

Cutting and Grinding Discs

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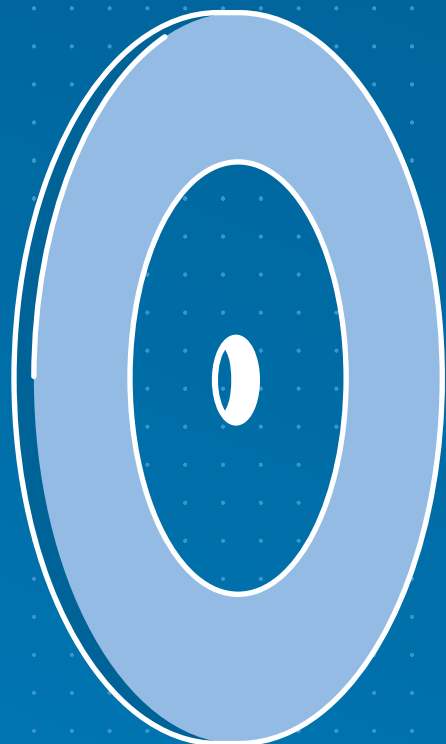
208 Grinding cup wheels

211 Diamondtools



Product line marking

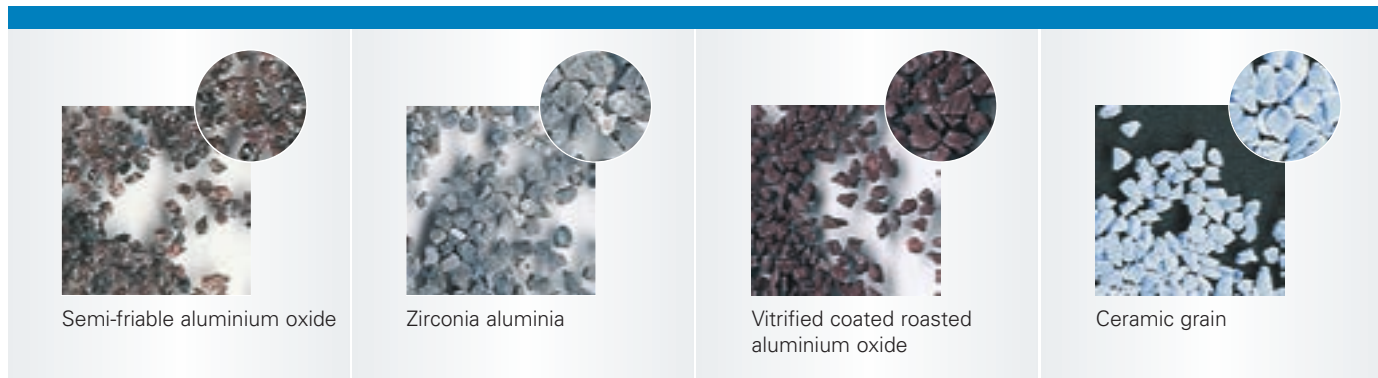
Product lines are labelled in the table header with the appropriate tabs. Further information on page **14** and **15**.



Structure and Components



Abrasives



Technical Information

Durability

Resin bonded grinding and cutting wheels for freehand applications must be depleted within three years of manufacture.

Please see metal ring for the expiry date which is specified by month and year; for instance V07/2018.



Labelling system for resin bonded grinding wheels

Example:



Abrasive Type	Grit			Hardness Grade			Bond
	coarse	medium	fine	soft	medium	hard	
A - aluminium oxide	12	36	60	M	R	U	BA – resin bond
C - silicon carbide	up to	up to	up to	Q	S	V	BF – resin bond, fibre-reinforced
Z - zirconia alumina	24	54	120	P	T	Z	

Operating speeds

LUKAS- grinding wheels and discs of the brand ROTTLUFF are developed and tested for particular working speeds and grinding processes.

Prior to the mounted of the grinding tool on the machine, it must be ensured that the machine's nominal speed (as specified on nameplate) does not exceed the maximum operating speed indicated on the grinding wheel or disc.



Maximum operating speed	Diameter of Disc [mm]/RPM [min ⁻¹]										
	50	76	100	115	125	150	180	230	300	350	400
80 m/s	30.500	20.100	15.300	13.300	12.200	10.200	8.500	6.600	5.100	4.400	3.800
100 m/s	38.200	25.100	19.100	16.650	16.600	12.700	10.600	8.300	6.400	5.400	4.700

Safety

With regards to occupational safety and operational convenience, LUKAS responsibility to the customer is taken very seriously. Our products are designed, manufactured and produced in accordance with the most stringent quality standards to provide a maximum of customer value at minimum risk. We are a member of both, the German Abrasive Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

Applied standards:

- Safety Requirements for Bonded Abrasives Products: EN12413
- Safety Requirements for Diamond Blades: EN 13236

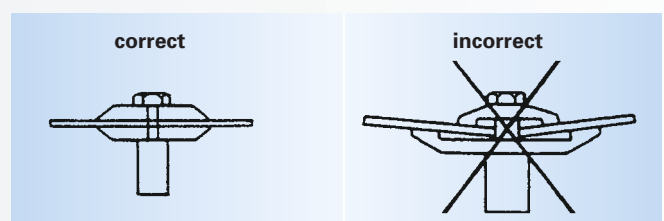


Safety recommendations

- Don't handle wheels roughly.
- Don't use non-reinforced cut-off wheels on portable machines.
- Don't store wheels in a damp atmosphere or in extreme temperatures.
- Don't mount a damaged wheel.
- Don't ever exceed the maximum operating speed marked on the wheel.
- Don't force a wheel onto a machine spindle.
- Don't use mounting flanges which are incorrect, damaged, dirty or burred.
- Don't tighten the mounting nut or locking flange excessively. To do so can distort the flanges and discs.
- Don't use a machine without a wheel guard.
- Don't use wheels without proper ventilation or dust protection equipment.
- Don't apply side pressure to cut-off wheels. You should not bend the wheel.
- Don't stop the wheel by applying pressure to the periphery or face. Always switch the machine off and allow the wheel to stop revolving.
- Don't allow the wheel to be trapped or pinched in the cut.
- Don't apply excessive pressure onto the wheel so that the driving motor slows down.
- Don't drop or lower a portable machine by the cable or airline onto the floor. A wheel can be easily cracked, if it is put down hard, by the weight of the machine. This is a common cause of wheel breakage.
- Don't grind with a depressed centre grinding wheel at an angle below 30 degrees to the work piece.
- Don't use a machine in a position where you do not have full control of the machine and you are not well balanced.

Clamping System

The use of flanges with unequal diameters is not allowed. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN60745-2-3:2007 and ANSI B.7.1).



Rottluff-Labeling

Safety standard

EAN Code

QR Code

Safety and operation Instructions

A = Aluminium oxide
C = Silicon carbide
AC = Aluminium oxide / Silicon carbide
ZA = zirconia alumina / aluminium oxide

60 = Grit size (16/very coarse, 36/medium, 60/Fine)

BF = resin bond, fibre-reinforced

HCS see page 183

Application


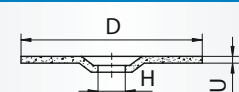
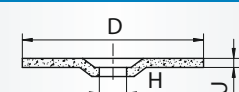
Manufactured according to EN 12413

max. operating speed

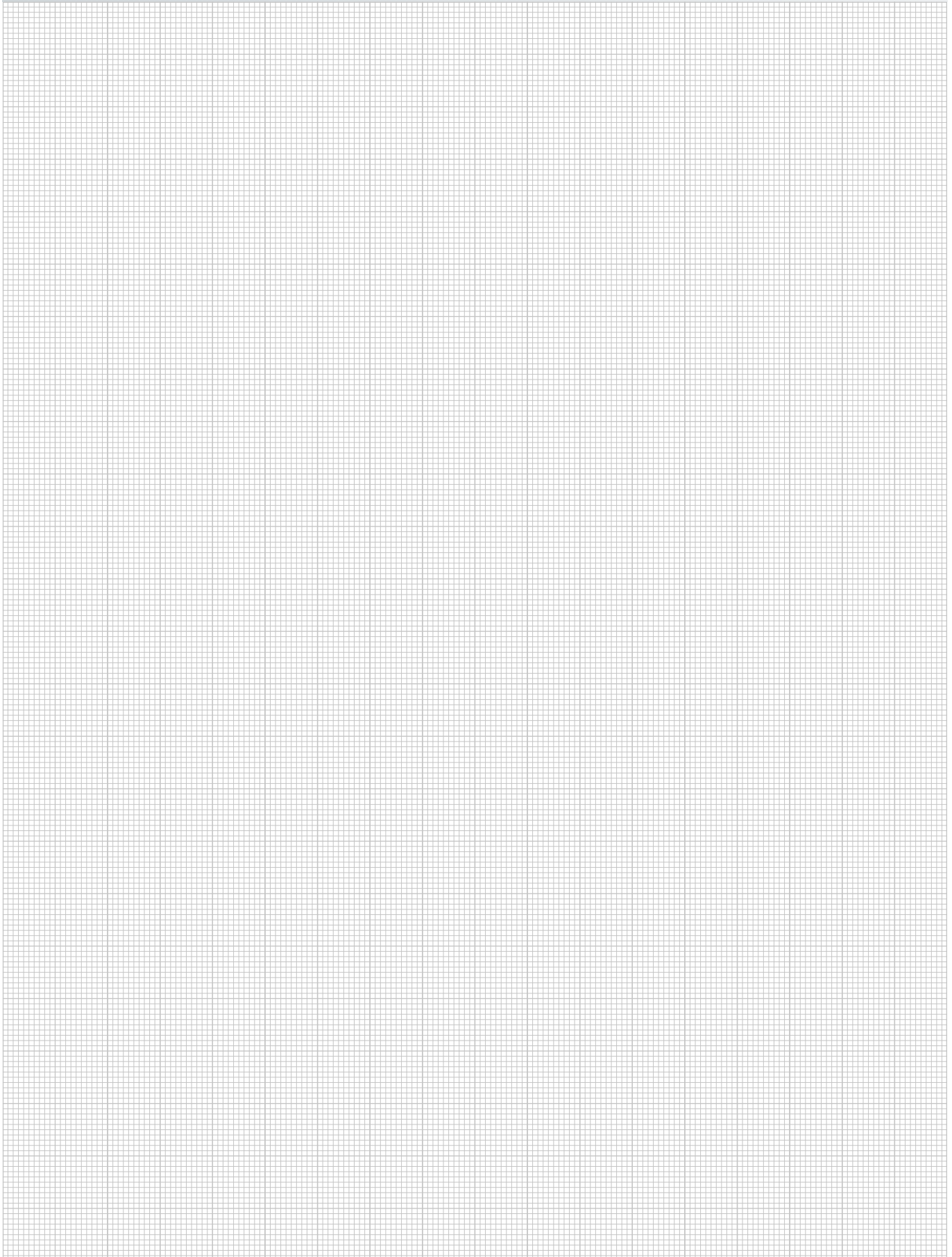
max. rpm

125 x 1,0 x 22,23 = D x U x H
5" x 0,04" x 7/8" = D x U x H
Diameter x thickness x bore size

Types of resin-bonded grinding wheels

 <p>Cutting discs U = (0,8 mm–4,5 mm) (USA: Typ 1)</p> <p>T 41 Straight cutting discs.</p> <ul style="list-style-type: none"> Available in diameters from 50 (2") to 230 mm (9") for freehand applications from 300 mm (12") to 500 mm (20") for use in stationary machines 	 <p>Cutting discs U = (0,8 mm–4,5 mm) (USA: Typ 27)</p> <p>T 42 Depressed centre cutting discs.</p> <ul style="list-style-type: none"> Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use. 	 <p>Grinding wheels U = (3 mm–10 mm) (USA: Typ 27)</p> <p>T 27 Depressed centre grinding wheels.</p> <ul style="list-style-type: none"> Available in diameters from 76 (3") to 230 mm (9"), allowed for freehand use.
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Notes

A large rectangular area filled with a fine grid pattern, intended for taking notes. The grid lines are light gray and form a consistent pattern across the page.

