

- 5.1 Cutting discs
- 5.2 Diamond cutting discs

# CUTTING

244–259  
260–267

TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS cutting discs

## SHELF LIFE

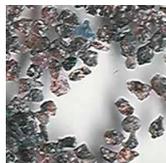
Resin-bonded cutting discs for handheld use may only be used for up to three years after the manufacture date. The expiry date (month and year) is stamped on the metal ring, e.g. V07/2022.



## LABELLING SYSTEM FOR RESIN-BONDED CUTTING DISCS

All of the important information about your LUKAS cutting disc is stated on the label: abrasive material, grit size, hardness and type of bond.

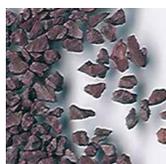
The following overview provides all the information concerning the abbreviations and markings.



**A**  
Semi-friable aluminium oxide



**Z**  
Zirconia alumina



**A**  
Ceramic-coated annealed aluminium oxide



**CER**  
Ceramic grain



**C**  
Silicon carbide

## ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

Abrasive	
A	Aluminium oxide
C	Silicon carbide
Z	Zirconia alumina
CER	Ceramic grain

## GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

coarse	medium	fine
12 to 24	36 to 54	60 to 120

## HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

soft	medium	hard
M	R	U
P	S	V
Q	T	Z

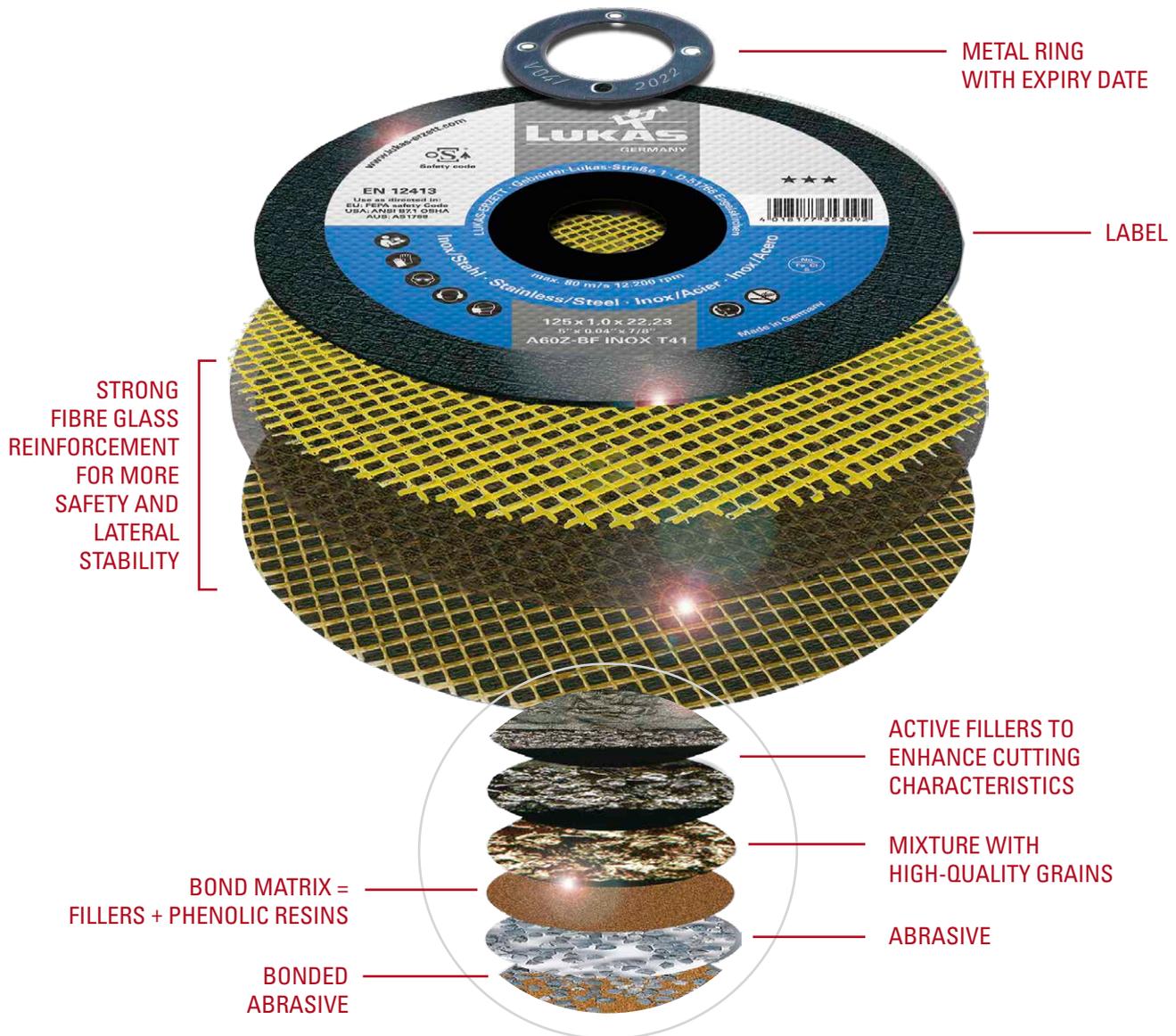
## BOND

The bond is to hold the abrasive grain in the disc. LUKAS cutting discs are available with the following two types of bond:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

## TECHNICAL INFORMATION

# Construction and components of LUKAS cutting discs



## OPERATING SPEED

LUKAS cutting discs are developed and tested for specified maximum operating speeds and grinding processes. Before attaching the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the cutting disc.

Maximum operating speed	Cutting disc diameter (mm)										
	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
	rpm										

## WORK SAFETY

# Safe cutting with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

## APPLIED STANDARDS

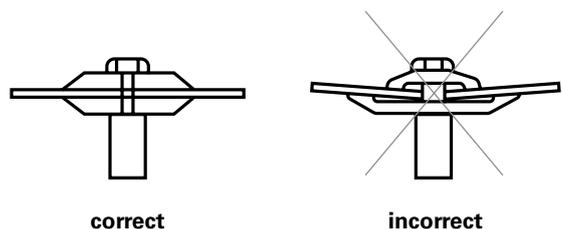
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

## SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced cutting discs on power tools.
- Store discs **in a dry place at room temperature.**
- Do not **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Use only discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Do not apply lateral pressure **to cutting discs.** Avoid bending the disc.
- Do not press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Do not cant and seize** the disc **when** cutting.
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Do not drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage.
- Do only use the machine only in a position where you have full control and are well balanced.

## CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).

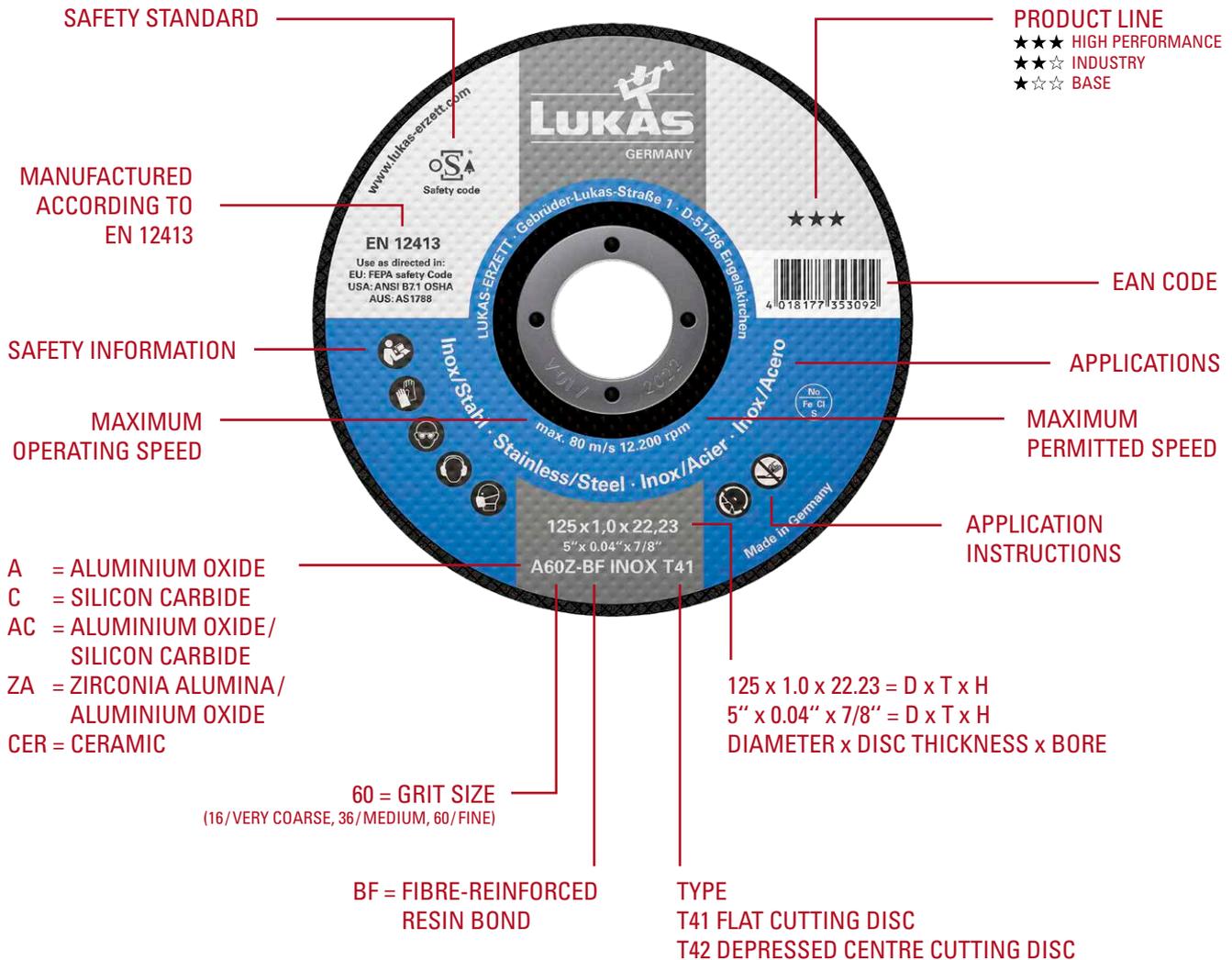


correct

incorrect

## LABELLING

## All important markings on the label

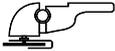
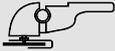


## TYPES OF RESIN-BONDED CUTTING DISCS

T41 Flat cutting discs	T42 Depressed centre cutting disc
<p>Cutting discs            T = (0.8 mm–4.5 mm)            (USA: Type 1)</p>	<p>Cutting discs            T = (0.8 mm–4.5 mm)            (USA: Type 27)</p>
<ul style="list-style-type: none"> <li>Available in diameters from 50 mm (2") to 230 mm (9"), for handheld use</li> <li>From 300 mm (12") to 500 mm (20") for stationary machines</li> </ul>	<ul style="list-style-type: none"> <li>Available in diameters from 76 mm (3") to 230 mm (9"), approved for handheld use</li> </ul>

## AREA OF USE

## Overview of types of LUKAS cutting discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast metal/ Construction material
<b>Handheld cutting discs for angle grinders</b> Diameter 100–230 mm 	★★★	 Pages 249 – 251	 Page 255		 Pages 263 and 266	 Page 262
	★★☆	 Page 252	 Page 255	 Page 256	 Pages 263, 265 and 266	
	★☆☆	 Pages 254 and 259	 Page 256		 Pages 257, 265 and 267	
<b>Handheld cutting discs with X-LOCK system for angle grinders</b> Diameter 115–125 mm 	★★☆	 Page 253			 Pages 264 and 267	
<b>Stationary cutting discs</b> Diameter Larger than 230 mm  	★★★				 Page 263	 Page 262
	★★☆				 Pages 263–264 and 266	
	★☆☆	 Page 258	 Pages 258 / 259			



## MAXIMUM PERFORMANCE AND COOL CUTTING

EXTREMELY DURABLE FOR CUTTING STAINLESS STEEL

LUKAS cutting discs with ceramic grain are perfectly suited for high performance steel cutting. Thanks to the fast but cool cutting, they can machine inox without any blue discolouration whatsoever and have an exceptional tool life due to the self-sharpening effect. In addition, this tool requires little force to be applied.

### EXTREME TOOL LIFE DUE TO SELF-SHARPENING EFFECT

The high performance cutting discs contain ceramic grit that constantly releases extremely fine particles in use. When the particles break off due to wear, new, sharp abrasive particles are immediately exposed. This self-sharpening effect allows

the highly-versatile cutting discs to achieve an excellent cutting performance consistently over the tool service life with little force required and boast impressive durability. This reduces the frequency of tool replacement significantly – lowering tool costs.

