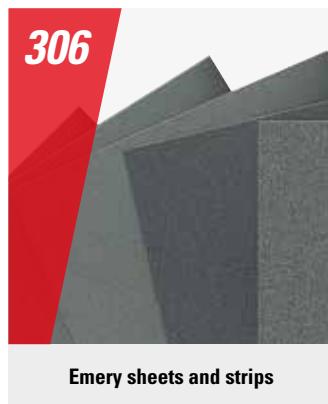
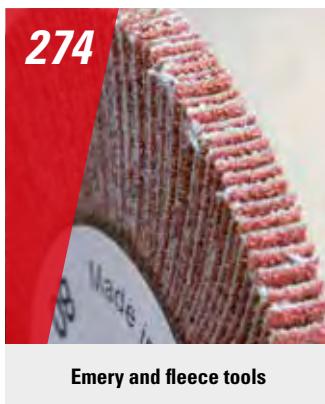
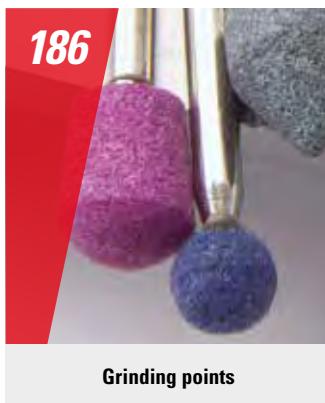
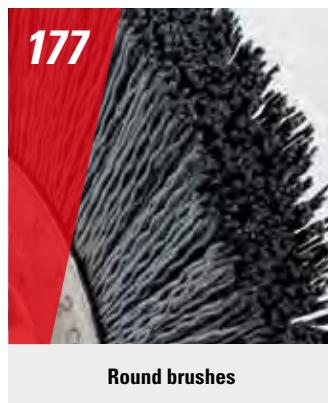


2

Grinding and polishing tools

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Grinding and polishing tools

Basic principles

Finest working processes in tool and mould making

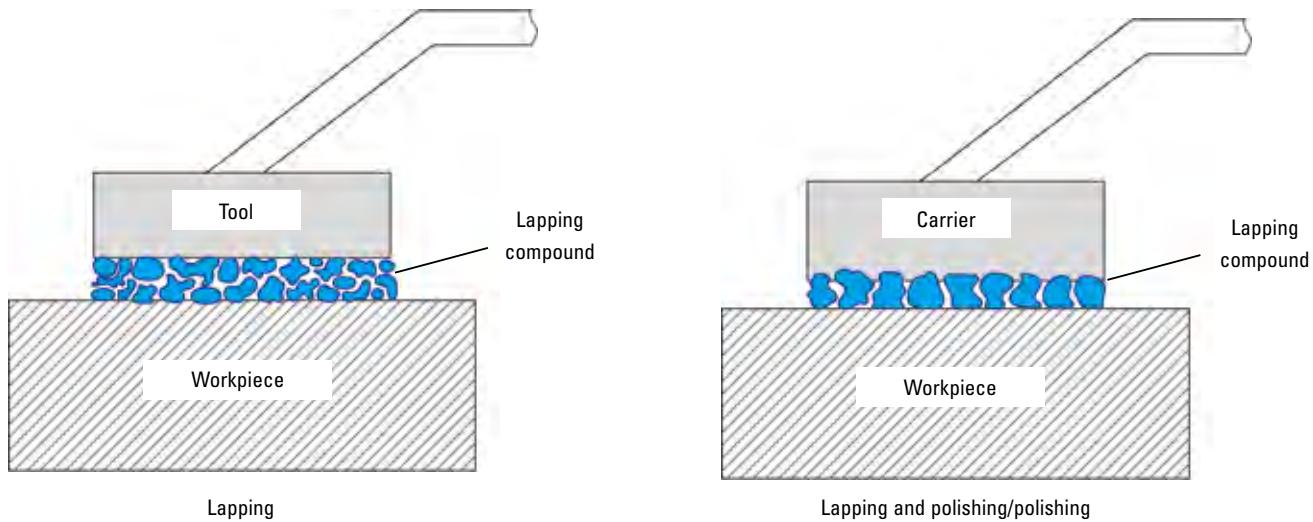
The border between grinding and polishing is not clear-cut and a clear distinction often difficult. Generally, three processes for the fine processing of surfaces can be identified: polishing, lapping and polishing/lapping, all of which are chipping processes with loose grit. These achieve the best roughness values (see page 100).

The surface quality achieved with these processes is mainly dependent on the following factors:

- Grit size of the abrasive
- Working pressure
- Work movement
- Grading of the various abrasives
- Choice of lapping and polishing agent carrier

Grinding

During preliminary processing, these very fine working processes (finishing) are often preceded by (manual) grinding. This involves a chipping process with firmly bound grit. See on the right side for an overview of typical abrasives.



Lapping

Lapping and polishing/polishing



Overview of work processes in tool and mould making

	Definition	Process	Result
Manual grinding	Chipping process with firmly bound grit	Directional movement, material is chipped by bound grit	Directional surface
Polishing		Directional or undirectional, grit "embedded" in polishing cloth or felt	High-gloss surface
Lapping	Chipping process with loose grit	Undirectional crossing movement, rolling grain	Matt surface
Lapping and polishing		Directional or undirectional movement, grit penetrates carrier	Shiny surface

Basic principles that should be adhered to:

- Always from coarse to fine
- Clean workpiece thoroughly after each grit change
- Change lapping or polishing medium carrier when changing grit

Grinding and polishing tools

Basic principles

The theoretical definition of abrasives includes all hard material grits, which are used to achieve stock removal. These are usually applied bound in grinding tools. A distinction is drawn made between natural grits such as quartz, corundum, emery, garnet and natural diamond and synthetic grits such as corundum, silicon carbide, chromium oxide, cubic boron nitride (CBN) and diamonds.

Corundum (aluminium oxide Al_2O_3)

The most widely used abrasive is classed according to its hardness and toughness:

Regular aluminium oxide: consists of approx. 95% Al_2O_3 predominantly from non-alloy and low alloyed steels as well as cast steel and grey cast iron.

Special fused aluminium oxide: owing to a 99.9% Al_2O_3 very hard and heat resistant up to 2,000 °C. Very suitable for tough unhardened steels of more than 60 HRC (tool steel), for working with glass and all steels that require cool grinding.

Semi corundum: mixture of the above. For steels with high hardness and toughness, that are not heat-sensitive.

Silicon carbide

Silicon carbide is mainly characterised by its hard and sharp crystals. It is heat-resistant up to approx. 1,370 °C. An abrasive grit generally only consists of one or a few crystals. This material is harder and more brittle than corundum. Silicon carbide is mainly used on non ferrous metals, rust-free steels, ceramic and mineral materials such as carbonaceous steels. It is also used for dressing grinding tools.

Cubic boron nitride (CBN)

Boron nitride is the second-toughest known material after diamond. It is only suitable as an abrasive in its cubic crystal form (CBN). It is produced synthetically from natural reserves of hexagonal crystalline boron nitride and is usually bound in resin or ceramic. It has a heat resistance of approx. 1,300 °C; from approx. 730 °C, it becomes even harder than diamond! It is used predominantly for grinding tough unhardened steels such as high-speed steel as well as hot- and coldwork steel. Not suitable for soft steels, tungsten carbides, nonferrous metals, chrome and nickel coatings as well as non-metals.

Diamond

The diamonds used today are almost exclusively synthetic. The hardness and geometries for specific applications achieved are superior to those of natural diamonds. Even as the hardest known material, diamonds are only heat-resistant up to 800 °C and their scope of application is therefore somewhat limited. Diamond tools are mainly used for precision grinding on tungsten carbide, grey cast iron, glass, ceramic, porcelain, fire-proof stones, germanium, graphite, cutting ceramics, silicon, rubber, non-ferrous heavy metal, cementite alloys, nickel and chrome alloys, ball bearing steel, tool steels with high carbon and low vanadium content.



manual grinding



Abrasive hardness according to Knoop

Diamond	6000
Cubic boron nitride (CBN)	4700
Boron carbide	2800
Silicon carbide	2480
Corundum	2050
Zirconium corundum	1800

Surface roughness

Overview of the surface roughness of the preliminary processing methods and the different grinding medium grit sizes in linear processing

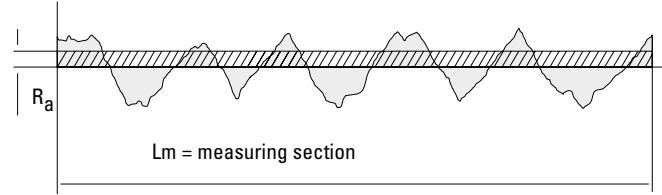
When selecting the correct grit size, a surface improvement by 1.5 roughness classes (coarse surfaces) to 0.5 roughness classes (fine surfaces) should be taken into account.

The tips of the wedges of preliminary processing are max. attainable values under good working conditions. The stock removal dimensions are usually higher than the absolute surface roughness (errors in the macrostructure and removal of the erosion skin). It may therefore be advisable to begin with a coarser grit size.

Surface roughness in mould building

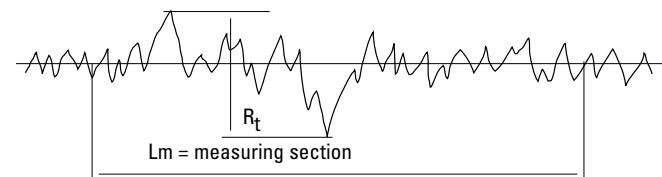
R_a

In by far the most cases, the surface roughness is indicated as an R_a value. The average roughness value finish R_a is the height of the fictitious surface over the midline, the magnitude of which corresponds to the sum of the individual surfaces above and below. The visual appearance may markedly deviate from the indication of the R_a value: e.g. smaller R_a value with visible isolated scratches.



R_t

The R_t value is considerably more meaningful for assessment of very fine surface finishes in mould making: the maximum peak-to-valley height R_t is the vertical distance between the highest and lowest point within the measuring section. For surface roughness indications in this catalogue, the maximum peak-to-valley height R_t is generally used.



Roughness classes

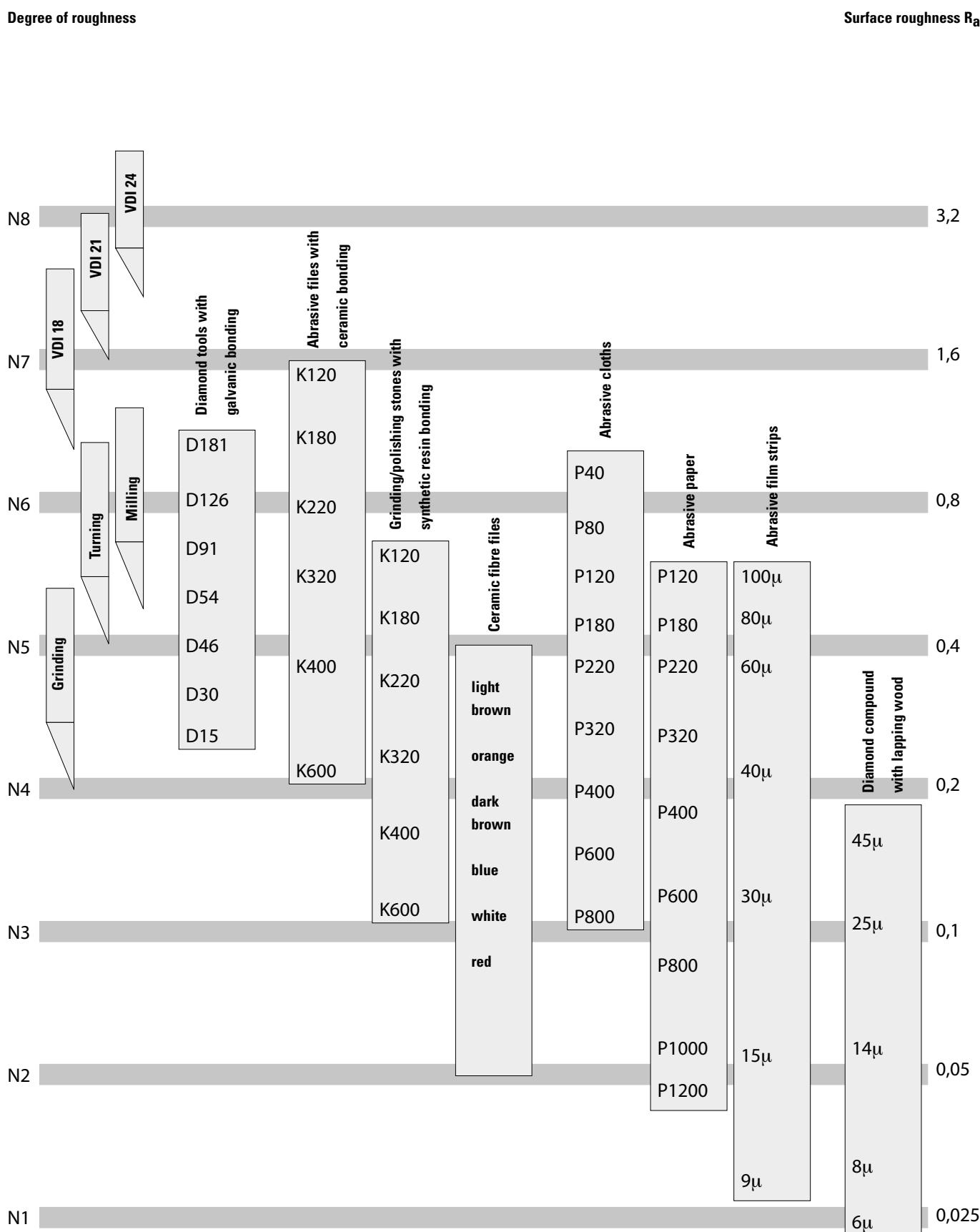
The roughness classes according to DIN/ISO 1302 are indicated as R_a values. The R_t values listed in the table are estimated values that are not contained in the standard. The ratio R_a:R_t corresponds to approx. 1:8 to 1:12 during manual working. As a result of the evenness of manual working and also less pressure and good lubrication, the ratio R_a:R_t can be reduced to 1:6. All the values indicated in this catalogue are empirically determined on steel 1.2767 with 53 HRC and represent non-binding guideline values.



Roughness classes according to DIN/ISO 1302

Degree of roughness No.	Roughness value R _a (μm)	Roughness value R _{max} (μm)
N 12	50	~ 500
N 11	25	~ 250
N 10	12.5	~ 125
N 9	6.3	~ 60
N 8	3.2	20 ... 40
N 7	1.6	10 ... 20
N 6	0.8	6 ... 10
N 5	0.4	2 ... 6
N 4	0.2	1.5 ... 2.5
N 3	0.1	0.75 ... 1.25
N 2	0.05	0.3 ... 0.7
N 1	0.025	0.1 ... 0.3

Surface roughness



Diamond compound polishing system joke Magic

joke Magic enables you to polish all types of steel, tungsten carbide, ceramics, aluminium and all non-ferrous metals. In no time at all. Reproducible. In material laboratory quality!

Diamond compound polishing system joke Magic

Everyone knows that many roads lead to Rome and there are just as many to the polishing result you want. Wouldn't it be nice to have a system that has been carefully devised to make sure you get the same highgloss finish on the workpiece every time? A system for achieving reproducible results on all types of steel, as well as on tungsten carbides, ceramics, nonferrous metals and aluminium.

Welcome to joke Magic!

joke Magic saves time...

...because its components make sure you attain smoother surfaces quicker without orange peel effect or excavations. With joke Magic you polish in logical steps.

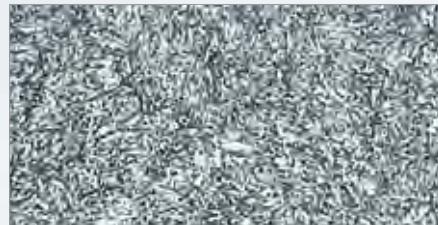
joke Magic saves money...

...because you achieve your goal using less "material". All its components give you the best results with optimised economy and longer life.

joke Magic just does it better...

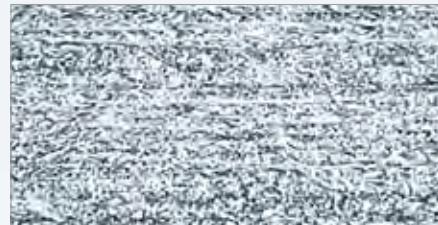
...see for yourself what joke Magic can do. It's time to switch!

joke Magic



Steel
Totally even surface

Standard



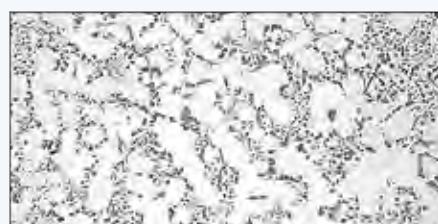
Steel
Uneven surface causes later blotching



Steel
Polishing without breakouts



Steel
Breakouts in material



Aluminium
All alloy components stay clean



Aluminium
Silicon torn out



Compounds and fluids



Diamond compounds joke Magic oil and alcohol soluble

Our best-selling diamond compound.

Specially designed for the new types of steel that tools are manufactured in. To be used neat or with just two drops of diamond fluid. Normally, diamond compounds must be used with a large amount of fluid. Using a large amount of fluid, however, has the effect of making the diamond compound runny, so that a lot of it is simply projected away during polishing. joke Magic diamond compound effectively creates a precisely calibrated, blocky diamond grit, which guarantees top-quality polishing. The result is an incomparably high level of removal on all materials: From soft aluminium to the hardest ceramics as well as for unlimited use on all grades of steel and tungsten carbides.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
Diamond compounds joke Magic, oil and alcohol soluble							
10 g	0.25 µm	extra high	grey	0 590 109			
	1 µm	extra high	blue	0 590 101			
	3 µm	extra high	green	0 590 102			
	6 µm	extra high	yellow	0 590 103			
	9 µm	extra high	red	0 590 104			
	14 µm	extra high	brown	0 590 105			
	25 µm	extra high	mahagony	0 590 106			
	45 µm	extra high	purple	0 590 107			
	70 µm	extra high	burgundy	0 590 108			
20 g	0.25 µm	high	grey	0 590 300			
	1 µm	high	blue	0 590 301			
	3 µm	high	green	0 590 302			
	6 µm	high	yellow	0 590 303			
	9 µm	high	red	0 590 304			
	14 µm	high	brown	0 590 305			
	25 µm	high	mahagony	0 590 306			
	45 µm	high	purple	0 590 307			
	70 µm	high	burgundy	0 590 308			
	0.25 µm	extra high	grey	0 590 200			
	1 µm	extra high	blue	0 590 201			
	3 µm	extra high	green	0 590 202			
	6 µm	extra high	yellow	0 590 203			
	9 µm	extra high	red	0 590 204			
	14 µm	extra high	brown	0 590 205			
	25 µm	extra high	mahagony	0 590 206			
	45 µm	extra high	purple	0 590 207			
	70 µm	extra high	burgundy	0 590 208			



joke Magic = unparalleled high diamond concentrations

joke Magic extra strong: Our Magic diamond compounds contain twice the quantity of diamonds in comparison to other compounds. Owing to a special manufacturing process, we have managed to rule out contact between the individual diamond grit particles in spite of twice the quantity. Consequently, an inimitable, extremely high stock removal is achieved.

joke Magic strong: the "strong" concentration of our Magic diamond compounds is already comparable to that of other compounds with concentrations indicated as "extra strong", "strong", "very strong", "SS", "K 100", "high", "heavy", etc.

The diamond compounds from the joke Magic series have become the favourite compounds of many polishers, since they always yield a perfect result as innovative all-round diamond compounds. This is something you should not miss either.



joke Magic 6 µm diamond grit – closely calibrated with uniform grit shape –



Standard compound, 6 µm diamond grit – poorly calibrated with uneven grit shape –

Diamond compounds joke Eco-Star the coloured

This diamond compound has been produced for all users who would like to work with a coloured compound. The compound is universally soluble and is recommended as a good alternative to other coloured diamond compounds owing to high stock removal and production of a good shine. Very good for wiping with polishing wool!

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
Diamond compounds joke Eco-Star, the coloured							
20 g	0.25 µm	extra high	grey	0 590 870			
	1 µm	extra high	blue	0 590 871			
	3 µm	extra high	green	0 590 872			
	6 µm	extra high	yellow	0 590 873			
	9 µm	extra high	red	0 590 874			
	15 µm	extra high	brown	0 590 875			
	25 µm	extra high	mahagony	0 590 876			
	45 µm	extra high	purple	0 590 877			



Each paste with individual identification colour!

Polishing starter set Diamond pastes and more to get started **NEW!**

Polishing starter set	Price from	
	Order No.	1 piece
The set contains:	1004	
<ul style="list-style-type: none"> • 1 x Storage box - twins • 1 x Diamondpaste joke Magic sample extra strong 3 µ, 2g • 1 x Diamondpaste joke - FAS, sample öllöslich, extra strong 6µ, 2g • 1 x Diamondpaste joke Magic sample extra strong 9 µ, 2g • 1 x Diamondpaste joke Magic sample extra strong 14µ, 2g • 1 x Diamond fluid joke Magic, oil soluble 10 ml • 1 x Super-fine polishing diamond suspension joke Magic, 1 µm, 10 ml, water- and alcohol soluble • 1 x Grinding and polishing stone oil (fluid), 20 ml • 1 x Rubber holder ROTAFLEX, Ø 18 mm, S.-Ø 3 x 26 mm, type RK 1 • 2 x Premium economy abrasive cloth rolls, corundum, KK114 F, 50 m x 50 mm, grit 320 • 2 x Kleenex polishing cloths - white, 3-ply, 1 pack (72 cloths), 20 x 20cm • 1 x Cleaning fluid joke X 73016-A, 500 ml spray can • 2 x Polishing felt, cylinder, Ø 6 x 10 mm, standard, shank-Ø 3 x 40 mm • 2 x Wooden lapping stick, hard, rectangular, 7 x 3 x 150 mm • 2 x Wooden lapping stick, soft, rectangular, 7 x 3 x 150 mm • 2 x Wooden lapping stick, hard, round Ø 3 x 150 mm • 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2402, 6 x 6 x 150 mm, grit 400 • 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2602, 6 x 6 x 150 mm, grit 600 • 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2301, 6 x 3 x 150 mm, grit 400 • 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2601, 6 x 3 x 150 mm, grit 600 • 3 x Polishing felts, cylinder Ø 10 x 10 mm, S.-Ø 3 x 40 mm • 5 x Polishing cloth, SAMBA-N, self adhesive, Ø 20 mm • 1 x Workpiece for polishing course, material 1.2767, 80 x 40 mm • 1 x Surfaces sample plate 		



Diamond compounds joke Magic ALU water and alcohol soluble

Special compound for aluminium and all non-ferrous metals. Can be used on all host materials, in either a rotating or a linear motion.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
Diamond compounds joke Magic ALU, water and alcohol soluble							
10 g	1 µm	extra high	blue	0 591 101			
	3 µm	extra high	green	0 591 102			
	6 µm	extra high	yellow	0 591 103			
	9 µm	extra high	red	0 591 104			
	14 µm	extra high	brown	0 591 105			

Diamond compounds joke Magic FAS the polycrystalline

joke Magic FAS diamond compound consists of a low-viscosity, easily spreadable oil-soluble carrier with hard synthetic diamonds (PKD). The polycrystalline diamond is significantly stronger than the cheaper monocrystalline diamond. Owing to the high stock removal rates, this compound is particularly suitable for hard materials such as ceramic, carbide, cobalt, titanium or nickel.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
joke Magic FAS diamond compounds, the polycrystalline							
10 g	0.25 µm	extra high	grey	0 590 820			
	1 µm	extra high	blue	0 590 821			
	3 µm	extra high	green	0 590 822			
	6 µm	extra high	yellow	0 590 823			
	9 µm	extra high	red	0 590 824			
	15 µm	extra high	brown	0 590 825			
	25 µm	extra high	mahagony	0 590 826			
■ NEW!	20 g	0.25 µm	extra high	grey	0 590 820-1		
	1 µm	extra high	blue	0 590 821-1			
	3 µm	extra high	green	0 590 822-1			
	6 µm	extra high	yellow	0 590 823-1			
	9 µm	extra high	red	0 590 824-1			
	15 µm	extra high	brown	0 590 825-1			
	25 µm	extra high	mahagony	0 590 826-1			

Diamond Compound joke Magic HYBRID poly- and monocrystalline

■ NEW!