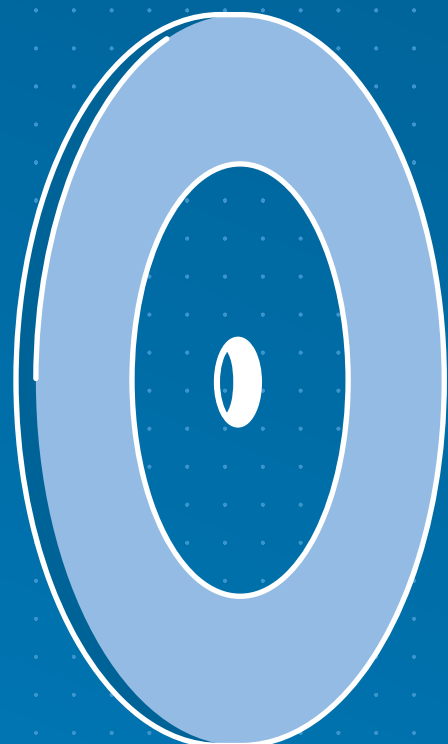
Cutting discs

- **182** Qualities and areas of application
- **184** Free-hand cutting disc for angle grinders
- **192** Large cutting disc (greater than 230 mm)
- **195** Small cutting disc (less than 100 mm)

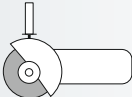









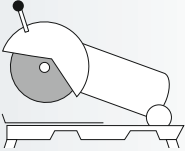
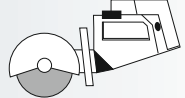









Product line marking

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



Cutting discs

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Free-hand cutting disc for angle grinders (100 mm–230 mm) 	High Performance				
	PROGRESS	Page 184 	Page 187 		
	Industry				
	PROMAX	Page 185 	Page 188 	Page 191 	Page 191 
	Base				
	PREMIUMFLEX BASE-X	Page 186-187 	Page 189-190 		Page 192 
Large cutting disc (greater than 230 mm)  	Industry				
	PROMAX		Page 189 		
	Base				
	PREMIUMFLEX BASE-X	Page 192 	Page 193 		Page 194 
	High Performance				
	PROGRESS	Page 195 			
Small cutting disc (less than 100 mm) 	Base				
	PREMIUMFLEX BASE-X	Page 195 			


HighCut-Solution – HCS

optimum cutting performance and service life

low odour and dust levels

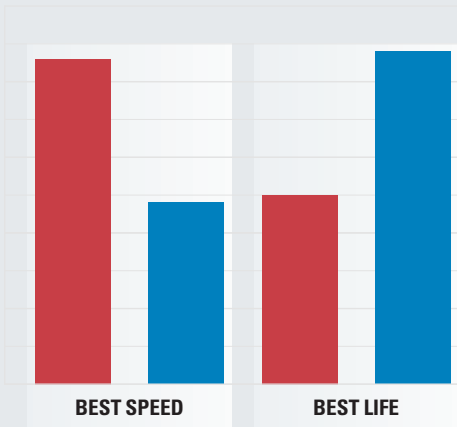
durable stable with regard to quality

optimised for top performance



- maximum service life and cutting performance due to innovative bonding technology
- high cutting speed at low cutting temperature
- low odour and dust levels during daily usage
- ergonomic work position and maximum durability without use of excessive force
- maximum shelf life with high levels of stability with regard to quality thanks to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process, made in Germany using up-to-date production processes and optimised formulations
- perfect for a wide variety of Inox and steel materials
- precise cutting

BEST SPEED and BEST LIFE – it's your choice!



Our tools are consistently designed for high performance. But as application parameters and expectations of our cutting and grinding discs can differ considerably, we offer two variants:

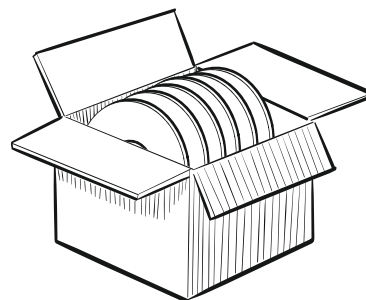
BEST SPEED is the right choice for all those who want quick results. Shorter cutting and grinding times ensure that work progresses with speed.

BEST LIFE ensures a high cutting rate per tool and optimises tool changing intervals.

■ Cutting speed
 ■ Service life

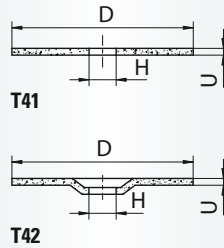
Packing units

Diameter (mm)	Disc width (mm)	Packing units
50–76	all	100 pieces
100–125	< 2	50 pieces (BASE-X 100 pieces)
	≥ 2	25 pieces
150–300	all	25 pieces
300–350	all	10 pieces
400	all	5 pieces



Cutting discs for stainless steel – PROGRESS

Ordering example: AT007226



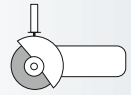
Packing unit:
see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

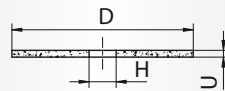
v_{max.}: 80 m/s



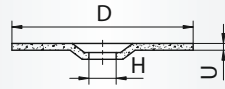
	Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for								
NEW	T41 PROGRESS	A60Z-BF INOX	HCS	100	1,0	16,00	15.300	AT007226	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A60Z-BF INOX	HCS	100	1,0	16,00	15.300	AT007227	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	100	1,6	16,00	15.300	AT007228	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	100	1,6	16,00	15.300	AT007229	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A60Z-BF INOX	HCS	115	1,0	22,23	13.300	AT007231	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A60Z-BF INOX	HCS	115	1,0	22,23	13.300	AT007232	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	115	1,6	22,23	13.300	AT007235	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	115	1,6	22,23	13.300	AT007236	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A30Z-BF INOX	HCS	115	2,5	22,23	13.300	AT007211	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A30Z-BF INOX	HCS	115	2,5	22,23	13.300	AT007212	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A60Z-BF INOX	HCS	125	1,0	22,23	12.200	AT007233	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A60Z-BF INOX	HCS	125	1,0	22,23	12.200	AT007234	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	125	1,6	22,23	12.200	AT007237	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	125	1,6	22,23	12.200	AT007238	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A30Z-BF INOX	HCS	125	2,5	22,23	12.200	AT007213	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A30Z-BF INOX	HCS	125	2,5	22,23	12.200	AT007214	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A60Z-BF INOX	HCS	150	1,0	22,23	10.200	AT007239	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A60Z-BF INOX	HCS	150	1,0	22,23	10.200	AT007240	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	150	1,6	22,23	10.200	AT007241	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	150	1,6	22,23	10.200	AT007242	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A30Z-BF INOX	HCS	150	2,5	22,23	10.200	AT007215	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A30Z-BF INOX	HCS	150	2,5	22,23	10.200	AT007216	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	180	1,6	22,23	8.500	AT007243	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	180	1,6	22,23	8.500	AT007244	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A30Z-BF INOX	HCS	180	2,5	22,23	8.500	AT007217	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A30Z-BF INOX	HCS	180	2,5	22,23	8.500	AT007218	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A46Z-BF INOX	HCS	230	1,9	22,23	6.600	AT007245	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A46Z-BF INOX	HCS	230	1,9	22,23	6.600	AT007246	1	2	3	4	5	6	7		■
NEW	T41 PROGRESS	A30Z-BF INOX	HCS	230	2,5	22,23	6.600	AT007219	1	2	3	4	5	6	7		■
NEW	T42 PROGRESS	A30Z-BF INOX	HCS	230	2,5	22,23	6.600	AT007220	1	2	3	4	5	6	7		■

Cutting discs for stainless steel – PROMAX

Ordering example: AT001634



T41



T42

Packing unit:

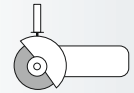
see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

v_{max.}: 80 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for									
								1	2	3	4	5	6	7			
T41 PROMAX	A60T-BF INOX	BEST SPEED	100	1,0	16,00	15.300	AT001634	1	2	3	4	5	6	7			■
T41 PROMAX	A60X-BF INOX	BEST LIFE	100	1,0	16,00	15.300	AT003000	1	2	3	4	5	6	7			■
T42 PROMAX	A60T-BF INOX	BEST SPEED	115	0,8	22,23	13.300	AT004266	1	2	3	4	5	6	7			■
T42 PROMAX	A60X-BF INOX	BEST LIFE	115	0,8	22,23	13.300	AT005301	1	2	3	4	5	6	7			■
T41 PROMAX	A60T-BF INOX	BEST SPEED	115	1,0	22,23	13.300	AT001655	1	2	3	4	5	6	7			■
T41 PROMAX	A60X-BF INOX	BEST LIFE	115	1,0	22,23	13.300	AT005841	1	2	3	4	5	6	7			■
T42 PROMAX	A60X-BF INOX	BEST LIFE	115	1,0	22,23	13.300	AT005299	1	2	3	4	5	6	7			■
T41 PROMAX	A46X-BF INOX	BEST LIFE	115	1,6	22,23	13.300	AT003346	1	2	3	4	5	6	7			■
T42 PROMAX	A46X-BF INOX	BEST LIFE	115	1,6	22,23	13.300	AT003347	1	2	3	4	5	6	7			■
T41 PROMAX	A36U-BF INOX	BEST LIFE	115	2,0	22,23	13.300	AT001657	1	2	3	4	5	6	7			■
T42 PROMAX	A60T-BF INOX	BEST SPEED	125	0,8	22,23	12.200	AT005287	1	2	3	4	5	6	7			■
T42 PROMAX	A60X-BF INOX	BEST LIFE	125	0,8	22,23	12.200	AT005302	1	2	3	4	5	6	7			■
T41 PROMAX	A60T-BF INOX	BEST SPEED	125	1,0	22,23	12.200	AT001685	1	2	3	4	5	6	7			■
T41 PROMAX	A60X-BF INOX	BEST LIFE	125	1,0	22,23	12.200	AT005842	1	2	3	4	5	6	7			■
T42 PROMAX	A60X-BF INOX	BEST LIFE	125	1,0	22,23	12.200	AT005300	1	2	3	4	5	6	7			■
T41 PROMAX	A46X-BF INOX	BEST LIFE	125	1,6	22,23	12.200	AT003348	1	2	3	4	5	6	7			■
T42 PROMAX	A46X-BF INOX	BEST LIFE	125	1,6	22,23	12.200	AT003353	1	2	3	4	5	6	7			■
T41 PROMAX	A36U-BF INOX	BEST LIFE	125	2,0	22,23	12.200	AT001687	1	2	3	4	5	6	7			■
T41 PROMAX	A30U-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT001691	1	2	3	4	5	6	7			■
T42 PROMAX	A30U-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT001696	1	2	3	4	5	6	7			■
T42 PROMAX	A60X-BF INOX	BEST LIFE	150	1,0	22,23	10.200	AT004221	1	2	3	4	5	6	7			■
T41 PROMAX	A46X-BF INOX	BEST LIFE	150	1,6	22,23	10.200	AT003327	1	2	3	4	5	6	7			■
T42 PROMAX	A30U-BF INOX	BEST LIFE	150	2,5	22,23	10.200	AT001725	1	2	3	4	5	6	7			■
T42 PROMAX	A46X-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT005571	1	2	3	4	5	6	7			■
T41 PROMAX	A36U-BF INOX	BEST LIFE	180	2,0	22,23	8.500	AT001743	1	2	3	4	5	6	7			■
T42 PROMAX	A30U-BF INOX	BEST LIFE	180	2,5	22,23	8.500	AT001751	1	2	3	4	5	6	7			■
T41 PROMAX	A46X-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT005864	1	2	3	4	5	6	7			■
T42 PROMAX	A46X-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT005877	1	2	3	4	5	6	7			■
T41 PROMAX	A36U-BF INOX	BEST LIFE	230	2,0	22,23	6.600	AT001782	1	2	3	4	5	6	7			■
T41 PROMAX	A30U-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT001786	1	2	3	4	5	6	7			■
T42 PROMAX	A30U-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT001791	1	2	3	4	5	6	7			■

NEW

NEW

NEW

NEW

NEW

NEW

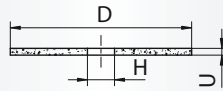
NEW

NEW

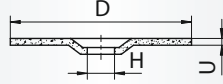
NEW

Cutting discs for stainless steel – PREMIUMFLEX

Ordering example: AT003108



T41



T42

Packing unit:

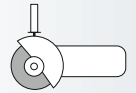
see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

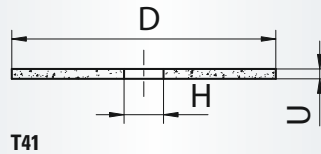
v_{max.}: 80 m/s



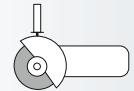
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for									
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	100	1,0	16,00	15.300	AT003108	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	100	1,6	16,00	15.300	AT000630	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	115	1,0	22,23	13.300	AT004643	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	115	1,2	22,23	13.300	AT000643	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A46P-BF INOX	BEST SPEED	115	1,6	22,23	13.300	AT003461	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	115	1,6	22,23	13.300	AT000647	1	2	3	4	5	6	7			■
NEW T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	115	2,5	22,23	13.300	AT001442	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A60S-BF INOX	BEST LIFE	125	1,0	22,23	12.200	AT002672	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	125	1,2	22,23	12.200	AT000670	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	125	1,6	22,23	12.200	AT000674	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT004154	1	2	3	4	5	6	7			■
NEW T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	2,5	22,23	12.200	AT004157	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	3,0	22,23	12.200	AT010154	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	150	1,6	22,23	10.200	AT000700	1	2	3	4	5	6	7			■
NEW T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	150	2,5	22,23	10.200	AT003162	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT000716	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	180	1,6	22,23	8.500	AT000718	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	2,5	22,23	8.500	AT003723	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	2,5	22,23	8.500	AT005450	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	3,0	22,23	8.500	AT003163	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A46P-BF INOX	BEST SPEED	230	1,9	22,23	6.600	AT003475	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT000742	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A46T-BF INOX	BEST LIFE	230	1,9	22,23	6.600	AT000744	1	2	3	4	5	6	7			■
T41 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT003568	1	2	3	4	5	6	7			■
NEW T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	2,5	22,23	6.600	AT005451	1	2	3	4	5	6	7			■
T42 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	3,0	22,23	6.600	AT004168	1	2	3	4	5	6	7			■

Cutting discs for stainless steel – BASE-X

Ordering example: A3890101150122002



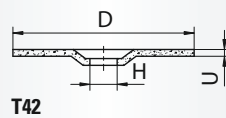
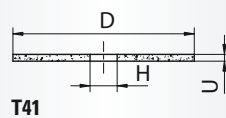
Packing unit:
see page 183
T41 = flat
T42 = depressed centre
Iron, sulphur and chlorine < 0,1%
 $v_{max.}$: 80 m/s



