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General

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Filing Discs and Filing Rings

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Types of cut and their application

Z1

Aluminium alloys,
plastics
v=38 – 150 m/min
Wood
v=150 – 300 m/min

Z2

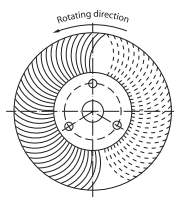
Aluminium alloys,
plastics
v=38 – 150 m/min
Bronze, brass
v=150 – 300 m/min

Z3

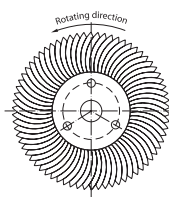
Steel up to 450 N/mm²
v=38 – 75 m/min
Cast and malleable iron
v=38 – 150 m/min

Number of teeth

Disc-Ø	Z1 cut coarse		Z2 cut medium		Z3 cut fine	
	Disc	Ring	Disc	Ring	Disc	Ring
160	120	160	160	200	200	240
210	160	200	200	240	240	280
260	200	240	240	280	280	320
310	240	280	280	320	320	360



Cut design 1
Right-hand cutting,
usable both sides



Cut design 4
One-sided cutting with
teeth on periphery

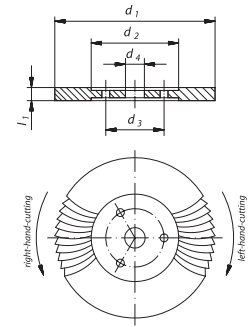
Recommended speeds

Material	Approx. RPM
Cast iron	75/150
Steel up to 450 N/mm ²	75
Aluminium alloys	75/150
Bronze, brass	300
Plastics	75/150
Wood	300

56 Filing Discs and Rings, Special production

Filing discs

Made of alloyed tool steel (WS) for all machinable materials with tensile strength up to approx. 450 N/mm². Particularly suitable for the machining of aluminium and non-ferrous metals. Filing discs in cut design 1 can be used on both sides. For the severest conditions, filing discs in HSS are also available on request.

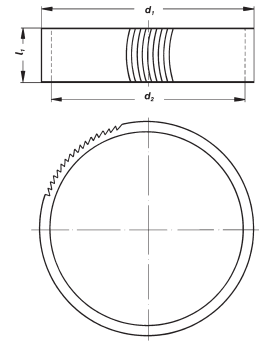


Description	d ₁ mm	d ₂ mm	d ₃ mm	d ₄ mm	l ₁ mm	Number of bores	cut		
							1	2	3
F 16-R-1	160	80	60	15	7	3	○	○	○
F 16-R-4	160	80	60	15	7	3	○	○	○
F 21-R-1	210	80	60	15	8	3	○	○	○
F 21-R-4	210	80	60	15	8	3	○	○	○
F 26-R-1	260	110	90	20	9	6	○	○	○
F 26-R-4	260	110	90	20	9	6	○	○	○
F 31-R-1	310	125	90	20	10	6	○	○	○
F 31-R-4	310	125	90	20	10	6	○	○	○

Packing unit: 1 pc. per type

Ordering example: F 16-R-1 Z3

If left-hand-cutting is desired for cut design 1 and cut design 4 please replace R by L in the Lukas-No.



Filing rings

Filing rings of WS are seamless forged. If correctly used, they will not crack even under the most severe conditions. Application – similar to filing discs. Not available in high speed steel.

Description	d ₁ mm	l ₁ mm	d ₂ mm				cut		
							1	2	3
FR 16	160	40	145				○	○	○
FR 21	210	40	195				○	○	○
FR 26	260	40	245				○	○	○
FR 31	310	40	295				○	○	○

Packing unit: 1 pc. per type

Ordering example: FR 16 Z3