### FASTER CUTS WITH HIGHER EFFICIENCY

The ceramic grain allows hard materials, such as hardened surfaces, wear-resistant steels, scale and hardened coatings, titanium alloys and reinforced weld seams, to be cut easily and quickly.

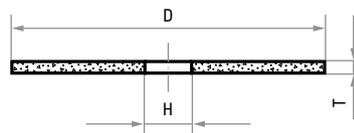


## Ceramic cutting disc **NEW**



★★★

- extremely long tool life
- energy optimised for the highest performance angle grinders
- maximum cutting performance
- little force required
- cool cutting



Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT008310V9802	T41 115x1.0	CER 46U-BF Inox	115	1.0	22.23	13,300	25
AT008312V9802	T41 125x1.0	CER 46U-BF Inox	125	1.0	22.23	12,200	25
AT008320V9802	T41 230x2.0	CER 46U-BF Inox	230	2.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium

# LUKAS CUTTING DISCS IN 3-STAR QUALITY

TOP PERFORMANCE FOR THE TOUGHEST JOBS



Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS cutting discs achieve the ultimate results.

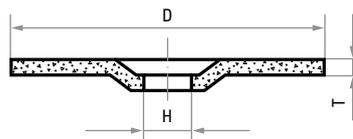
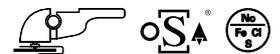
The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star cutting discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety.

Eco-friendly production combined with first-class raw materials, optimised formulas and state-of-the-art production processes provide for high quality and a maximum storage time.

- maximum tool life and cutting performance with innovative bonding technology
- high cutting speed at a cool cutting temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in to quality thanks to top quality raw materials
- energy optimised for your high-performance angle grinders
- environmentally friendly production using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of inox and steel materials
- precise cutting

CUTTING

## COOL JOBBER - cutting and grinding disc for stainless steel



- for cutting and grinding with one tool
- carry out two work steps without changing tools
- practical, precise and safe

★★★

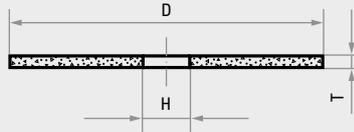
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS015675V9802	T27 115x2.0	A36V-BF Inox COOL JOBBER	115	2.0	22.23	13,300	25
AS015676V9802	T27 125x2.0	A36V-BF Inox COOL JOBBER	125	2.0	22.23	12,200	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium



## Cutting disc for stainless steel

- iron-, chloride- and sulphur-free tool
- cuts precisely at a high cutting speed and low cutting temperature
- maximum tool life and cutting performance through innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



★★★

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007231V9802	T41 115x1.0	A60Z-BF Inox		115	1.0	22.23	13,300	50
AT007235V9802	T41 115x1.6	A46Z-BF Inox		115	1.6	22.23	13,300	50
AT007211V9802	T41 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT007233V9802	T41 125x1.0	A60Z-BF Inox		125	1.0	22.23	12,200	50
AT007237V9802	T41 125x1.6	A46Z-BF Inox		125	1.6	22.23	12,200	50
AT007213V9802	T41 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007239V9802	T41 150x1.2	A60Z-BF Inox		150	1.2	22.23	10,200	50
AT007241V9802	T41 150x1.6	A46Z-BF Inox		150	1.6	22.23	10,200	25
AT007243V9802	T41 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007245V9802	T41 230x2.0	A46Z-BF Inox		230	2.0	22.23	6,600	25
AT007219V9802	T41 230x2.5	A30Z-BF Inox	230	2.5	22.23	6,600	25	
AT005301V9802	T42 115x0.8	A60Z-BF Inox		115	0.8	22.23	13,300	50
AT007212V9802	T42 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT005302V9802	T42 125x0.8	A60Z-BF Inox		125	0.8	22.23	12,200	50
AT007214V9802	T42 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007244V9802	T42 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007246V9802	T42 230x1.9	A46Z-BF Inox		230	1.9	22.23	6,600	25
AT007220V9802	T42 230x2.5	A30Z-BF Inox		230	2.5	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

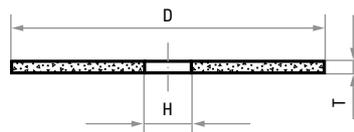
CUTTING



## Cutting disc set

The handy choice, e.g. for the construction site

- cutting discs in a metal can
- safely packed
- moisture-proof

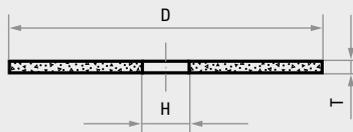


★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007231V9807010	T41 115x1.0	A60Z-BF Inox	115	1.0	22.23	13,300	10
AT007233V9807010	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

## Cutting disc for stainless steel



- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

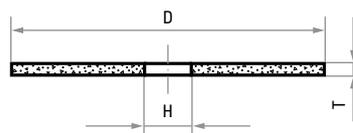
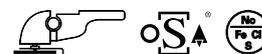
★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005841V9802	T41 115x1.0	A60X-BF Inox		115	1.0	22.23	13,300	50
AT003346V9802	T41 115x1.6	A46X-BF Inox		115	1.6	22.23	13,300	50
AT001657V9802	T41 115x2.0	A36U-BF Inox		115	2.0	22.23	13,300	25
AT005842V9802	T41 125x1.0	A60X-BF Inox		125	1.0	22.23	12,200	50
AT003348V9802	T41 125x1.6	A46X-BF Inox		125	1.6	22.23	12,200	50
AT001687V9802	T41 125x2.0	A36U-BF Inox		125	2.0	22.23	12,200	25
AT003327V9802	T41 150x1.6	A46X-BF Inox		150	1.6	22.23	10,200	25
AT001743V9802	T41 180x2.0	A36U-BF Inox		180	2.0	22.23	8,500	25
AT005864V9802	T41 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT001782V9802	T41 230x2.0	A36U-BF Inox		230	2.0	22.23	6,600	25
AT001696V9802	T42 125x2.5	A30U-BF Inox		125	2.5	22.23	12,200	25
AT005571V9802	T42 180x1.6	A46X-BF Inox		180	1.6	22.23	8,500	25
AT005877V9802	T42 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT004464V9802	T42 230x3.0	A30U-BF Inox		230	3.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

CUTTING

## Cutting disc set



- The handy choice, e.g. for the construction site
- cutting discs in a metal can
  - safely packed
  - moisture-proof

★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005841V9807010	T41 115x1.0	A60X-BF Inox	115	1.0	22.23	13,300	10
AT005842V9807010	T41 125x1.0	A60X-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Photo: Bosch

## TOOL CHANGE WITH JUST A CLICK

CHANGING CUTTING DISCS IS FASTER AND SIMPLER THAN EVER

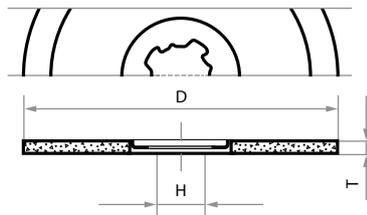
With the new X-LOCK system, simply position the LUKAS cutting disc on the angle grinder's mounting fixture, allow it to engage and you're done. The click sound tells you the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

### TOOL CHANGE IN NO TIME AT ALL

The X-LOCK allows you to change LUKAS cutting discs in seconds, as well as other LUKAS tool products such as the mounted flap discs found on **pages 144 and 154**.