The new joke Magic HYBRID compound consists of a combination of polycrystalline and monocrystalline diamonds. The friable polycrystalline diamond ensures rapid stock removal even on hard surfaces, while the monocrystalline diamond raises a high gloss. The diamond compound is universally soluble.

Grit size	Concentration	Colour	Order No.	Price from		
				1 piece	3 pieces	6 pieces
Diamond Compound joke Magic HYBRID						
1 µm	extra high	blue	0 590 881			
3 µm	extra high	green	0 590 882			
6 µm	extra high	yellow	0 590 883			



Diamond compounds joke Magic US universally soluble

Can be mixed with water, oil or alcohol. Very smooth, very easy to clean.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
joke Magic US diamond compound, universally soluble							
10 g	1 µm	extra high	blue	0 590 351			
	3 µm	extra high	green	0 590 352			
	6 µm	extra high	yellow	0 590 353			
	9 µm	extra high	red	0 590 354			
	14 µm	extra high	brown	0 590 355			
	25 µm	extra high	mahagony	0 590 356			
	45 µm	extra high	purple	0 590 357			
	70 µm	extra high	burgundy	0 590 358			
	90 µm	extra high	grey	0 590 359			



Diamond compounds joke Magic WS water and alcohol soluble

The compound you need to achieve very high gloss effects. Fantastic with high-speed steels!

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
joke Magic WS diamond compound, water and alcohol soluble							
10 g	1 µm	extra high	blue	0 590 701			
	3 µm	extra high	green	0 590 702			
	6 µm	extra high	yellow	0 590 703			
	9 µm	extra high	red	0 590 704			
	14 µm	extra high	brown	0 590 705			
	25 µm	extra high	mahagony	0 590 706			
	45 µm	extra high	purple	0 590 707			
	70 µm	extra high	burgundy	0 590 708			
	90 µm	extra high	grey	0 590 709			



Diamond sprays joke Magic alcohol soluble

These diamond sprays contain extremely hard, synthetically manufactured diamonds in an alcohol soluble carrier. Also ideal for hard materials such as ceramic and carbide. **CFC-free**

Content	Grit size	Order No.	Price from	
				1 piece
Diamond spray joke Magic, alcohol soluble				
200 ml	1 µm	0 590 910		
	3 µm	0 590 913		
	6 µm	0 590 914		
	9 µm	0 590 915		
	15 µm	0 590 916		



Diamond gels joke Magic water and alcohol soluble

NEW!

The joke Magic diamond gels are "ready to use" and can be used without any other fluids.

The viscosity of the gel is maintained even over a prolonged period. The diamond concentration within the gel is very high and thus enables economical use even on larger areas. Always take care to shake the gel well for sufficient time before use.

						Price from	
	Content	Grit size	Colour	Type	Order No.	1 piece	5 pieces
Diamond gels joke Magic							
	20 g	1 µm	blue	WS	0 590 650		
	20 g	3 µm	green	WS	0 590 651		
	20 g	6 µm	yellow	WS	0 590 652		
	20 g	9 µm	red	WS	0 590 653		
	20 g	14 µm	brown	WS	0 590 654		
	20 g	25 µm	mahagony	WS	0 590 655		



Also available as „**polycrystalline**“ version.

Order example:
0 590 650-P for 1µm polycrystalline

Diamond fluids

Diamond fluid joke Magic, oil soluble

Thinner for joke Magic diamond compounds, joke Magic US and joke Eco-Star

		Content	Order No.	Price from
			1 piece	
Diamond fluid joke Magic, oil soluble				
		0.5 l	0 590 451	
		2.5 l	0 590 451-1	
		10 l	0 590 452	



Diamond fluid joke Magic w/a water and alcohol soluble

Specially for joke Magic W/A diamond compounds, with 100% corrosion protection

		Content	Order No.	Price from
			1 piece	
Diamond fluid joke Magic W/A, water and alcohol soluble				
		500 ml	0 591 451	



Accessories / spare parts

		Content	Order No.	Price from
			1 piece	
Dosing bottle with pipette, oilproof, 30 ml				
			0 590 491-1	

Super-fine polishing suspensions joke Magic water soluble

1
2
3
4
5
6
7

Magic super-fine polishingsuspension

Magic super-fine polishing suspension with combined anti-corrosion power gives workpieces that final, brilliant gloss. This thin suspension and the blocky, agglomerate-free diamonds it contains enables totally scratch-free polishing. If necessary, you can use the super-fine polishing suspension together with the Magic „Clean“ cloth to remove any shadows created during final polishing.

		Content	Grit size	Price from Order No. 1 piece
Super-fine diamond plastic polishing medium joke Magic	specially developed for polishing plastics. Use with polishing cloth Magic SHINE.	50 ml 500 ml 50 ml 50 ml	1 µm 1 µm 3 µm 6 µm	0 590 901 0 590 902 0 590 903 0 590 904
Super-fine diamond polishing suspension joke Magic	water soluble and alcohol soluble, with anti-corrosion power. For the final, brilliant mirror finish.	50 ml 500 ml 50 ml 500 ml 50 ml 500 ml	1 µm 1 µm 3 µm 3 µm 6 µm 6 µm	0 590 400-1 0 591 401 0 590 401-1 0 590 401 0 590 402-2 0 591 402
		NEW!		



Grinding and polishing stones joke Magic STONES

Magic STONES grinding stones

A complete system incorporating grinding stones for pretreatment purposes. The fixed connection to the connecting rod (click system) ensures that no edging takes place whenever the Magic STONES are fitted, which prevents the rat marks usually created otherwise. The spherical pressure load ensures that grinding is vibration-free and leads to a totally even grinding result. The Magic STONES guarantee that the subsequent steps in the process can be carried out errorfree.

	Dimensions	Grit size	Packing quantity	Price from Order No. 1 pack
Grinding and polishing stones joke Magic STONES				
rectangular				
	7 x 9 x 4 mm	220	10 pieces	0 590 759
		320	10 pieces	0 590 760
		400	10 piece	0 590 761
		600	10 piece	0 590 762



⚙ Accessories / spare parts

	Dimensions	Price from Order No. 1 piece
Ball-ended rod for Magic STONES, length 80 mm		
	80 mm	0 590 753
Ball-ended rod for Magic STONES, length 140 mm		
	140 mm	0 590 752

Polishing cloths self-adhesive

Polishing cloths, self-adhesive

Polishing cloths are perfect for final polishing. Thanks to their self-adhesive backing, these cloths can be mounted on a wide variety of holders. Thus, for example, tools used during preparation can be reused simply by sticking the polishing cloth on them. You can choose between standard polishing cloths and Magic JOKER, FINAL and SHINE polishing cloths, which were specially designed for use with joke Magic diamond compound. JOKER and FINAL cloths can be used on 99% of materials. They are ideal for polishing all types of steel and aluminium. SHINE cloths were developed specially for polishing plastics. The cushioning base layer in these cloths means that they are very quiet to use and reduces score marks on the material. Breakouts and dimpling are prevented.

	Shape	Dimensions	Design	Type	Packing quantity	Price from	Order No.	1 pack
Polishing cloths joke Magic, self-adhesive								
	Magic JOKER (synthetic fibre cloth) for diamond compound grit sizes 6 to 3 µm	round round rectangular square	Ø 20 x 1 mm Ø 32 x 1 mm 9 x 11.5 x 1 mm 100 x 100 mm	self-adhesive self-adhesive self-adhesive self-adhesive	Magic JOKER Magic JOKER Magic JOKER Magic JOKER	50 pieces 50 pieces 50 pieces 50 pieces	0 591 501 0 591 502 0 591 503 0 591 505	
	Magic FINAL (short flocked cloth) for diamond compound grit sizes 3 to 1 µm	round round rectangular square	Ø 20 x 2 mm Ø 32 x 2 mm 9 x 11.5 x 2 mm 100 x 100 mm	self-adhesive self-adhesive self-adhesive self-adhesive	Magic FINAL Magic FINAL Magic FINAL Magic FINAL	50 pieces 50 pieces 50 pieces 50 pieces	0 591 601 0 591 602 0 591 603 0 591 605	
	Magic SHINE especially for plastics. Diamond compound grit sizes 6, 3 and 1 µm	round round round rectangular square	Ø 12 mm Ø 18 x 2 mm Ø 30 x 2 mm 9 x 11.5 x 2 mm 100 x 100 mm	self-adhesive self-adhesive self-adhesive self-adhesive self-adhesive	Magic SHINE Magic SHINE Magic SHINE Magic SHINE Magic SHINE	50 pieces 50 pieces 50 pieces 50 pieces 50 pieces	0 591 707 0 591 701 0 591 702 0 591 703 0 591 706	

Accessories / spare parts

	Dimensions	Shank dimensions	Type	Suitable abrasive discs	Packing quantity	Price from	Order No.	1 piece	1 pack	5 pieces
Toggle rod for tool carrier, length 140 mm										
				Ø 3 mm				0 411 008		
Supports for felts and cloths										
				9 x 11.5				10 pieces	0 411 009-2	
Rubber holder ROTAFLEX										
	Ø 10 mm Ø 18 mm Ø 30 mm	Ø 3 x 26 mm Ø 3 x 26 mm Ø 3 x 26 mm	RK 0 RK 1 RK 2	R 0 R 1 R 2				0 544 101 0 544 103 0 544 104		

Polishing cloths self-adhesive

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	Shape	Dimensions	Design	Type	Packing quantity	Order No.	Price from	1 pack	5 packs
Standard polishing cloths, self-adhesive									
Type 450 for diamond compound grit sizes 6 to 3 µm	round	Ø 12 x 0.8 mm	self-adhesive	450	10 pieces	0 543 311			
	round	Ø 20 x 0.8 mm	self-adhesive	450	10 pieces	0 543 312			
	round	Ø 33 x 0.8 mm	self-adhesive	450	10 pieces	0 543 313			
	round	Ø 50 x 0.8 mm	self-adhesive	450	10 pieces	0 543 314			
	round	Ø 78 x 0.8 mm	self-adhesive	450	10 pieces	0 543 316			
Type 432 for diamond compound grit sizes 3 to 1/4 µm	round	Ø 12 x 1.0 mm	self-adhesive	432	10 pieces	0 543 301			
	round	Ø 20 x 1.0 mm	self-adhesive	432	10 pieces	0 543 302			
	round	Ø 33 x 1.0 mm	self-adhesive	432	10 pieces	0 543 303			
	round	Ø 50 x 1.0 mm	self-adhesive	432	10 pieces	0 543 304			
	round	Ø 78 x 1.0 mm	self-adhesive	432	10 pieces	0 543 306			

Polishing cloths Kleenex

High quality 3-ply cloth for wiping after polishing and for applying joke Magic very fine polishing suspension (similar illustration).

	Design	Content	Colour	Dimensions	Order No.	Price from	1 piece
Polishing cloths Kleenex							
	3 layers	72 cloths	white	20 x 20 cm	0 590 602		



Diamond compounds Hyprez®



Diamond compounds Hyprez®

The diamonds

Our Hyprez® diamond compounds contain only special, tested and approved diamonds, ("Advanced Technology Diamonds") from brand manufacturers. They are selected with the greatest care for their size, purity and shape. The diamonds are very pressure-resistant and stay "aggressive" for as long as it is needed. Decades of use of Hyprez® diamond products in industrial mould-making as well as electronics and nanotechnology demonstrate that these products can meet the toughest requirements.

The host material

The host material will not separate from the diamond content and does not dry out. Its compatibility with the various solvents and the solubility of the compounds is also monitored closely.

Continuity thanks to quality

Hyprez® compounds deliver consistent, optimum polishing results. The durability of the diamond compounds is outstanding. The production process, which is continually improved and checked, ensures that their extremely high quality really lasts.

All Hyprez® diamond compounds at a glance

F - Versatile compound	The widest and most varied range of concentrations.
S - Economy compound	Developed for simple, cost-effective jobs.
W - Eco-compound	Water-based W compound developed for environment-friendly and oil-sensitive tasks.
OS - Oil-soluble compound	The ideal compound for high stock removal requirements.
L - for hard cases	Especially for working on tungsten carbide, ceramics and hardened steel.
Super-L - finishing compound	Finest grits for finishing hardened steels and ceramics.
C11 - Stabilised compound	The best compound for direct use on hot moulds or upright walls. Special host material providing optimum tool adhesion.
SC-HT	For high-temperature-areas up to 250°C.

Diamond compounds Hyprez® F oil and water soluble

For maximum flexibility the Hyprez® F series offers both water and oil soluble hosts and a large selection of diamond concentrations. 5 g in Hyplicator® or 10 g syringe.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® F, oil and water soluble								
5 g	0.10 µm	high	grey	1/10-F 2	0 580 002			
	0.25 µm	high	grey	1/4-F 2	0 580 004			
	1 µm	low	blue	1-F 1	0 580 005			
	1 µm	high	blue	1-F 3	0 580 006			
	1 µm	extra high	blue	1-F 4	0 580 007			
	3 µm	medium	green	3-F 3	0 580 009			
	3 µm	high	green	3-F 4	0 580 010			
	3 µm	extra high	green	3-F 6	0 580 011			
	6 µm	medium	yellow	6-F 4	0 580 012			
	6 µm	high	yellow	6-F 5	0 580 013			
	6 µm	extra high	yellow	6-F 7	0 580 014			
	8 µm	medium	red	8-F 6	0 580 015			
	8 µm	high	red	8-F 8	0 580 016			
	14 µm	medium	brown	14-F 6	0 580 018			
	14 µm	high	brown	14-F 8	0 580 019			
	14 µm	extra high	brown	14-F 9	0 580 020			
	25 µm	medium	mahagony	25-F 6	0 580 021			
	25 µm	high	mahagony	25-F 8	0 580 022			
	45 µm	medium	purple	45-F 6	0 580 024			
	45 µm	high	purple	45-F 8	0 580 025			
	60 µm	extra high	orange	60-F 9	0 580 027			
10 g	0.10 µm	high	grey	1/10-F 2	0 580 032			
	0.25 µm	high	grey	1/4-F 2	0 580 034			
	1 µm	low	blue	1-F 1	0 580 035			
	1 µm	high	blue	1-F 3	0 580 036			
	1 µm	extra high	blue	1-F 4	0 580 037			
	3 µm	medium	green	3-F 3	0 580 039			
	3 µm	high	green	3-F 4	0 580 040			
	3 µm	extra high	green	3-F 6	0 580 041			
	6 µm	medium	yellow	6-F 4	0 580 042			
	6 µm	high	yellow	6-F 5	0 580 043			
	6 µm	extra high	yellow	6-F 7	0 580 044			
	8 µm	medium	red	8-F 6	0 580 045			
	8 µm	high	red	8-F 8	0 580 046			
	14 µm	medium	brown	14-F 6	0 580 048			
	14 µm	high	brown	14-F 8	0 580 049			
	14 µm	extra high	brown	14-F 9	0 580 050			
	25 µm	medium	mahagony	25-F 6	0 580 051			
	25 µm	high	mahagony	25-F 8	0 580 052			
	45 µm	medium	purple	45-F 6	0 580 054			
	45 µm	high	purple	45-F 8	0 580 055			
	60 µm	extra high	orange	60-F 9	0 580 057			

Diamond compounds Hyprez® OS oil soluble

This oil-based compound is ideal for all uses that require a high level of stock removal.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® OS, oil soluble								
5 g	1 µm	high	blue	1-OS 3	0 580 206			
	1 µm	extra high	blue	1-OS 4	0 580 207			
	3 µm	medium	green	3-OS 3	0 580 209			
	3 µm	high	green	3-OS 4	0 580 210			
	3 µm	extra high	green	3-OS 6	0 580 211			
	6 µm	medium	yellow	6-OS 4	0 580 212			
	6 µm	high	yellow	6-OS 5	0 580 213			
	6 µm	extra high	yellow	6-OS 7	0 580 214			
	8 µm	medium	red	8-OS 6	0 580 215			
	8 µm	high	red	8-OS 8	0 580 216			
	8 µm	extra high	red	8-OS 9	0 580 217			
	14 µm	medium	brown	14-OS 6	0 580 218			
	14 µm	high	brown	14-OS 8	0 580 219			
	14 µm	extra high	brown	14-OS 9	0 580 220			
	25 µm	medium	mahagony	25-OS 6	0 580 221			
	25 µm	high	mahagony	25-OS 8	0 580 222			
	25 µm	extra high	mahagony	25-OS 9	0 580 223			
	45 µm	medium	purple	45-OS 6	0 580 224			
	45 µm	extra high	purple	45-OS 9	0 580 226			
10 g	1 µm	high	blue	1-OS 3	0 580 236			
	1 µm	extra high	blue	1-OS 4	0 580 237			
	3 µm	medium	green	3-OS 3	0 580 239			
	3 µm	high	green	3-OS 4	0 580 240			
	3 µm	extra high	green	3-OS 6	0 580 241			
	6 µm	medium	yellow	6-OS 4	0 580 242			
	6 µm	high	yellow	6-OS 5	0 580 243			
	6 µm	extra high	yellow	6-OS 7	0 580 244			
	8 µm	medium	red	8-OS 6	0 580 245			
	8 µm	high	red	8-OS 8	0 580 246			
	8 µm	extra high	red	8-OS 9	0 580 247			
	14 µm	medium	brown	14-OS 6	0 580 248			
	14 µm	high	brown	14-OS 8	0 580 249			
	14 µm	extra high	brown	14-OS 9	0 580 250			
	25 µm	medium	mahagony	25-OS 6	0 580 251			
	25 µm	high	mahagony	25-OS 8	0 580 252			
	25 µm	extra high	mahagony	25-OS 9	0 580 253			
	45 µm	medium	purple	45-OS 6	0 580 254			
	45 µm	extra high	purple	45-OS 9	0 580 256			



Diamond compounds Hyprez® S oil and water soluble

This compound consists of "Advanced Technology" diamonds which are used in more economical doses than F series compounds, for example. They are ideal for simple, economical uses.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® S, oil and water soluble							
10 g	1 µm	medium	blue	0 580 381			
	3 µm	medium	green	0 580 382			
	6 µm	medium	yellow	0 580 383			
	8 µm	medium	red	0 580 384			
	14 µm	medium	brown	0 580 385			
	25 µm	medium	mahagony	0 580 386			
	45 µm	medium	purple	0 580 387			
20 g	1 µm	medium	blue	0 580 391			
	3 µm	medium	green	0 580 392			
	6 µm	medium	yellow	0 580 393			
	8 µm	medium	red	0 580 394			
	14 µm	medium	brown	0 580 395			
	25 µm	medium	mahagony	0 580 396			
	45 µm	medium	purple	0 580 397			



Diamond compounds Hyprez® W water soluble

The compound for environmentally friendly and oil-sensitive jobs. It is water soluble and contains exclusively natural diamonds.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® W, water soluble								
5 g	1 µm	high	blue	1-W 3	0 580 106			
	1 µm	extra high	blue	1-W 4	0 580 107			
	3 µm	medium	green	3-W 3	0 580 109			
	3 µm	extra high	green	3-W 6	0 580 111			
	6 µm	low	yellow	6-W 4	0 580 112			
	6 µm	extra high	yellow	6-W 7	0 580 114			
	14 µm	medium	brown	14-W 6	0 580 118			
10 g	1 µm	high	blue	1-W 3	0 580 136			
	1 µm	extra high	blue	1-W 4	0 580 137			
	3 µm	medium	green	3-W 3	0 580 139			
	3 µm	extra high	green	3-W 6	0 580 141			
	6 µm	low	yellow	6-W 4	0 580 142			
	6 µm	extra high	yellow	6-W 7	0 580 144			
	14 µm	medium	brown	14-W 6	0 580 148			



Diamond compounds Hyprez® SC-HT oil soluble-up to 250 °C

Newly developed diamond compound with quick-cutting, sharp-cutting diamond particles for rapid, high stock removal. The diamond particles are embedded in an innovative carrier with excellent sliding characteristics and extremely high temperature resistance. Workpieces with a surface temperature of up to max. 250 °C can easily be processed with this compound without the compound melting.

					Price from	1 piece	3 pieces	6 pieces
Content	Grit size	Concentration	Colour	Order No.				
Diamond compounds Hyprez® SC-HT, oil soluble								
5 g	1 µm	extra high	white	0 580 270				
	3 µm	extra high	yellow	0 580 271				
	6 µm	extra high	orange	0 580 272				
	9 µm	extra high	green	0 580 273				
	20 µm	extra high	blue	0 580 274				
	30 µm	extra high	red	0 580 275				
	45 µm	extra high	brown	0 580 276				
	60 µm	extra high	black	0 580 277				

Diamond compounds Hyprez® C11 water soluble

Especially for difficult applications on hot moulds or standing walls. The uneven surfaces of high-strength diamond grits ensure a high level of material removal, even in difficult situations.

						Price from	1 piece	3 pieces	6 pieces
Content	Grit size	Concentration	Colour	Type	Order No.				
Diamond compounds Hyprez® C11, water soluble									
5 g	1 µm	high	light yellow	1-C 11	0 580 701				
	3 µm	high	yellow	3-C 11	0 580 702				
	6 µm	high	ochre	6-C 11	0 580 703				
	14 µm	high	light blue	14-C 11	0 580 704				
	25 µm	high	red	25-C 11	0 580 705				
	45 µm	high	brown	45-C 11	0 580 706				
20 g	1 µm	high	light yellow	1-C 11	0 580 711				
	3 µm	high	yellow	3-C 11	0 580 712				
	6 µm	high	ochre	6-C 11	0 580 713				
	14 µm	high	light blue	14-C 11	0 580 714				
	25 µm	high	red	25-C 11	0 580 715				

Diamond compounds Hyprez® Super-L oil soluble

Very fine grits and extremely stable diamonds for final finishing of tungsten, ceramics and powder metallurgic steels.

Content	Grit size	Concentration	Order No.	Price from		
				1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® Super L, oil soluble						
5 g	0.10 µm	high	0 580 260			
	0.25 µm	high	0 580 261			
	0.75 µm	high	0 580 262			
	1 µm	high	0 580 263			
	2 µm	high	0 580 264			
	3 µm	high	0 580 265			



Diamond compounds Hyprez® L oil soluble

Hyprez® L compound was developed for particularly hard materials. It is oil soluble and the best choice for treating tungsten carbide, ceramics, hardened and powder metallurgic steels. 5 g in Hyplicator® or 10 g spray.

Content	Grit size	Concentration	Colour	Type	Price from		
					1 piece	3 pieces	6 pieces
Diamond compounds Hyprez® L, oil soluble							
5 g	1 µm	extra high	blue	1-L 2	0 580 302		
	3 µm	high	green	3-L 3	0 580 304		
	6 µm	high	yellow	6-L 4	0 580 306		
	14 µm	medium	brown	14-L 3	0 580 309		
	14 µm	high	brown	14-L 5	0 580 310		
	25 µm	medium	mahagony	25-L 4	0 580 311		
	25 µm	high	mahagony	25-L 6	0 580 312		
	45 µm	medium	purple	45-L 4	0 580 313		
	45 µm	high	purple	45-L 5	0 580 314		
	60 µm	high	orange	60-L 6	0 580 316		
10 g	1 µm	extra high	blue	1-L 2	0 580 322		
	3 µm	high	green	3-L 3	0 580 324		
	6 µm	high	yellow	6-L 4	0 580 326		
	14 µm	medium	brown	14-L 3	0 580 329		
	14 µm	high	brown	14-L 5	0 580 330		
	25 µm	medium	mahagony	25-L 4	0 580 331		
	25 µm	high	mahagony	25-L 6	0 580 332		
	45 µm	medium	purple	45-L 4	0 580 333		
	45 µm	high	purple	45-L 5	0 580 334		
	60 µm	high	orange	60-L 6	0 580 336		



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Diamond fluids Hyprez® OS oil soluble

Thinner for all oil soluble diamond compounds Hyprez®

	Content	Type	Price from Order No.	1 piece
Diamond fluid Hyprez® OS, oil soluble				
	1 litre	OS	0 580 504	
	2 litres	OS	0 580 507	
	5 litres	OS	0 580 510	



Diamond fluids Hyprez® W water soluble

Thinner for all water soluble diamond compounds Hyprez®

	Content	Type	Price from Order No.	1 piece
Diamond fluid Hyprez® W, water soluble				
	1 litre	W	0 580 505	
	2 litres	W	0 580 508	



⚙ Accessories / spare parts

	Price from Order No.	1 piece
Pump spray bottle, 250 ml		
	0 580 455	
Spray bottle, 100 ml		0 580 515-2



Diamond gels Hyprez®

Hyprez® diamond gels combine the advantages of diamond compounds and diamond emulsions in one efficient product – ideal for polishing large surface areas. They work in the conventional way but need no additional fluid or other substances. The gel retains its viscosity even for longer periods. The diamond grits are always uniformly distributed. The practical dispensing bottle is simple to use and enables economical dosing. Please be careful not to apply too much diamond gel - one drop is generally enough for the entire surface to be polished.

