas-erzett.com](http://www.lukas-erzett.com)



Industry

## Marbling points, Shape ZY, Cylinder

Ordering example: A29200200306021



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

v<sub>max</sub>: 10 m/s

Description	Quality/ Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P6MA ZY 2030.06	SC 46 MWP	20	30	6	80	A29200200306021	1 2 3 4 5 6 7 9	■
P6MA ZY 3030.06	SC 46 MWP	30	30	6	80	A29200300306021	1 2 3 4 5 6 7 9	■
P6MA ZY 4030.06	SC 46 MWP	30	30	6	80	A29200400306046	1 2 3 4 5 6 7 9	■
P6MA ZY 5030.06	SC 46 MWP	30	30	6	80	A29200500306046	1 2 3 4 5 6 7 9	■
P6MA ZY 6030.06	SC 46 MWP	30	30	6	80	A29200600306046	1 2 3 4 5 6 7 9	■

The marbling points can be used to work stainless steels, aluminium and non-ferrous metals (peacock-eye, clouds).

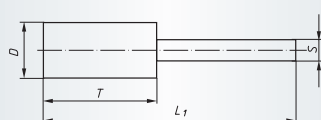
The marbling points do not load with abrasive dust and their quality lasts up to the plastic cap.



Industry

## Polishing points, Shape ZY, Cylindrical

Ordering example: A29300160203028



**Packing unit:**

10 pcs. per type

Further dimensions and grit sizes on request

v<sub>max</sub>: 20 m/s

Description	Quality/ Grit	D mm	T mm	S mm	L <sub>1</sub> mm	Product-Number	recommended for	
P6ZY 1320.03	SC 80 HP	13	20	3	50	A29300130203048	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 46 HP	16	20	3	50	A29300160203028	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 80 HP	16	20	3	50	A29300160203048	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 150 HP	16	20	3	50	A29300160203068	1 2 3 4 5 6 7 9	■
P6ZY 1620.03	SC 240 HP	16	20	3	50	A29300160203078	1 2 3 4 5 6 7 9	■
P6ZY 2020.06	SC 46 HP	20	20	6	60	A29300200206028	1 2 3 4 5 6 7 9	■
P6ZY 2020.06	SC 150 HP	20	20	6	60	A29300200206068	1 2 3 4 5 6 7 9	■
P6ZY 2520.06	SC 80 HP	25	20	6	60	A29300250206048	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 46 HP	30	30	6	70	A29300300306028	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 150 HP	30	30	6	70	A29300300306068	1 2 3 4 5 6 7 9	■
P6ZY 3030.06	SC 240 HP	30	30	6	70	A29300300306078	1 2 3 4 5 6 7 9	■
P6ZY 4040.06	SC 46 HP	40	40	6	80	A29300400406028	1 2 3 4 5 6 7 9	■
P6ZY 4040.06	SC 150 HP	40	40	6	80	A29300400406068	1 2 3 4 5 6 7 9	■
P6ZY 5040.06	SC 46 HP	50	40	6	80	A29300500406028	1 2 3 4 5 6 7 9	■
P6ZY 5040.06	SC 150 HP	50	40	6	80	A29300500406068	1 2 3 4 5 6 7 9	■
P6ZY 6040.06	SC 46 HP	60	40	6	80	A29300600406028	1 2 3 4 5 6 7 9	■
P6ZY 6040.06	SC 150 HP	60	40	6	80	A29300600406068	1 2 3 4 5 6 7 9	■

The polishing points are most suitable to work metal parts which are difficult or not accessible with grinding wheels.

**Applications:**

Bores, Hollow weldings, Moulding tools

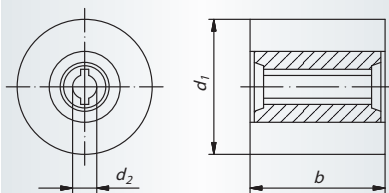
# 160 Polishing roll, group P6



Industry

## Polishing roll, P6PW

Ordering example: A29401000500041



**Packing unit:**

1 pc. per type

Further dimensions and grit sizes on request

Machine to suit: ESM 1310

$v_{max.}$ : 16 m/s

Description	Quality/ Grit	d <sub>1</sub> mm	b mm	d <sub>2</sub> mm	Product-Number	recommended for	
P6PW 100050	SC 80 MWP	100	50	19	A29401000500041	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 46 WP	100	100	19	A29401001000020	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 80 WP	100	100	19	A29401001000040	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 24 MWP	100	100	19	A29401001000011	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 46 MWP	100	100	19	A29401001000021	1 2 3 4 5 6 7 9	■
P6PW 100100	SC 80 MWP	100	100	19	A29401001000041	1 2 3 4 5 6 7 9	■



Industry

## Conditioning machine ESM 1310

Ordering example: A3995ESM1310



**Packing unit:**

1 pc. per type

**Weight:** approx. 2,9 kg

Description	Idle speed min <sup>-1</sup>	Power input W	Max. tool diameter	Tool width mm Ø mm	Hole size mm	Product-Number	
ESM 1310	1.300 - 3.050	1.300	120	100	19	A3995ESM1310	■

## Specification and application P7

LUKAS polishing points, discs and lenses have been especially developed for intricate mechanical and laboratory use. Other applications include model building and jewellery production; such highly regarded tools contain a soft elastomer bond.

The smallest dimensions in various shapes allow for the fine machining of intricate workpieces and structures.