- faster and simpler tool changes thanks to the latest X-LOCK system
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



### X-LOCK cutting disc **NEW**

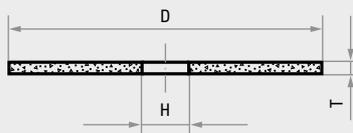


★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT115010V980201	T41 115x1.0x22.23 X-LOCK	A46U-BF Inox	115	1.0	22.23	13,300	50
AT125010V980202	T41 125x1.0x22.23 X-LOCK	A46U-BF Inox	125	1.0	22.23	12,200	50

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

## Cutting disc for stainless steel



- free of iron, chlorine and sulphur
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

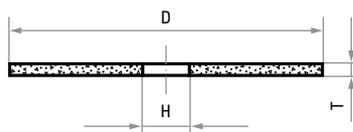
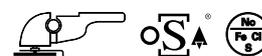
☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT003108V9802	T41 100x1.0	A60S-BF Inox		100	1.0	16.00	15,300	50
AT004643V9802	T41 115x1.0	A60S-BF Inox		115	1.0	22.23	13,300	50
AT000647V9802	T41 115x1.6	A46T-BF Inox		115	1.6	22.23	13,300	50
AT002672V9802	T41 125x1.0	A60S-BF Inox		125	1.0	22.23	12,200	50
AT000674V9802	T41 125x1.6	A46T-BF Inox		125	1.6	22.23	12,200	50
AT000700V9802	T41 150x1.6	A46T-BF Inox		150	1.6	22.23	10,200	25
AT000716V9802	T41 180x1.6	A46T-BF Inox		180	1.6	22.23	8,500	25
AT000742V9802	T41 230x1.9	A46T-BF Inox		230	1.9	22.23	6,600	25
AT003568V9802	T41 230x3.0	A24/30S-BF Inox		230	3.0	22.23	6,600	25
AT001442V9802	T42 115x2.5	A24/30S-BF Inox			115	2.5	22.23	13,300
AT004157V9802	T42 125x2.5	A24/30S-BF Inox	125		2.5	22.23	12,200	25
AT000718V9802	T42 180x1.6	A46T-BF Inox	180		1.6	22.23	8,500	25
AT000744V9802	T42 230x1.9	A46T-BF Inox	230		1.9	22.23	6,600	25
AT005451V9802	T42 230x2.5	A24/30S-BF Inox	230		2.5	22.23	6,600	25
AT004168V9802	T42 230x3.0	A24/30S-BF Inox	230		3.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium

CUTTING

## Cutting disc set



- The handy choice, e.g. for the construction site
- cutting discs in a metal can
  - safely packed
  - moisture-proof

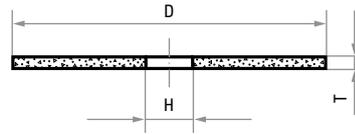
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Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT004643V9807010	T41 115x1.0	A60S-BF Inox	115	1.0	22.23	13,300	10
AT002672V9807010	T41 125x1.0	A60S-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium



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- maximum tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



## Cutting disc for machining steel



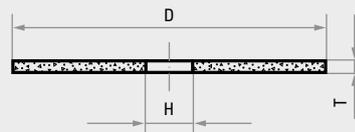
★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007276V9802	T41 115x1.0	A60Z-BF Steel	115	1.0	22.23	13,300	50
AT007271V9802	T41 115x1.6	A46Z-BF Steel	115	1.6	22.23	13,300	50
AT007278V9802	T41 125x1.0	A60Z-BF Steel	125	1.0	22.23	12,200	50
AT007273V9802	T41 125x1.6	A46Z-BF Steel	125	1.6	22.23	12,200	50
AT007284V9802	T41 230x1.9	A46Z-BF Steel	230	1.9	22.23	6,600	25

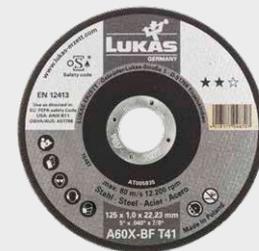
Recommended for: ● Steel ● Cast material



- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



## Cutting disc for steel

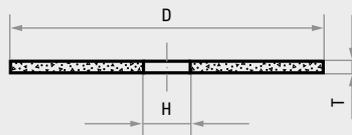


★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005840V9802	T41 115x1.0	A60X-BF Steel		115	1.0	22.23	13,300	50
AT013301V9802	T41 115x1.6	A46X-BF Steel		115	1.6	22.23	13,300	50
AT001656V9802	T41 115x2.0	A36U-BF Steel		115	2.0	22.23	13,300	25
AT005835V9802	T41 125x1.0	A60X-BF Steel		125	1.0	22.23	12,200	50
AT013302V9802	T41 125x1.6	A46X-BF Steel		125	1.6	22.23	12,200	50
AT001686V9802	T41 125x2.0	A36U-BF Steel		125	2.0	22.23	12,200	25
AT011086V9802	T41 125x2.5	A30X-BF Steel		125	2.5	22.23	12,200	25
AT013303V9802	T41 150x1.6	A46X-BF Steel		150	1.6	22.23	10,200	25
AT013305V9802	T41 180x1.6	A46X-BF Steel		180	1.6	22.23	8,500	25
AT001742V9802	T41 180x2.0	A36U-BF Steel		180	2.0	22.23	8,500	25
AT005867V9802	T41 230x1.9	A46X-BF Steel	230	1.9	22.23	6,600	25	
AT001781V9802	T41 230x2.0	A36U-BF Steel	230	2.0	22.23	6,600	25	
AT001785V9802	T41 230x3.0	A30U-BF Steel	230	3.0	22.23	6,600	25	
AT001665V9802	T42 115x2.5	A30U-BF Steel		115	2.5	22.23	13,300	25
AT001695V9802	T42 125x2.5	A30U-BF Steel		125	2.5	22.23	12,200	25
AT001724V9802	T42 150x2.5	A30U-BF Steel		150	2.5	22.23	10,200	25
AT001750V9802	T42 180x3.0	A30U-BF Steel		180	3.0	22.23	8,500	25
AT001790V9802	T42 230x2.5	A30U-BF Steel		230	2.5	22.23	6,600	25