Tip: to thoroughly clean the tool after polishing, we recommend X 73016-A cleaner.

					Price from
	Content	Grit size	Colour	Type	Order No.
Diamond gels Hyprez®					1 piece 5 pieces
	20 g	1 µm 3 µm 6 µm 8 µm 15 µm 30 µm 45 µm	red yellow yellow green blue blue blue	HYG 450 HYG 430 HYG 420 HYG 410 HYG 320 HYG 310 HYG 300	0 580 371 0 580 372 0 580 373 0 580 374 0 580 375 0 580 376 0 580 377

Diamond sprays Hyprez®

For efficient, economic polishing and lapping of large surfaces as well as impregnating polishing cloths and plates. The solvent contained in the diamond spray ensures the even distribution of diamond grits. Diamond particles do not clump together, which guarantees the full cutting power of every individual particle.

				Price from
	Content	Grit size	Order No.	1 piece 5 pieces
Diamond spray Hyprez®				Order No.
	75 g	0.10 µm 0.25 µm 1 µm 3 µm 6 µm 8 µm 14 µm 25 µm 45 µm	0 580 361 0 580 362 0 580 363 0 580 364 0 580 365 0 580 366 0 580 367 0 580 368 0 580 369	



Polishing compounds

Dialux

Ranging from "normal" polishing to superfinishing. The right compound for every application. Owing to the very good adhesive properties, the Dialux polishing compounds are perfectly suited to work with polishing felts and brushes.

				Content	Colour	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Polishing compounds Dialux									
	for polishing metals, chromium etc.	140 g	green	0 580 560					
	high-gloss polishing for all metals	125 g	white	0 580 561					
	for super-finishing of all metals	120 g	blue	0 580 562					
	for eliminating scratches and streaks (high-gloss polish white is additionally required for this purpose)	145 g	orange	0 580 563					
	for refreshing stainless steels	125 g	grey	0 580 564					
	for polishing or refreshing non-ferrous metals and aluminium	110 g	yellow	0 580 565					
	Polishing compound type 462 – without particles of animal origin • Specially designed for use in the food and chemical industry!	700 g	blue	0 580 566					

Polishing compounds

Dipo

The "classic" product uses corundum as abrasive for polishing unhardened steels and aluminium. Available as a tube (50 ml) or in the large canister (1,000 ml).

				Content	Grit size	Order No.	Price from	
							1 piece	25 pieces
Lapping and polishing compounds Dipo								
	50 ml tube	5 - 8 µm, very fine		0 580 571				
		10 - 15 µm, fine		0 580 572				
		30 - 50 µm, coarse		0 580 573				
		80 - 100 µm, very coarse		0 580 574				
	1,000 ml can	5 - 8 µm, very fine		0 580 575				
		10 - 15 µm, fine		0 580 576				
		30 - 50 µm, coarse		0 580 577				
		80 - 100 µm, very coarse		0 580 578				

Marking compounds

For controlling surfaces. The parts to be controlled are covered in marking compound after processing. The movement of components on a surface plate or against each other results in a colour layer, which provides information regarding the surface quality. Can be easily removed with a cleaning agent.

	Content	Colour	Price from Order No. 1 piece
Marking compounds			
heat resistant up to 60 °C			
	60 g tube	blue	0 202 252
	225 g can	blue	0 202 251-1
heat resistant up to 200 °C			
	60 g tube	blue	0 202 255
	225 g can	blue	0 202 257-1

Special grinding compounds

For fine grinding, lapping and dressing work. Also suitable for plastics. The paste with SiC abrasive can be diluted and removed with oil, petroleum or petroleum spirit.

	Content	Grit size	Price from Order No. 1 piece
Special grinding compounds			
	220 ml can	8 - 11 µm, very fine	0 580 581-1
		16 - 20 µm, fine	0 580 582-1
		27 - 31 µm, medium fine	0 580 583-1
		42 - 47 µm, medium	0 580 584-1
		88 - 105 µm, very coarse	0 580 586-1

Polishing compounds

Elsterglanz polishing compound

Original Elsterglanz safely cleans, polishes and preserves surfaces of different materials. Elsterglanz is non-corrosive, acidfree and completely material-friendly. Special ingredients have a water-repellant and preserving effect, thereby providing long-lasting protection against tarnishing and resoiling.

	Content	Application	Order No.	Price from 1 piece	10 pieces
Elsterglanz polishing compound					
	150 ml tube	Universal, particularly for stainless steels	0 580 630		
		Copper, brass, bronze	0 580 631		



Polishing compounds

Simichrome polishing compound

Suitable for almost all metals such as stainless steel, chrome, copper, tin, aluminium, brass, magnesium, gold and silver.

- Extremely fine metal polish
- Removes small scratches and aging layers
- Leaves an absolutely tremendous shine
- Additionally forms an ultrafine and lasting protective film

	Content	Order No.	Price from 1 piece
Simichrome polishing compound			
	50 g tube	0 580 638-1	
	250 g can	0 580 642-1	



Polishing compounds

Polishing compound Dur-Plastic-Polish

Care from a tube for all ungrained hard plastics. Returns clarity to dull Plexiglas and Macrolon panes and creates a shine on polyester and Plexiglas products. In paste form; use undiluted with a soft cloth.

	Content	Price from Order No. 1 piece
Dur-Plastic-Polish		
	125 ml tube	0 960 024-1
	1,000 ml can	0 960 014



Polishing compounds

Polishing medium METAREX

A polishing medium consisting of impregnated cotton for use on metals. Very well suited for repolishing PET bottle moulds. Gently eliminates everything that may have accumulated on the material (rust, verdigris, sulphide and oxide blackening) gently without leaving traces (scratches, white residues). Protects against premature oxidation.

	Content	Suitable for materials	Price from Order No. 1 piece
Polishing medium METAREX			
	100 g can	Metal	0 960 028
	200 g can	Metal	0 960 029



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Polishing pad Micro-Mesh® ideal for small polishing work

The polishing pads are the ideal partner for minor repairs and polishing work on smaller workpieces. The abrasive is applied on both sides and a larger surface area of the grinding points is achieved by the flexible carrier. The pads can be used wet or dry. Also very good for processing aluminium; an appropriate cooling fluid should be used in this case and the processing speed should be reduced.

Dimensions	Grit size	Design	Packing quantity	Order No.	Price from		
					1 piece	30 pieces	50 pieces
Polishing pads Micro-Mesh®, Ultra-Flex							
50 x 50 mm	60	Ultra-Flex	10 pieces	0 402 091			
	80	Ultra-Flex	10 pieces	0 402 092			
	100	Ultra-Flex	10 pieces	0 402 093			
	120	Ultra-Flex	10 pieces	0 402 094			
	150	Ultra-Flex	10 pieces	0 402 095			
	180	Ultra-Flex	10 pieces	0 402 096			
	240	Ultra-Flex	10 pieces	0 402 097			
	320	Ultra-Flex	10 pieces	0 402 098			
	360	Ultra-Flex	10 pieces	0 402 099			
	400	Ultra-Flex	10 pieces	0 402 100			
	600	Ultra-Flex	10 pieces	0 402 101			
	800	Ultra-Flex	10 pieces	0 402 102			
	1200	Ultra-Flex	10 pieces	0 402 103			



matching set

Dimensions	Content	Order No.	Price from	
			1 set	3 set
Polishing pad set Micro-Mesh®, Ultra-Flex				
50 x 50 mm	13 pads	0 402 090		



Know-how!

60 MX corresponds to approx. grit size P 240

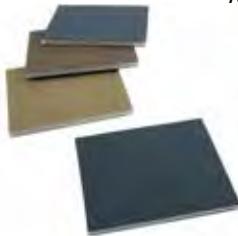
Material

60 MX – 600 MX = SiC
800 MX – 1200 MX = corundum

Polishing pad Micro-Mesh® ideal for small polishing work

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Dimensions	Grit size	Design	Packing quantity	Order No.	Price from
					1 piece
					30 pieces
Polishing pads Micro-Mesh®, Ultra-Flex					
76 x 102 mm	60	Ultra-Flex	10 pieces	0 402 065	
	80	Ultra-Flex	10 pieces	0 402 066	
	100	Ultra-Flex	10 pieces	0 402 067	
	120	Ultra-Flex	10 pieces	0 402 068	
	150	Ultra-Flex	10 pieces	0 402 069	
	180	Ultra-Flex	10 pieces	0 402 070	
	240	Ultra-Flex	10 pieces	0 402 071	
	320	Ultra-Flex	10 pieces	0 402 072	
	360	Ultra-Flex	10 pieces	0 402 073	
	400	Ultra-Flex	10 pieces	0 402 075	
	600	Ultra-Flex	10 pieces	0 402 076	
	800	Ultra-Flex	10 pieces	0 402 077	
	1200	Ultra-Flex	10 pieces	0 402 078	



Schmitzol's Wiener Kalk

Look it up in a German dictionary and you will find that the German word "Wienern" means polishing, buffing and raising a shine. That is what this original has been producing for more than 125 years: brilliance. Excellent for caring for and cleaning stainless steel, chrome, brass, copper, nickel, gold, silver, aluminium, glass, varnish and plastic. Even tiles, baths, washbasins and hobs are given a shine. Wiener Kalk is very well suited for cleaning moulds polished with up to 6 µm diamond. As a pure natural product, it is completely free of organic substances, phosphates and heavy metals. It does not contain any lime (Kalk) either; the name has merely grown up historically over the years.

	Content	Price from
	Order No.	1 piece
Schmitzol's Wiener Kalk		
	125 g can	0 960 020



Ouator polishing medium

Cotton wool balls for gentle polishing of aluminium, metal and plastic. The cotton wool is impregnated with a polishing medium and can be plucked piecewise from the ball. This allows very economical use, all the more so in that the individual pieces can easily be reused several times (keep in a bag after use!).

A deep gloss can be achieved on all materials with this cotton wool - perfect for cleaning and raising a shine. Furthermore, the surface is slightly sealed, which protects against water droplets and corrosion.

Content	Type	Colour	Suitable for materials	Order No.	Price from 1 piece
Ouator polishing medium					
250 g can	A	pink	Aluminium	0 960 025	
	M	blue	Metal	0 960 026	
	MPT	white	Plastic	0 960 027	



Polishing wool

If it is good for human skin, it cannot fail to be right for technical surfaces. Cotton wool is a universal cleaning aid. A choice between cotton and viscose (rayon) in addition to a "50/50 blend" of both is available. Rayon very rapidly absorbs liquid, whereas cotton stores it longer and offers better cohesion of the fibres. Cotton wool pads (100 % cotton) are available in addition to the loose cotton wool balls.

Design	Material	Content	Order No.	Price from 1 pack
Polishing wool				
Cotton wool	50 % viscose / 50 % cotton	100 g in the bag	0 960 010	
	100 % cotton	100 g in the bag	0 960 011	
	100 % viscose	180 g in the bag	0 960 013-1	
Cotton wool pads	100 % cotton	40 pieces in the bag	0 960 015	



Polishing cloths Kleenex

High quality 3-ply cloth for wiping after polishing and for applying joke Magic very fine polishing suspension (similar illustration).

Design	Content	Colour	Dimensions	Order No.	Price from 1 piece
Polishing cloths Kleenex					
3 layers	72 cloths	white	20 x 20 cm	0 590 602	

Cleaning wires

Flexible and firm at the same time. Particularly suitable for detaching and removing simple soiling in the drilling holes. Trimming made of soft cotton, with and without incorporated bristles (for maximum cleaning power). The wires are resistant against cleaning media and can be used both wet and dry. Available in long (150 mm) and longer (300 mm), conically wound respectively.

	Material	Dimensions	Packing quantity	Price from Order No.	1 pack
Cleaning wires					
	Cotton wool without bristles	Ø 4/5 x 150 mm	80 pieces	0 960 005	
	Cotton wool with bristles	Ø 4/5 x 150 mm Ø 3.5/5.5 x 300 mm	80 pieces 50 pieces	0 960 006 0 960 007	



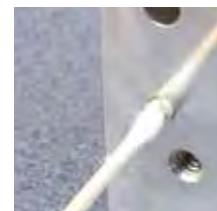
Cotton wool without bristles



Cotton wool with bristles

Cotton buds

Familiar in principle to any child. The joke cotton buds have a very dense and firm cotton wool head trimming (small and large version available). With their long wooden shanks, they are markedly superior to PP sticks, since more rigid and resistant to cleaners. Furthermore, their diameter also fits in the collets of our handpieces. Use wet or dry for cleaning and with compound for polishing.



	Design	Dimensions	Packing quantity	Price from Order No.	1 pack
Cotton buds on wooden sticks					
	small head (Ø approx. 4 – 5.5 mm)	Ø 2.3 x 150 mm	100 pieces	0 960 001	
	large head (Ø approx. 10 – 12 mm)	Ø 3 x 200 mm	50 pieces	0 960 002	

Cleaning stick

The lint-free cleaning sticks are highly absorbent and owing to their pointed shape, ideal for use in model and mould making as well as in areas such as optics, laser and microtechnology. The rods have a very dense and firm head made of highest-quality cotton. They are therefore super absorbent, suitable for solvents and retain their shape when wet. Perfect for all cleaning tasks in hard-to-reach areas or for precise application of liquids (e. g. adhesives, resins, alcohols).

	Packing quantity	Price from Order No.	1 pack
Cleaning stick			
	Sharp head on both sides, Ø 5 x 13 mm, hard, head and stick made of cotton	100 pieces	0 960 003

Felts and cloths

Our polishing felt selection is the result of long, practical experience. All common shapes, dimensions and grades of hardness are available. joke polishing felts are distinguished both by the high stability and outstanding elasticity of their material. In order to no need for new paragraph results at all times, they should always be used in conjunction with Magic and/or Hyprez® diamond compounds available from joke. Polishing felts from our company enable you to polish safely, cleanly and efficiently even the most complicated moulds, such as die-casting and injection moulds, cutting tools, dies etc.

Shank-Ø:

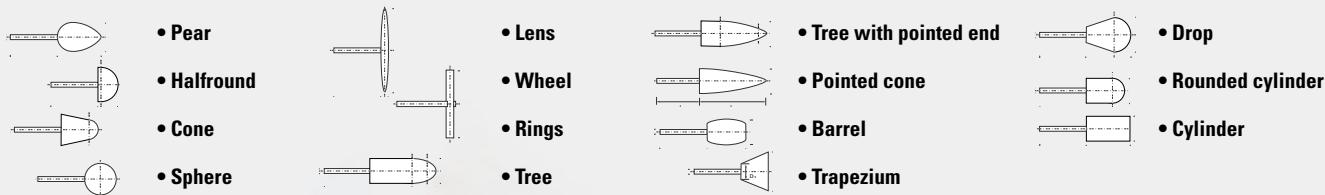
- Ø 2.35 x 40 mm
- Ø 3 x 40 mm
- Ø 6 x 40 mm

Hardness grades:

Soft: felt on its own without any impregnation ($< 0.65 \text{ g/cm}^3$ density)

Standard: light impregnation means greater stability ($< 0.65 \text{ g/cm}^3$ density)

Super-hard: total shape stability due to special, additional impregnation (0.65 g/cm^3 density)

15 different shapes:**133** Polishing felts with shank**140** Brass filament polishing felts**143** Felt sticks • Felt sheets**137** Polishing felt rings and lenses**142** Felt lamellas on shank

Polishing felts shank Ø 2.35 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from
							1 piece 50 pieces
Polishing felts, shank Ø 2.35 x 40 mm							
cylinder							
	Ø 4 x 10 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 107	
	Ø 4 x 12 mm	super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 494	
	Ø 8 x 12 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 105	
sphere							
	Ø 6 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 104	
pointed cone							
	Ø 6 x 18 mm	super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 490	
	Ø 7 x 15 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 109	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 451	
pear							
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 114	
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 110	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 452	
cone							
	Ø 7 x 15 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 116	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 454	
lens							
	Ø 17 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 121	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 458	
	Ø 22 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 120	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 457	
wheel							
	Ø 17 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 119	
	Ø 22 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 118	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 456	
barrel							
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 112	
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 111	
trapeze							
	Ø 12 / 8 x 12 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 117	
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 455	
drop							
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 115	
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	0 570 113	

Polishing felts shank Ø 3 x 40 mm

Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from 1 piece	50 pieces
Polishing felts, shank Ø 3 x 40 mm							
cylinder							
	■ Ø 6 x 10 mm	standard super-hard soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 301 0 570 461 0 570 315	
	Ø 6 x 13 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 322	
	Ø 8 x 10 mm	standard super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 302 0 570 462	
	■ Ø 8 x 12 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 317	
	Ø 10 x 10 mm	standard super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 303 0 570 463	
	■ Ø 10 x 12 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 319	
	Ø 10 x 13 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 323	
	Ø 10 x 15 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 320	
	Ø 10 x 20 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 354	
	Ø 13 x 20 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 324	
	Ø 15 x 20 mm	standard	Ø 3 x 30 mm	10 m/s	10 pieces	0 570 355	
	Ø 15 x 32 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 347	
	Ø 16 x 30 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 325	
	Ø 20 x 20 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 498	
	Ø 20 x 40 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 326	
rounded cylinder							
	■ Ø 6 x 10 mm ■ Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 312 0 570 313	
sphere							
	Ø 6 mm Ø 8 mm Ø 10 mm Ø 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 356 0 570 357 0 570 358 0 570 359	
pointed cone							
	■ Ø 6 x 18 mm ■ Ø 7 x 16 mm ■ Ø 10 x 18 mm	super-hard standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 328 0 570 327 0 570 304	
lens							
	Ø 21 x 4 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 459	
wheel							
	Ø 21 x 4 mm	standard	Ø 3 x 37 mm	10 m/s	10 pieces	0 570 489	

Polishing felts shank Ø 3 x 40 mm

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	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from
							1 piece
							50 pieces
rounded arch							
	Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 308	
		super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 466	
	Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 311	
tree with pointed end							
	Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 310	
	Ø 7 x 15 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 314	
	Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 309	
		super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 465	
trapeze							
	Ø 9 / 6 x 15 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 491	
	Ø 10 / 7 x 15 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 469	
	Ø 15 / 10 x 15 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 321	
		standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 305	
		super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 464	
drop							
	Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 306	
	Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	0 570 307	

 *matching set*

	Price from
	Order No.
	1 set
Set Polishing felts, shank Ø 3 x 40 mm	
Content: 14 pieces	
0 570 300	



Other polishing felts on request!

We will also be pleased to supply polishing felts in other shapes, hardnesses, head and shank dimensions.

Please consult **Markus Abstoss**:
Tel. +49 (0)2204/839-0
m.abstoss@joke.de

Polishing felts shank Ø 6 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Order No.	Price from
						1 piece
						50 pieces
Polishing felts, shank Ø 6 x 40 mm						
cylinder						
		Ø 10 x 12 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 331
		Ø 12 x 12 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 332
		Ø 15 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 333
			super-hard	Ø 6 x 40 mm	10 m/s	0 570 471
		Ø 15 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 334
		Ø 20 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 335
			super-hard	Ø 6 x 40 mm	10 m/s	0 570 472
		Ø 20 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 336
		Ø 25 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 337
		Ø 30 x 35 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 338
			super-hard	Ø 6 x 40 mm	10 m/s	0 570 473
sphere						
		Ø 12 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 360
		Ø 20 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 362
cone						
		Ø 20 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 339
			super-hard	Ø 6 x 40 mm	10 m/s	0 570 474
rounded arch						
		Ø 15 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 340
			super-hard	Ø 6 x 40 mm	10 m/s	0 570 475
tree, XL						
		Ø 20 x 70 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 342
trapeze						
		Ø 30 / 22 x 25 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 493
halfround						
		Ø 30 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	0 570 341

Polishing felts shank Ø 6 x 40 mm

 matching set

	Price from	Order No.	1 set
Set of polishing felts, shank Ø 6 x 40 mm			
	Content: 12 pieces	0 570 330	

Polishing felts Polishing felt rings

	Exterior Ø	Interior Ø	Height	Hardness	Cutting speed max.	Packing quantity	Price from	Order No.	1 pack	10 packs
Polishing felt rings										
non-self-adhesive										
	18 mm	7 mm	4 mm	standard	10 m/s	10 pieces	0 570 412			
	30 mm	12 mm	4 mm	standard	10 m/s	10 pieces	0 570 414			
	45 mm	18 mm	4 mm	standard	10 m/s	10 pieces	0 570 415			
self-adhesive										
	18 mm	7 mm	4 mm	standard	10 m/s	10 pieces	0 570 422			
	30 mm	12 mm	4 mm	standard	10 m/s	10 pieces	0 570 424			
	45 mm	18 mm	4 mm	standard	10 m/s	10 pieces	0 570 425			

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Polishing felts

rings • lenses • holders

Magic polishing felts – with barrier layer

A newly developed special impregnation technique ensures you get the best polishing results when using Magic polishing felts. It means you to get less moisture absorption than with normal felts, which enables the diamonds to provide their best cutting performance. joke Magic polishing felts have a wavy surface and are not impregnated, yet they need up to 40% less diamond compound than normal felts. Their precise, smooth surface creates a rapid, even surface on the material being worked and consistently prevents dimpling. A barrier located on the rear side of the felts prevents the ingress of liquid adhesive whenever the felts are glued to the rubber holders. It also prevents the felts from being affected by the adhesive and the adhesive from softening due to the polish used on the felts.

Dimensions	Hardness	Packing quantity	Order No.	1 piece	5 pieces	1 pack	5 packs	Price from
Polishing felts joke Magic, non-self adhesive								
Ø 30 / 12 x 4 mm	standard	10 pieces	0 590 501					
								
100 x 30 x 2 mm	standard	10 pieces	0 590 502					
								
290 x 280 x 2 mm	standard	10 pieces	0 411 370					

Accessories / spare parts

Dimensions	Hardness	Order No.	1 piece	10 pieces	Price from
Adhesive Pattex, 125 g tube					
	for fixing polishing felt rings to rubber supports	0 570 420-1			

Felt sheets

Dimensions	Hardness	Order No.	1 piece	5 pieces	Price from
Felt sheets					
6 x 250 x 250 mm	soft	0 411 341			
	medium	0 411 351			
	standard	0 411 361			
10 x 250 x 250 mm	soft	0 411 342			
	medium	0 411 352			
	standard	0 411 362			
12 x 250 x 250 mm	medium	0 411 353			
	standard	0 411 363			
25 x 250 x 250 mm	soft	0 411 345			
	medium	0 411 355			
	standard	0 411 365			

Felt sheets, self-adhesive

3 x 250 x 250 mm	standard	0 411 368
		



Hardness grades

Soft	0.48 g/cm ³
Medium	0.56 g/cm ³
Standard	0.64 g/cm ³
Super-hard	0.64 g/cm ³ (with impregnation!)

Polishing felts Polishing felt bodies

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	Dimensions	Hardness	Shank dimensions	Cutting speed max.	Order No.	Price from
						1 piece
						10 pieces
Polishing felt bodies (rubber holders with attached felt ring)						
	Ø 18 mm	standard	Ø 3 x 26 mm	10 m/s	0 570 403	
	Ø 30 mm	standard	Ø 3 x 26 mm	10 m/s	0 570 404	
	Ø 45 mm	standard	Ø 6 x 32 mm	10 m/s	0 570 405	



Polishing felts Polishing felt lenses

	Dimensions	Drilling dimension	Hardness	Suitable mounting shank	Cutting speed max.	Order No.	Price from
							1 piece
							50 pieces
Polishing felt lenses without shank							
	Ø 13 x 4 mm	2 mm	standard	Type 21, 22, 23	10 m/s	0 570 431	
	Ø 19 x 5 mm	2 mm	standard	Type 26, 27	10 m/s	0 570 433	
	Ø 25 x 6 mm	2 mm	standard	Type 26, 27	10 m/s	0 570 434	
	Ø 38 x 6 mm	2 mm	standard	Type 26, 27	10 m/s	0 570 435	
	Ø 51 x 8 mm	6 mm	standard	Type 41	10 m/s	0 570 436	



⚙ Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from
						1 piece
						10 pieces
CRATEX® grinding wheel holder						
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275	
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276	
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277	
	Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	0 545 280	
	Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	0 545 281	
	Ø 6 mm	Ø 6 x 25 mm	41	Ø 75 x 9.5 mm	0 545 282	

Brass filament polishing felts

shank Ø 3 and 6 mm

Brass filament polishing felts

The felts, which contain brass filaments, are excellent for working with complex geometries, such as with aluminium. In conjunction with compounds, they can be used to remove process residues (e.g. on milling lines) very rapidly. Cloths, felt discs, polishing felts or polishing brushes can be used for final polishing.