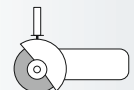
Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 BASE-X	A60T-BF INOX	115	1,0	22,23	13.300	A3890101150122002	1 2 3 4 5 6 7	■
T41 BASE-X	A60T-BF INOX	125	1,0	22,23	12.200	A3890101250122002	1 2 3 4 5 6 7	■
T41 BASE-X	A46T-BF INOX	230	1,8	22,23	6.600	A3890102300122002	1 2 3 4 5 6 7	■

Cutting discs for metal – PROGRESS

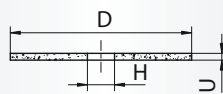
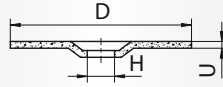
Ordering example: AT007276



Packing unit:
see page 183
T41 = flat
T42 = depressed centre
 $v_{max.}$: 80 m/s



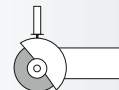
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for		
T41 PROGRESS	A60Z-BF	HCS	115	1,0	22,23	13.300	AT007276	1 2 3 5	■	NEW
T42 PROGRESS	A60Z-BF	HCS	115	1,0	22,23	13.300	AT007277	1 2 3 5	■	NEW
T41 PROGRESS	A46Z-BF	HCS	115	1,6	22,23	13.300	AT007271	1 2 3 5	■	NEW
T42 PROGRESS	A46Z-BF	HCS	115	1,6	22,23	13.300	AT007272	1 2 3 5	■	NEW
T41 PROGRESS	A60Z-BF	HCS	125	1,0	22,23	12.200	AT007278	1 2 3 5	■	NEW
T42 PROGRESS	A60Z-BF	HCS	125	1,0	22,23	12.200	AT007279	1 2 3 5	■	NEW
T41 PROGRESS	A46Z-BF	HCS	125	1,6	22,23	12.200	AT007273	1 2 3 5	■	NEW
T42 PROGRESS	A46Z-BF	HCS	125	1,6	22,23	12.200	AT007274	1 2 3 5	■	NEW
T41 PROGRESS	A46Z-BF	HCS	230	1,9	22,23	6.600	AT007284	1 2 3 5	■	NEW
T42 PROGRESS	A46Z-BF	HCS	230	1,9	22,23	6.600	AT007285	1 2 3 5	■	NEW

Cutting discs for metal – PROMAX
Ordering example: AT000556

T41

T42
Packing unit:

see page 183

T41 = flat

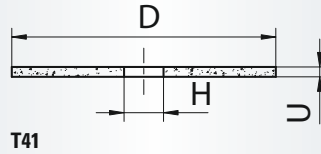
T42 = depressed centre

 $v_{max.}: 80 \text{ m/s}$


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for								
T41 PROMAX	A36U-BF	BEST SPEED	100	2,0	16,00	15.300	AT000556	1	2	3	5					■
T41 PROMAX	A60X-BF	BEST LIFE	115	1,0	22,23	13.300	AT005840	1	2	3	5					■
T41 PROMAX	A46X-BF	BEST LIFE	115	1,6	22,23	13.300	AT013301	1	2	3	5					■
T41 PROMAX	A36U-BF	BEST SPEED	115	2,0	22,23	13.300	AT001656	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	115	2,5	22,23	13.300	AT001665	1	2	3	5					■
T41 PROMAX	A60X-BF	BEST LIFE	125	1,0	22,23	12.200	AT005835	1	2	3	5					■
T41 PROMAX	A46X-BF	BEST LIFE	125	1,6	22,23	12.200	AT013302	1	2	3	5					■
T41 PROMAX	A36U-BF	BEST SPEED	125	2,0	22,23	12.200	AT001686	1	2	3	5					■
T41 PROMAX	A30U-BF	BEST SPEED	125	2,5	22,23	12.200	AT001690	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	125	2,5	22,23	12.200	AT001695	1	2	3	5					■
T41 PROMAX	A30X-BF	BEST LIFE	125	2,5	22,23	12.200	AT011086	1	2	3	5					■
T41 PROMAX	A46X-BF	BEST LIFE	150	1,6	22,23	10.200	AT013303	1	2	3	5					■
T41 PROMAX	A36U-BF	BEST SPEED	150	2,0	22,23	10.200	AT001717	1	2	3	5					■
T41 PROMAX	A30U-BF	BEST SPEED	150	2,5	22,23	10.200	AT001720	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	150	2,5	22,23	10.200	AT001724	1	2	3	5					■
NEW T41 PROMAX	A46X-BF	BEST LIFE	180	1,6	22,23	8.500	AT013305	1	2	3	5					■
T41 PROMAX	A36U-BF	BEST SPEED	180	2,0	22,23	8.500	AT001742	1	2	3	5					■
T41 PROMAX	A30U-BF	BEST SPEED	180	2,5	22,23	8.500	AT001746	1	2	3	5					■
T42 PROMAX	A36U-BF	BEST SPEED	180	2,0	22,23	8.500	AT001744	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	180	2,5	22,23	8.500	AT001750	1	2	3	5					■
T41 PROMAX	A46X-BF	BEST LIFE	230	1,9	22,23	6.600	AT005867	1	2	3	5					■
T41 PROMAX	A36U-BF	BEST SPEED	230	2,0	22,23	6.600	AT001781	1	2	3	5					■
T41 PROMAX	A30U-BF	BEST SPEED	230	2,5	22,23	6.600	AT001785	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	230	2,5	22,23	6.600	AT001790	1	2	3	5					■
T42 PROMAX	A30U-BF	BEST SPEED	230	3,0	22,23	6.600	AT001802	1	2	3	5					■

Stationary rail cutting disc – PROMAX

Ordering example: AT004110



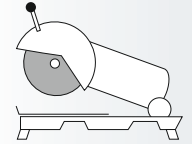
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

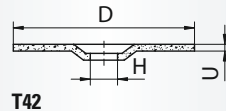
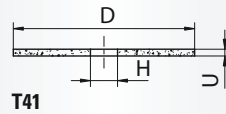
v_{max.}: 80 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PROMAX	ZA24R-BF	BEST LIFE	350	4,0	22,23	5.400	AT004110	1 2 3 5	■ NEW
T41 PROMAX	ZA24R-BF	BEST LIFE	350	4,0	25,40	5.400	AT004109	1 2 3 5	■ NEW
T41 PROMAX	ZA30Q-BF	BEST LIFE	350	4,0	22,23	5.400	AT005828	1 2 3 5	■
T41 PROMAX	ZA24R-BF	BEST LIFE	400	4,0	25,40	4.700	AT004116	1 2 3 5	■ NEW

Cutting discs for metal – PREMIUMFLEX

Ordering example: AT000636



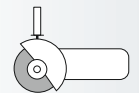
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

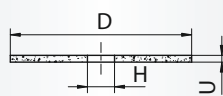
v_{max.}: 80 m/s



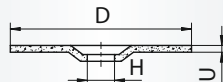
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	100	3,0	16,00	15.300	AT000636	1 2 3 5	■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	100	3,0	16,00	15.300	AT000638	1 2 3 5	■
T41 PREMIUMFLEX	A60S-BF	BEST LIFE	115	1,0	22,23	13.300	AT006440	1 2 3 5	■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	115	1,2	22,23	13.300	AT000644	1 2 3 5	■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	115	1,6	22,23	13.300	AT000648	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	115	2,5	22,23	13.300	AT000656	1 2 3 5	■
T41 PREMIUMFLEX	A24P-BF	BEST SPEED	115	3,0	22,23	13.300	AT005161	1 2 3 5	■
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	115	3,0	22,23	13.300	AT005162	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	115	3,0	22,23	13.300	AT000660	1 2 3 5	■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	115	3,0	22,23	13.300	AT000662	1 2 3 5	■
T41 PREMIUMFLEX	A60S-BF	BEST LIFE	125	1,0	22,23	12.200	AT006710	1 2 3 5	■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	125	1,2	22,23	12.200	AT000671	1 2 3 5	■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	125	1,6	22,23	12.200	AT000675	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	125	2,5	22,23	12.200	AT000679	1 2 3 5	■
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	125	3,0	22,23	12.200	AT005164	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	125	3,0	22,23	12.200	AT000686	1 2 3 5	■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	125	3,0	22,23	12.200	AT000688	1 2 3 5	■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	150	1,6	22,23	10.200	AT000701	1 2 3 5	■ NEW
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	150	3,0	22,23	10.200	AT000707	1 2 3 5	■

Cutting discs for metal – PREMIUMFLEX

Ordering example: AT000717



T41



T42

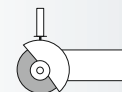
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

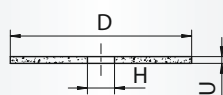
v_{max} : 80 m/s



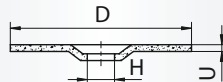
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for								
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	180	1,6	22,23	8.500	AT000717	1	2	3	5					■
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	180	3,0	22,23	8.500	AT001239	1	2	3	5					■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	180	3,0	22,23	8.500	AT000728	1	2	3	5					■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	180	3,0	22,23	8.500	AT000732	1	2	3	5					■
T41 PREMIUMFLEX	A46T-BF	BEST LIFE	230	1,9	22,23	6.600	AT000743	1	2	3	5					■
T42 PREMIUMFLEX	A46T-BF	BEST LIFE	230	1,9	22,23	6.600	AT000745	1	2	3	5					■
T41 PREMIUMFLEX	A36T-BF	BEST LIFE	230	2,0	22,23	6.600	AT000967	1	2	3	5					■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	230	2,5	22,23	6.600	AT000861	1	2	3	5					■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	230	2,5	22,23	6.600	AT004063	1	2	3	5					■
T41 PREMIUMFLEX	A24P-BF	BEST SPEED	230	3,0	22,23	6.600	AT005165	1	2	3	5					■
T42 PREMIUMFLEX	A24P-BF	BEST SPEED	230	3,0	22,23	6.600	AT005166	1	2	3	5					■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	230	3,0	22,23	6.600	AT000750	1	2	3	5					■
T42 PREMIUMFLEX	A24R-BF	BEST LIFE	230	3,0	22,23	6.600	AT000754	1	2	3	5					■

Cutting discs for metal – BASE-X

Ordering example: A3890101150122001



T41



T42

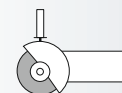
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

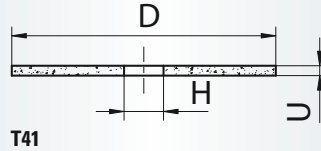
v_{max} : 80 m/s



Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for								
T41 BASE-X	A60T-BF	115	1,0	22,23	13.300	A3890101150122001	1	2	3	5					■
T41 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322002	1	2	3	5					■
T42 BASE-X	A30R-BF	115	3,0	22,23	13.300	A3890101150322001	1	2	3	5					■
T41 BASE-X	A60T-BF	125	1,0	22,23	12.200	A3890101250122001	1	2	3	5					■
T41 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322002	1	2	3	5					■
T42 BASE-X	A30R-BF	125	3,0	22,23	12.200	A3890101250322001	1	2	3	5					■
T41 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322002	1	2	3	5					■
T42 BASE-X	A30R-BF	180	3,0	22,23	8.500	A3890101800322001	1	2	3	5					■
T41 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322002	1	2	3	5					■
T42 BASE-X	A30R-BF	230	3,0	22,23	6.600	A3890102300322001	1	2	3	5					■

Cutting discs for non-ferrous metals – PROMAX

Ordering example: AT000920



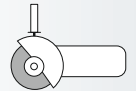
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

v_{max}: 80 m/s



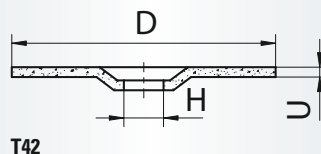
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PROMAX	A60N-BF ALU	BEST LIFE	115	1,0	22,23	13.300	AT000920	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A46N-BF ALU	BEST LIFE	115	1,6	22,23	13.300	AT004776	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	115	2,5	22,23	13.300	AT001664	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A60N-BF ALU	BEST LIFE	125	1,0	22,23	12.200	AT000950	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A46N-BF ALU	BEST LIFE	125	1,6	22,23	12.200	AT004788	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	125	2,5	22,23	12.200	AT001694	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A46N-BF ALU	BEST LIFE	150	1,6	22,23	10.200	AT001000	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	150	2,5	22,23	10.200	AT001723	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A46N-BF ALU	BEST LIFE	180	1,6	22,23	8.500	AT000985	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	180	2,5	22,23	8.500	AT001755	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A46N-BF ALU	BEST LIFE	230	1,9	22,23	6.600	AT002613	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	230	2,5	22,23	6.600	AT001789	① ② ③ ④ ⑤ ⑥ ⑦	■
T41 PROMAX	A36N-BF ALU	BEST LIFE	230	3,0	22,23	6.600	AT003459	① ② ③ ④ ⑤ ⑥ ⑦	■

NEW

NEW

Cutting discs for stone, concrete and cast iron – PROMAX

Ordering example: AT003017



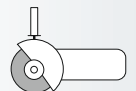
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

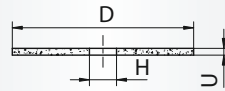
v_{max}: 80 m/s



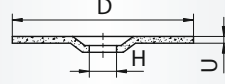
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T42 PROMAX	C30X-BF	BEST LIFE	230	3,0	22,23	6.600	AT003017	⑤ ⑩ ⑪ ⑫	■