Recommended for: ● Steel ● Cast material

## Cutting disc for steel



- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

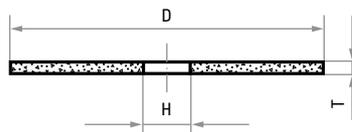
☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT006440V9802	T41 115x1.0	A60S-BF Steel		115	1.0	22.23	13,300	50
AT000648V9802	T41 115x1.6	A46T-BF Steel		115	1.6	22.23	13,300	50
AT000656V9802	T41 115x2.5	A24R-BF Steel		115	2.5	22.23	13,300	25
AT006710V9802	T41 125x1.0	A60S-BF Steel		125	1.0	22.23	12,200	50
AT000675V9802	T41 125x1.6	A46T-BF Steel		125	1.6	22.23	12,200	50
AT000679V9802	T41 125x2.5	A24R-BF Steel		125	2.5	22.23	12,200	25
AT000707V9802	T41 150x2.5	A24R-BF Steel		150	2.5	22.23	10,200	25
AT000717V9802	T41 180x1.6	A46T-BF Steel		180	1.6	22.23	8,500	25
AT000728V9802	T41 180x3.0	A24R-BF Steel		180	3.0	22.23	8,500	25
AT000743V9802	T41 230x1.9	A46T-BF Steel		230	1.9	22.23	6,600	25
AT000967V9802	T41 230x2.0	A36T-BF Steel		230	2.0	22.23	6,600	25
AT000750V9802	T41 230x3.0	A24R-BF Steel		230	3.0	22.23	6,600	25
AT000662V9802	T42 115x2.5	A24R-BF Steel			115	2.5	22.23	13,300
AT000688V9802	T42 125x2.5	A24R-BF Steel	125		2.5	22.23	12,200	25
AT000732V9802	T42 180x3.0	A24R-BF Steel	180		3.0	22.23	8,500	25
AT000745V9802	T42 230x1.9	A46T-BF Steel	230		1.9	22.23	6,600	25
AT000754V9802	T42 230x3.0	A24R-BF Steel	230		3.0	22.23	6,600	25

Recommended for: ● Steel ● Cast material

CUTTING

## NEW Cutting disc for machining non-ferrous metals



- easily cuts soft, light metals
- no smearing when used on aluminium
- ideal combination of abrasive grit and bonding agent

☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT000920V9802	T41 115x1.0	A60N-BF Alu	115	1.0	22.23	13,300	50
AT000950V9802	T41 125x1.0	A60N-BF Alu	125	1.0	22.23	12,200	50
AT001694V9802	T41 125x2.5	A36N-BF Alu	125	2.5	22.23	12,200	25
AT001789V9802	T41 230x2.5	A36N-BF Alu	230	2.5	22.23	6,600	25

Recommended for: ● Aluminium

# THE DISC FOR UNIVERSAL USE

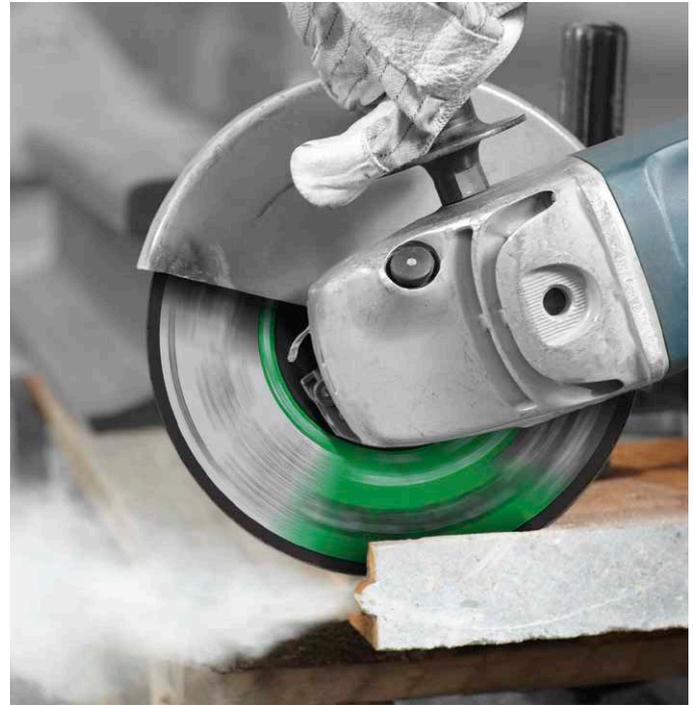
EFFICIENTLY CUT CONCRETE, STONE OR CAST MATERIAL

## FLEXIBLE, FAST WORKING

Especially in structural and civil engineering, for new buildings or structural alterations on existing ones and in road construction, tools are required that allow flexible machining of a broad range of building materials. Regardless of whether you are working with brickwork, cast pipes or concrete supports – LUKAS cutting discs for stone, concrete and cast material cut reliably and quickly. They are the perfect alternative for tradespeople who do not regularly use diamond cutting discs.

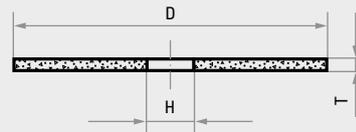
## BROAD RANGE OF APPLICATIONS

This disc is also used for fettling in many foundries and fettling shop, where they come into their own thanks to their high silicon carbide content. As a result, cast parts with inclusions and defects in the surface can be machined quickly and reliably. Risers and sprues can easily be cut off.