	Head dimensions	Shank dimensions	Cutting speed max.	Order No.	Price from 1 piece	Price from 50 pieces
Brass filament polishing felts with shank						
cylinder						
	Ø 6 x 10 mm	Ø 3 x 40 mm	10 m/s	0 570 291		
	Ø 8 x 10 mm	Ø 3 x 40 mm	10 m/s	0 570 292		
	Ø 10 x 10 mm	Ø 3 x 40 mm	10 m/s	0 570 293		
	Ø 12 x 12 mm	Ø 6 x 40 mm	10 m/s	0 570 296		
	Ø 15 x 20 mm	Ø 6 x 40 mm	10 m/s	0 570 297		
	Ø 20 x 20 mm	Ø 6 x 40 mm	10 m/s	0 570 298		
	Ø 25 x 30 mm	Ø 6 x 40 mm	10 m/s	0 570 299		
sphere						
	Ø 12 mm	Ø 6 x 40 mm	10 m/s	0 570 398		
pointed cone						
	Ø 10 x 18 mm	Ø 3 x 40 mm	10 m/s	0 570 294		
trapeze						
	Ø 15 / 10 x 15 mm	Ø 3 x 40 mm	10 m/s	0 570 295		

Brass filament polishing felts Rings

	Exterior Ø	Interior Ø	Height	Packing quantity	Order No.	Price from 1 pack	5 packs
Brass polishing felt rings, non-self adhesive							
	18 mm	7 mm	4 mm	10 pieces	0 570 392		
	30 mm	12 mm	4 mm	10 pieces	0 570 394		



⚙ Accessories / spare parts

	Order No.	Price from 1 piece	10 pieces
Adhesive Pattex, 125 g tube			
for fixing polishing felt rings to rubber supports	0 570 420-1		



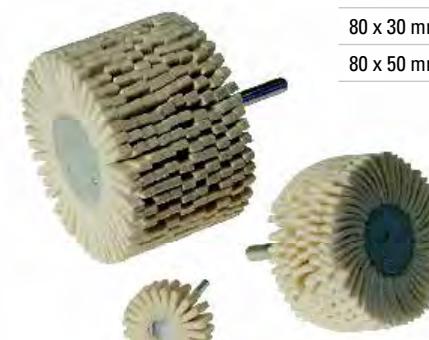
Felt lamellas

shank Ø 3 and 6 mm

Felt lamellas

The main strength of these polishing felts is their elasticity. They fit perfectly onto the contours of the tool being used. In particular, their "slit shape" is a must-have for this type of work. Because these felts fit tool contours, you need less working pressure and that means less "scoring" on the workpiece. Essentially you just get better results. Ideal for use with jokeFlex Premium Plus or Power Motor Systems.

Recommended speed: 3,000 – 6,000 rpm

	Head dimensions	Hardness	Felt thickness	Shank dimensions	Cutting speed max.	Order No.	Price from	
							1 piece	
							10 pieces	
Felt lamellas on shank								
standard								
								
	20 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 701		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 721		
	20 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 702		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 722		
	25 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 703		
	25 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 704		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 724		
	25 x 30 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 705		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 725		
	30 x 5 mm	H 40	3 mm	Ø 3 x 40 mm	10 m/s	0 411 710		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 712		
	40 x 5 mm	H 40	3 mm	Ø 3 x 40 mm	10 m/s	0 411 711		
		H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 713		
	50 x 5 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 714		
	slit							
								
	30 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 706		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 726		
	30 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 707		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 727		
	30 x 30 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	0 411 708		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	0 411 728		
	40 x 10 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 733		
	40 x 20 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 734		
	40 x 30 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 735		
	40 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 736		
	50 x 20 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 741		
	50 x 30 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 742		
	50 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 743		
	50 x 50 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 744		
	60 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 751		
	60 x 50 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	0 411 752		
	80 x 30 mm	H 40	5 mm	Ø 6 x 40 mm	10 m/s	0 411 765		
	80 x 50 mm	H 40	5 mm	Ø 6 x 40 mm	10 m/s	0 411 767		

Felt sticks

Felt sticks without shank

	Dimensions	Hardness	Order No.	Price from	1 piece	10 pieces
Felt sticks						
square						
	6 x 6 x 150 mm	medium	0 411 301			
		standard	0 411 304			
	10 x 10 x 150 mm	medium	0 411 302			
		standard	0 411 305			
	12 x 12 x 150 mm	medium	0 411 303			
		standard	0 411 306			

 matching set

	Dimensions	Hardness	Order No.	Price from	1 set
Assorted felt sticks					
					
	Content: 18 felt sticks, three in each hardness and design		0 411 300		

Felt sticks

shank Ø 3.2 mm

	Dimensions	Hardness	Shank dimensions	Order No.	Price from	1 piece	10 pieces
Felt sticks with shank, 30° slant							
	6 x 6 x 37 mm	medium	Ø 3.2 x 30 mm	0 411 321			
		standard	Ø 3.2 x 30 mm	0 411 324			
		super-hard	Ø 3.2 x 30 mm	0 411 327			
	10 x 10 x 45 mm	medium	Ø 3.2 x 30 mm	0 411 322			
		standard	Ø 3.2 x 30 mm	0 411 325			
	12 x 12 x 45 mm	medium	Ø 3.2 x 30 mm	0 411 323			
		standard	Ø 3.2 x 30 mm	0 411 326			

 matching set

	Dimensions	Hardness	Order No.	Price from	1 set
Assorted felt sticks with shank					
					
	Content: 6 pieces		0 411 320		



Lapping tools

145 Lapping and polishing points made of wood

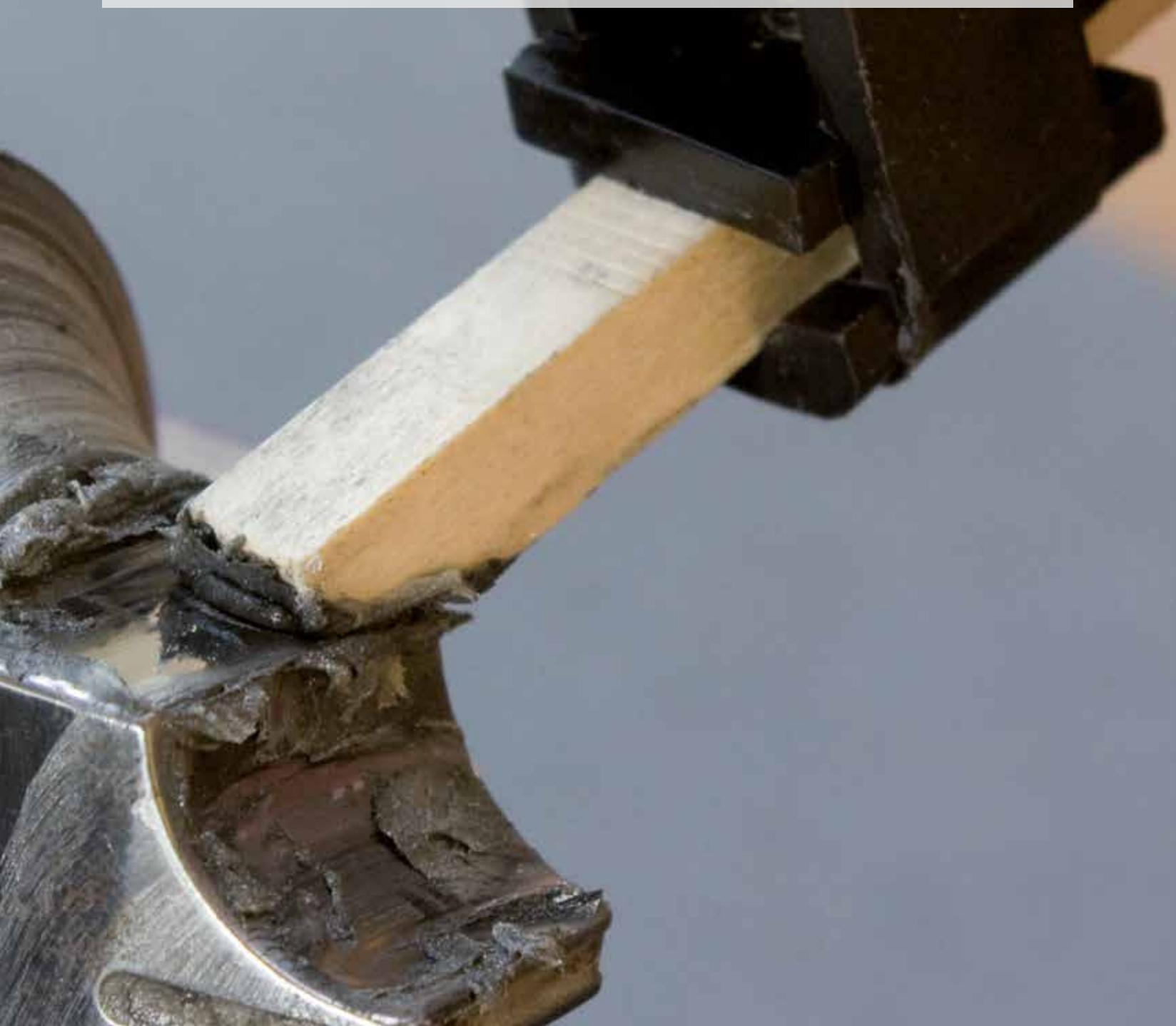
146 Lapping sticks made of wood and Plexiglas

148 Lapping and polishing tools

152 HELICAL LAP

Discover the entire range of abrasives and grinding tools.

Regardless of whether rotating on a shank, cap and sleeve-shaped, as belts, sheets, discs, emery papers and/or strips...we've got the right tool to match your grinding task!



Lapping and polishing points made of wood shank Ø 3 mm

Lapping and polishing points made of wood

These points made of hard and soft wood can be used rotating or linear (in hand-filing machines). These points can also be shaped for processing radii and the like. Use mainly with compounds.

Design	Shape	Head dimensions	Shank dimensions	Order No.	Price from	
					1 piece	10 pieces
Lapping and polishing points made of wood, shank Ø 3 mm						
hard wood	cylinder	Ø 6 x 15 mm	Ø 3 x 30 mm	0 570 174		
	cylinder	Ø 10 x 20 mm	Ø 3 x 30 mm	0 570 173		
	cylinder	Ø 15 x 25 mm	Ø 3 x 30 mm	0 570 172		
	cylinder	Ø 20 x 30 mm	Ø 3 x 30 mm	0 570 171		
	sphere	Ø 10 x 10 mm	Ø 3 x 30 mm	0 570 176		
	flame	Ø 10 x 30 mm	Ø 3 x 30 mm	0 570 178		
soft wood	cylinder	Ø 6 x 15 mm	Ø 3 x 30 mm	0 570 184		
	cylinder	Ø 10 x 20 mm	Ø 3 x 30 mm	0 570 183		
	cylinder	Ø 15 x 25 mm	Ø 3 x 30 mm	0 570 182		
	cylinder	Ø 20 x 30 mm	Ø 3 x 30 mm	0 570 181		
	sphere	Ø 10 x 10 mm	Ø 3 x 30 mm	0 570 186		
	flame	Ø 10 x 30 mm	Ø 3 x 30 mm	0 570 188		

Lapping and polishing points made of wood shank Ø 6 mm

Lapping and polishing points made of wood

These points made of hard and soft wood can be used rotating or linear (in hand-filing machines). These points can also be shaped for processing radii and the like. Use mainly with compounds.

Design	Shape	Head dimensions	Shank dimensions	Order No.	Price from	
					1 piece	10 pieces
Lapping and polishing points made of wood, shank Ø 6 mm						
hard wood	cylinder	Ø 15 x 25 mm	Ø 6 x 30 mm	0 570 272		
	cylinder	Ø 20 x 30 mm	Ø 6 x 30 mm	0 570 271		
soft wood	cylinder	Ø 15 x 25 mm	Ø 6 x 30 mm	0 570 282		
	cylinder	Ø 20 x 30 mm	Ø 6 x 30 mm	0 570 281		

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Wooden lapping sticks hard and soft

These sticks are made from laminated hard wood. The individual layers are pressed together crossways to their grain under very high pressure. This results in a long service life with very high structural stability. Use with diamond compounds before final polishing and whenever high stock removal is required.

	Dimensions	Hardness	Order No.	Price from 1 piece	10 pieces
Wooden lapping sticks, hard (beech laminated)					
round, pointed					
	Ø 3 x 150 mm	hard	0 411 277		
	Ø 4.5 x 150 mm	hard	0 411 278		
	Ø 6.5 x 150 mm	hard	0 411 279		
round, unpointed					
	Ø 10 x 300 mm	hard	0 411 290		
square, with chamfer					
	3 x 3 x 150 mm	hard	0 411 271		
	4.5 x 4.5 x 150 mm	hard	0 411 272		
	6.5 x 6.5 x 150 mm	hard	0 411 273		
rectangular, with chamfer					
	7 x 3 x 150 mm	hard	0 411 274		
	12.5 x 8 x 150 mm	hard	0 411 275		
	19 x 8 x 150 mm	hard	0 411 276		



Wooden lapping stick set, hard (9 pcs)

Price from
Order No. 1 set

0 411 270



Wooden lapping sticks hard and soft

These soft wooden lapping sticks are used as carriers for fine diamond compounds during polishing. Precision is therefore a must. That is why only carefully selected, clean and absolutely inclusion-free wood is able to complete its career as a soft wood lapping stick at joke.

	Dimensions	Hardness	Order No.	Price from 1 piece	10 pieces
Wooden lapping sticks, soft (lime)					
round, pointed					
	Ø 3 x 150 mm	soft	0 411 287		
	Ø 4.5 x 150 mm	soft	0 411 288		
	Ø 6.5 x 150 mm	soft	0 411 289		
square, with chamfer					
	3 x 3 x 150 mm	soft	0 411 281		
	4.5 x 4.5 x 150 mm	soft	0 411 282		
	6.5 x 6.5 x 150 mm	soft	0 411 283		
rectangular, with chamfer					
	7 x 3 x 150 mm	soft	0 411 284		
	12.5 x 8 x 150 mm	soft	0 411 285		
	19 x 8 x 150 mm	soft	0 411 286		



Wooden lapping stick set, soft (9 pcs)

Price from
Order No. 1 set

0 411 280



Plexiglas lapping sticks

We offer these Plexiglas lapping sticks for all those unable to choose between hard and soft wood for their lapping sticks. Their hardness falls right between both wood versions. Likewise used with diamond compounds.

	Dimensions	Hardness	Order No.	Price from 1 piece	10 pieces
Plexiglas lapping sticks					
square, with chamfer					
	3 x 3 x 150 mm	medium	0 411 251		
	4.5 x 4.5 x 150 mm	medium	0 411 252		
	6.5 x 6.5 x 150 mm	medium	0 411 253		
rectangular, with chamfer					
	7 x 3 x 150 mm	medium	0 411 254		
	12.5 x 8 x 150 mm	medium	0 411 255		
	19 x 8 x 150 mm	medium	0 411 256		

Lapping and polishing tools flex-poli-snap

These lapping and polishing tools are linked to the ball-ended rod via a clever snap-mechanism. This prevents the ball-ended rod from slipping during processing and damaging the material. Simply "snap in" and get down to work.

	Design	Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from
						1 pack
						3 packs
Lapping and polishing tools flex-poli-snap						
square						
	plastic	4 x 4 mm	0 411 174 / 170	50 pieces	0 411 610-50	
		5 x 5 mm	0 411 175 / 171	50 pieces	0 411 611-50	
		6 x 6 mm	0 411 176 / 172	50 pieces	0 411 612-50	
		8 x 8 mm	0 411 177 / 173	50 pieces	0 411 613-50	
	brass	4 x 4 mm	0 411 174 / 170	50 pieces	0 411 630-50	
		5 x 5 mm	0 411 175 / 171	50 pieces	0 411 631-50	
		6 x 6 mm	0 411 176 / 172	50 pieces	0 411 632-50	
		8 x 8 mm	0 411 177 / 173	50 pieces	0 411 633-50	
ring						
	plastic	Ø 4 mm	0 411 174 / 170	50 pieces	0 411 600-50	
		Ø 5 mm	0 411 175 / 171	50 pieces	0 411 601-50	
		Ø 6 mm	0 411 176 / 172	50 pieces	0 411 602-50	
		Ø 8 mm	0 411 177 / 173	50 pieces	0 411 603-50	
	brass	Ø 4 mm	0 411 174 / 170	50 pieces	0 411 620-50	
		Ø 5 mm	0 411 175 / 171	50 pieces	0 411 621-50	
		Ø 6 mm	0 411 176 / 172	50 pieces	0 411 622-50	
		Ø 8 mm	0 411 177 / 173	50 pieces	0 411 623-50	

matching set



	Price from
	Order No.
	1 set
	3 set
Set flex-poli-snap lapping and polishing tool set	
10 tools each in brass and plastic, Ø or edge length: 4, 5, 6 and 8 mm	0 411 189

The flex-poli-snap ball-ended rods are available with angular and straight heads (only in the set!). Both versions offer the "click" for a secure snap-on connection between tool and rod.

	Head dimensions	for lapping tool size	Design	Shank dimensions	Order No.	Price from
						1 piece
Ball-ended rods flex-poli-snap						
	Ø 1.9 mm	Ø 4 / 4 x 4 mm	angular	Ø 3.5 mm	0 411 174	
	Ø 2.4 mm	Ø 5 / 5 x 5 mm	angular	Ø 3.5 mm	0 411 175	
	Ø 2.9 mm	Ø 6 / 6 x 6 mm	angular	Ø 3.5 mm	0 411 176	
	Ø 3.9 mm	Ø 8 / 8 x 8 mm	angular	Ø 3.5 mm	0 411 177	

matching set



	Price from
	Order No.
	1 set
flex-poli-snap ball-ended rod set	
The set contains 4 straight and 4 angular flex-poli-snap ball-ended rods, rod holder, allen key and a hand rest including suitable stopper.	0 411 169

Lapping and polishing rings for rotating processing

Lapping and polishing rings for driving by the corresponding articulated handle and an angle handpiece.
Tip: the Ø 12 mm can also be used for linear movement with a ball-ended rod, for example in hand-filing machines.

	Design	Dimensions	Packing quantity	Order No.	Price from 1 pack
Lapping and polishing rings					
	plastic	Ø 8 mm	10 pieces	0 570 045	
		Ø 12 mm	10 pieces	0 570 055-10	
		Ø 20 mm	10 pieces	0 570 075	
	plastic collar ring	Ø 12 mm	5 pieces	0 570 063	
	brass	Ø 8 mm	10 pieces	0 570 044	
		Ø 12 mm	10 pieces	0 570 054-10	
		Ø 20 mm	10 pieces	0 570 074	
	brass collar ring	Ø 12 mm	5 pieces	0 570 062	

Lapping and polishing rings for rotating processing

Diamond lapping and polishing rings with metalbound diamonds for lapping of copied, milled, turned and eroded surfaces with peak-to-valley heights greater than 5 µm. Ring and workpiece must be free of oil. Build-up edges must be removed with the ring on abrasive paper of grit size 80-120.

	Dimensions	Grit size	Order No.	Price from 1 piece
Diamond lapping and polishing rings				
	Ø 8 mm	D 151	0 570 041	
	Ø 12 mm	D 151	0 570 051	
	Ø 20 mm	D 151	0 570 071	

⚙ Accessories / spare parts

	Dimensions	Shank dimensions	Order No.	Price from 1 piece
suitable articulated handles for lapping and polishing rings				
	Ø 8 mm	Ø 3 mm	0 570 050	
	Ø 12 mm	Ø 3 mm	0 570 060	
	Ø 20 mm	Ø 3 mm	0 570 080	
		Ø 6 mm	0 570 081	

2 Lapping and polishing tools for linear processing

Rings, squares and triangles made of brass and plastic for lapping and polishing of small faces, corners and edges (particularly triangles). Linear movement through ball-ended rods, which are clamped into hand-filing machines.

	Design	Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from
						1 pack
						3 packs
Lapping and polishing tools						
triangle						
	brass	3.5 x 3.5 x 3.5 mm	0 411 141	50 pieces	0 411 117-50	
		6 x 6 x 6 mm	0 411 142	50 pieces	0 411 118-50	
		8 x 8 x 8 mm	0 411 144	50 pieces	0 411 119-50	
	plastic	3.5 x 3.5 x 3.5 mm	0 411 141	100 pieces	0 411 137	
		6 x 6 x 6 mm	0 411 142	100 pieces	0 411 138	
		8 x 8 x 8 mm	0 411 144	100 pieces	0 411 139	
square						
	brass	2 x 2 x 1.5 mm	0 411 141	50 pieces	0 411 111-50	
		2.5 x 2.5 x 1.5 mm	0 411 142	50 pieces	0 411 112-50	
		3 x 3 x 2 mm	0 411 143	50 pieces	0 411 113-50	
		4 x 4 x 3 mm	0 411 144	50 pieces	0 411 114-50	
		5 x 5 x 3 mm	0 411 145	50 pieces	0 411 115-50	
		6 x 6 x 4 mm	0 411 146	50 pieces	0 411 116-50	
	plastic	2 x 2 x 1.5 mm	0 411 141	100 pieces	0 411 131	
		3 x 3 x 2 mm	0 411 143	100 pieces	0 411 133	
		4 x 4 x 3 mm	0 411 144	100 pieces	0 411 134	
		5 x 5 x 3 mm	0 411 145	100 pieces	0 411 135	
ring						
	brass	Ø 2 x 1.5 mm	0 411 141	50 pieces	0 411 101-50	
		Ø 2.5 x 1.5 mm	0 411 142	50 pieces	0 411 102-50	
		Ø 3 x 2 mm	0 411 143	50 pieces	0 411 103-50	
		Ø 4 x 3 mm	0 411 144	50 pieces	0 411 104-50	
		Ø 5 x 3 mm	0 411 145	50 pieces	0 411 105-50	
		Ø 6 x 4 mm	0 411 146	50 pieces	0 411 106-50	
	plastic	Ø 2 x 1.5 mm	0 411 141	100 pieces	0 411 121	
		Ø 2.5 x 1.5 mm	0 411 142	100 pieces	0 411 122	
		Ø 3 x 2 mm	0 411 143	100 pieces	0 411 123	
		Ø 4 x 3 mm	0 411 144	100 pieces	0 411 124	

Lapping and polishing tools for linear processing

Accessories / spare parts

	Dimensions	Shank dimensions	Price from Order No.	1 piece
Ball-ended rods, straight				
	Ø 1.8 x 140 mm	Ø 3.5 mm	0 411 141	
	Ø 2.2 x 140 mm	Ø 3.5 mm	0 411 142	
	Ø 2.7 x 140 mm	Ø 3.5 mm	0 411 143	
	Ø 3.5 x 140 mm	Ø 3.5 mm	0 411 144	
	Ø 4.5 x 140 mm	Ø 3.5 mm	0 411 145	
	Ø 5.5 x 140 mm	Ø 3.5 mm	0 411 146	

matching set

	Price from Order No.	5 set	1 set
Lapping and polishing tool set, triangles			



50 pcs of each dimension in brass and plastic

0 411 120

Lapping and polishing tool set, rings and squares



Approx. 25 pcs per dimension and shape in brass and plastic **0 411 100**

Lapping tools and sticks

SPEED LAP

■ NEW!