Cutting discs for stone, concrete and cast iron – PREMIUMFLEX

Ordering example: AT000637



T41



T42

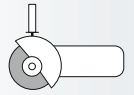
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

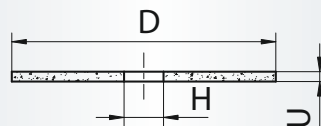
v_{max.}: 80 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	C30S-BF	BEST LIFE	100	3,0	16,00	15.300	AT000637	5 10 11 12	■
T42 PREMIUMFLEX	C30S-BF	BEST LIFE	100	3,0	16,00	15.300	AT000639	5 10 11 12	■
T41 PREMIUMFLEX	C46R-BF	BEST LIFE	115	1,6	22,23	13.300	AT002317	5 10 11 12	■
T42 PREMIUMFLEX	C46R-BF	BEST LIFE	115	1,6	22,23	13.300	AT002318	5 10 11 12	■
T41 PREMIUMFLEX	C30S-BF	BEST LIFE	115	3,0	22,23	13.300	AT000661	5 10 11 12	■
T42 PREMIUMFLEX	C30S-BF	BEST LIFE	115	3,0	22,23	13.300	AT000664	5 10 11 12	■
T41 PREMIUMFLEX	C46R-BF	BEST LIFE	125	1,6	22,23	12.200	AT002377	5 10 11 12	■
T41 PREMIUMFLEX	C30S-BF	BEST LIFE	125	3,0	22,23	12.200	AT000687	5 10 11 12	■
T42 PREMIUMFLEX	C30S-BF	BEST LIFE	125	3,0	22,23	12.200	AT000689	5 10 11 12	■
T41 PREMIUMFLEX	C46R-BF	BEST LIFE	180	1,6	22,23	8.500	AT002381	5 10 11 12	■
T41 PREMIUMFLEX	C30S-BF	BEST LIFE	180	3,0	22,23	8.500	AT000730	5 10 11 12	■
T42 PREMIUMFLEX	C30S-BF	BEST LIFE	180	3,0	22,23	8.500	AT000734	5 10 11 12	■
T41 PREMIUMFLEX	C46R-BF	BEST LIFE	230	1,9	22,23	6.600	AT001372	5 10 11 12	■
T42 PREMIUMFLEX	C46R-BF	BEST LIFE	230	1,9	22,23	6.600	AT001373	5 10 11 12	■
T41 PREMIUMFLEX	C30S-BF	BEST LIFE	230	3,0	22,23	6.600	AT000752	5 10 11 12	■
T42 PREMIUMFLEX	C30S-BF	BEST LIFE	230	3,0	22,23	6.600	AT000756	5 10 11 12	■
T42 PREMIUMFLEX	AC24R-BF	BEST LIFE	230	3,0	22,23	6.600	AT011009	5 10 11 12	■

Stationary cutting discs for stainless steel – PREMIUMFLEX

Ordering example: AT010003



T41

Packing unit:

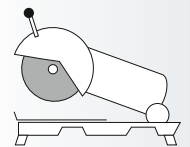
see page 183

T41 = flat

T42 = depressed centre

Iron, sulphur and chlorine < 0,1%

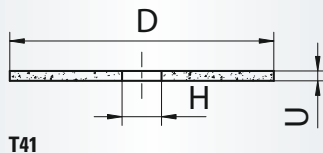
v_{max.}: 80 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	300	3,5	32,00	5.100	AT010003	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A36S-BF INOX	BEST LIFE	350	2,6	25,40	4.400	AT020208	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	350	3,5	32,00	4.400	AT010011	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	25,40	3.800	AT010014	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	32,00	3.800	AT010015	1 2 3 4 5 6 7	■
T41 PREMIUMFLEX	A30S-BF INOX	BEST LIFE	400	4,0	40,00	3.800	AT010016	1 2 3 4 5 6 7	■

Cutting discs for metal – PREMIUMFLEX

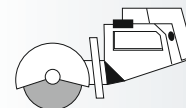
Ordering example: AT010052



T41

Packing unit:

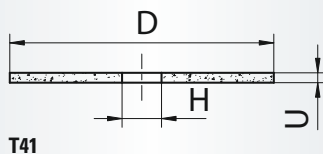
see page 183
T41 = flat
T42 = depressed centre
 $v_{max.}$: 100 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	300	4,0	20,00	6.400	AT010052	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT010055	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	350	4,0	25,40	5.400	AT010057	1 2 3 5	■
T41 PREMIUMFLEX	A24R-BF	BEST LIFE	400	4,0	22,23	4.700	AT002844	1 2 3 5	■

Stationary cutting discs for metal – PREMIUMFLEX

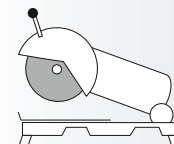
Ordering example: AT010028



T41

Packing unit:

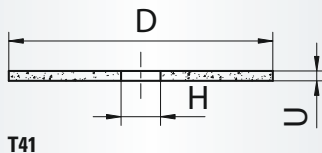
see page 183
T41 = flat
T42 = depressed centre
 $v_{max.}$: 80 m/s or 100 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	300	2,6	25,40	5.100 / 80 m/s	AT010028	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	22,23	6.400 / 100 m/s	AT001774	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	25,40	6.400 / 100 m/s	AT001776	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	300	3,5	32,00	6.400 / 100 m/s	AT010020	1 2 3 5	■
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	350	2,6	25,40	4.400 / 80 m/s	AT010029	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	350	3,5	25,40	5.400 / 100 m/s	AT010022	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	350	3,5	32,00	5.400 / 100 m/s	AT010023	1 2 3 5	■
T41 PREMIUMFLEX	A36S-BF	BEST LIFE	400	3,2	25,40	3.800 / 80 m/s	AT010030	1 2 3 5	■
T41 PREMIUMFLEX	A30T-BF	BEST LIFE	400	4,0	32,00	4.700 / 100 m/s	AT010026	1 2 3 5	■

Cutting discs for stone, concrete and cast iron – PREMIUMFLEX

Ordering example: AT010060



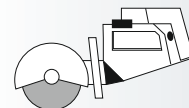
Packing unit:

see page 183

T41 = flat

T42 = depressed centre

v_{max.}: 80 m/s



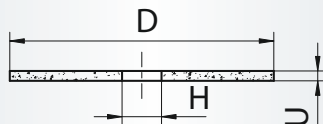
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T41 PREMIUMFLEX	C24R-BF	BEST LIFE	300	4,0	25,40	6.400	AT010060	5 10 11 12	■
T41 PREMIUMFLEX	AC24R-BF	BEST LIFE	300	4,0	20,00	6.400	AT000788	5 10 11 12	■
T41 PREMIUMFLEX	C24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT010061	5 10 11 12	■
T41 PREMIUMFLEX	AC24R-BF	BEST LIFE	350	4,0	20,00	5.400	AT000816	5 10 11 12	■

Application example Cutting disc for stone, concrete and cast iron



Small cutting discs for stainless steel – PROGRESS

Ordering example: AT007201



T41

Packing unit:

see page 183

T41 = flat

Iron, sulphur and chlorine < 0,1%

v_{max}: 80 m/s

See page 411 for suitable mounting arbors. .



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for		
T41 PROGRESS	A60Z-BF INOX	HCS	50	1,0	10,00	30.500	AT007201	1 2 3 4 5 6 7	■	NEW
T41 PROGRESS	A60Z-BF INOX	HCS	76	1,0	10,00	20.100	AT007200	1 2 3 4 5 6 7	■	NEW

Small cutting discs for stainless steel – PREMIUMFLEX

Ordering example: AT501006



T41

Packing unit:

see page 183

T41 = flat

Iron, sulphur and chlorine < 0,1%

v_{max}: 80 m/s

See page 411 for suitable mounting arbors.



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for		
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	1,0	6,00	30.500	AT501006	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	1,0	10,00	30.500	AT501010	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	50	2,0	6,00	30.500	AT502006	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	1,0	10,00	20.100	AT761010	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	2,0	6,00	20.100	AT762006	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	2,0	10,00	20.100	AT762010	1 2 3 4 5 6 7	■	
T41 PREMIUMFLEX	A46S-BF INOX	BEST LIFE	76	3,0	10,00	20.100	AT763010	1 2 3 4 5 6 7	■	

Always the right tool

For Highest Standards in Surface Finishing!



Grinding discs

- 198** Qualities and areas of application

- 200** Free-hand grinding discs for angle grinders

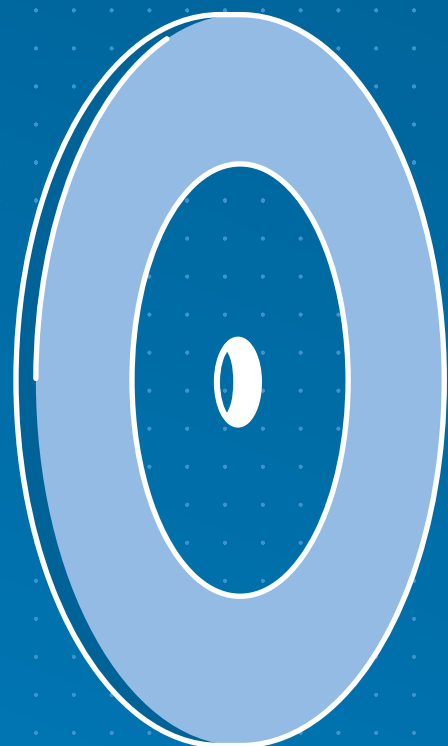
- 207** Small grinding discs

- 208** Cup Wheels

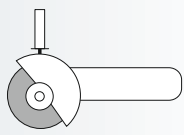




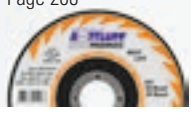


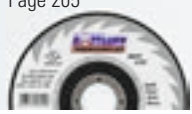





Product line marking

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



Grinding discs

Type	Product line	Material			
		INOX/Steel	Steel	Aluminium	Stone/Cast material
Free-hand grinding discs for angle grinders 	High Performance				
	PROGRESS	Page 200-201 	Page 204 		
	Industry				
	PROMAX	Page 200-202 	Page 203-204 	Page 206 	Page 206-207 
	Base				
	PREMIUMFLEX BASE-X	Page 203 	Page 205 		Page 207 
Small grinding discs 	Base				
	PREMIUMFLEX BASE-X	Page 207 			



Peter Smith
Sales Department



Always the right tool

Cutting and grinding discs „PROGRESS“:
Please convince yourself of our top quality products with an **optimal tool life** to cost ratio!

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HighCut-Solution – HCS

optimum cutting performance and service life

low odour and dust levels

HighCut SOLUTION

optimised for top performance

- maximum service life and cutting performance due to innovative bonding technology
- high cutting speed at low cutting temperature
- low odour and dust levels during daily usage
- ergonomic work position and maximum durability without use of excessive force
- maximum shelf life with high levels of stability with regard to quality thanks to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process, made in Germany using up-to-date production processes and optimised formulations
- perfect for a wide variety of Inox and steel materials
- precise cutting

durable stable with regard to quality

BEST SPEED and BEST LIFE – it's your choice!

Our tools are consistently designed for high performance. But as application parameters and expectations of our cutting and grinding discs can differ considerably, we offer you variants:

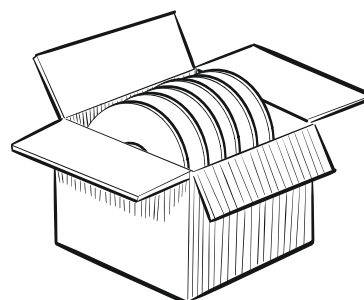
BEST SPEED is the right choice for all those who want quick results. Shorter grinding times ensure that work progresses with speed.

BEST LIFE ensures a long service life per tool and optimizes tool changing intervals

■ Cutting speed
 ■ Service life

Packing units

Diameter (mm)	Disc width (mm)	Packing units
76	all	50 pieces
100–230	3	25 pieces
	4	20 pieces
	≥ 6	10 pieces





Cutting and grinding without tool change.

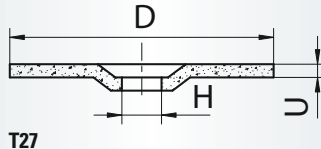
Safe. Precise. Perfect.