## Cutting disc for stone and cast material NEW

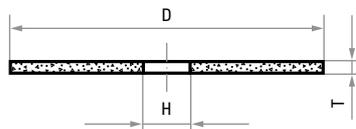
- for universal use
- for use on construction sites
- preferable to diamond cutting discs thanks to its excellent value for money and high speed



Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT115025V980201	T41 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980201	T41 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT180030V980201	T41 180x3.0	C24S-BF Stone		180	3.0	22.23	8,500	25
AT230030V980201	T41 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT115025V980202	T42 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980202	T42 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT230030V980202	T42 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT230030V980203	T42 230x3.0	C24R-BF Stone		230	3.0	22.23	6,600	25

Recommended for: ● Stone ● Cast material

## Stationary cutting disc for machining stainless steel



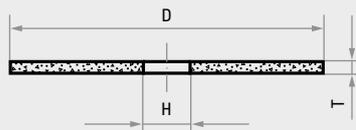
- free of iron, chlorine and sulphur
- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT010003	T41 300x3.5	A30S-BF Inox	300	3.5	32.00	5,100	10
AT020208	T41 350x2.6	A30S-BF Inox	350	2.6	25.40	4,400	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

## Cutting disc for machining steel



- large cutting disc for stationary and handheld use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

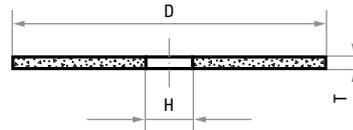
☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT010052	T41 300x4.0	A24R-BF	300	4.0	20.00	6,400	10
AT010055	T41 350x4.0	A24R-BF	350	4.0	20.00	5,400	10
AT010057	T41 350x4.0	A24R-BF	350	4.0	25.40	5,400	10

Recommended for: ● Steel ● Cast material



## Stationary cutting disc for machining steel

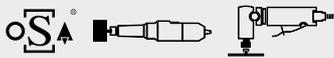


- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

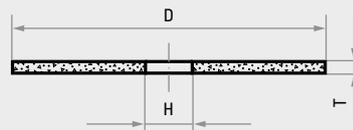
★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT010028	T41 300x2.6	A36S-BF Steel	300	2.6	25.40	6,400/80 m/s	10
AT001774	T41 300x3.5	A30T-BF Steel	300	3.5	22.23	6,400/100 m/s	10
AT001776	T41 300x3.5	A30T-BF Steel	300	3.5	25.40	6,400/100 m/s	10
AT010020	T41 300x3.5	A30T-BF Steel	300	3.5	32.00	6,400/100 m/s	10
AT010029	T41 350x2.6	A36S-BF Steel	350	2.6	25.40	5,400/80 m/s	10
AT010022	T41 350x3.5	A30T-BF Steel	350	3.5	25.40	5,400/100 m/s	10
AT010023	T41 350x3.5	A30T-BF Steel	350	3.5	32.00	5,400/100 m/s	10
AT010030	T41 400x3.2	A36S-BF Steel	400	3.2	25.40	4,700/80 m/s	5
AT010026	T41 400x4.0	A30T-BF Steel	400	4.0	32.00	4,700/100 m/s	5

Recommended for: ● Steel ● Cast material



## Small cutting disc for machining stainless steel NEW



- The thin width of less than a millimetre allows you to get to hard-to-reach places.
- delicately machine small parts
- free of iron, chlorine and sulphur
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT501006V9802	T41 50x1.0	A46S-BF Inox	50	1.0	6.0	30,500	50
AT501010V9802	T41 50x1.0	A46S-BF Inox	50	1.0	10.0	30,500	50
AT761006V9802	T41 76x1.0	A46S-BF Inox	76	1.0	6.0	20,100	50
AT761010V9802	T41 76x1.0	A46S-BF Inox	76	1.0	10.0	20,100	50
AT763010V9802	T41 76x3.0	A46S-BF Inox	76	3.0	10.0	20,100	50

Recommended for: ● Inox/Steel ● Steel

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS diamond cutting discs

## DIAMOND

Diamond is the hardest material in the world. The type of diamond chosen depends on what it is used for. Only synthetic diamonds are used for the diamond cutting discs. Unlike natural diamonds, their properties can be reproduced and controlled.

The following characteristics are significant when selecting diamonds:

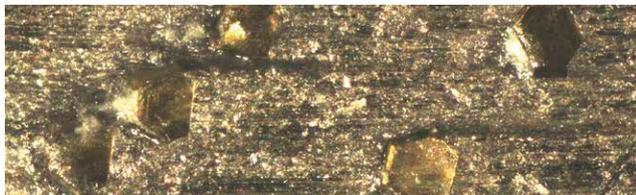
- degree of purity
- defined fracture strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grit sizes.



## SEGMENT

The segments consist of a diamond-embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists of bronze, cobalt, iron, carbide, or tungsten carbide, for example. The various characteristics of the metal powder give the segment sharpness and the all-important wear resistance. The segment coating is produced by a sintering process. A hard bond is selected for abrasive construction materials, while a soft bond is needed for hard structural materials.



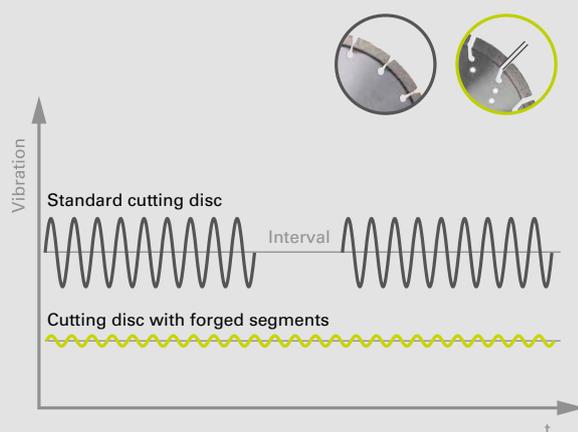
## SEGMENT GEOMETRY

The patented forged segment geometry allows even tall segments to be arranged very close to each other. This significantly reduces vibration for the user. Another crucial advantage is safety. The dense, porelessly forged segments have welds that provide much more safety against fracturing compared to the usual sintered segments.

- universal and fast due to new types of alloys in the segments
- less vibration through trapezium segment geometry
- more safety due to segment feet that are poreless and provide the utmost safety against fracturing
- long tool life thanks to taller segments and slower rate of diamond shedding

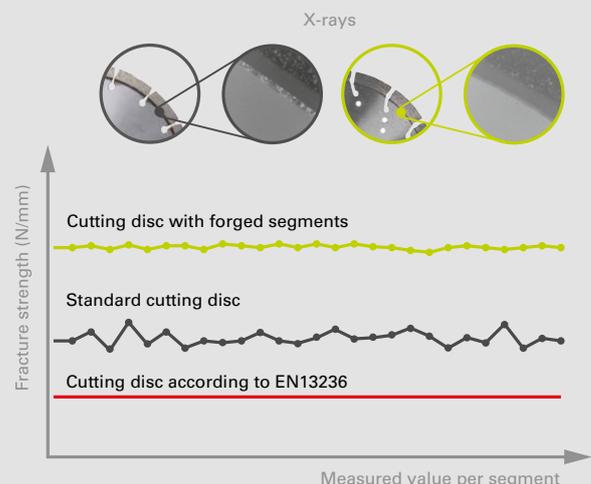
## COMPARISON OF CUTTING PROPERTIES

Low-vibration, narrow-gap cutting discs compared to cutting discs with forged segment



## WELDING PROPERTIES OF FORGED SEGMENTS

Highest level of safety against fracturing



## USAGE INSTRUCTIONS

# The right disc for your application

LUKAS has diamond cutting discs for a variety of materials. Whether you are working with concrete, tile or asphalt, you'll

find the perfect tool for every application. Select the material that you want to cut from the table below.