**Industry**

### Polishing discs and polishing lenses in a soft elastomer bonding

Ordering example: A2950000101007

		<b>Packing unit:</b> 100 pcs. per type Further dimensions and grit sizes on request $v_{max}$ : 16 m/s Suitable mounting arbors on request														
Description	Quality	Shape	D mm	T mm	H mm	Product-Number	recommended for									
P7- R22 M	SICGR 240		22	3,5	1,8	A2950000101007	<table border="1"> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>9</td> </tr> </table>	1	2	3	4	5	6	7	9	■
1	2	3	4	5	6	7	9									
P7- L22 M	SICGR 240		22	3,4	1,8	A2950000105007	<table border="1"> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>9</td> </tr> </table>	1	2	3	4	5	6	7	9	■
1	2	3	4	5	6	7	9									



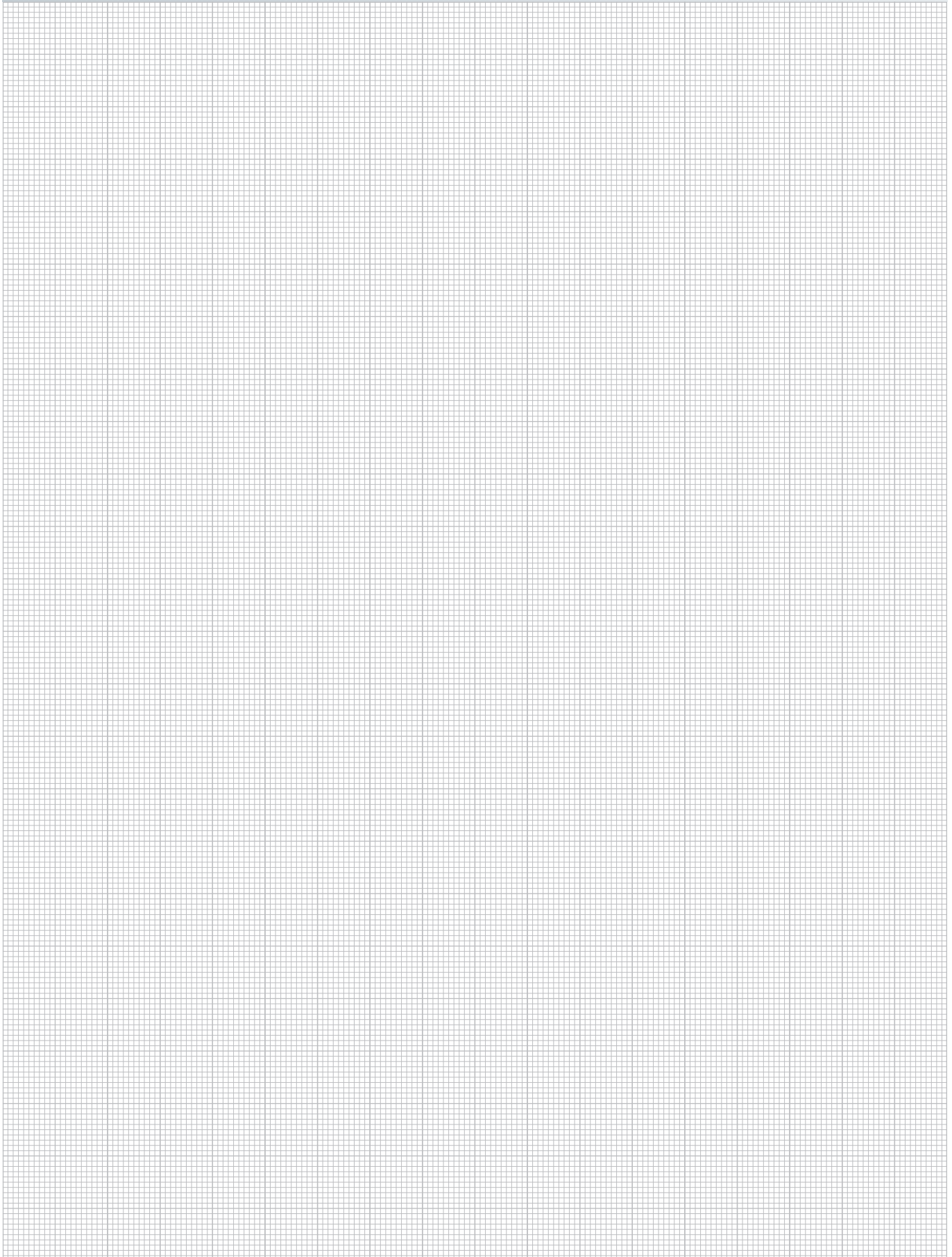
**Industry**

### Assortment of small polishing points with soft elastomer bond mounted on shaft 2.35 mm

Ordering example: A29551301582077

		<b>Packing unit:</b> 1 pc. per type Individual tools available on request $v_{max}$ : 16 m/s												
Description	Quality	Contents	Shank mm	Product-Number	recommended for									
P7-Assortment M	SICGR 240	12-pieces	2,35	A29551301582077	<table border="1"> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>9</td> </tr> </table>	1	2	3	4	5	6	7	9	■
1	2	3	4	5	6	7	9							
P7-Assortment F	SICGR 400	12-pieces	2,35	A29551301582071	<table border="1"> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>9</td> </tr> </table>	1	2	3	4	5	6	7	9	■
1	2	3	4	5	6	7	9							

Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid consists of small squares, with slightly larger squares forming a header area at the top left.