ROTLUFF

High Performance

Grinding and cutting disc to machine stainless steel – PROGRESS COOL JOBBER

Ordering example: AS015675



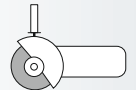
Packing unit:

see page 199

T27 = depressed centre

Iron, sulphur and chlorine < 0,1%

v_{max.}: 80 m/s



Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for
NEW T27 PROGRESS	A36V-BF INOX COOL JOBBER	HCS	115	3,0	22,23	13.300	AS015675	1 2 3 4 6
NEW T27 PROGRESS	A36V-BF INOX COOL JOBBER	HCS	125	3,0	22,23	12.200	AS015676	1 2 3 4 6
NEW T27 PROGRESS	A36V-BF INOX COOL JOBBER	HCS	150	3,0	22,23	10.200	AS015677	1 2 3 4 6
NEW T27 PROGRESS	A36V-BF INOX COOL JOBBER	HCS	180	3,0	22,23	8.500	AS015678	1 2 3 4 6
NEW T27 PROGRESS	A36V-BF INOX COOL JOBBER	HCS	230	3,0	22,23	6.600	AS015684	1 2 3 4 6

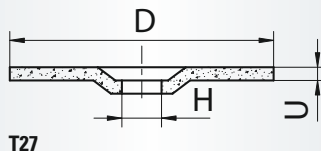
• Excellent grinding performance, thanks to the pimples in its structure

ROTLUFF

Industry

Grinding and cutting disc to machine stainless steel – PROMAX COOL JOBBER

Ordering example: AS005674



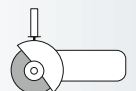
Packing unit:

see page 199

T27 = depressed centre

Iron, sulphur and chlorine < 0,1%

v_{max.}: 80 m/s

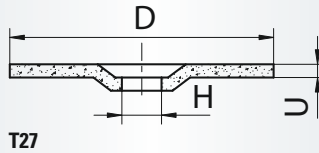


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for
NEW T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	115	3,0	22,23	13.300	AS005674	1 2 3 4 6
T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	125	3,0	22,23	12.200	AS005705	1 2 3 4 6
NEW T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	150	3,0	22,23	10.200	AS005706	1 2 3 4 6
NEW T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	180	3,0	22,23	8.500	AS005766	1 2 3 4 6
NEW T27 PROMAX	A24S-BF INOX COOL JOBBER	BEST SPEED	230	3,2	22,23	6.600	AS005785	1 2 3 4 6

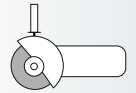
• Excellent grinding performance, thanks to the pimples in its structure

Grinding and cutting disc to machine stainless steel – PROMAX

Ordering example: AS001674



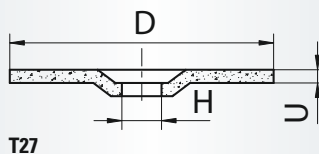
Packing unit:
see page 199
T27 = depressed centre
Iron, sulphur and chlorine < 0,1%
 v_{max} : 80 m/s



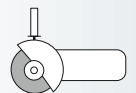
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for									
T27 PROMAX	A24V-BF INOX	BEST SPEED	115	4,0	22,23	13.300	AS001674	1	2	3	4	6					■
T27 PROMAX	A24V-BF INOX	BEST SPEED	125	4,0	22,23	12.200	AS001705	1	2	3	4	6					■
T27 PROMAX	A24V-BF INOX	BEST SPEED	150	4,0	22,23	10.200	AS001521	1	2	3	4	6					■
T27 PROMAX	A24V-BF INOX	BEST SPEED	180	4,0	22,23	8.500	AS001766	1	2	3	4	6					■
T27 PROMAX	A24V-BF INOX	BEST SPEED	230	4,0	22,23	6.600	AS001805	1	2	3	4	6					■

Grinding disc to machine stainless steel – PROGRESS

Ordering example: AS013491



Packing unit:
see page 199
T27 = depressed centre
Iron, sulphur and chlorine < 0,1%
 v_{max} : 80 m/s

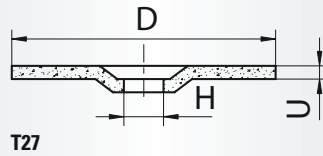


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for										
T27 PROGRESS	A24U-BF INOX	HCS	115	7,0	22,23	13.300	AS013491	1	2	3	4	6					■	NEW
T27 PROGRESS	A24U-BF INOX	HCS	125	7,0	22,23	12.200	AS013492	1	2	3	4	6					■	NEW
T27 PROGRESS	A24U-BF INOX	HCS	150	7,0	22,23	10.200	AS013410	1	2	3	4	6					■	NEW
T27 PROGRESS	A24U-BF INOX	HCS	180	7,0	22,23	8.500	AS013494	1	2	3	4	6					■	NEW
T27 PROGRESS	A24U-BF INOX	HCS	230	7,0	22,23	6.600	AS013496	1	2	3	4	6					■	NEW

• Excellent grinding performance, thanks to the pimples in its structure

Grinding discs for stainless steel – PROMAX

Ordering example: AS003392



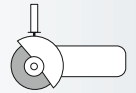
Packing unit:

see page 199

T27 = depressed centre

Iron, sulphur and chlorine < 0,1%

v_{max.}: 80 m/s

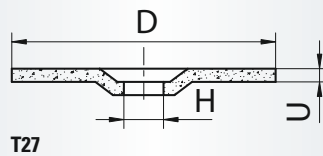


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
NEW T27 PROMAX	A24S-BF INOX	BEST SPEED	115	7,0	22,23	13.300	AS003392	1 2 3 4 6	■
T27 PROMAX	A24S-BF INOX	BEST SPEED	125	7,0	22,23	12.200	AS003393	1 2 3 4 6	■
NEW T27 PROMAX	A24S-BF INOX	BEST SPEED	150	7,0	22,23	10.200	AS003788	1 2 3 4 6	■
NEW T27 PROMAX	A24S-BF INOX	BEST SPEED	180	7,0	22,23	8.500	AS003394	1 2 3 4 6	■
NEW T27 PROMAX	A24S-BF INOX	BEST SPEED	230	7,0	22,23	6.600	AS003396	1 2 3 4 6	■

• Excellent grinding performance, thanks to the pimples in its structure

Grinding discs for stainless steel – PROMAX

Ordering example: AS003100



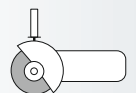
Packing unit:

see page 199

T27 = depressed centre

Iron, sulphur and chlorine < 0,1%

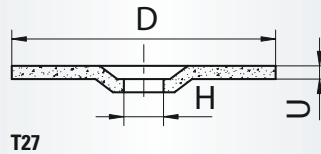
v_{max.}: 80 m/s



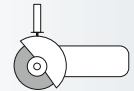
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A24X-BF INOX	BEST LIFE	115	7,0	22,23	13.300	AS003100	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	125	7,0	22,23	12.200	AS001709	1 2 3 4 6	■
T27 PROMAX	A24X-BF INOX	BEST LIFE	125	7,0	22,23	12.200	AS003101	1 2 3 4 6	■
T27 PROMAX	A24X-BF INOX	BEST LIFE	180	7,0	22,23	8.500	AS003103	1 2 3 4 6	■
T27 PROMAX	A24V-BF INOX	BEST SPEED	230	7,0	22,23	6.600	AS001810	1 2 3 4 6	■
T27 PROMAX	A24X-BF INOX	BEST LIFE	230	7,0	22,23	6.600	AS003104	1 2 3 4 6	■

Grinding discs for stainless steel – PREMIUMFLEX

Ordering example: AS002037



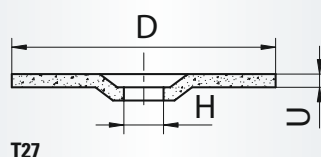
Packing unit:
see page 199
T27 = depressed centre
Iron, sulphur and chlorine < 0,1%
 v_{max} : 80 m/s



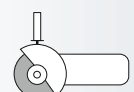
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	100	6,0	16,00	15.300	AS002037	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	115	6,4	22,23	13.300	AS000105	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	4,0	22,23	12.200	AS003106	1 2 3 4	■
T27 PREMIUMFLEX	A24/30Q-BF INOX	BEST SPEED	125	6,0	22,23	12.200	AS001603	1 2 3 4	■
T27 PREMIUMFLEX	A24P-BF INOX	BEST SPEED	125	6,0	22,23	12.200	AS000694	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	125	6,4	22,23	12.200	AS000106	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	150	6,4	22,23	10.200	AS000107	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	6,4	22,23	8.500	AS000108	1 2 3 4	■
T27 PREMIUMFLEX	A24/30Q-BF INOX	BEST SPEED	180	8,0	22,23	8.500	AS001606	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	180	8,0	22,23	8.500	AS002108	1 2 3 4	■
T27 PREMIUMFLEX	A24/30S-BF INOX	BEST LIFE	230	6,4	22,23	6.600	AS000109	1 2 3 4	■
T27 PREMIUMFLEX	A24P-BF INOX	BEST SPEED	230	6,5	22,23	6.600	AS000763	1 2 3 4	■

Grinding and cutting disc for steel – PROMAX

Ordering example: AS001675



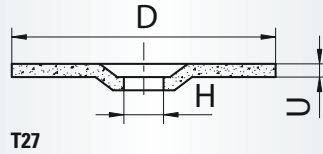
Packing unit:
see page 199
T27 = depressed centre
 v_{max} : 80 m/s



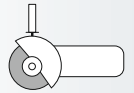
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for		
T27 PROMAX	A24T-BF	BEST LIFE	115	4,0	22,23	13.300	AS001675	1 2 3	■	NEW
T27 PROMAX	A24T-BF	BEST LIFE	125	4,0	22,23	12.200	AS001706	1 2 3	■	
T27 PROMAX	A24T-BF	BEST LIFE	150	4,0	22,23	10.200	AS001732	1 2 3	■	NEW
T27 PROMAX	A24T-BF	BEST LIFE	180	4,0	22,23	8.500	AS001767	1 2 3	■	NEW
T27 PROMAX	A24T-BF	BEST LIFE	230	4,0	22,23	6.600	AS001806	1 2 3	■	NEW

Grinding disc for steel – PROGRESS

Ordering example: AS012451



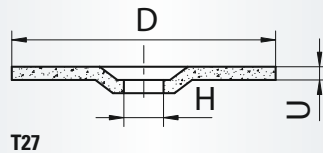
Packing unit:
see page 199
T27 = depressed centre
V_{max}: 80 m/s



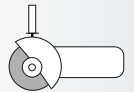
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
NEW T27 PROGRESS	A24X-BF	HCS	115	7,0	22,23	13.300	AS012451	1 2 3	■
NEW T27 PROGRESS	A24X-BF	HCS	125	7,0	22,23	12.200	AS012453	1 2 3	■
NEW T27 PROGRESS	A24X-BF	HCS	150	7,0	22,23	10.200	AS012458	1 2 3	■
NEW T27 PROGRESS	A24X-BF	HCS	180	7,0	22,23	8.500	AS012466	1 2 3	■
NEW T27 PROGRESS	A24X-BF	HCS	230	7,0	22,23	6.600	AS012468	1 2 3	■

Grinding disc for steel – PROMAX

Ordering example: AS001679



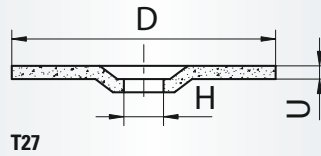
Packing unit:
see page 199
T27 = depressed centre
V_{max}: 80 m/s



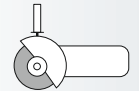
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A24/30T-BF	BEST SPEED	115	7,0	22,23	13.300	AS001679	1 2 3 5	■
T27 PROMAX	A24/30T-BF	BEST SPEED	125	7,0	22,23	12.200	AS001710	1 2 3 5	■
NEW T27 PROMAX	A24/30T-BF	BEST SPEED	150	7,0	22,23	10.200	AS001736	1 2 3 5	■
T27 PROMAX	A24/30T-BF	BEST SPEED	180	7,0	22,23	8.500	AS001772	1 2 3 5	■
T27 PROMAX	A24/30T-BF	BEST SPEED	230	7,0	22,23	6.600	AS001811	1 2 3 5	■

Grinding disc for steel – PREMIUMFLEX

Ordering example: AS000642



Packing unit:
see page 199
T27 = depressed centre
 v_{max} : 80 m/s

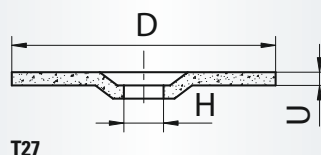


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	100	6,0	16,00	15.300	AS000642	1 2 3	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	115	6,0	22,23	13.300	AS000667	1 2 3	■
T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	115	6,0	22,23	13.300	AS000992	1 2 3 5	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	4,0	22,23	12.200	AS000690	1 2 3	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	6,0	22,23	12.200	AS000692	1 2 3	■
T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	125	6,0	22,23	12.200	AS000999	1 2 3 5	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	125	8,0	22,23	12.200	AS000696	1 2 3	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	150	4,0	22,23	10.200	AS002920	1 2 3	■
T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	150	6,0	22,23	10.200	AS003712	1 2 3 5	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	150	6,0	22,23	10.200	AS000712	1 2 3	■
T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	180	6,5	22,23	8.500	AS001009	1 2 3 5	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	180	6,5	22,23	8.500	AS000737	1 2 3	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	180	8,0	22,23	8.500	AS000740	1 2 3	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	230	6,5	22,23	6.600	AS000762	1 2 3	■
T27 PREMIUMFLEX	A24/30P-BF	BEST SPEED	230	6,5	22,23	6.600	AS001017	1 2 3 5	■
T27 PREMIUMFLEX	A24/30S-BF	BEST LIFE	230	8,0	22,23	6.600	AS000767	1 2 3	■

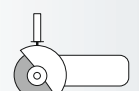


Grinding disc for steel – BASE-X

Ordering example: A3891101150622001



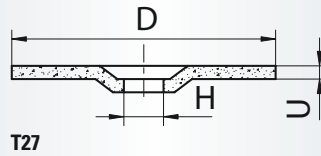
Packing unit:
see page 199
T27 = depressed centre
 v_{max} : 80 m/s



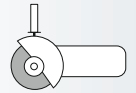
Description	Quality	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 BASE-X	A24R-BF	115	6,0	22,23	13.300	A3891101150622001	1 2 3	■
T27 BASE-X	A24R-BF	125	6,0	22,23	12.200	A3891101250622001	1 2 3	■
T27 BASE-X	A24R-BF	180	6,0	22,23	8.500	A3891101800622001	1 2 3	■
T27 BASE-X	A24R-BF	230	6,0	22,23	6.600	A3891102300622001	1 2 3	■