The SPEED LAP lapping tools and lapping sticks work quickly and reliably during stock removal and offer many advantages:

- every other grit can be omitted
- even, gentle work
- prevents scratches
- the properties of the metallic component prevent the formation of orange peel through combined lapping and polishing work
- good stock removal rates with low surface roughness
- the dimensional stability of the lapping tools encourages maintenance of the given geometry
- The lapping sticks can be sharpened to a point and retain their shape, so that even sharp inner edges are easy to process

SPEED LAP means a reduction in working stages, time saving and enhancement of surface quality

Preparation of the lapping tools:

- dress before use with fine diamond grits on a ground surface

Preparation of the lapping sticks:

- adapt the lapping sticks to approximate the geometry to be processed (new steel file, diamond film)

Grit sizes:

- lapping can be performed down to 1 µ
- every other grit size can be omitted (e.g. instead of 6 µ-3 µ-1 µ now 6 µ-1 µ)
- after the preparatory work with joke Magic Stone grit size 600, lapping with 6 µ can be performed on readily polishable steels, otherwise with 9 µ.
- the diamond compound should be sufficiently diluted with fluid.
- work with light pressure for about 2/3 of the working stage and without pressure for the last third (finishing).
- use full speed in linear motion with a rather short stroke and max. 3000 rpm for rotary processing

			Price from				
	Dimensions	Packing quantity	Order No.	1 pack	3 packs	5 packs	10 packs
Lapping sticks SPEED LAP							
	Ø 3 x 50 mm	15 pieces	0 570 005				
	Ø 4 x 140 mm	5 pieces	0 570 006				
	Ø 5 x 140 mm	5 pieces	0 570 007				
	Ø 6 x 140 mm	5 pieces	0 570 008				
	Ø 8 x 140 mm	5 pieces	0 570 009				
	4 x 4 x 140 mm	5 pieces	0 570 011				
	5 x 5 x 140 mm	5 pieces	0 570 012				
	6 x 6 x 140 mm	5 pieces	0 570 013				
	8 x 8 x 140 mm	5 pieces	0 570 014				
	4 x 6 x 140 mm	5 pieces	0 570 015				
	6 x 10 x 140 mm	5 pieces	0 570 016				
	8 x 15 x 140 mm	5 pieces	0 570 017				

Lapping tools and sticks SPEED LAP

NEW!

Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from 1 pack	3 packs	5 packs
Lapping tools SPEED LAP						
triangle						
	6 x 6 x 6 x 3 mm	0 570 035	25 pieces	0 570 028		
	8 x 8 x 8 x 4 mm	0 570 036	25 pieces	0 570 029		
square						
	4 x 4 x 2,5 mm	0 570 035	25 pieces	0 570 024		
	5 x 5 x 3,0 mm	0 570 035	25 pieces	0 570 025		
	6 x 6 x 3,5 mm	0 570 036	25 pieces	0 570 026		
	8 x 8 x 4 mm	0 570 036	25 pieces	0 570 027		
ring						
	Ø 4 x 2,5 mm	0 570 035	25 pieces	0 570 020		
	Ø 5 x 3,0 mm	0 570 035	25 pieces	0 570 021		
	Ø 6 x 3,5 mm	0 570 036	25 pieces	0 570 022		
	Ø 8 x 4,0 mm	0 570 036	25 pieces	0 570 023		

⚙ Accessories / spare parts

Order No.	Price from 1 piece	5 pieces
Ball-ended rod SPEED LAP 2,5 mm		
	0 570 035	
Ball-ended rod SPEED LAP 3,3 mm		
	0 570 036	

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Internal lapping tools HELICAL LAP

The ideal solution for perfect bores

HELICAL LAP internal and external lapping tools

are made of close-grained grey cast iron. A homogeneous smooth structure is achieved by a special annealing process making HELILAP the ideal carrier for any lapping media, especially for joke Magic and/or Hyprez® diamond compounds.

HELICAL LAP internal lapping tools

have a spiral cut and taper bore, which fits precisely to the corresponding shaft. These two features guarantee a uniform and cylindrical expansion of the lapping tools. Roundness and parallelism of bores can be achieved quickly and economically within extremely fine limits. All internal lapping tools are ground. The retraction tool is used for the expanded lapping tool. It is available with several inserts; for applications refer to the table.

HELICAL LAP outside lapping tools

also have a spiral cut and must be used with the corresponding holder. First, the lapping tool is fixed in the holder to prevent the tool from rotating simultaneously. The inside diameter of the lapping tool can be adjusted to a precisely round shape by contracting the holder. – All external lapping tools are ground and supplied at least 0.02 mm bigger than the indicated nominal diameter.

Basic principles

- Internal lapping tools should be longer than the bore to be lapped
- External lapping tools should be shorter than the shaft to be lapped
- Lapping tools should be stored separately according to the grit size.



Looking for the right compound?

Flip through to page 106. A large selection of the widest variety of compounds is to be found on 24 pages. **Markus Abstoss** will be pleased to help you with any enquiries:
Tel. +49 (0)2204/839-0
m.abstoss@joke.de



The HELICAL LAP system works

Work instructions

Drilling and reaming, then finishing with
HELICAL LAP, Tolerance $+0.002$
 -0

All finished bores must be cylindrical and round,
max. deviation 0.2 μm .
The R_a value must not exceed 0.05 μm .

Measuring results

1. INITIAL SITUATION

Steel bush, hardened Ø 16 x 35 mm
Measuring instrument: Taylor Hobson
Talyrond Roundness error: 0.04 mm
Measured R_a value: 0.6 μm

2. ROUGH LAPPING

Time: 5 min
Tool: HELICAL LAP
Lapping compound: joke HYPREZ®
diamond compound 14 μm
Correction of roundness to 0.0004 mm

3. FINISHING

Time: 5 min
Tool: HELICAL LAP
Lapping compound: joke HYPREZ®
diamond compound 3 μm
Correction of roundness to 0.0002 mm
Measured R_a value: 0.04 μm



Internal lapping tools HELICAL LAP

Standard dimensions

Design	End Ø E	Total length D	Suitable push-fit shaft	Suitable driver	Suitable retraction tool	Price from Order No.
						1 piece
Internal lapping tool HELICAL LAP						
without radial groove	1.674 - 1.930 mm	16 mm	0 586 102	0 586 152	0 586 201	0 586 302
	1.956 - 2.311 mm	16 mm	0 586 102	0 586 152	0 586 201	0 586 303
	2.362 - 2.743 mm	19 mm	0 586 103	0 586 153	0 586 201	0 586 304
	2.743 - 3.099 mm	19 mm	0 586 103	0 586 154	0 586 201	0 586 305
	3.149 - 3.479 mm	22 mm	0 586 104	0 586 154	0 586 201	0 586 306
	3.530 - 3.886 mm	22 mm	0 586 104	0 586 154	0 586 201	0 586 307
	3.937 - 4.318 mm	22 mm	0 586 104	0 586 154	0 586 201	0 586 308
	4.318 - 4.673 mm	22 mm	0 586 104	0 586 154	0 586 201	0 586 309
with radial groove	4.724 - 5.105 mm	35 mm	0 586 105	0 586 155	0 586 211	0 586 310
	5.130 - 5.461 mm	35 mm	0 586 105	0 586 155	0 586 211	0 586 311
	5.537 - 5.918 mm	45 mm	0 586 106	0 586 156	0 586 211	0 586 312
	5.918 - 6.248 mm	45 mm	0 586 106	0 586 156	0 586 211	0 586 313
	6.324 - 6.705 mm	50 mm	0 586 107	0 586 157	0 586 211	0 586 314
	6.731 - 7.010 mm	50 mm	0 586 107	0 586 157	0 586 211	0 586 315
	7.112 - 7.340 mm	50 mm	0 586 107	0 586 157	0 586 211	0 586 316
	7.518 - 7.670 mm	50 mm	0 586 107	0 586 157	0 586 211	0 586 317
	7.924 - 8.305 mm	50 mm	0 586 108	0 586 158	0 586 211	0 586 318
	8.305 - 8.610 mm	50 mm	0 586 108	0 586 158	0 586 211	0 586 319
	8.712 - 8.915 mm	50 mm	0 586 108	0 586 158	0 586 211	0 586 320
	9.093 - 9.245 mm	50 mm	0 586 108	0 586 158	0 586 211	0 586 321
	9.499 - 9.855 mm	63 mm	0 586 109	0 586 159	0 586 211	0 586 322
	9.906 - 10.185 mm	63 mm	0 586 109	0 586 159	0 586 211	0 586 323
	10.287 - 10.515 mm	63 mm	0 586 109	0 586 159	0 586 211	0 586 324
	10.693 - 10.845 mm	63 mm	0 586 109	0 586 159	0 586 211	0 586 325
	11.074 - 11.430 mm	63 mm	0 586 110	0 586 160	0 586 211	0 586 326
	11.480 - 11.785 mm	63 mm	0 586 110	0 586 160	0 586 211	0 586 327
	11.861 - 12.090 mm	63 mm	0 586 110	0 586 160	0 586 211	0 586 328
	12.268 - 12.420 mm	63 mm	0 586 110	0 586 160	0 586 211	0 586 329
	12.674 - 13.081 mm	83 mm	0 586 111	0 586 161	0 586 211	0 586 330
	13.081 - 13.487 mm	83 mm	0 586 111	0 586 161	0 586 211	0 586 331
	13.462 - 13.868 mm	83 mm	0 586 111	0 586 161	0 586 211	0 586 332



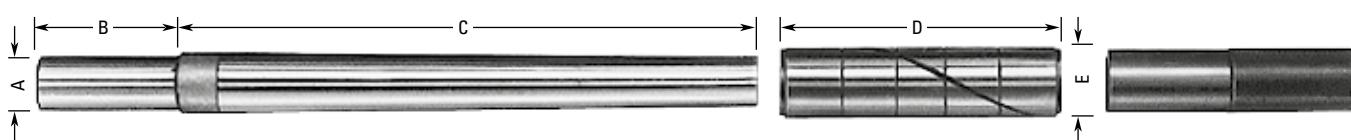
Practical tips

If the desired diameter cannot be found in the table, rework the next largest lapping tool to the suitable diameter, e.g. on a lathe. The recesses must be retained, since they serve as a compound reservoir.

The diameter to be adjusted is always the actual bore diameter minus 2 x stated grit size of the compound used. Process, clean and measure the bore and subsequently fit the tool to the mandrel accordingly by expansion.

Special sizes available on request! Please enquire about our special sizes, indicating the actual diameter of the workpiece to be processed.

Speed: 100 – 200 1/min



Internal lapping tools HELICAL LAP

Standard dimensions

Accessories / spare parts

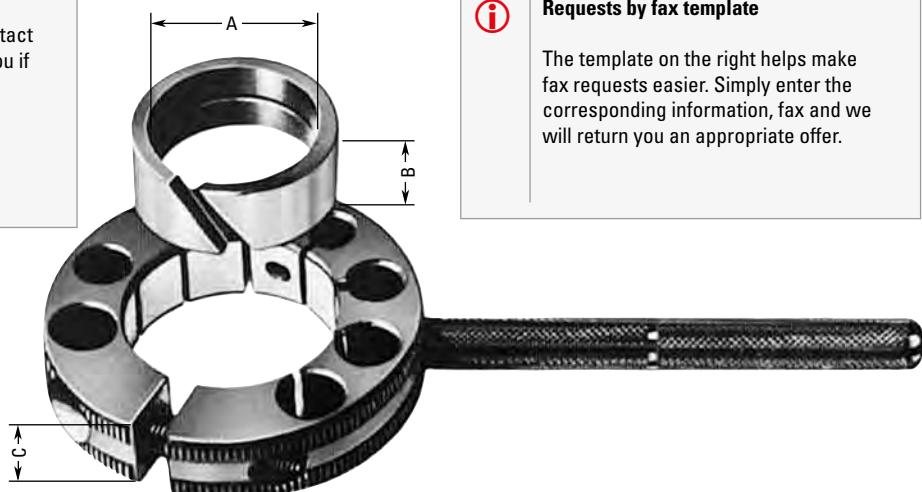
Type	Shank dimensions A x B	Cone length C	Price from Order No. 1 piece
Push-fit shafts HELICAL LAP			
3/0	Ø 3.2 x 19 mm	38 mm	0 586 102
2/0	Ø 3.2 x 19 mm	41 mm	0 586 103
0	Ø 3.2 x 19 mm	44 mm	0 586 104
1	Ø 4.8 x 25 mm	70 mm	0 586 105
2	Ø 4.8 x 25 mm	76 mm	0 586 106
3	Ø 4.8 x 25 mm	102 mm	0 586 107
4	Ø 5.6 x 25 mm	102 mm	0 586 108
5	Ø 7.2 x 38 mm	127 mm	0 586 109
6	Ø 8.0 x 38 mm	127 mm	0 586 110
7	Ø 9.5 x 38 mm	152 mm	0 586 111
Driver HELICAL LAP			
3/0			0 586 152
2/0			0 586 153
0			0 586 154
1			0 586 155
2			0 586 156
3			0 586 157
4			0 586 158
5			0 586 159
6			0 586 160
7			0 586 161
Retraction tool HELICAL LAP			
Size 0			0 586 201
Size 1			0 586 211



Your choice made easy

Refer to the relevant column in the "internal lapping tools" table to find the matching accessories. Enquiries pleased, your contact **Markus Abstoss** will be pleased to help you if you still have any further questions:

Tel. +49(0)2204/839-0
m.abstoss@joke.de



Requests by fax template

The template on the right helps make fax requests easier. Simply enter the corresponding information, fax and we will return you an appropriate offer.

Technical support HELICAL LAP

1

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3

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7

Request HELICAL LAP

Fax No. +49 (0) 2204 / 839-540

Mail sales@joke.de

Internal lapping tool

Actual Ø of bore

.....



Actual
Ø

Depth/length of bore

.....

Blind hole bore

yes no

Number of internal lapping tools required



Depth/length of bore

External lapping tool

Actual Ø of shaft

.....



Actual
Ø

Required width of lapping tool

.....



Actual
width

Actual shaft width

.....

Number of external lapping tools required

.....

Sender

Company

.....

Name

.....

First name

.....

Department

.....

Street

.....

Postcode / town / city

.....

Phone no.

.....

Fax no.

.....

Mail

.....

Date, signature

.....

Polishing brushes and buff wheels

158	Fleece polishing wheels with shank	176	Convolute compact grinding discs	180	Jet brushes
161	Polishing brushes and buff wheels with shaft	177	Round brushes	182	Pipe brushes
170	Polishing grinding discs joke HABRAS	178	Polishing buffering discs	184	Nylon honing brushes



Characteristics and fields of application of the brush trimmings

Trimming material	Characteristics	Field of application
Fine cotton	<ul style="list-style-type: none">• Natural product, soft• Picked• Highly adaptable	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds
Felt buff	<ul style="list-style-type: none">• Natural product• Highly adaptable	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds
Muslin/fleece	<ul style="list-style-type: none">• Highly adaptable• High strength• High stock removal until completely worn	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds• Deburring
Goat hair	<ul style="list-style-type: none">• Very flexible, very soft• Absorbent• Natural product	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds (< 6 µm)
Horsehair	<ul style="list-style-type: none">• Flexible yet hard• Absorbent• Natural product	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds (< 6 µm)
Bristles (black or white)	<ul style="list-style-type: none">• Flexible, yet hard• Elastic• Strongest of all natural products• Good compound absorbence in the individual bristles (hollow!)	<ul style="list-style-type: none">• Shining, polishing, dust removal• Use with compounds (< 6 µm)



Polishing wheels, brushes, buff wheels Overview



Characteristics and fields of application of the brush trimmings

Trimming material	Characteristics	Field of application
Nylon/synthetic	<ul style="list-style-type: none"> Better than chemical fibres with regard to friction resistance, elasticity, flexibility and durability Resistant to solvents, but readily soluble in acids Preferably used in the food and chemical industry (in contrast to natural products --> bristles) 	<ul style="list-style-type: none"> Shining, polishing, dust removal Use with compounds (< 6 µm)
Deerskin	<ul style="list-style-type: none"> Highly adaptable Natural product Resistant High stock removal 	<ul style="list-style-type: none"> Shining, polishing, dust removal Use with compounds
Brass wire	<ul style="list-style-type: none"> More supple and softer in the polished section than steel wires Discoloration on the workpiece possible 	<ul style="list-style-type: none"> Polishing, descaling, deburring Use with and without compounds
BAE steel, Bessemer wire, steel wire	<ul style="list-style-type: none"> Flexible and elastic Leave a distinctly visible polished section 	<ul style="list-style-type: none"> Preliminary polishing, descaling, deburring Use with and without compounds
V2A wire	<ul style="list-style-type: none"> Comparable to steel wire Resistant to acids and alkalis More unbreakable than steel Does not leave any rust residues and may also be used with water 	<ul style="list-style-type: none"> Preliminary polishing, polishing, deburring of stainless steel and aluminium Polishing with water and at high temperatures Use with and without compounds
HABRAS discs	<ul style="list-style-type: none"> Work without additional abrasive Very flexible, soft plastic Excellent service life High, uniform stock removal until completely worn 	<ul style="list-style-type: none"> Soft metals, aluminium, non-ferrous metals to a shine Deburring of hard plastic Deburring, matting and working to a finish
HABRAS brushes	<ul style="list-style-type: none"> High elasticity and resistance to buckling High, uniform stock removal until completely worn Long service life Low dust generation Work without additional abrasive 	<ul style="list-style-type: none"> General deburring Preparation for polishing
Nylon bristles	<ul style="list-style-type: none"> Work without additional abrasive High elasticity and resistance to buckling High, uniform stock removal until completely worn Little contact pressure required 	<ul style="list-style-type: none"> Deburring Matting Surface smoothing
Grinding fleece	<ul style="list-style-type: none"> Work without additional abrasive High, uniform stock removal until completely worn Cool, soft cut Usable on all materials Adapts to contours 	<ul style="list-style-type: none"> Deburring Matting Surface smoothing

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Polishing wheels, foamed shank Ø 2.35 x 40 mm

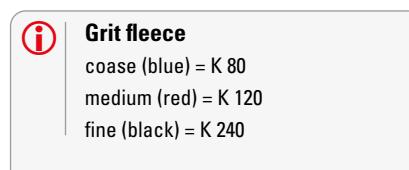
Polishing wheels and abrasive fleece

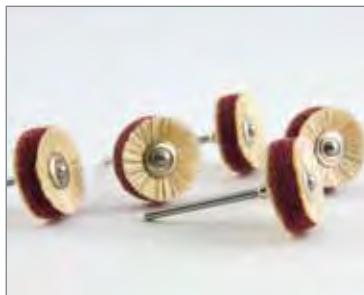
Foamed polishing wheels are highly dimensionally stable and are used in grooves and for edge processing. Abrasive fleece may be used wet and dry for deburring, matting and improving surfaces. They are characterised by a cool, soft cut. Owing to their elasticity, they adapt well to the surface contours. Use on all steels, non-ferrous metals, aluminium and plastics.

Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from 1 piece	Price from 50 pieces
Polishing wheel, foamed, shank Ø 2.35 mm								
Ø 25 x 6 mm	medium	coarse	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 950		

Polishing wheels, foamed shank Ø 3 x 40 mm

Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from 1 piece	Price from 50 pieces
Polishing wheel, foamed, shank Ø 3 mm								
Ø 25 x 6 mm	soft	fine	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 926		
	hard	medium	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 923		
	hard	coarse	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 922		
Ø 25 x 12 mm	hard	medium	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 924		
	hard	coarse	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 925		
Ø 30 x 3 mm	medium	medium	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 933		
Ø 30 x 6 mm	soft	fine	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 932		
	medium	medium	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 931		
	hard	coarse	Ø 3 x 40 mm	15000 1/min	10 pieces	0 570 930		
Ø 40 x 3 mm	medium	medium	Ø 3 x 40 mm	12000 1/min	10 pieces	0 570 937		
Ø 40 x 6 mm	soft	fine	Ø 3 x 40 mm	12000 1/min	10 pieces	0 570 936		
	medium	medium	Ø 3 x 40 mm	12000 1/min	10 pieces	0 570 935		
	hard	coarse	Ø 3 x 40 mm	12000 1/min	10 pieces	0 570 934		





Fleece polishing wheels shank Ø 2.35 x 40 mm

Material	Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Price from		
							Order No.	1 piece	50 pieces
Abrasive fleece, shank Ø 2.35 mm, dual-layer									
	Ø 25 x 6 mm	medium	medium	Ø 2.35 x 40 mm	5000 1/min	10 pieces	0 570 951		
	Ø 25 x 6 mm	medium	fine	Ø 2.35 x 40 mm	5000 1/min	10 pieces	0 570 952		
	Ø 25 x 6 mm	medium	very fine	Ø 2.35 x 40 mm	5000 1/min	10 pieces	0 570 956		
Abrasive fleece, shank Ø 2.35 mm, triple-layer									
	Ø 25 x 8 mm	medium	medium	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 953		
Polishing brush, shank Ø 2.35 mm									
	Scotch-Brite, fine and Chung-King	Ø 22 x 8 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 888		

Polishing and deburring sets shank Ø 2.35 x 48 mm

These tools are suitable for all metals, non-ferrous metals, gold and silver etc. Ideally suited for machining bores and transverse holes. Depending on the grit size, these tools can be used for deburring or polishing to a mirror finish. The polishers can be used dry and without additional compound.

	Abrasive	Grit size	Shank dimensions	Total length	Packing quantity	Price from		
						Order No.	1 set	3 set
Polishing and deburring set, Ø 14 x 30 mm								
	Set includes 1 piece each:	corundum	fine	2.35 mm	48 mm	4 pieces	0 402 104	
	• grit size 800							
	• grit size 1000							
	• grit size 1200							
	• grit size 1500							
	Set includes 1 piece each:	corundum	coarse	2.35 mm	48 mm	6 pieces	0 402 105	
	• grit size 80							
	• grit size 150							
	• grit size 220							
	• grit size 320							
	• grit size 400							
	• grit size 600							
	Set includes 1 piece each:	corundum	fine - coarse	2.35 mm	48 mm	10 pieces	0 402 106	
	• grit size 80 to 1500							

Fleece polishing wheels shank Ø 3 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from 1 piece	50 pieces
Abrasive fleece, shank Ø 3 mm, triple-layer								
For deburring, derusting, etc. • firm grade	Ø 22 x 13 mm	hard	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 309		
	Ø 25 x 17 mm	hard	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 310		
	Ø 30 x 17 mm	hard	Ø 3 x 40 mm	8000 1/min	10 pieces	0 572 311		
Ideally suited for all metals. High stock removal on aluminium, gold and silver. • very coarse grade	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 570 966		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 940		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 945		
For processing all materials, ideal for removing small scratches, for deburring etc.	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 570 967		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 941		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 946		
Very well suited for processing aluminium and stainless steel. • very firm grade	Ø 22 x 13 mm	very hard	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 315		
	Ø 25 x 17 mm	very hard	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 316		
	Ø 30 x 17 mm	very hard	Ø 3 x 40 mm	8000 1/min	10 pieces	0 572 317		
Very well suited for processing aluminium and stainless steel. • very firm grade.	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 570 968		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 942		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 947		
For processing all metals, highly versatile	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 570 969		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 943		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 948		
Using this grinding fleece results in a slight shine. Ideal for aluminium, stainless steels, etc.	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 301		
	Ø 25 x 17 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 302		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 572 303		
Very fine grinding nylon and grit. Ideal for processing gold, silver, brass, copper and aluminium..	Ø 22 x 13 mm	soft	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 305		
	Ø 25 x 17 mm	soft	Ø 3 x 40 mm	10000 1/min	10 pieces	0 572 304		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 958		
Grinding nylon without grit, ideal in combination with diamond compounds or also other polishing compounds	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	0 570 970		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 944		
	Ø 30 x 17 mm	hard	Ø 3 x 40 mm	8000 1/min	10 pieces	0 572 306		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	0 570 949		

Fleece polishing wheels shank Ø 3 x 40 mm

NEW!**Grit fleece**

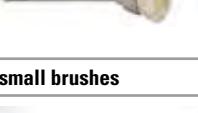
very coarse = K 60
coarse = K 80
medium = K 180
fine = K 240
very fine = K 400
ultra fine = K 1000

*matching set*

	Price from	Order No.	1 set	5 set
Set fleece polihing wheels, triple-layer, Ø 22 x 13 mm, shank Ø 3 mm, 9 pieces				
Set includes 1 piece:			0 572 320	
• 0572309				
• 0570966				
• 0570967				
• 0572315				
• 0570968				
• 0570969				
• 0572301				
• 0572305				
• 0570970				