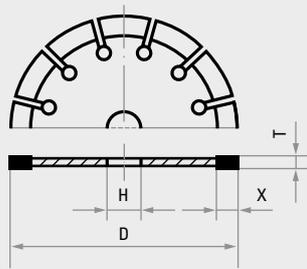
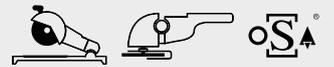
		<span style="display: inline-block; width: 10px; height: 10px; background-color: #c00000; margin-right: 5px;"></span> best suitable <span style="display: inline-block; width: 10px; height: 10px; background-color: #ff0000; margin-left: 20px; margin-right: 5px;"></span> suitable		Tile			Granite, hard materials			Concrete			Building material				Asphalt, abrasive materials					
Page	Product	Product line	Segment height mm	Tile	Fine stoneware	Granite tile	Granite	Porphyry	Clinker brick	Reinforced concrete	Exposed aggregate concrete	Concrete products	Brick, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Scree	Fresh concrete	Asphalt	Grey iron	
<b>Diamond cutting discs</b>																						
262	VDC	★★★★	7																			
263	LD Multi S13		13																			
263/264	LD3 S10/ LD3 S10 X-LOCK	★★★☆☆	10																			
264	LD7 S10		10																			
265	Turbo S10		10																			
265	Blue Cut S10		10																			
265	TC7	★★☆☆☆	7																			
<b>Tile cutting discs</b>																						
266	FAST CUT S10	★★★★	10																			
266/267	FLIESE S7/ FLIESE S7 X-LOCK	★★★☆☆	7																			
267	FC7	★★☆☆☆	7																			

# VDC – AGGRESSIVE APPLICATION WITH EXTREME TOOL LIFE

STAYS COOL. NO DUST OR ODOURS. NO EXPIRY DATE.



## VDC diamond cutting disc



- the diamond cutting disc that revolutionised cutting cast iron
- ideal for cutting cast iron (GG, GGG), fibreglass reinforced plastics (GFRP) and mineralisation
- not suitable for high-alloy materials containing nickel!

★★★

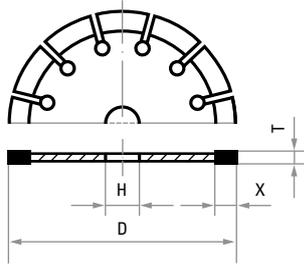
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	$n_{max}$ rpm	Pack contains
A34901152222	VDC 115022	115	7.0	2.2	22.23	13,300	1
A34901252222	VDC 125022	125	7.0	2.2	22.23	12,200	1
A34901802622	VDC 180026	180	7.0	2.2	22.23	8,500	1
A34902303022	VDC 230030	230	7.0	3.0	22.23	6,600	1
A34903503632	VDC 350036	350	7.0	3.6	32.00	4,400	1

Recommended for: ● Stone/Construction material ● Cast material ● Plastic



## LD Multi S13 diamond cutting disc

- professional disc for concrete and construction materials
- extremely versatile with optimum cutting speed
- long tool life
- Trapezium-shaped segments ensure low vibration.
- segment produced using forge technology



★★★

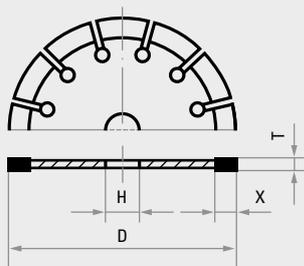
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344031151213083	LD Multi S13	115	13	2.4	22.23	13,300	1
A344031251213093	LD Multi S13	125	13	2.4	22.23	12,200	1
A344031501213113	LD Multi S13	150	13	2.4	22.23	10,200	1
A344031801213133	LD Multi S13	180	13	2.4	22.23	8,500	1
A344032301213153	LD Multi S13	230	13	2.6	22.23	6,600	1
A344033002213183	LD Multi S13	300	13	2.8	25.4	6,400	1
A344033502213213	LD Multi S13	350	13	3.0	25.4	5,500	1
A344034002213243	LD Multi S13	400	13	3.2	25.4	4,800	1

Recommended for: ● Stone/Construction material



## LD3 S10 diamond cutting disc

- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- excellent price-performance ratio
- laser-welded joints



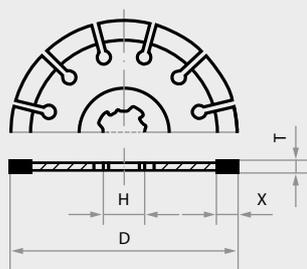
★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344131151210083	LD3 S10	115	11	2.4	22.23	13,300	1
A344131251210093	LD3 S10	125	11	2.4	22.23	12,200	1
A344131801210143	LD3 S10	180	11	2.4	22.23	8,500	1
A344132301210163	LD3 S10	230	11	2.6	22.23	6,600	1
A344133002210163	LD3 S10	300	11	2.8	25.4	6,400	1
A344133502210163	LD3 S10	350	11	3.0	25.4	5,500	1
A344134002210163	LD3 S10	400	11	3.2	25.4	4,800	1

Recommended for: ● Stone/Construction material



**NEW** LD3 S10 X-LOCK diamond cutting disc



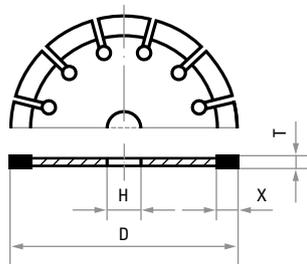
- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- Tool change is as easy as a click. No accessories needed due to the innovative X-LOCK system.
- excellent price-performance ratio
- laser-welded joints

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344131259210083	LD3 S10 X-LOCK	125	10	2.3	22.23	12,200	10

Recommended for: ● Stone/Construction material

**LD 7 S10 diamond cutting disc**



- perfect for cutting asphalt
- specially formed segments for high running smoothness and core protection
- laser-welded joints