Grinding discs for non-ferrous metals – PROMAX

Ordering example: AS001677



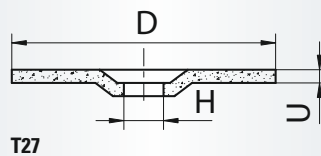
Packing unit:
see page 199
T27 = depressed centre
 $v_{max.}$: 80 m/s



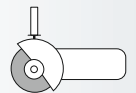
Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	A36N-BF ALU	BEST LIFE	115	7,0	22,23	13.300	AS001677	① ② ③ ④ ⑥	■
T27 PROMAX	A36N-BF ALU	BEST LIFE	125	7,0	22,23	12.200	AS001708	① ② ③ ④ ⑥	■
T27 PROMAX	A36N-BF ALU	BEST LIFE	180	7,0	22,23	8.500	AS001770	① ② ③ ④ ⑥	■
T27 PROMAX	A36N-BF ALU	BEST LIFE	230	7,0	22,23	6.600	AS001809	① ② ③ ④ ⑥	■

Grinding discs for cast iron – PROMAX

Ordering example: AS001773



Packing unit:
see page 199
T27 = depressed centre
 $v_{max.}$: 80 m/s

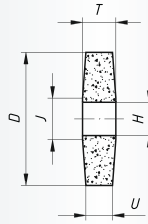
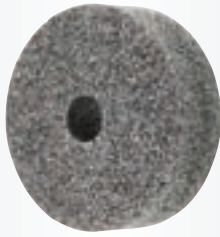


Description	Quality	Variant	Ø D mm	Thickness U mm	Bore H mm	n max. (1/min)	Product-Number	recommended for	
T27 PROMAX	ZA24R-BF	BEST LIFE	180	7,0	22,23	8.500	AS001773	① ② ③ ⑤	■
NEW T27 PROMAX	ZAC24R-BF	BEST LIFE	230	4,8	22,23	6.600	AS000499	⑤	■
T27 PROMAX	ZA24R-BF	BEST LIFE	230	7,0	22,23	6.600	AS001812	① ② ③ ⑤	■



Taper sided, grinding wheel, Shape SE4 (nach ISO 603-12)

Ordering example: A2039080200320001



Packing unit:
10 pcs. per type
max. operating speed
50 m/s = 11.900 1/min

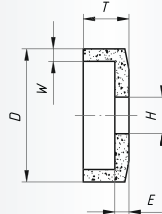
Description	Quality	D mm	T mm	U mm	H mm	J mm	Product-Number	recommended for	
SE4 08020.16	HK 24 M BA. soft	80	20	16	16	25	A2039080200320001	④ ⑤	■
SE4 08020.16	HK 16 P BA. hard	80	20	16	16	25	A2039080200320002	④ ⑤	■
SE4 08020.20	HK 24 M BA. soft	80	20	16	20	25	A2039080200320003	④ ⑤	■
SE4 08020.20	HK 16 P BA. hard	80	20	16	20	25	A2039080200320004	④ ⑤	■

These tools must be used with a flange which complies with the regulations of DIN 69864.



Cup wheels for angle grinders, shape SE 6 (to ISO 603-7)

Ordering example: A204108027027



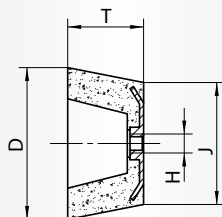
Packing unit:
5 pcs.
max. operating speed
50 m/s = 11.900 1/min

Description	Quality	D mm	T mm	H mm	W mm	E mm	Product-Number	recommended for	
SE6 08027.22	A 24 P BA	80	27	22,2	8	8	A204108027027	② ③ ⑤	■
SE6 08027.22	A 36 P BA	80	27	22,2	8	8	A2041080270270001	② ③ ⑤	■
SE6 08027.22	C 30 N BA	80	27	22,2	8	8	A204108027039	② ③ ④ ⑤ ⑥	■



Cup wheels for angle grinders, shape SE11 with screw thread

Ordering example: A2094110551111



Packing unit:
10 pcs., up to Ø 130 mm 5 pcs.
 v_{max} : 50 m/s

Description	Quality	D mm	J mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
SE11 110055.M14	A 16 Q BA	110	90	55	M14	8.600	A2094110551111	1 3 4 5	■
SE11 110055.M14	A 24 Q BA	110	90	55	M14	8.600	A2094110551211	1 3 4 5	■
SE11 110055.M14	A 36 Q BA	110	90	55	M14	8.600	A2094110551311	1 3 4 5	■
SE11 110055.M14	C 16 N BA	110	90	55	M14	8.600	A2094110551121	5 10 11 12 13	■
SE11 110055.M14	C 24 N BA	110	90	55	M14	8.600	A2094110551221	5 10 11 12 13	■
SE11 110055.M14	C 36 N BA	110	90	55	M14	8.600	A2094110551321	5 10 11 12 13	■
SE11 110055.M14	C 60 N BA	110	90	55	M14	8.600	A2094110551521	5 10 11 12 13	■
SE11 110055.M14	C 80 N BA	110	90	55	M14	8.600	A2094110551621	5 10 11 12 13	■
SE11 110055.M14	C 120 N BA	110	90	55	M14	8.600	A2094110551721	5 10 11 12 13	▲
SE11 130055.M14	A 16 Q BA	130	90	55	M14	7.300	A2094130551111	1 3 4 5	▲
SE11 130055.M14	A 24 Q BA	130	90	55	M14	7.300	A2094130551211	1 3 4 5	▲
SE11 130055.M14	C 16 N BA	130	90	55	M14	7.300	A2094130551121	5 10 11 12 13	■
SE11 130055.M14	C 24 N BA	130	90	55	M14	7.300	A2094130551221	5 10 11 12 13	■
SE11 130055.M14	C 36 N BA	130	90	55	M14	7.300	A2094130551321	5 10 11 12 13	■
SE11 130055.M14	C 60 N BA	130	90	55	M14	7.300	A2094130551521	5 10 11 12 13	▲

This product excels in

- High stock removal
- Long life
- Less vibration
- Low noise
- Aggressive cut

Applications for the A quality, brown aluminium oxide

- Welding seams
- Grinding in corners and edges
- Steel sheets
- Railway tracks
- Descaling
- Trimming of castings
- Thin profiles

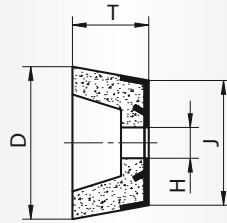
Applications for the C quality, silicon carbide

- Ductile cast iron pipes
- Spherical castings
- Malleable cast iron
- Reinforced concrete
- Roof tiles
- Lime sand brick, artificial stone and dressed stone
- General stone
- Ceramic
- Grey iron castings
- Steel castings
- Marble
- Bottom plates
- Curbstones
- Fair faced brick
- Floating screed



Cup wheels for angle grinders, shape SE11 with steel cover and bore

Ordering example: A209411055511



Packing unit:

10 pcs., up to Ø 130 mm 5 pcs.

v_{max} : 50 m/s

Description	Quality	D mm	J mm	T mm	H mm	n max. (1/min)	Product-Number	recommended for	
SE11 110055.22	A 16 Q BA	110	90	55	22,23	8.600	A2094110555111	1 3 4 5	■
SE11 110055.22	A 24 Q BA	110	90	55	22,23	8.600	A2094110555211	1 3 4 5	■
SE11 110055.22	A 36 Q BA	110	90	55	22,23	8.600	A2094110555311	1 3 4 5	▲
SE11 110055.22	A 60 Q BA	110	90	55	22,23	8.600	A2094110555511	1 3 4 5	▲
SE11 110055.22	C 16 N BA	110	90	55	22,23	8.600	A2094110555121	5 10 11 12 13	■
SE11 110055.22	C 24 N BA	110	90	55	22,23	8.600	A2094110555221	5 10 11 12 13	■
SE11 110055.22	C 60 N BA	110	90	55	22,23	8.600	A2094110555521	5 10 11 12 13	■
SE11 110055.22	C 80 N BA	110	90	55	22,23	8.600	A2094110555621	5 10 11 12 13	▲
SE11 110055.22	C 120 N BA	110	90	55	22,23	8.600	A2094110555721	5 10 11 12 13	■
SE11 130055.22	A 16 Q BA	130	90	55	22,23	7.300	A2094130555111	1 3 4 5	▲
SE11 130055.22	A 24 Q BA	130	90	55	22,23	7.300	A2094130555211	1 3 4 5	■
SE11 130055.22	C 16 N BA	130	90	55	22,23	7.300	A2094130555121	5 10 11 12 13	■
SE11 130055.22	C 24 N BA	130	90	55	22,23	7.300	A2094130555221	5 10 11 12 13	▲

This product excels in

- High stock removal
- Long life
- Less vibration
- Low noise
- Aggressive cut

Applications for the A quality, brown aluminium oxide

- Welding seams
- Grinding in corners and edges
- Steel sheets
- Railway tracks
- Descaling
- Trimming of castings
- Thin profiles

Applications for the C quality, silicon carbide

- Ductile cast iron pipes
- Spherical castings
- Malleable cast iron
- Reinforced concrete
- Roof tiles
- Lime sand brick, artificial stone and dressed stone
- General stone
- Ceramic
- Grey iron castings
- Steel castings
- Marble
- Bottom plates
- Curbstones
- Fair faced brick
- Floating screed

Diamondtools

212 Technical Information

213 Qualities and application

214 Vacuum-Brazed Diamond cutting discs

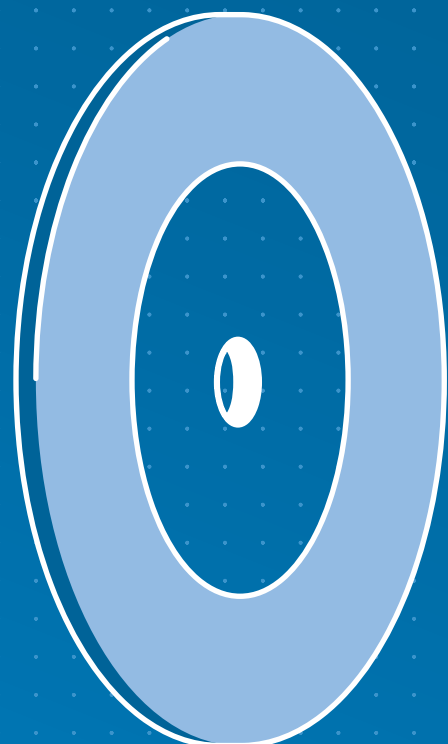
216 Diamond cutting discs

224 Diamond cup wheels



Product line marking

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



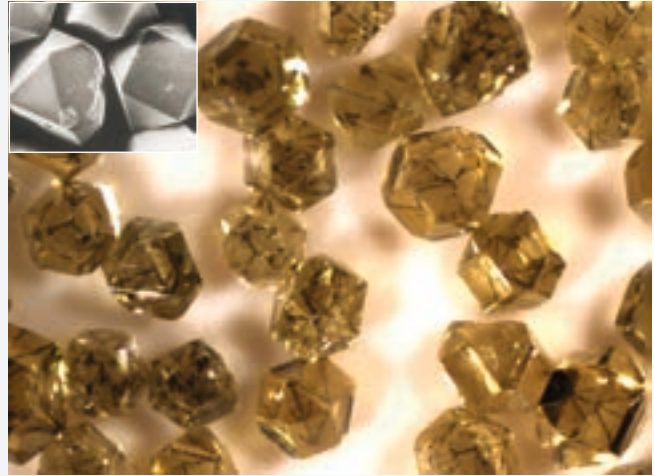
Technical Information

The Diamond

Diamonds are the hardest known material. They are selected depending on the field of application. For diamond blade manufacture synthetic diamonds are solely used. Compared to natural diamonds, their properties are reproducible and controllable. The following quality characteristics are significant for selecting diamonds:

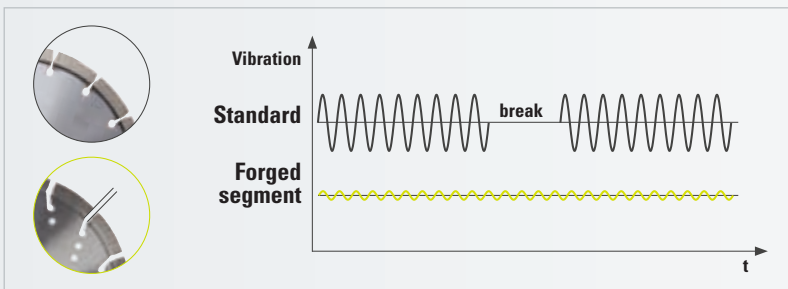
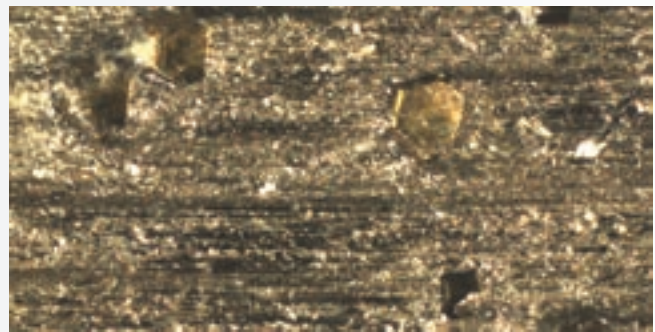
- degree of purity
- defined breaking strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grain sizes.