Polishing brushes shank Ø 2.35 mm

Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
								1 p.	50 p.
Polishing brushes, shank Ø 2.35 mm									
cup									
	BAE steel, corrugated	Ø 12 x 6 mm Ø 12 x 8 mm Ø 12 x 6 mm	0.08 mm 0.08 mm 0.10 mm	straight straight, steep bevelled	Ø 2.35 x 40 mm Ø 2.35 x 40 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 570 0 570 160 0 570 571	
		Ø 12 x 6 mm Ø 12 x 6 mm	0.08 mm 0.10 mm	straight bevelled	Ø 2.35 x 40 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 520 0 570 503	
		Ø 12 x 6 mm Ø 12 x 8 mm	0.08 mm 0.10 mm	straight straight, steep	Ø 2.35 x 35 mm	10000 1/min	10 pieces	0 570 610 0 570 501	
	brass, corrugated	Ø 12 x 6 mm Ø 12 x 8 mm	0.08 mm 0.08 mm	straight straight, steep	Ø 2.35 x 40 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 133 0 570 663	
		Ø 8 x 4 mm Ø 12 x 8 mm Ø 12 x 8 mm		bevelled straight straight, steep	Ø 2.35 x 40 mm Ø 2.35 x 35 mm Ø 2.35 x 40 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 660 0 570 130 0 570 661	
		Ø 12 x 8 mm Ø 12 x 8 mm		bevelled straight	Ø 2.35 x 35 mm Ø 2.35 x 40 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 714 0 570 710	
	bristles, black	Ø 12 x 8 mm Ø 12 x 8 mm		straight, steep bevelled	Ø 2.35 x 40 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 128 0 570 711	
		Ø 8 x 4 mm Ø 12 x 6 mm		bevelled straight, steep	Ø 2.35 x 40 mm Ø 2.35 x 40 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 754 0 570 751-0	
		Ø 12 x 6 mm	0.30 mm	straight, steep	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 872	
	goat hair, white	Ø 8 x 4 mm Ø 12 x 6 mm Ø 12 x 8 mm		bevelled straight, steep bevelled	Ø 2.35 x 40 mm Ø 2.35 x 40 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 871-0 0 570 870	
small brushes									
	V2A wire, corrugated	Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm Ø 6 x 13 mm	0.10 mm 0.10 mm 0.10 mm 0.10 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm Ø 2.35 x 25 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces 10 pieces	0 570 513 0 570 510 0 570 511 0 570 502	
		Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm 0.10 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 560 0 570 561	
		Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm 0.10 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 620 0 570 621	
	brass, corrugated	Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm Ø 2.35 x 25 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 669 0 570 670 0 570 671		
		Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm Ø 2.35 x 25 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 670 0 570 720 0 570 721		
		Ø 4 x 8 mm Ø 5.5 x 11 mm Ø 7 x 13 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm Ø 2.35 x 35 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 723 0 570 673 0 570 674		
	goat hair, white	Ø 4 x 8 mm Ø 5.5 x 11 mm		Ø 2.35 x 25 mm Ø 2.35 x 25 mm	10000 1/min 10000 1/min	10 pieces 10 pieces	0 570 673 0 570 674		

Polishing brushes shank Ø 2.35 mm

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Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from 1 p. 50 p.
small brushes with elastic protection								
	V2A wire, corruga- ted	Ø 4 x 8 mm	0.10 mm	Ø 2.35 x 25 mm	10000 1/min	10 pieces	0 570 512	
	BAE steel, corruga- ted	Ø 4 x 8 mm	0.10 mm	Ø 2.35 x 35 mm	10000 1/min	10 pieces	0 570 562	
	brass, corruga- ted	Ø 4 x 8 mm	0.10 mm	Ø 2.35 x 25 mm	10000 1/min	10 pieces	0 570 622	
	bristles, white	Ø 4 x 8 mm		Ø 2.35 x 25 mm	10000 1/min	10 pieces	0 570 672	
	bristles, black	Ø 4 x 8 mm		Ø 2.35 x 25 mm	10000 1/min	10 pieces	0 570 722	
wheel								
	VA wire, corruga- ted	Ø 12 mm	0.06 mm	Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 583	
		Ø 14 mm	0.06 mm	Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 585	
	V2A wire, corruga- ted	Ø 16 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 505	
		Ø 19 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 500	
		Ø 22 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 504	
	BAE steel, corruga- ted	Ø 16 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 553	
		Ø 19 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 551	
		Ø 22 x 2 mm	0.10 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 550	
	brass, corruga- ted	Ø 16 x 2 mm	0.10 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 605	
		Ø 19 x 2 mm	0.10 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 600	
		Ø 22 x 2 mm	0.08 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 601	
	goat hair, grey	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 575	
	horsehair, grey	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 576	
	horsehair, silver-grey	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 577	
	Chungking bristles, white	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 578	
	cotton	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 579	
	Scotch Brite, rough	Ø 10 mm		Ø 2.35 x 30 mm	10000 1/min	10 pieces	0 570 582	
	bristles, white	Ø 16 x 1 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 653	
		Ø 19 x 1 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 652	
		Ø 22 x 1 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 651	

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Polishing brushes shank Ø 2,35 mm

Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
								1 p.	50 p.
bristles, black	Ø 16 x 1 mm			Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 703		
	Ø 19 x 1 mm			Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 702		
	Ø 22 x 1 mm			Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 701		
nylon	Ø 16 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 752		
	Ø 19 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 753		
	Ø 22 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 750		
goat hair, white	Ø 16 x 1 mm			Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 851		
	Ø 22 x 1 mm			Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 850		

 matching set

	Price from		
Order No.	1 set	3 set	
Set polishing brushes			
The set contains 12 brushes in the shape of a wheel, Ø 10 mm, shaft Ø 2.35 x 40 mm with the following fill material:	0 570 887		
<ul style="list-style-type: none"> • Order No. 0 570 574 goat hair, white • Order No. 0 570 577 horse hair • Order No. 0 570 575 goat hair, grey • Order No. 0 570 580 stainless steel • Order No. 0 570 581 steel wire • Order No. 0 570 606 brass wire • Order No. 0 570 705 Chung King bristle, black • Order No. 0 570 578 Chung King bristle, white • Order No. 0 570 240 Muslin • Order No. 0 570 579 cotton • Order No. 0 570 582 cotch-Brite, coarse • Order No. 0 570 541 Nylon, smooth, white, 0.2 mm 			



Polishing brushes shank Ø 3 mm

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Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Price from		
							Order No.	1 p.	50 p.
Polishing brushes, shank Ø 3 mm									
cup									
	BAE steel, corrugated	Ø 8 x 5 mm Ø 10 x 6 mm	0.08 mm 0.08 mm	straight straight	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 587	
	BAE steel, corrugated	Ø 12 x 6 mm Ø 12 x 6 mm	0.08 mm 0.10 mm	straight bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 568	
	bristles, black	Ø 8 x 4 mm Ø 12 x 8 mm Ø 12 x 8 mm		bevelled straight bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 775	
	bristles, white	Ø 8 x 4 mm Ø 12 x 8 mm Ø 12 x 8 mm		bevelled straight bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 777	
	brass, corrugated	Ø 6.5 x 4 mm / 0.08 mm Ø 6.5 x 4 mm / 0.10 mm Ø 12 x 6 mm	0.08 mm 0.10 mm 0.08 mm	bevelled bevelled straight	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 785	
	nylon	Ø 12 x 6 mm Ø 12 x 6 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 614	
	horse hair, black	Ø 25 x 15 mm		bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 779	
	Steel wire, corrugated	Ø 6.5 x 4 mm	0.08 mm	bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 787	
	V2A wire, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 521	
	V2A wire, corrugated	Ø 12 x 6 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 736	
	goat hair, grey	Ø 25 x 15 mm		bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 874	
	goat hair, white	Ø 8 x 4 mm Ø 12 x 8 mm		bevelled bevelled	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 773	
small brushes									
	BAE steel, corrugated	Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 564	
	bristles, black	Ø 4 x 8 mm Ø 5.5 x 11 mm Ø 7 x 13 mm			Ø 3 x 30 mm Ø 3 x 30 mm Ø 3 x 30 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 727	
	bristles, white	Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm			Ø 3 x 30 mm Ø 3 x 30 mm Ø 3 x 30 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 737	
	brass, corrugated	Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 728	
	V2A wire, corrugated	Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm Ø 3 x 30 mm Ø 3 x 30 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 668	
	V2A wire, corrugated	Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 676	
	goat hair, white	Ø 6 x 13 mm Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 677	
	goat hair, white	Ø 4 x 8 mm Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 625	
	goat hair, white	Ø 4 x 8 mm Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 626	
	V2A wire, corrugated	Ø 3 x 8 mm Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm Ø 3 x 30 mm Ø 3 x 30 mm	10000 1/min 10000 1/min 10000 1/min	10 pieces 10 pieces 10 pieces	0 570 761	
	V2A wire, corrugated	Ø 4 x 8 mm Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 762	
	V2A wire, corrugated	Ø 5.5 x 11 mm Ø 6 x 13 mm	0.10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 763	
	goat hair, white	Ø 4 x 8 mm Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 729	
	goat hair, white	Ø 4 x 8 mm Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 679	
	goat hair, white	Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 760	

Polishing brushes shank Ø 3 mm

Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Price from		
							Order No.	1 p.	50 p.
small brushes with elastic protection									
	BAE steel, corrugated	Ø 4 x 8 mm	0.10 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 567		
	bristles, black	Ø 4 x 8 mm		Ø 3 x 25 mm	10000 1/min	10 pieces	0 570 719		
	bristles, white	Ø 4 x 8 mm		Ø 3 x 25 mm	10000 1/min	10 pieces	0 570 678		
	brass, corrugated	Ø 4 x 8 mm	0.10 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 764		
	V2A wire, corrugated	Ø 4 x 8 mm	0.10 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 765		
wheel									
	BAE steel, corrugated	Ø 16 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 770		
		Ø 19 x 2 mm	0.08 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 771		
		Ø 22 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 554		
	cotton	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 794		
	bristles, black	Ø 16 x 1 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 709		
		Ø 19 x 1 mm		Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 708		
		Ø 22 x 1 mm		Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 731		
	bristles, white	Ø 16 x 1 mm		Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 657		
		Ø 19 x 1 mm		Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 656		
		Ø 22 x 1 mm		Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 732		
	Chungking bristles, black	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 793		
	Chungking bristles, white	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 792		
	brass, corrugated	Ø 10 mm	0.08 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 795		
		Ø 16 x 2 mm	0.10 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 769		
		Ø 19 x 2 mm	0.10 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 607		
		Ø 22 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 603		
		Ø 32 x 2 mm	0.10 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 602		
	nylon	Ø 16 x 1.5 mm	0.15 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 767		
		Ø 19 x 1.5 mm	0.15 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 768		
		Ø 22 x 1.5 mm	0.15 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 755		
	horsehair, grey	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 790		
	horsehair, silver-grey	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 791		
	Scotch Brite, rough	Ø 10 mm		Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 798		
	Steel wire, corrugated	Ø 10 mm	0.08 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 797		
	V2A wire, corrugated	Ø 16 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 772		
		Ø 19 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 508		
		Ø 22 x 2 mm	0.08 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 506		
	VA wire, corrugated	Ø 10 mm	0.08 mm	Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 796		
		Ø 12 mm	0.06 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 584		
		Ø 14 mm	0.06 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 586		

Polishing brushes shank Ø 3 mm

Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Price from	
							Order No.	1 p. 50 p.
goat hair, grey	Ø 10 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 789	
goat hair, white	Ø 10 mm			Ø 3 x 30 mm	10000 1/min	10 pieces	0 570 788	
	Ø 16 x 1 mm			Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 766	
	Ø 22 x 1 mm			Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 730	

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Polishing brushes shank Ø 6 mm

Material	Head dimensions	Trimming Ø	Shank dimensions	Rotation speed max.	Price from	
					Order No.	1 piece 25 pieces
Polishing brushes, shank Ø 6 mm						
wheel						
goat hair	Ø 45 / 25 x 4 mm	0.10 mm	Ø 6 x 40 mm	10000 1/min	0 570 243	
cotton	Ø 45 / 25 x 4 mm		Ø 6 x 40 mm	10000 1/min	0 570 246	
fleece, 8 layers	Ø 80 / 40 x 8 mm		Ø 6 x 40 mm	10000 1/min	0 570 144	
perlon	Ø 45 / 25 x 4 mm	0.30 mm	Ø 6 x 40 mm	10000 1/min	0 570 244	
bristles, black	Ø 45 / 25 x 4 mm		Ø 6 x 40 mm	10000 1/min	0 570 245	
brass wire	Ø 30 / 18 x 6 mm	0.10 mm	Ø 6 x 40 mm	10000 1/min	0 570 223	
	Ø 50 / 25 x 6 mm	0.10 mm	Ø 6 x 40 mm	10000 1/min	0 570 229	
Bessemer wire	Ø 45 / 25 x 4 mm	0.10 mm	Ø 6 x 40 mm	10000 1/min	0 570 241	

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Diamond polishing brushes shank Ø 3 mm

Material	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	5 pieces	10 pieces
Polishing brushes, shank Ø 3 mm								
cup								
Nylon-Diamond	Ø 25 x 8 mm	# 400	Ø 3 x 30 mm	10000 1/min	0 572 370			
	Ø 25 x 8 mm	# 600	Ø 3 x 30 mm	10000 1/min	0 572 371			
	Ø 25 x 8 mm	# 800	Ø 3 x 30 mm	10000 1/min	0 572 372			
	Ø 14 x 7 mm	# 400	Ø 3 x 30 mm	10000 1/min	0 572 373			
	Ø 14 x 7 mm	# 600	Ø 3 x 30 mm	10000 1/min	0 572 374			
	Ø 14 x 7 mm	# 800	Ø 3 x 30 mm	10000 1/min	0 572 375			
Nylon-SiC	Ø 25 x 8 mm	# 120	Ø 3 x 30 mm	10000 1/min	0 572 385			
	Ø 25 x 8 mm	# 320	Ø 3 x 30 mm	10000 1/min	0 572 386			
	Ø 25 x 8 mm	# 500	Ø 3 x 30 mm	10000 1/min	0 572 387			
	Ø 30 x 8 mm	# 120	Ø 3 x 30 mm	10000 1/min	0 572 388			
	Ø 30 x 8 mm	# 320	Ø 3 x 30 mm	10000 1/min	0 572 389			
	Ø 30 x 8 mm	# 500	Ø 3 x 30 mm	10000 1/min	0 572 390			
wheel								
Nylon-Diamond	Ø 20 x 2 mm	# 400	Ø 3 x 30 mm	10000 1/min	0 572 376			
	Ø 20 x 2 mm	# 600	Ø 3 x 30 mm	10000 1/min	0 572 377			
	Ø 20 x 2 mm	# 800	Ø 3 x 30 mm	10000 1/min	0 572 378			
	Ø 25 x 2 mm	# 400	Ø 3 x 30 mm	10000 1/min	0 572 379			
	Ø 25 x 2 mm	# 600	Ø 3 x 30 mm	10000 1/min	0 572 380			
	Ø 25 x 2 mm	# 800	Ø 3 x 30 mm	10000 1/min	0 572 381			

Diamond polishing brushes shank Ø 6 mm

Material	Head dimen-sions	Grit size	Shank dimen-sions	Rotation speed max.	Order No.	Price from		
						1 piece	5 pieces	10 pieces
Polishing brushes, shank Ø 6 mm								
cup								
Nylon-SiC	Ø 40 x 24 mm	# 80	Ø 6 x 40 mm	10000 1/min	0 572 400			
	Ø 40 x 24 mm	# 120	Ø 6 x 40 mm	10000 1/min	0 572 401			
	Ø 40 x 24 mm	# 240	Ø 6 x 40 mm	10000 1/min	0 572 402			
	Ø 50 x 24 mm	# 80	Ø 6 x 40 mm	10000 1/min	0 572 403			
	Ø 50 x 24 mm	# 120	Ø 6 x 40 mm	10000 1/min	0 572 404			
	Ø 50 x 24 mm	# 240	Ø 6 x 40 mm	10000 1/min	0 572 405			
wheel								
Nylon-SiC	Ø 40 x 10 mm	# 80	Ø 6 x 40 mm	10000 1/min	0 572 391			
	Ø 40 x 10 mm	# 120	Ø 6 x 40 mm	10000 1/min	0 572 392			
	Ø 40 x 10 mm	# 240	Ø 6 x 40 mm	10000 1/min	0 572 393			
	Ø 50 x 10 mm	# 80	Ø 6 x 40 mm	10000 1/min	0 572 394			
	Ø 50 x 10 mm	# 120	Ø 6 x 40 mm	10000 1/min	0 572 395			
	Ø 50 x 10 mm	# 240	Ø 6 x 40 mm	10000 1/min	0 572 396			
	Ø 65 x 10 mm	# 80	Ø 6 x 40 mm	10000 1/min	0 572 397			
	Ø 65 x 10 mm	# 120	Ø 6 x 40 mm	10000 1/min	0 572 398			
	Ø 65 x 10 mm	# 240	Ø 6 x 40 mm	10000 1/min	0 572 399			

Polishing buff wheels shank Ø 2.35 mm

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	Material	Layers	Head dimensions	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from
								1 piece 50 pieces
Polishing buff wheels, shank Ø 2.35 mm								
	fine cotton		Ø 22 x 6 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 900	
	felt	3 layers	Ø 22 x 6 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 980	
	deerskin	5 layers	Ø 22 x 8 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 800	
	muslin	16 layers	Ø 22 x 3 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 990	
	fleece	16 layers	Ø 21 x 3 mm	Ø 2.35 x 40 mm	10000 1/min	10 pieces	0 570 143	

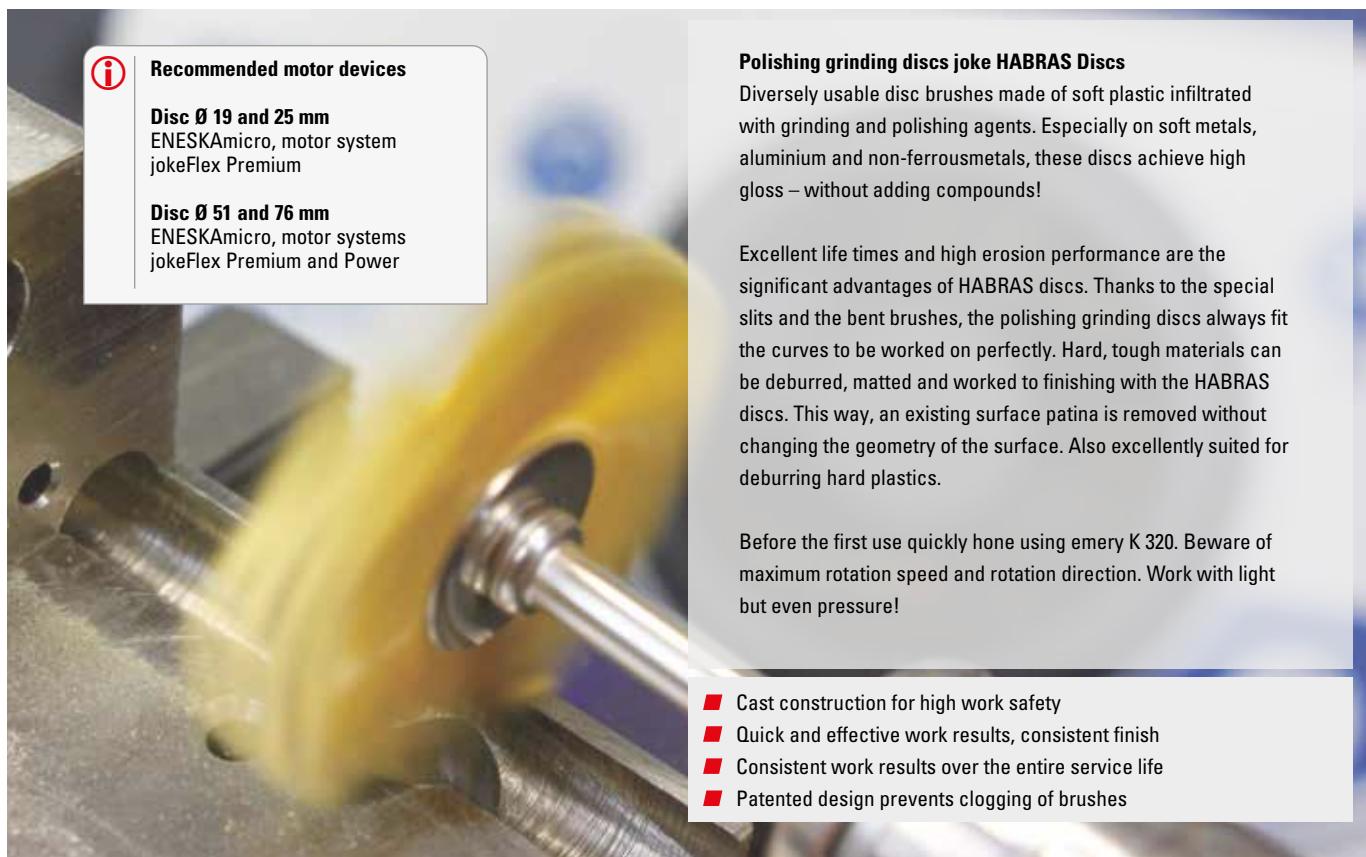


Polishing buff wheels shank Ø 3 mm

	Material	Layers	Head dimensions	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from
								1 piece 50 pieces
Polishing buff wheels, shank Ø 3 mm								
	fine cotton		Ø 22 x 6 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 900-0	
	felt	3 layers	Ø 22 x 6 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 984	
	deerskin	5 layers	Ø 22 x 8 mm	Ø 3 x 37 mm	10000 1/min	10 pieces	0 570 801	



Polishing grinding discs joke HABRAS Discs



Overview HABRAS discs				Available diameters							
Use	Abrasive	Grit size	Colour	Ø 19 mm		Ø 25 mm*		Ø 51 mm		Ø 76 mm	
				with shank Ø 3 x 40 mm	with shank Ø 3 x 40 mm	with shank Ø 6 x 40 mm	without shank	with shank Ø 6 x 40 mm	without shank	with shank Ø 6 x 40 mm	without shank
Deburring, Matting	Corundum	extra coarse P 36	brown	✗	✓ 0571067	✗	✗	✗	✗	✗	✗
		very coarse P 50	green	✗	✓ 0571068	✗	✗	✗	✗	✗	✗
		coarse P 80	yellow	✓ 0571031	✓ 0571061	✓ 0571501	✓ 0571521	✓ 0571511	✓ 0571531	✓ 0571519	✓ 0571539
Deburring, Matting, Cross fading		medium P 120	white	✗	✓ 0571069	✓ 0571509	✓ 0571529	✓ 0571519	✓ 0571539	✓ 0571519	✓ 0571539
		standard P 220	red	✓ 0571032	✓ 0571062	✓ 0571502	✓ 0571522	✓ 0571512	✓ 0571532	✓ 0571512	✓ 0571532
Matting, Cleaning	Pumic stone	fine P 400	blue	✓ 0571033	✓ 0571063	✓ 0571503	✓ 0571523	✓ 0571513	✓ 0571533	✓ 0571513	✓ 0571533
Cleaning, Finishing		very fine –	pink	✓ 0571034	✗	✓ 0571504	✓ 0571524	✓ 0571514	✓ 0571534	✓ 0571514	✓ 0571534
Finishing	High-grade corundum (EKR)	extra fine 6 µm	orange	✓ 0571035	✗	✓ 0571505	✓ 0571525	✓ 0571515	✓ 0571535	✓ 0571515	✓ 0571535
		ultra fine 1 µm	light green	✓ 0571036	✗	✓ 0571506	✓ 0571526	✓ 0571516	✓ 0571536	✓ 0571516	✓ 0571536

* HABRAS Pro: The especially robust version.

Polishing grinding discs joke HABRAS Discs shank Ø 3 x 40 mm

joke HABRAS discs are characterised by excellent service life and uniform stock removal. Work is performed directly without addition of compounds. Especially for mirror-polishing soft metals, aluminium and non-ferrous metals. Hard, tough metals such as titanium and stainless steels can be matted and mirror-polished. Any existing surface patina is removed without changing the surface geometry. Well suited for deburring hard plastics. Owing to their slotted design, joke HABRAS discs adapt to the surface shape.

TIP: briefly dress joke HABRAS discs before first time use and observe the maximum speed and direction of rotation. Work with light but even working pressure.

Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Polishing grinding discs joke HABRAS Discs, shank Ø 3 x 40 mm									
corundum									
	coarse	Ø 19 mm	P 80	yellow	Ø 3 x 40 mm	5,000 1/min	0 571 031		
	standard	Ø 19 mm	P 220	red	Ø 3 x 40 mm	5,000 1/min	0 571 032		
	fine	Ø 19 mm	P 400	blue	Ø 3 x 40 mm	5,000 1/min	0 571 033		
Pumice									
	very fine	Ø 19 mm		pink	Ø 3 x 40 mm	5,000 1/min	0 571 034		
extra fine high-grade corundum									
	high gloss	Ø 19 mm	1 µm	light green	Ø 3 x 40 mm	5,000 1/min	0 571 036		
	shine	Ø 19 mm	6 µm	orange	Ø 3 x 40 mm	5,000 1/min	0 571 035		


TIP:

The worn grinding discs can be replaced! In doing so, you can reuse the shanks!

Replacement discs for shank mounting on page 174!

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Polishing grinding discs joke HABRAS Discs Pro shank Ø 3 x 40 mm

Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Polishing grinding discs joke HABRAS Discs Pro, shank Ø 3 x 40 mm									
corundum									
extra coarse	Ø 25 x 4 mm	P 36	brown	Ø 3 x 37 mm	5,000 1/min	0 571 067			
very coarse	Ø 25 x 4 mm	P 50	green	Ø 3 x 37 mm	5,000 1/min	0 571 068			
coarse	Ø 25 x 4 mm	P 80	yellow	Ø 3 x 37 mm	5,000 1/min	0 571 061			
medium	Ø 25 x 4 mm	P 120	white	Ø 3 x 37 mm	5,000 1/min	0 571 069			
standard	Ø 25 x 4 mm	P 220	red	Ø 3 x 37 mm	5,000 1/min	0 571 062			
extra fine high-grade corundum									
fine	Ø 25 x 4 mm	P 400	blue	Ø 3 x 37 mm	5,000 1/min	0 571 063			

Polishing grinding discs joke HABRAS Discs shank Ø 6 x 40 mm

Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Polishing grinding discs joke HABRAS Discs, 4 layers, shank Ø 6 x 40 mm									
corundum									
coarse	Ø 51 x 5 mm Ø 76 x 5 mm	P 80 P 80	yellow yellow	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 501 0 571 511			
medium	Ø 51 x 5 mm Ø 76 x 5 mm	P 120 P 120	white white	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 509 0 571 519			
standard	Ø 51 x 5 mm Ø 76 x 5 mm	P 220 P 220	red red	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 502 0 571 512			
fine	Ø 51 x 5 mm Ø 76 x 5 mm	P 400 P 400	blue blue	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 503 0 571 513			
Pumice									
	very fine	Ø 51 x 5 mm	very fine	pink	Ø 6 x 40 mm	1,400 1/min	0 571 504		
extra fine high-grade corundum									
shine	Ø 51 x 5 mm Ø 76 x 5 mm	6 µm 6 µm	orange orange	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 505 0 571 515			
high gloss	Ø 51 x 5 mm Ø 76 x 5 mm	1 µm 1 µm	light green light green	Ø 6 x 40 mm Ø 6 x 40 mm	1,400 1/min 1,400 1/min	0 571 506 0 571 516			

Polishing grinding discs joke HABRAS Discs without shank for self-assembly



HABRAS Discs without shank

Simply go and make yourself your own HABRAS disc tool! The individual solution tailored to your application.

The individually available HABRAS discs are supplied in the same versions, grit sizes and diameters as the shank-mounted discs.

Dimensions	Drilling dimension	Polish	Grit size	Colour	Recommended speed	Packing quantity	Order No.	Price from		
								1 pack	5 packs	10 packs
Polishing grinding discs joke HABRAS without shank										
	Ø 19 mm	1.8 mm	coarse	P 80	yellow	5.000 1/min	4 pieces	0 571 037		
		1.8 mm	coarse	P 80	yellow	5.000 1/min	48 pieces	0 571 043		
		1.8 mm	medium	P 120	white	5.000 1/min	4 pieces	0 571 075		
		1.8 mm	medium	P 120	white	5.000 1/min	48 pieces	0 571 076		
		1.8 mm	standard	P 220	red	5.000 1/min	4 pieces	0 571 038		
		1.8 mm	standard	P 220	red	5.000 1/min	48 pieces	0 571 044		
		1.8 mm	fine	P 400	blue	5.000 1/min	4 pieces	0 571 039		
		1.8 mm	fine	P 400	blue	5.000 1/min	48 pieces	0 571 045		
		1.8 mm	very fine	very fine	pink	5.000 1/min	4 pieces	0 571 040		
		1.8 mm	very fine	very fine	pink	5.000 1/min	48 pieces	0 571 046		
		1.8 mm	shine	6 µm	orange	5.000 1/min	4 pieces	0 571 041		
		1.8 mm	shine	6 µm	orange	5.000 1/min	48 pieces	0 571 047		
		1.8 mm	high gloss	1 µm	light green	5.000 1/min	4 pieces	0 571 042		
		1.8 mm	high gloss	1 µm	light green	5.000 1/min	48 pieces	0 571 048		

Dimensions	Drilling dimension	Polish	Grit size	Colour	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Polishing grinding discs joke HABRAS without shank									
	Ø 51 x 5 mm	5 mm	coarse	P 80	yellow	1,400 1/min	0 571 521		
		5 mm	medium	P 120	white	1,400 1/min	0 571 529		
		5 mm	standard	P 220	red	1,400 1/min	0 571 522		
		5 mm	fine	P 400	blue	1,400 1/min	0 571 523		
		5 mm	very fine	very fine	pink	1,400 1/min	0 571 524		
		5 mm	shine	6 µm	orange	1,400 1/min	0 571 525		
		5 mm	high gloss	1 µm	light green	1,400 1/min	0 571 526		
	Ø 76 x 5 mm	5 mm	coarse	P 80	yellow	1,400 1/min	0 571 531		
		5 mm	medium	P 120	white	1,400 1/min	0 571 539		
		5 mm	standard	P 220	red	1,400 1/min	0 571 532		
		5 mm	fine	P 400	blue	1,400 1/min	0 571 533		
		5 mm	shine	6 µm	orange	1,400 1/min	0 571 535		
		5 mm	high gloss	1 µm	light green	1,400 1/min	0 571 536		



Matching mounting shanks on page 220:

- for discs Ø 19 mm: type 21, 22, 23, 24, 25, 26, 27
- for discs Ø 51 and 76 mm: type 41, 42

Note: 4 layers are bound together here to form a disc

Polishing grinding brushes joke HABRAS

shank Ø 3 x 40 mm

Polishing grinding brushes joke HABRAS

The carrier material of these polishing grinding brushes consists of nylon fibre, the characteristics of which, such as elasticity and bend-resistance are of advantage for all applications. The silicon carbide and corundum abrasives are applied with even distribution in the individual fibres.

Owing to the different grit sizes, the brushes in the HABRAS series are highly versatile in use. During processing, the HABRAS brushes are characterised above all by high stability with simultaneously low dust production.

Use for example for deburring cutting edges in carbide metal. Simply condition on K 320 emery before using for the first time!



HABRAS brushes and HABRAS

discs – what is the difference?

In both versions, the grit is embedded in the carrier material and is not released during work. Consequently, the result is consistent until completely worn out.

The discs are manufactured in their entirety using the injection moulding method and are only available as wheels. In the case of the brushes, the nylon fibres are grouped together as a pencil, wheel or cup. In contrast to the discs, it is not necessary to observe the direction of rotation in this case!

	Abra-sive	Fibre	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from	1 piece	10 pieces
Polishing grinding brushes joke HABRAS											
cup											
 corundum	coarse	Ø 12 / 6 mm	P 320	blue/red	Ø 3 x 40 mm	2800 1/min	0 571 013				
	medium	Ø 12 / 6 mm	P 500	blue/green	Ø 3 x 40 mm	2800 1/min	0 571 012				
	fine	Ø 12 / 6 mm	P 600	blue	Ø 3 x 40 mm	2800 1/min	0 571 011				
 SiC	coarse	Ø 12 / 6 mm	P 320	green	Ø 3 x 40 mm	2800 1/min	0 571 016				
	medium	Ø 12 / 6 mm	P 500	red	Ø 3 x 40 mm	2800 1/min	0 571 015				
	extra fine	Ø 12 / 6 mm	P 800	white	Ø 3 x 40 mm	2800 1/min	0 571 014				
small brushes											
 corundum	coarse	Ø 5 / 8 mm	P 320	blue/red	Ø 3 x 40 mm	6000 1/min	0 571 023				
	medium	Ø 5 / 8 mm	P 500	blue/green	Ø 3 x 40 mm	6000 1/min	0 571 022				
	fine	Ø 5 / 8 mm	P 600	blue	Ø 3 x 40 mm	6000 1/min	0 571 021				
 SiC	coarse	Ø 5 / 8 mm	P 320	green	Ø 3 x 40 mm	6000 1/min	0 571 026				
	medium	Ø 5 / 8 mm	P 500	red	Ø 3 x 40 mm	6000 1/min	0 571 025				
	extra fine	Ø 5 / 8 mm	P 800	white	Ø 3 x 40 mm	6000 1/min	0 571 024				
wheel											
 corundum	coarse	Ø 22 mm	P 320	blue/red	Ø 3 x 37 mm	6000 1/min	0 571 003				
	medium	Ø 22 mm	P 500	blue/green	Ø 3 x 37 mm	6000 1/min	0 571 002				
	fine	Ø 22 mm	P 600	blue	Ø 3 x 37 mm	6000 1/min	0 571 001				
 SiC	coarse	Ø 22 mm	P 320	green	Ø 3 x 37 mm	6000 1/min	0 571 006				
	medium	Ø 22 mm	P 500	red	Ø 3 x 37 mm	6000 1/min	0 571 005				
	extra fine	Ø 22 mm	P 800	white	Ø 3 x 37 mm	6000 1/min	0 571 004				

Convolute compact grinding discs

Convolute compact grinding discs

Wound, not pressed. These special grinding discs have been developed for the demanding preliminary and final processing of surfaces of the widest array of materials. They result from winding nylon fleece fabric around a hard core. Beforehand, the fabric is wetted with a special abrasive resin system. The winding results in a very uniform structure with which the direction of rotation must nevertheless be observed.

The discs are available in two abrasive finishes grit sizes in addition to three hardnesses.

The advantages:

- long service life
- consistent stock removal, dust-free
- highly resistant with only minor edge wear
- little contact heating
- no smearing of the surface
- rapid and easy profiling
- simple to use = efficient work
- optimally adapts to the workpiece
- no workpiece damage



Hardness grades

- 9 = extra hard
8 = hard
7 = medium/hard



	Dimensions	Drilling dimension	Hardness	Grit size	Rotation speed max.	Order No.	Price from
							1 piece
Convolute compact grinding discs							
Corundum							
	The best choice for working on steel, aluminium, zinc, die-cast metal and brass.	Ø 150 x 12.5 mm Ø 200 x 25.4 mm	25.4 mm 76.2 mm	8 7	A-Medium A-Medium	5500 1/min 4500 1/min	0 430 021 0 430 022
Silicon carbide							
	For final finishing on stainless steel, titanium, cobalt chrome and nickel alloys.	Ø 150 x 12.5 mm Ø 150 x 25.4 mm Ø 200 x 25.4 mm Ø 200 x 25.4 mm Ø 200 x 25.4 mm	25.4 mm 25.4 mm 76.2 mm 76.2 mm 76.2 mm	7 7 7 7 9	S-Fine S-Fine S-medium S-Fine S-medium	5500 1/min 5500 1/min 4500 1/min 4500 1/min 4500 1/min	0 430 031 0 430 033 0 430 036 0 430 037 0 430 040 0 430 041



Applications for the convolute compact grinding discs

Application	Specification	Recommended working speed
Cleaning: general cleaning, removal of rust, oxidation and slight scale, cleaning of pipe threads and slight casting burrs	6 S-Fine 7 S-Fine 8 S-Fine	11 – 32 m/sec.
Deburring: mouldings and milled parts, rounding of edges on metal parts, slight deburring of piston rings and other metal parts	7 S-Medium 8 S-Medium 9 S-Medium 9 S-Fine	28 – 41 m/sec.
Overlaying: turbine blades, preparation of surfaces before galvanising, forging flashes on turbine blades, overlaying sanding marks of grit size 60/80/120	7 S-Fine 8 A-Medium	28 – 41 m/sec.
Final finishing: satin finishing, finishing of aluminium parts, final surface finishing before coating, final finishing of cutlery, final finishing of hand-held tools before coating	S-Med finishing S-Fine finishing 8 S-Fine 9 S-Fine	2 – 15 m/sec.

Round brushes with nylon grinding bristles

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Round brushes with nylon grinding bristles

The nylon fibres of these brushes are interspersed with silicon carbide. The latter is constantly released during work and a highly even grinding effect with a highly uniform ground section is produced.

The nylon polishing bristles are extremely elastic and flexible and consequently absolutely unbreakable. The trimming area does not clog with work residues during deployment and the polishing effect remains constantly high throughout the entire working period. Suitable for wet and dry use.



Further advantages:

- long service life
- only very light contact pressure required
- low heat generation
- usable for clockwise and anticlockwise running
- suitable for machine and manual use

Dimensions	Grit size	Drilling dimension	Rotation speed max.	Order No.	Price from
Round brushes with nylon grinding bristles (silicon-carbide-embedded)					1 piece 3 pieces
	Ø 75 x 12 mm	K 80	15.9 mm	20000 1/min	0 571 370
		K 120	15.9 mm	20000 1/min	0 571 371
		K 180	15.9 mm	20000 1/min	0 571 372
		K 320	15.9 mm	20000 1/min	0 571 373
	Ø 100 x 13 mm	K 80	15.9 mm	12000 1/min	0 571 374
		K 120	15.9 mm	12000 1/min	0 571 375
		K 180	15.9 mm	12000 1/min	0 571 376
		K 320	15.9 mm	12000 1/min	0 571 377
	Ø 125 x 16 mm	K 80	15.9 mm	12000 1/min	0 571 378
		K 120	15.9 mm	12000 1/min	0 571 379
		K 180	15.9 mm	12000 1/min	0 571 380
		K 320	15.9 mm	12000 1/min	0 571 381
	Ø 150 x 18 mm	K 80	20 mm	6000 1/min	0 571 382
		K 120	20 mm	6000 1/min	0 571 383
		K 180	20 mm	6000 1/min	0 571 384
		K 320	20 mm	6000 1/min	0 571 385

Accessories / spare parts

	for bore dimensions	Shank dimensions	Price from
Clamping mandrel		Order No.	1 piece
	using this clamping mandrel, the round brushes Ø 75, 100 and 125 mm can be operated manually on the jokeFlex Power motor unit.	Ø 15.9 mm Ø 6 x 40 mm	0 571 400

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Polishing buffing discs OPTI for use on polishing machines

Polishing buffing discs OPTI

These discs are used on stationary polishing machines in conjunction with solid polishing compounds (Dialux).

Available in two versions:

Cotton, soft:

- highly adaptable
- use for final polishing

Cotton, hard (quilted):

- very firm
- high stock removal rates
- highly dimensionally stable



	Head dimensions	Material	Drilling dimension	Rotation speed max.	Order No.	Price from 1 piece
Polishing buffing discs OPTI						
	Ø 200 x 20 mm	cotton, soft	15.9 mm	3000 1/min	0 041 622	
		cotton, hard (quilted)	15.9 mm	3000 1/min	0 041 623	
	Ø 250 x 25 mm	cotton, soft	20 mm	3000 1/min	0 041 632	
		cotton, hard (quilted)	20 mm	3000 1/min	0 041 633	

The perfect complement

OPTI polish

The ideal polishing machine for fine machining



Order No.
0 041 620-0



The perfect complement

Dialux polishing compound

- polishing compounds in "bar form"
- use up to finishing stage
- perfect for use with felts, brushes and buffers



Order No.
0 580 560

The perfect complement

Protective goggles

- Clear, optically correct, scratchproof PC glasses
- Comfort cushions on the sidepiece ends
- Soft nose pad



Order No.
0 203 083-1

The perfect complement

Universal-Spray joke X 73020

- Five products rolled into one: corrosion protection, cleaning, water repellence, lubrication and preservation
- Cleans surfaces and cares for tools



Order No.
0 580 526

Drilling brushes

Drilling brushes

Do you often struggle with heavy burrs on tough materials? From now on, the odds will be in your favour, for we are providing you with the appropriate "weapon" in the form of these new brushes.

The special feature: triangular piano wire is used as the trimming, which is additionally twisted again around its own axis.

The drilling brushes are available with three different head versions:

1. Wire, oval: for readily accessible transverse holes.
2. Wire, crossed: for transverse holes and end face processing in addition to non-concentric holes.
3. Wire, knotted: for transverse holes at the bottom of the blind hole. For removing very heavy burrs.

	Head dimensions	Trimming Ø	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from		
							1 piece	3 pieces	5 pieces
Drilling brushes									
Wire, crossed									
	Ø 3 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 1/min	0 571 721			
	Ø 4 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 1/min	0 571 722			
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 1/min	0 571 723			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 1/min	0 571 724			
	Ø 7 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 1/min	0 571 725			
	Ø 8 x 35 mm	Ø 0.7 mm	Ø 5 x 45 mm	100 mm	700 1/min	0 571 726			
Wire, oval									
	Ø 3 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 1/min	0 571 701			
	Ø 4 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 1/min	0 571 702			
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 1/min	0 571 703			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 1/min	0 571 704			
	Ø 7 x 40 mm	Ø 0.7 mm	Ø 5 x 40 mm	100 mm	700 1/min	0 571 705			
	Ø 8 x 40 mm	Ø 0.7 mm	Ø 5 x 40 mm	100 mm	700 1/min	0 571 706			
	Ø 9 x 45 mm	Ø 0.7 mm	Ø 6 x 35 mm	100 mm	700 1/min	0 571 707			
Wire, knotted									
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 1/min	0 571 711			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 1/min	0 571 712			
	Ø 7 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 1/min	0 571 713			
	Ø 8 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 1/min	0 571 714			
	Ø 9 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 1/min	0 571 715			
	Ø 10 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 1/min	0 571 716			
	Ø 11 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 1/min	0 571 717			



The drilling brushes are available with three different head versions:

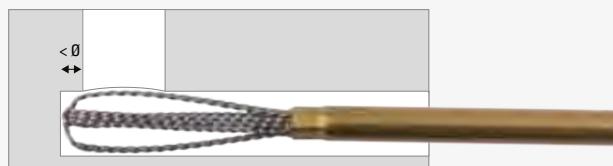
1. **Wire, oval:** for readily accessible transverse holes.



2. **Wire, crossed:** for transverse holes and end face processing in addition to non-concentric holes.



3. **Wire, knotted:** for transverse holes at the bottom of the blind hole. For removing very heavy burrs.



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Jet brushes shaft with eyelets

Jet brushes

The solution for inner cleaning, dust removal and varnish removal for jets, pipes, hoses, threaded holes, crossed holes, cylinders and much more.

Created for real men capable of driving the brushes with sheer muscle power. For those with less brute force, the brushes can also be inserted using a cordless screw driver. To do this, simply cut off the eyelets. The jet brushes are wound clockwise.

Available with nylon trimming and corrugated wire made of brass, steel or stainless steel.

- Processing of (cross) drill holes, jets, cylinders etc.
- Optimum for deburring, dust removal and varnish removal
- Drive by muscle power or machine (cordless screw driver)
- Available in four trimming versions



A little thicker please!

For optimum results, select the following excess brush dimensions according to the drilling hole diameter:

- Drilling hole > 4 mm: approx. 10 – 15 %
- Drilling hole > 15 mm: approx. 20 – 25 %

	Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.	Price from	
						1 piece	
						10 pieces	
Jet brushes, cylinders, shaft with eyelets							
nylon							
		Excellent elasticity and durability. Resistant to solvents, but easily dissolved in acid. To shine, polish and clean. Possible to use with compounds.	Ø 2 x 100 mm	0.06 mm	Ø 1.4 x 200 mm	300 mm	0 571 240
			Ø 3 x 100 mm	0.10 mm	Ø 1.6 x 200 mm	300 mm	0 571 241
			Ø 4 x 100 mm	0.15 mm	Ø 1.4 x 200 mm	300 mm	0 571 200
			Ø 5 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	0 571 201
			Ø 6 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	0 571 202
			Ø 8 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 203
			Ø 10 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 204
			Ø 12 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 205
			Ø 15 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 206
			Ø 18 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 207
			Ø 20 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	0 571 208
			Ø 25 x 100 mm	0.35 mm	Ø 3.2 x 200 mm	300 mm	0 571 209
Corrugated brass wire							
		Silkier and softer grinding pattern than steel wires. Possible discolouration on workpiece. For polishing, descaling, deburring. Possible to use with and without compounds.	Ø 4 x 100 mm	0.08 mm	Ø 1.8 x 200 mm	300 mm	0 571 210
			Ø 5 x 100 mm	0.08 mm	Ø 1.8 x 200 mm	300 mm	0 571 211
			Ø 6 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	0 571 212
			Ø 8 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	0 571 213
			Ø 10 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	0 571 214
			Ø 12 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	0 571 215
			Ø 15 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	0 571 216
			Ø 18 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	0 571 217
			Ø 20 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	0 571 218
			Ø 25 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	0 571 219

Jet brushes shaft with eyelets

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	Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.	Price from	
						1 piece	10 pieces
Steel wire, corrugated							
	Bendable and elastic wire which leaves a significantly visible grinding pattern on the work piece. For pre-polishing, descaling, deburring. Possible to use with and without compounds.	Ø 4 x 100 mm Ø 5 x 100 mm Ø 6 x 100 mm Ø 8 x 100 mm Ø 10 x 100 mm Ø 12 x 100 mm Ø 15 x 100 mm Ø 18 x 100 mm Ø 20 x 100 mm Ø 25 x 100 mm	0.10 mm 0.10 mm 0.10 mm 0.15 mm 0.15 mm 0.15 mm 0.15 mm 0.15 mm 0.20 mm 0.20 mm	Ø 1.8 x 200 mm Ø 1.8 x 200 mm Ø 1.8 x 200 mm Ø 3.7 x 200 mm Ø 3.7 x 200 mm Ø 3.7 x 200 mm Ø 4.6 x 200 mm Ø 4.6 x 200 mm Ø 4.6 x 200 mm Ø 4.6 x 200 mm	300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm	0 571 220 0 571 221 0 571 222 0 571 223 0 571 224 0 571 225 0 571 226 0 571 227 0 571 228 0 571 229	
Stainless steel wire, corrugated							
	Comparable with steel wire but resistant to acids and alkalis. More break resistant than steel. Can also be used with water and leaves no rust residues on the material. For pre-polishing, descaling, deburring especially for stainless steels and aluminium. With and without compounds.	Ø 4 x 100 mm Ø 5 x 100 mm Ø 6 x 100 mm Ø 8 x 100 mm Ø 10 x 100 mm Ø 12 x 100 mm Ø 15 x 100 mm Ø 25 x 100 mm	0.10 mm 0.10 mm 0.10 mm 0.15 mm 0.15 mm 0.15 mm 0.15 mm 0.15 mm	Ø 1.8 x 200 mm Ø 1.8 x 200 mm Ø 1.8 x 200 mm Ø 1.8 x 200 mm Ø 3.7 x 200 mm Ø 3.7 x 200 mm Ø 4.6 x 200 mm Ø 4.6 x 200 mm	300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm 300 mm	0 571 230 0 571 231 0 571 232 0 571 233 0 571 234 0 571 235 0 571 236 0 571 239	

Jet brushes stainless steel shank with eyelets

	Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.	Price from	
						1 piece	10 pieces
Jet brush, cylinder, stainless steel shank with eyelets							
nylon							
	Very good elasticity, durability and resistance to solvents. For shining, polishing and cleaning. Can be used with compounds. What is special about these jet brushes is the stainless steel shank. This ensures that no corrosion forms when used with water.	2 x 100 mm 3 x 100 mm 4 x 100 mm 5 x 100 mm 6 x 100 mm 8 x 100 mm 10 x 100 mm 12 x 100 mm 20 x 100 mm 30 x 100 mm 40 x 100 mm 60 x 100 mm 100 x 100 mm	0.08 mm 0.10 mm 0.10 mm 0.10 mm 0.10 mm 0.15 mm 0.15 mm 0.15 mm 0.15 mm 0.30 mm 0.30 mm 0.30 mm 0.30 mm	Ø 0.93 x 200 mm Ø 1.50 x 200 mm Ø 2.22 x 200 mm Ø 2.96 x 200 mm Ø 3.33 x 200 mm Ø 3.70 x 200 mm Ø 3.70 x 200 mm Ø 4.62 x 200 mm	300 mm 300 mm	0 571 801 0 571 802 0 571 803 0 571 804 0 571 805 0 571 806 0 571 807 0 571 808 0 571 809 0 571 810 0 571 811 0 571 812 0 571 813	

Pipe brushes

nylon with silicon carbide

Pipe brushes

Pipe brushes are ideally suited for deburring and cleaning work in crossways drillings and insertions. The flexible trimming made of nylon or steel prevents breakage of the material even with the highest stress and deformation.