★★☆

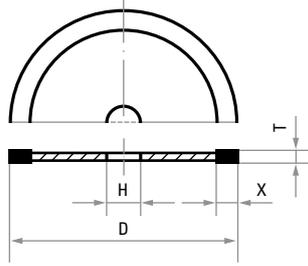
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344173002210183	LD7 S10	300	11	3.2	25.4	6,400	1
A344173502210213	LD7 S10	350	11	3.2	25.4	5,500	1
A344174002210243	LD7 S10	400	11	3.5	25.4	4,800	1
A344174502210283	LD7 S10	450	11	4.0	25.4	2,700	1

Recommended for: ● Stone/Construction material



## TURBO S10 diamond cutting disc

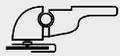
- ideal for cleanly cutting construction materials or concrete
- suitable for various applications



★★☆

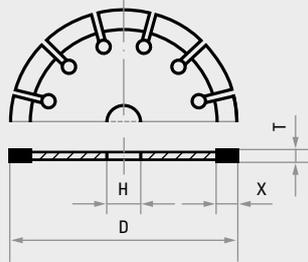
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344141151110013	TURBO S10	115	10	1.8	22.23	13,300	1
A344141251110013	TURBO S10	125	10	1.8	22.23	12,200	1
A344141801110013	TURBO S10	180	10	2.2	22.23	8,500	1
A344142301110013	TURBO S10	230	10	2.4	22.23	6,600	1

Recommended for: ● Stone/Construction material



## Blue Cut S10 diamond cutting disc

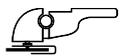
- especially popular on construction sites
- excellent price-performance ratio



★★☆

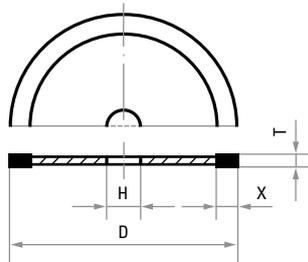
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345241151110085	Blue Cut S10	115	10	2.0	22.23	13,300	1
A345241251110095	Blue Cut S10	125	10	2.0	22.23	12,200	1
A345241501110125	Blue Cut S10	150	10	2.2	22.23	10,200	1
A345241801110145	Blue Cut S10	180	10	2.4	22.23	8,500	1
A345242301110165	Blue Cut S10	230	10	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material



## TC7 diamond cutting disc

- the turbo disc for precise cutting
- great price-performance ratio

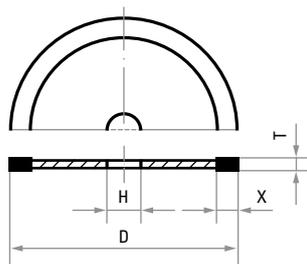


★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345241151107775	TC7	115	7	2.4	22.23	13,300	1
A345241251107775	TC7	125	7	2.6	22.23	12,200	1
A345242301107775	TC7	230	7	3.2	22.23	6,600	1

Recommended for: ● Stone/Construction material

## FAST CUT diamond cutting disc



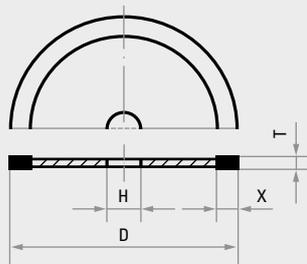
- extra-thin diamond cutting disc for ceramic and fine stone applications
- cuts through the hardest tiles quickly and cleanly
- offers an extra-thin segment coating and reinforced flange area

★★★

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	$n_{max}$ rpm	Pack contains
A344091151110013	FAST CUT S10	115	10	1.4	22.23	13,300	1
A344091251110013	FAST CUT S10	125	10	1.4	22.23	12,200	1

Recommended for: ● Stone/Construction material

## FLIESE S7 diamond cutting disc



- the popular choice cutting discs for tile and ceramic
- also cuts exactly through glazed ceramic

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	$n_{max}$ rpm	Pack contains
A344111151107013	FLIESE S7	115	7	1.6	22.23	13,300	1
A344111251107013	FLIESE S7	125	7	1.6	22.23	12,200	1
A344112301107013	FLIESE S7	230	7	2.0	22.23	6,600	1

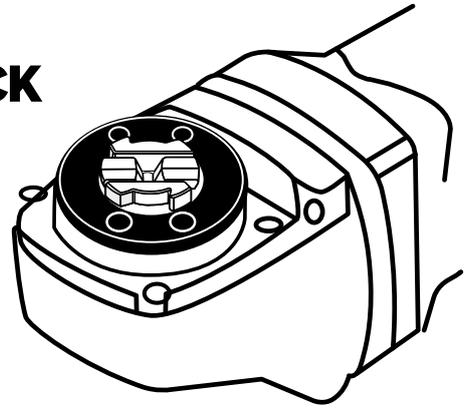
Recommended for: ● Stone/Construction material

# TOOL CHANGE WITH JUST A CLICK

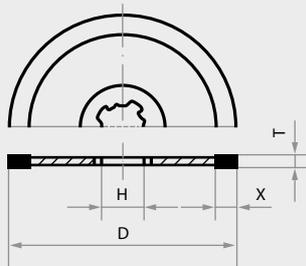
CHANGE TOOL QUICKLY AND EASILY WITH NO NEEDED ACCESSORIES

With the new X-LOCK system, simply position the LUKAS diamond cutting disc on the angle grinder's mounting fixture, allow it to engage and you are done. The click sound lets you know that the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

## X-LOCK



## FLIESE S7 X-LOCK diamond cutting disc **NEW**



- cutting disc for tile and ceramic, with practical X-LOCK system
- tool change without accessories; turn in your hand
- also cuts exactly through glazed ceramic

★★☆

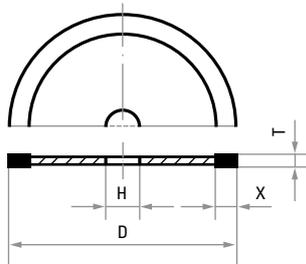
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344111259107013	FLIESE S7 X-LOCK	125	7	1.5	22.23	12,200	10

Recommended for: ● Stone/Construction material

CUTTING



## FC7 diamond cutting disc



- cuts through tiles with ease
- excellent price-performance ratio

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345211151107015	FC7	115	7	1.8	22.23	13,300	1
A345211251107015	FC7	125	7	2.0	22.23	12,200	1
A345212301107015	FC7	230	7	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material