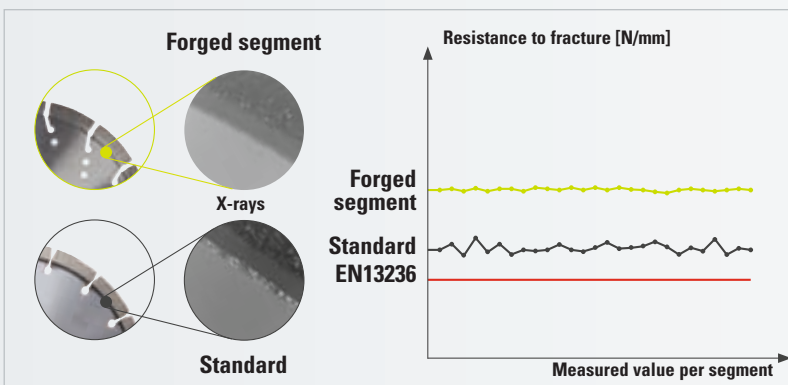


The Segment

The segments consist of diamond embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists, for example, of bronze, cobalt, iron, metal carbides, tungsten carbide. The various properties of metal powder provide for sharpness and wear and tear of the segment. Segment coating is carried out by sintering. Therefore, abrasive materials require a hard bond against what hard materials call for soft bond.



Comparison of cutting properties low vibration cutting discs with narrow gaps



Welding properties of forged segment: with highest safety against fracture

Due to the patented forged segment geometry even high segments can be arranged with small gaps in between. This produces considerably lower vibration for the user. Another essential advantage is safety. The dense segments have been forged without any pores. This ensures welding properties which provide much more safety against fracture compared to the usual sintered segments.

- Universal and fast – owing to new types of alloys in the segments
- Less vibration – owing to a trapezoid segment geometry
- More safety – owing to segment feet which are free of pores and provide for the utmost safety
- Against a fracture of the segment
- Longer life – owing to higher segments and retarded diamond shedding

User instructions

Type	Catalogue page	Tiles			Granite, hard materials			Concrete			Building material				Asphalt, abrasive materials				Grey iron		Segment height
		Tiles	Fine stoneware	Granite tiles	Granite	Porphyry	Clinker bricks	Reinforced concrete	Exposed aggregate concrete	Concrete products	Bricks, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Screed	Fresh concrete	Asphalt	Grey iron		
Diamond cutting discs																					
VDCM	214																				
VDC	215																				
LD MULTI S13	216																				
LD 3 S13	217																				
TURBO HP S12	217																				
ABRASIV S13	223																				
LD7 S13	223																				
LD7 S10	224																				
LD3 S10	218																				
TURBO S10	218																				
BLUE CUT plus S10	219																				
BLUE CUT S10	221																				
BC7	219																				
BG-Laser	220																				
TC7	220																				
Tile cutting discs																					
FAST CUT S7	221																				
FLIESE S7	222																				
FC7	222																				
Diamond cup wheels																					
DST HP S5	224																				
DST S6	225																				
DST S5	225																				

High Performance
High Performance

- extremely quick cut, even through difficult materials
- Very good service life and designed for universal applications, for professional use

Industry
Industry

- quick cut and reliable
- long service life

Base
Base

- price-conscious and good

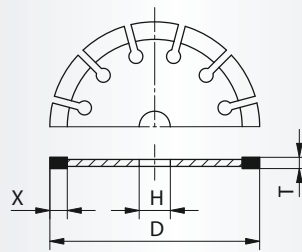
214 Vacuum-Brazed Diamond Cutting Disc



High Performance

VDCM Multi, the exceptional cutting disc for nearly any workpiece

Ordering example: A34911152022



Packing unit:
1 pc.
 v_{max} : 80 m/s

VDC MULTI
Series

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDCM 115020	115	7,0	2,0	22,23	13.300	A34911152022	① 5 8 10 11 12	■
VDCM 125020	125	7,0	2,0	22,23	12.200	A34911252022	① 5 8 10 11 12	■
VDCM 180026	180	7,0	2,6	22,23	8.500	A34911802622	① 5 8 10 11 12	■
VDCM 230030	230	7,0	3,0	22,23	6.600	A34912303022	① 5 8 10 11 12	■

The segment coating made of carbide granulates prevents the disc from getting stuck in soft workpieces. The result is a clean cut.

Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter
- vacuum-brazed
- very aggressive

Ideal for cutting of

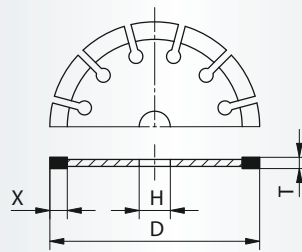
- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GRP)
- Steel
- Bricks
- Reinforced concrete
- Stone, tiles, wood



High Performance

VDC, a revolution in the cutting of grey cast iron

Ordering example: A34901152222



Packing unit:
1 pc.
 v_{max} : 80 m/s



Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
VDC 115022	115	7,0	2,2	22,23	13.300	A34901152222	5	■
VDC 125022	125	7,0	2,2	22,23	12.200	A34901252222	5	■
VDC 180026	180	7,0	2,6	22,23	8.500	A34901802622	5	■
VDC 230030	230	7,0	3,0	22,23	6.600	A34902303022	5	■
VDC 350036	350	7,0	3,6	32,00	4.400	A34903503632	5	■

Special properties:

- Low temperatures
- No dust and build-up of odours
- No expiry date
- No reduction in diameter
- vacuum-brazed
- very aggressive
- extreme tool life

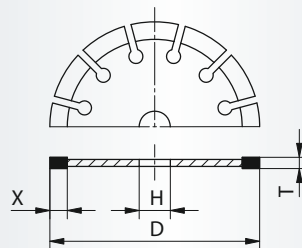
Ideal for cutting of

- Grey cast iron (GG, GGG)
- Glass-fibre reinforced plastic (GFK)
- burning-in

Not suitable for high-alloyed nickel-containing materials.

LD Multi S13, the professional disc for concrete and construction material

Ordering example: A344031151213083



Packing unit:

1 pc.

v_{max} : 80 m/s

Ø 300, 350, 400 mm: 100m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
LD Multi S13	115	13	2,4	22,23	13.300	A344031151213083	10 11 14	■
LD Multi S13	125	13	2,4	22,23	12.200	A344031251213093	10 11 14	■
LD Multi S13	150	13	2,4	22,23	10.200	A344031501213113	10 11 14	■
LD Multi S13	180	13	2,4	22,23	8.500	A344031801213133	10 11 14	■
LD Multi S13	230	13	2,6	22,23	6.600	A344032301213153	10 11 14	■
LD Multi S13	300	13	2,8	25,4	6.400	A344033002213183	10 11 14	▲
LD Multi S13	350	13	3,0	25,4	5.500	A344033502213213	10 11 14	▲
LD Multi S13	400	13	3,2	25,4	4.800	A344034002213243	10 11 14	▲

This diamond cutting disc excels in:

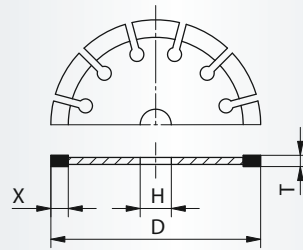
- Most universal properties along with optimum cutting speed
- Long life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

Bonding method: laser welded

Note: Cutting discs with 300 to 400 mm diameter are available on request with 20 mm and 30 mm bore. Please refer to the chart on page 213 for detailed information on applications.

LD3 S13, for top performance in granite, concrete and construction material

Ordering example: A344031151713083



Packing unit:

1 pc.

v_{max} : 80 m/s

Ø 300, 350, 400 mm: 100m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
LD3 S13	115	13	2,4	22,23	13.300	A344031151713083	10 11 14	■
LD3 S13	125	13	2,4	22,23	12.200	A344031251713093	10 11 14	■
LD3 S13	150	13	2,4	22,23	10.200	A344031501713113	10 11 14	▲
LD3 S13	180	13	2,4	22,23	8.500	A344031801713133	10 11 14	▲
LD3 S13	230	13	2,6	22,23	6.600	A344032301713153	10 11 14	■
LD3 S13	300	13	2,8	25,4	6.400	A344033002713183	10 11 14	▲
LD3 S13	350	13	3,0	25,4	5.500	A344033502713213	10 11 14	▲
LD3 S13	400	13	3,2	25,4	4.800	A344034002713243	10 11 14	▲

This diamond cutting disc excels in:

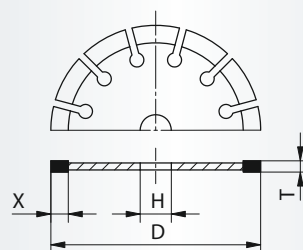
- Most universal properties along with optimum cutting speed
- Long life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

Bonding method: laser welded

Note: Cutting discs with 300 to 400 mm diameter are available on request with 20 mm and 30 mm bore. Please refer to the chart on page 213 for detailed information on applications.

Turbo HP S12, with turbo segments, also suitable for reinforced concrete

Ordering example: A344031151212093



Packing unit:

1 pc.

v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
TURBO HP S12	115	12	2,4	22,23	13.300	A344031151212093	10 11 14	■
TURBO HP S12	125	12	2,4	22,23	12.200	A344031251212103	10 11 14	■
TURBO HP S12	150	12	2,4	22,23	10.200	A344031501212123	10 11 14	▲
TURBO HP S12	180	12	2,6	22,23	8.500	A344031801212143	10 11 14	■
TURBO HP S12	230	12	3,0	22,23	6.600	A344032301212153	10 11 14	■

This diamond cutting disc excels in:

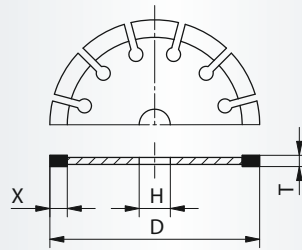
- A wide field of applications
- Long life
- Good cutting speed

Bonding method: laser welded

Please refer to the chart on page 213 for detailed information on applications.

LD3 S10, for a high cutting rate in concrete and construction material

Ordering example: A344131151210083



Packing unit:
1 pc.
 $v_{max.}$: 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
LD3 S10	115	10	2,3	22,23	13.300	A344131151210083	10 11	■
LD3 S10	125	10	2,3	22,23	12.200	A344131251210093	10 11	■
LD3 S10	150	10	2,3	22,23	10.200	A344131501210113	10 11	▲
LD3 S10	180	10	2,3	22,23	8.500	A344131801210143	10 11	■
LD3 S10	230	10	2,3	22,23	6.600	A344132301210163	10 11	■

This diamond cutting disc excels in:

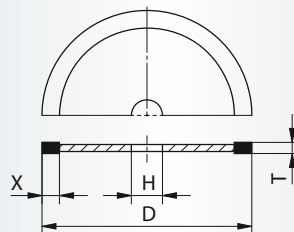
- Universal use in concrete/building material
- Excellent price-performance ratio

Bonding method: laser welded

Please refer to the chart on page 213 for detailed information on applications.

Turbo S 10, the disc for the clear cut in building material or concrete

Ordering example: A344141151110013



Packing unit:
1 pc.
 $v_{max.}$: 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
TURBO S10	115	10	2,2	22,23	13.300	A344141151110013	10 11	■
TURBO S10	125	10	2,2	22,23	12.200	A344141251110013	10 11	■
TURBO S10	150	10	2,2	22,23	10.200	A344141501110013	10 11	▲
TURBO S10	180	10	2,6	22,23	8.500	A344141801110013	10 11	■
TURBO S10	230	10	2,6	22,23	6.600	A344142301110013	10 11	■

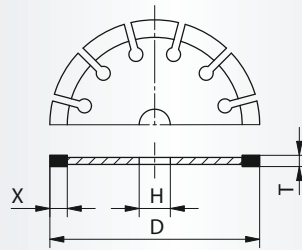
This diamond cutting disc excels in:

- Various applications
- Clear cuts

Please refer to the chart on page 213 for detailed information on applications.

BLUE CUT plus S10, the universal disc for construction sites

Ordering example: A344141151110093



Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
BLUE CUT plus S10	115	10	1,8	22,23	13.300	A344141151110093	10 11	■
BLUE CUT plus S10	125	10	1,8	22,23	12.200	A344141251110093	10 11	■
BLUE CUT plus S10	180	10	2,2	22,23	8.500	A344141801110093	10 11	■
BLUE CUT plus S10	230	10	2,4	22,23	6.600	A344142301110093	10 11	■

This diamond cutting disc excels in:

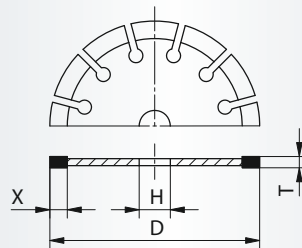
- An optimum price-performance ratio

Please refer to the chart on page 213 for detailed information on applications.



BC7, the cost-effective disc for building and handicraft

Ordering example: A345241151107085



Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
BC7	115	7	2,0	22,23	13.300	A345241151107085	10 11	■
BC7	125	7	2,0	22,23	12.200	A345241251107095	10 11	■
BC7	230	7	2,5	22,23	6.600	A345242301107165	10 11	■

Please refer to the chart on page 213 for detailed information on applications.

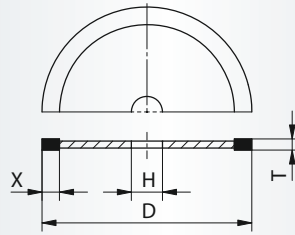
220 Diamond cutting discs

ROTLUFF

Base

TC7, the cost-effective turbo disc for a clean cut

Ordering example: A345241151107775



Packing unit:

1 pc.
v_{max}: 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
TC7	115	7	2,4	22,23	13.300	A345241151107775	⑩ ⑪	■
TC7	125	7	2,6	22,23	12.200	A345241251107775	⑩ ⑪	■
TC7	230	7	3,2	22,23	6.600	A345242301107775	⑩ ⑪	■

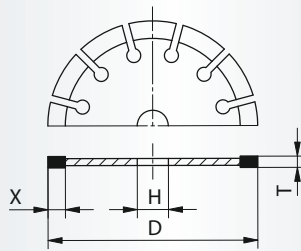
Please refer to the chart on page 213 for detailed information on applications.

ROTLUFF

Base

BG-Laser, the price-conscious disc for granite and concrete

Ordering example: A345231251207105



Packing unit:

1 pc.
v_{max}: 80 m/s

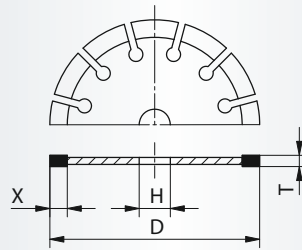
Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
BG-Laser	125	7	2,2	22,23	12.200	A345231251207105	⑩ ⑪ ⑭	■
BG-Laser	230	7	2,5	22,23	6.600	A345232301207165	⑩ ⑪ ⑭	■

Bonding method: laser welded

Please refer to the chart on page 213 for detailed information on applications.

Blue Cut S10, the popular disc for construction sites

Ordering example: A345241001110075



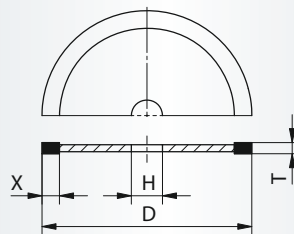
Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
Blue Cut S10	100	10	1,8	16,00	15.300	A345241001110075	10 11	■
Blue Cut S10	115	10	2,0	22,23	13.300	A345241151110085	10 11	■
Blue Cut S10	125	10	2,0	22,23	12.200	A345241251110095	10 11	■
Blue Cut S10	150	10	2,2	22,23	10.200	A345241501110125	10 11	■
Blue Cut S10	180	10	2,4	22,23	8.500	A345241801110145	10 11	■
Blue Cut S10	230	10	2,5	22,23	6.600	A345242301110165	10 11	■

Please refer to the chart on page 213 for detailed information on applications.

FAST CUT S7, the extra thin turbo cutting disc for ceramics and stoneware

Ordering example: A344091151107013



Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
FAST CUT S7	115	7	1,2	22,23	13.300	A344091151107013	12 14	■
FAST CUT S7	125	7	1,2	22,23	12.200	A344091251107013	12 14	■
FAST CUT S7	150	7	1,2	22,23	10.200	A344091501107013	12 14	▲
FAST CUT S7	180	7	1,6	22,23	8.500	A344091801107013	12 14	▲
FAST CUT S7	230	7	1,6	22,23	6.600	A344092301107013	12 14	■

This diamond cutting disc excels in:

- An extra-thin segment coating and a reinforced flange area
- Fast and clear cuts through the hardest tiles

Please refer to the chart on page 213 for detailed information on applications.

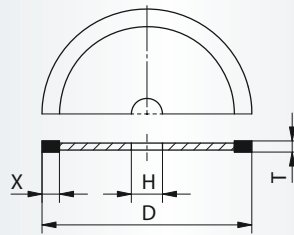
222 Diamond cutting discs

ROTLUFF

Industry

FLIESE S7, the popular cutting disc for tiles and ceramics

Ordering example: A34411151107013



Packing unit:

1 pc.

v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
FLIESE S7	115	7	1,5	22,23	13.300	A34411151107013	12	■
FLIESE S7	125	7	1,5	22,23	12.200	A344111251107013	12	■
FLIESE S7	150	7	1,5	22,23	10.200	A344111501107013	12	▲
FLIESE S7	180	7	1,6	22,23	8.500	A344111801107013	12	■
FLIESE S7	230	7	1,65	22,23	6.600	A344112301107013	12	■

This diamond cutting disc excels in:

- Clean cuts into glazed ceramics

Please refer to the chart on page 213 for detailed information on applications.

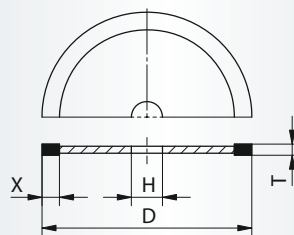


ROTLUFF

Base

FC7, the cost-effective tile cutting disc

Ordering example: A34521151107015



Packing unit:

1 pc.

v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
FC7	115	7	1,8	22,23	13.300	A34521151107015	12	■
FC7	125	7	2,0	22,23	12.200	A345211251107015	12	■
FC7	230	7	2,5	22,23	6.600	A345212301107015	12	■

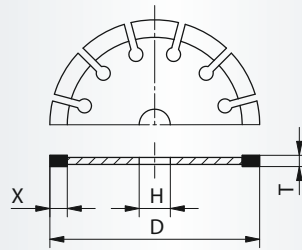
This diamond cutting disc excels in:

- An optimum price-performance ratio

Please refer to the chart on page 213 for detailed information on applications.

ABRASIV S13, the professional disc for fresh concrete and much more

Ordering example: A344053002213203



Packing unit:

1 pc.
 v_{max} : 80 m/s
 Ø 300, 350, 400 mm: 100m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
ABRASIV S13	115	13	2,4	22,23	13.300	A344051151213083	10 11 15 16	■
ABRASIV S13	125	13	2,4	22,23	12.200	A344051251213093	10 11 15 16	■
ABRASIV S13	180	13	2,4	22,23	8.500	A344051801213133	10 11 15 16	▲
ABRASIV S13	230	13	2,6	22,23	6.600	A344052301213163	10 11 15 16	■
ABRASIV S13	300	13	2,8	25,4	6.400	A344053002213203	10 11 15 16	▲
ABRASIV S13	350	13	3,0	25,4	5.500	A344053502213243	10 11 15 16	▲
ABRASIV S13	400	13	3,2	25,4	4.800	A344054002213283	10 11 15 16	▲
ABRASIV S13	450	13	3,6	25,4	3.400	A344054502213253	10 11 15 16	▲
ABRASIV S13	500	13	3,6	25,4	3.100	A344055002213303	10 11 15 16	▲

This diamond cutting disc excels in:

- Very universal properties along with optimum life
- Extreme running smoothness
- Low vibration due to trapezoid segment geometry
- The production process for the segments in forging technology has been covered by patents

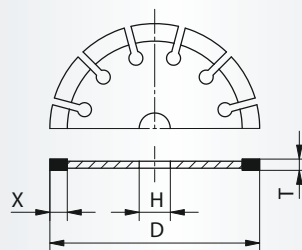
Bonding method: laser welded

Note: Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

Please refer to the chart on page 213 for detailed information on applications.

LD7 S13, for top performance in asphalt

Ordering example: A344073002213183



Packing unit:

1 pc.
 v_{max} : 80 m/s
 Ø 300, 350, 400 mm: 100m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
LD7 S13	300	10	2,8	25,4	6.400	A344073002213183	15 16	■
LD7 S13	350	10	3,0	25,4	5.400	A344073502213213	15 16	■
LD7 S13	400	10	3,2	25,4	4.700	A344074002213243	15 16	■
LD7 S13	450	10	3,6	25,4	3.400	A344074502213253	15 16	▲
LD7 S13	500	10	3,6	25,4	3.100	A344075002213303	15 16	▲

This diamond cutting disc excels in:

- forging technology
- laser welded

Please refer to the chart on page 213 for detailed information on applications.

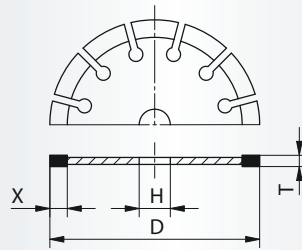
224 Diamond cutting discs/Diamond cup wheels

ROTLUFF

Industry

LD7 S10 for a perfect cutting of asphalt

Ordering example: A344173002210183



Packing unit:

1 pc.

v_{max} : 80 m/s

Description	D mm	Height of segments X mm	Width of segments T mm	H mm	n max. (1/min)	Product-Number	recommended for	
LD7 S10	300	10	3,2	25,4	5.100	A344173002210183	15 16	▲
LD7 S10	350	10	3,2	25,4	4.400	A344173502210213	15 16	■
LD7 S10	400	10	3,5	25,4	3.800	A344174002210243	15 16	■
LD7 S10	450	10	4,0	25,4	3.400	A344174502210283	15 16	▲
LD7 S10	500	10	4,0	25,4	3.100	A344175002210303	15 16	▲

This diamond cutting disc excels in:

- Especially shaped segments providing extreme running smoothness and core protection

Bonding method: laser welded

Note: Cutting discs with 300 to 400 mm diameter are available on request with 20 mm bore.

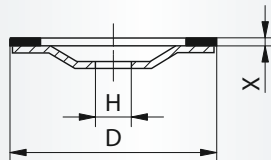
Please refer to the chart on page 213 for detailed information on applications.

ROTLUFF

High Performance

DST HP S5 to meet the highest expectations for stock removal and smooth running

Ordering example: A344331001505083



Packing unit:

1 pc.

v_{max} : 80 m/s

Description	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
DST HP S5	100	5	22,23	15.300	A344331001505083	10 11 14	▲
DST HP S5	125	5	22,23	12.200	A344331251505083	10 11 14	■
DST HP S5	180	5	22,23	8.500	A344331801505123	10 11 14	▲

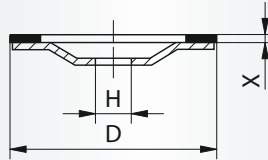
This diamond cup wheel excels in:

- High performance segments for maximum stock removal
- Universal segment alloy for concrete/granite
- Low vibration during working due to inductive welded segments (no imbalance in tool)
- Optimum suction at segment

Please refer to the chart on page 213 for detailed information on applications.

DST S6, the cup wheel for universal application

Ordering example: A344431251606183



Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
DST S6	125	6	22,23	12.200	A344431251606183	10 11	■
DST S6	180	6	22,23	8.500	A344431801606183	10 11	▲

This diamond cup wheel excels in:

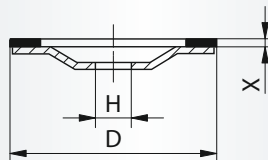
- Excellent price-performance ratio
- Optimum arrangement of segments for high grinding performance and clean surface

Please refer to the chart on page 213 for detailed information on applications.



DST S5, the cost-effective cup wheel for numerous application

Ordering example: A345531151607185



Packing unit:
1 pc.
 v_{max} : 80 m/s

Description	D mm	Height of segments X mm	H mm	n max. (1/min)	Product-Number	recommended for	
DST S5	115	5	22,23	13.300	A345531151607185	10 11	■
DST S5	125	5	22,23	12.200	A345531251607185	10 11	■

Please refer to the chart on page 213 for detailed information on applications.

Material classification

1	STEELS AND CAST STEELS Rm up to 800 N/mm ²	5	CAST IRON
	<ul style="list-style-type: none"> • common structural steels • free cutting steels • case hardened steels • fine grained structural steels • extruded steels • toughened structural steels • boiler plate • nitrided steels • cast steels • heat treated steels • heat resistant structural steels 	6	ALUMINIUM, MAGNESIUM AND COPPER ALLOYS
			<ul style="list-style-type: none"> • over 300 HB • 200-300 HB • up to 200 HB • over 15% Si • 10-15% Si • 0,5-10% Si • below 0,5% Si
2	ALLOYED, TEMPERED STEELS Rm 800 up to 1200 N/mm ²	7	TITANIUM AND NICKEL ALLOYS
	<ul style="list-style-type: none"> • case hardened steels • spring steels • fine grained structural steels • nitrided steels • heat treated steels • wear resistant steels • bearing steels 		<ul style="list-style-type: none"> • Rm 900 up to 1500 N/mm² • Rm up to 900 N/mm²
3	TOOL STEELS Rm up to 1300 N/mm ²	8	PLASTICS, WOOD, RUBBER
	<ul style="list-style-type: none"> • 60 - 65 HRC • high-speed steels • non-alloyed tool steels • cold working tool steels • hot working tool steels 	9	GLASS / CARBIDES
4	RUST, ACID AND HEAT RESISTANT STEELS AND CAST STEELS	10	STONE / TILES / GAS CEMENT
	<ul style="list-style-type: none"> • austenitic • ferritic • ferritic-austenitic • heat-resistant • martensitic • stainless, sulphurized 	11	CONCRETE / REINFORCED CONCRETE
		12	CERAMIC / FLOOR TILES
		13	MARBLE
		14	GRANITE
		15	FRESHLY POURED CONCRETE
		16	ASPHALT

- best suitable
- suitable
- delivery ex-stock
- ▲ delivery on request

Safety Symbols

(Depending on the product these symbols may vary)



Wear eye protection



Wear hearing protection



Wear a respirator



Read the instructions



Wear gloves



Only permitted with a back-up pad



Not permitted for wet grinding



Not permitted for face grinding



Do not use if damaged



Not permitted for hand-held or manually-guided grinding