The pipe brushes are available in four different versions:

- nylon standard with silicon carbide
- nylon standard with corundum
- nylon-diamond
- steel without additional abrasive.

	Abrasive	Head dimensions	Grit size	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from 1 piece	Price from 10 pieces
Nylon silicon carbide pipe brushes									
SiC									
Using nylon pipe brushes smooths the surface and positively influences the latter for subsequent use. The twisted wire is zinc-coated. Linear use by hand and clockwise in machines.	SiC	Ø 0.7 x 12 mm	K 1000	Ø 0.42 mm	100 mm	700 1/min	0 571 101		
	SiC	Ø 1.2 x 12 mm	K 1000	Ø 0.47 mm	100 mm	700 1/min	0 571 102		
	SiC	Ø 1.9 x 18 mm	K 1000	Ø 0.74 mm	100 mm	700 1/min	0 571 103		
	SiC	Ø 2.2 x 18 mm	K 1000	Ø 0.94 mm	100 mm	700 1/min	0 571 104		
	SiC	Ø 2.6 x 25 mm	K 1000	Ø 1.08 mm	100 mm	700 1/min	0 571 105		
	SiC	Ø 3.2 x 25 mm	K 1000	Ø 1.66 mm	100 mm	700 1/min	0 571 106		
	SiC	Ø 3.5 x 25 mm	K 1000	Ø 1.66 mm	100 mm	700 1/min	0 571 107		
Nylon-corundum pipe brushes									
corundum									
Using nylon pipe brushes smooths the surface and positively influences the latter for subsequent use. The twisted wire is zinc-coated. Linear use by hand and clockwise in machines.	Corundum	Ø 4.2 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 1/min	0 571 108		
	Corundum	Ø 4.8 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 1/min	0 571 109		
	Corundum	Ø 5.5 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 1/min	0 571 110		
	Corundum	Ø 6.6 x 25 mm	K 600	Ø 3 mm	125 mm	700 1/min	0 571 111		
	Corundum	Ø 8.2 x 25 mm	K 600	Ø 3 mm	125 mm	700 1/min	0 571 112		
	Corundum	Ø 9.8 x 25 mm	K 600	Ø 3.4 mm	125 mm	700 1/min	0 571 113		
	Corundum	Ø 11.5 x 25 mm	K 600	Ø 3.4 mm	125 mm	700 1/min	0 571 114		
	Corundum	Ø 13.0 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 1/min	0 571 115		
	Corundum	Ø 16.0 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 1/min	0 571 116		
	Corundum	Ø 17.5 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 1/min	0 571 117		
	Corundum	Ø 19.4 x 25 mm	K 600	Ø 5.6 mm	125 mm	700 1/min	0 571 118		
	Corundum	Ø 22.6 x 25 mm	K 600	Ø 5.6 mm	125 mm	700 1/min	0 571 119		
	Corundum	Ø 25.8 x 25 mm	K 600	Ø 6.2 mm	125 mm	700 1/min	0 571 120		

Pipe brushes nylon with diamond

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	Abrasive	Head dimensions	Grit size	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from 1 piece	Price from 3 pieces
Nylon-diamond pipe brushes									
Diamond									
	Diamond	Ø 2 x 20 mm	K 400	Ø 1 mm	100 mm	700 1/min	0 571 121		
		Ø 2,5 x 20 mm	K 400	Ø 1 mm	100 mm	700 1/min	0 571 122		
		Ø 3 x 20 mm	K 400	Ø 1.5 mm	100 mm	700 1/min	0 571 123		
		Ø 3,5 x 20 mm	K 400	Ø 1.5 mm	100 mm	700 1/min	0 571 124		
		Ø 4 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 125		
		Ø 5 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 126		
		Ø 6 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 127		
		Ø 7 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 128		
		Ø 8 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 129		
		Ø 9 x 20 mm	K 400	Ø 3 mm	115 mm	700 1/min	0 571 130		
		Ø 10 x 20 mm	K 400	Ø 4 mm	115 mm	700 1/min	0 571 131		
		Ø 12 x 20 mm	K 400	Ø 6 mm	115 mm	700 1/min	0 571 132		

Pipe brushes Steel

	Trimming	Head dimensions	Trimming Ø	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from 1 piece	Price from 10 pieces
Steel pipe brushes									
	Steel	Ø 6 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 170		
		Ø 8 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 171		
		Ø 10 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 172		
		Ø 11 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 173		
		Ø 13 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 174		
		Ø 14 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 175		
		Ø 16 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 1/min	0 571 176		

Nylon honing brushes Novoflex-B

Nylon honing brushes Novoflex-B

An innovative tool for perfect results on surfaces or in bores. These silicon carbide abrasive balls have a flexible arrangement and therefore adapt to the processed surface – even in non-concentric bores. These brushes are useful for example for removing burr on all common materials. The Novoflex-B honing brushes leave a cross-grinding on the surface, which is the perfect carrier for an possible oil film. The surface is free from cold-shaped or deformed material. The only „hardware“ you need to work with these brushes is a conventionel hand drill. Honing machines or cordless screwdrivers can be used for serial production.

Possible applications:

- Motor cylinders
- Drive rods
- Bores on shafts and crank levers
- Pneumatic and hydraulic cylinders
- Valve guides
- Compressed air units
- Wheel brake cylinders
- Brake control cylinders
- Pipes and hoses
- Many more applications in the automotive, aeronautics and aerospace construction and in the firearms industry.



Tip: jet and pipe brushes are best suited for bores < 8 mm (see pages 180 and 182)!

Important points for the use of Novoflex-B nylon honing brushes?

1. Always choose the brush diameter according to the bore. If the desired brush size is not available, use the next larger one.
2. Always use the brushes with oil with a viscosity between 10 and 30 or with special honing oil. We also recommend joke lubricant X 73012.
3. Recommended speed: 350 – 700 rpm; Rotation: 60 – 120 strokes/min
4. Optimum processing time: approx. 20 to 40 seconds.

Nylon honing brushes Novoflex-B

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for bore dimensions	Head dimensions	Grit size	Shank dimensions	Total length	Price from Order No.	1 piece
Nylon honing brushes Novoflex-B						
Ø 8 mm	Ø 9 x 50 mm	120	Ø 3.7 mm	200 mm	0 571 300	
	Ø 9 x 50 mm	180	Ø 3.6 mm	200 mm	0 571 330	
Ø 10 mm	Ø 11 x 60 mm	120	Ø 3.7 mm	200 mm	0 571 301	
	Ø 11 x 60 mm	180	Ø 3.6 mm	200 mm	0 571 331	
Ø 11 mm	Ø 12 x 60 mm	120	Ø 3.7 mm	200 mm	0 571 302	
	Ø 12 x 60 mm	180	Ø 3.6 mm	200 mm	0 571 332	
Ø 12 mm	Ø 13 x 60 mm	120	Ø 3.7 mm	200 mm	0 571 303	
	Ø 13 x 60 mm	180	Ø 3.6 mm	200 mm	0 571 333	
Ø 14 mm	Ø 15.5 x 60 mm	120	Ø 3.7 mm	200 mm	0 571 304	
	Ø 15.5 x 60 mm	180	Ø 3.6 mm	200 mm	0 571 334	
Ø 16 mm	Ø 18 x 60 mm	120	Ø 4.6 mm	200 mm	0 571 305	
	Ø 18 x 60 mm	180	Ø 4.6 mm	200 mm	0 571 335	
Ø 18 mm	Ø 20 x 60 mm	120	Ø 4.6 mm	200 mm	0 571 306	
	Ø 20 x 60 mm	180	Ø 4.6 mm	200 mm	0 571 336	
Ø 20 mm	Ø 22 x 70 mm	120	Ø 4.6 mm	200 mm	0 571 307	
	Ø 22 x 70 mm	180	Ø 4.6 mm	200 mm	0 571 337	
Ø 22 mm	Ø 25 x 70 mm	120	Ø 4.6 mm	200 mm	0 571 308	
	Ø 25 x 70 mm	180	Ø 4.6 mm	200 mm	0 571 338	
Ø 24 mm	Ø 27 x 70 mm	120	Ø 5.1 mm	200 mm	0 571 309	
	Ø 27 x 70 mm	180	Ø 5.1 mm	200 mm	0 571 339	
Ø 25 mm	Ø 28 x 70 mm	120	Ø 5.1 mm	200 mm	0 571 310	
	Ø 28 x 70 mm	180	Ø 5.1 mm	200 mm	0 571 340	
Ø 27 mm	Ø 30 x 70 mm	120	Ø 5.1 mm	200 mm	0 571 311	
	Ø 30 x 70 mm	180	Ø 5.1 mm	200 mm	0 571 341	
Ø 29 mm	Ø 32 x 70 mm	120	Ø 5.1 mm	200 mm	0 571 312	
	Ø 32 x 70 mm	180	Ø 5.1 mm	200 mm	0 571 342	
Ø 32 mm	Ø 35 x 70 mm	120	Ø 5.1 mm	200 mm	0 571 313	
	Ø 35 x 70 mm	180	Ø 5.7 mm	200 mm	0 571 343	
Ø 35 mm	Ø 38 x 70 mm	120	Ø 5.7 mm	200 mm	0 571 314	
	Ø 38 x 70 mm	180	Ø 5.7 mm	200 mm	0 571 344	
Ø 38 mm	Ø 41 x 70 mm	120	Ø 5.7 mm	200 mm	0 571 315	
	Ø 41 x 70 mm	180	Ø 5.7 mm	200 mm	0 571 345	
Ø 42 mm	Ø 45 x 70 mm	120	Ø 5.7 mm	200 mm	0 571 316	
	Ø 45 x 70 mm	180	Ø 5.7 mm	200 mm	0 571 346	
Ø 45 mm	Ø 48 x 70 mm	120	Ø 5.7 mm	200 mm	0 571 317	
	Ø 48 x 70 mm	180	Ø 5.7 mm	200 mm	0 571 347	



In order to avoid blunders...

...the honing brushes are colour-coded to distinguish between the grit sizes:

Grit 120 = yellow
Grit 180 = red

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Grinding points



The maximum permissible speeds depending on the cutting speed:

\varnothing	V_c 35 m/s	V_c 50 m/s
4 mm	170,000 1/min	240,000 1/min
6 mm	110,000 1/min	160,000 1/min
8 mm	80,000 1/min	120,000 1/min
10 mm	65,000 1/min	95,000 1/min
12 mm	55,000 1/min	80,000 1/min
20 mm	33,000 1/min	47,000 1/min



Grinding points Overview

-  very well suited
-  suitable

	Cast iron, malleable cast iron	Steel, cast steel	Alloyed/hardenend and tempered steels	High and highest alloyed steels	Welding seams on alloyed and non-alloyed steels	Hardened tool steels	Hard chrome-plated steels	Titanium, cobalt and nickel alloys	Glass/ceramic/carbide metal	Aluminium/soft non-ferrous metals
AWCO grinding points										
	188									
Aluminium oxide fibre grinding points										
	190									
Silicon carbide for aluminium (SiC-Alu)										
	191									
High-grade corundum pink (EKR)										
	192									
High-grade corundum white-brown (EKWbr)										
	197									
High-grade corundum white (EKW)										
	198									
High-grade corundum dark red (EKD)										
	199									
Blue Stones										
	200									
NORTON										
	201									
VORTEX										
	202									
Fibre-laminated grinding and polishing points										
	206									

Grinding points AWCO

shank Ø 3 x 30 mm, hardness J

Grinding points AWCO

The ideal points for regrounding repair weldings. Produced from ceramic bond with a mixture of white high-grade corundum and blue ceramic sintered corundum. This material combination results in extraordinarily high chip removal rates with an excellent service life.

The advantages:

- cool cutting owing to friability of the grit mixture
- high stock removal rates with a very good service life
- self-sharpening effect of the sintered corundum for consistent stock removal rates

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Order No.	Price from	1 piece	20 pieces	50 pieces
AWCO grinding points, shank Ø 3 x 30 mm										
cylinder										
	Ø 1 x 5 mm	J	320	Ø 3 x 30 mm	50 m/s	0 542 421				
	Ø 1.5 x 8 mm	J	320	Ø 3 x 30 mm	50 m/s	0 542 422				
	Ø 1.7 x 8 mm	J	320	Ø 3 x 30 mm	50 m/s	0 542 423				
	Ø 2 x 5 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 424				
	Ø 3 x 6 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 427				
	Ø 3 x 6 mm	J	120	Ø 3 x 30 mm	50 m/s	0 542 428				
	Ø 4 x 8 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 429				
	Ø 4 x 8 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 430				
	Ø 4 x 8 mm	J	100	Ø 3 x 30 mm	50 m/s	0 542 431				
	Ø 5 x 10 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 432				
	Ø 5 x 10 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 433				
	Ø 5 x 10 mm	J	100	Ø 3 x 30 mm	50 m/s	0 542 434				
	Ø 6 x 13 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 436				
	Ø 8 x 16 mm	J	46	Ø 3 x 30 mm	50 m/s	0 542 439				
	Ø 8 x 16 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 440				
	Ø 8 x 16 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 441				
sphere										
	Ø 3 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 447				
	Ø 6 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 449				
	Ø 8 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 452				
wheel										
	Ø 13 x 3 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 443				
	Ø 20 x 6 mm	J	46	Ø 3 x 30 mm	50 m/s	0 542 444				
	Ø 20 x 6 mm	J	60	Ø 3 x 30 mm	50 m/s	0 542 445				
tree with pointed end										
	Ø 3 x 6 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 455				
	Ø 4 x 8 mm	J	80	Ø 3 x 30 mm	50 m/s	0 542 458				

matching set

	Content: 12 pieces	Price from	Order No.	1 set
Set of grinding points AWCO				
		0 542 420		

Grinding points AWCO

Ø 6 x 40 mm, hardness J

Grinding points AWCO

The ideal points for regrinding repair weldings. Produced from ceramic bond with a mixture of white high-grade corundum and blue ceramic sintered corundum. This material combination results in extraordinarily high chip removal rates with an excellent service life.

The advantages:

- cool cutting owing to friability of the grit mixture
- high stock removal rates with a very good service life
- self-sharpening effect of the sintered corundum for consistent stock removal rates

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Order No.	Price from		
							1 piece	20 pieces	50 pieces
AWCO grinding points, shank Ø 6 x 40 mm									
cylinder									
	Ø 8 x 16 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 471			
	Ø 10 x 13 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 473			
	Ø 10 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 475			
	Ø 13 x 25 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 477			
	Ø 16 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 479			
	Ø 16 x 32 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 481			
	Ø 20 x 25 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 483			
	Ø 20 x 40 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 485			
sphere									
	Ø 13 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 491			
tree with pointed end									
	Ø 13 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	0 542 494			

 matching set

	Content: 10 pieces	Price from
		Order No.
		1 set
Set of grinding points AWCO		
		
0 542 470		



Aluminium oxide fibre grinding points shank Ø 3 x 30 mm

Aluminium oxide fibre grinding points

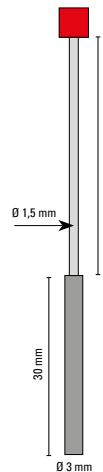
- Deburring and chamfering of cross holes
- Removing burr at the bottom of blind holes
- Precision removal of fine burr
- Self-sharpening without grinding dust
- High edge stability and dimensional stability for extended service life
- Elastic shank with high bending radius (2 mm)
- Range of different grit sizes
- Versatile application areas
- Use by hand and machine (processing centres, special machines, drilling machines, with robots, etc.)



Head dimensions	Collar dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from
							1 piece 3 pieces 5 pieces

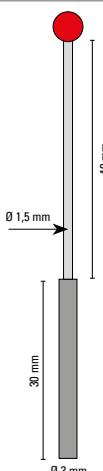
Aluminium oxide fibre grinding points, shank Ø 3 mm

cylinder



Ø 3 x 3 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 181
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 182
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 183
Ø 4 x 4 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 184
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 185
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 186
Ø 5 x 5 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 187
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 188
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 189

sphere



Ø 3 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 161
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 162
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 163
Ø 4 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 164
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 165
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 166
Ø 5 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 167
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 168
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 169
Ø 6 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 170
	Ø 1.5 x 40 mm	# 400	orange	Ø 3 x 30 mm	6000 1/min	0 425 171
	Ø 1.5 x 40 mm	# 800	blue	Ø 3 x 30 mm	6000 1/min	0 425 172
Ø 10 mm	Ø 1.5 x 40 mm	# 220	grey	Ø 3 x 30 mm	6000 1/min	0 425 173

Grinding points SiC-Alu shank Ø 3 x 30 mm and 6 x 40 mm

Grinding points SiC-Alu

These grinding points were especially developed for processing aluminium. The high plasticity of aluminium means that if the wrong grinding points are used, "smearing" and "clogging" of the tool occurs.

Owing to their special structural configuration, extremely long service lives are achieved, as the pores of the points do not become clogged during processing. The selfsharpening effect is enhanced by the special impregnation of these grinding points.

Particularly suitable for:

- non-ferrous metals (especially aluminium)
- hard-chromium plated steels
- high and highest-alloyed steels

Also suitable for:

- tempered and hardened steels
- soft non-ferrous metals



Head dimensions	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
						1 piece	20 pieces	50 pieces
SiC-Alu grinding points, shank Ø 3 x 30 mm								
cylinder								
	Ø 4 x 8 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 501		
	Ø 5 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 502		
	Ø 6 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 503		
	Ø 8 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 504		
	Ø 10 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 505		
SiC-Alu grinding points, shank Ø 6 x 40 mm								
cylinder								
	Ø 10 x 13 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 506		
	Ø 16 x 32 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 511		
	Ø 20 x 25 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 513		



			Price from
	Grit size	Order No.	1 set

Set of grinding points SiC-Alu



The set consists of the following five cylindrical grinding points with a grit size of SiC 80, shank Ø 3 x 30 mm:

K 80

0 542 530

- Cylinder, Ø 4 x 8 mm (order no. 0 542 501)
- Cylinder, Ø 5 x 10 mm (order no. 0 542 502)
- Cylinder, Ø 6 x 10 mm (order no. 0 542 503)
- Cylinder, Ø 8 x 10 mm (order no. 0 542 504)
- Cylinder, Ø 10 x 10 mm (order no. 0 542 505)

The grinding points are particularly suitable for processing aluminium and hard chrome-plated steels as well as high-alloy and ultra high alloy steels. They are also suitable for annealed and hardened steels and for soft non-ferrous metals.

Grinding points EKR

shank Ø 2.35 x 40 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	1 piece	20 pieces	50 pieces
EKR grinding points, shank Ø 2.35 x 40 mm											
cylinder											
	Ø 2 x 5 mm	N	120	Ø 2.35 x 40 mm	50 m/s	10 pieces	0 542 101				
	Ø 3 x 6 mm	N	100	Ø 2.35 x 40 mm	50 m/s	10 pieces	0 542 102				
	Ø 4 x 8 mm	N	80	Ø 2.35 x 40 mm	50 m/s	10 pieces	0 542 103				
wheel											
	Ø 10 x 3 mm	N	100	Ø 2.35 x 40 mm	50 m/s	10 pieces	0 542 107				
sphere											
	Ø 5 mm	N	100	Ø 2.35 x 40 mm	50 m/s	10 pieces	0 542 114				

Grinding points EKR

shank Ø 3 x 30 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	1 piece	20 pieces	50 pieces
EKR grinding points, shank Ø 3 x 30 mm											
cylinder											
	Ø 2 x 5 mm	N	120	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 131				
	Ø 2.5 x 6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 922				
	Ø 3 x 6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 132				
	Ø 4 x 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 133				
	Ø 5 x 6 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 923				
	Ø 5 x 10 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 134				
	Ø 6 x 6 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 924				
	Ø 6 x 10 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 135				

Grinding points EKR

shank Ø 3 x 30 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
pointed cylinder										
	Ø 5 x 7 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 932			
	Ø 8 x 10 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 140			
wheel										
	Ø 4 x 1 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 904			
	Ø 5 x 3 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 905			
	Ø 8 x 2 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 903			
	Ø 9 x 2 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 901			
	Ø 9 x 3 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 902			
	Ø 10 x 5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 139			
conical										
	Ø 3.3 / 2.2 x 6.4 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 929			
	Ø 4.4 / 3 x 10 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 930			
	Ø 7 / 3.5 x 6 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 906			
cone										
	Ø 6 x 11 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 936			
	Ø 8 x 8 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 149			
	Ø 10 x 10 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 150			
trapeze										
	Ø 3.2 / 2 x 4 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 910			
	Ø 5 / 2 x 2.5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 907			
	Ø 5 / 3 x 5 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 911			
	Ø 7 / 5 x 6 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 912			
	Ø 8 / 3.5 x 4 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 909			
tree with pointed end										
	Ø 4.3 x 7 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 934			
	Ø 5 x 10 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 147			
	Ø 6 x 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 933			
	Ø 6 x 10 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 935			

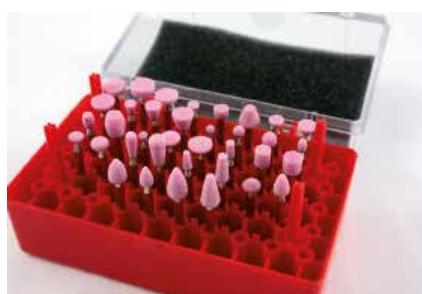
Grinding points EKR

shank Ø 3 x 30 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from			
									1 piece	20 pieces	50 pieces
barrel											
	Ø 4 x 5 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 917				
	Ø 6 x 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 918				
rhombus											
	Ø 7 x 5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 920				
mushroom											
	Ø 8 x 1.6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 921				
sphere											
	Ø 3 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 913				
	Ø 4 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 914				
	Ø 5 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 915				
	Ø 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 145				
	Ø 10 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	0 542 146				
wheel											
	Ø 5 x 1.5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 925				
	Ø 6 x 2.5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	0 540 926				

matching set

	Price from
	Order No.
	1 set
Set of grinding points EKR	
Content: 36 pieces	
0 540 900	



Grinding points EKR shank Ø 6 x 40 mm, hardness N

1
2
3
4
5
6
7

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
EKR grinding points, shank Ø 6 x 40 mm										
cylinder										
	Ø 4 x 8 mm	N	80	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 702			
	Ø 5 x 10 mm	N	80	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 703			
	Ø 6 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 704			
	Ø 8 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 705			
	Ø 8 x 16 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 706			
	Ø 10 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 707			
	Ø 10 x 20 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 708			
	Ø 13 x 13 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 710			
	Ø 13 x 20 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 711			
	Ø 16 x 16 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 712			
	Ø 16 x 20 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 713			
	Ø 16 x 32 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 714			
	Ø 20 x 20 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 715			
	Ø 20 x 25 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 716			
	Ø 20 x 40 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 718			
sphere										
	Ø 8 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 747			
	Ø 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 736			
	Ø 16 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 738			
	Ø 20 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 739			
cone										
	Ø 16 x 32 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 742			
	Ø 16 x 40 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 743			
	Ø 20 x 32 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 744			
	Ø 20 x 40 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 745			
wheel										
	Ø 25 x 6 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 728			
	Ø 32 x 8 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 730			
	Ø 40 x 10 mm	N	30	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 731			
	Ø 40 x 20 mm	N	30	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 724			

Grinding points EKR

shank Ø 3 x 40/60 mm, hardness N • Shanks made from rustproof steel

Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from 1 piece	20 pieces	50 pieces	
EKR grinding points, shank Ø 3 x 40 mm, rustproof steel										
cylinder										
	Ø 2 x 5 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 651	4.03 €	3.74 €	3.24 €
	Ø 3 x 5 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 652	4.06 €	3.75 €	3.25 €
	Ø 4 x 8 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 653	3.43 €	3.20 €	2.75 €
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 663	4.89 €	4.50 €	3.91 €
	Ø 5 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 654	3.46 €	3.23 €	2.77 €
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 664	4.92 €	4.53 €	3.94 €
	Ø 6 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 655	3.68 €	3.38 €	2.92 €
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 665	5.06 €	4.68 €	4.03 €
	Ø 7 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	0 542 656	3.90 €	3.60 €	3.11 €
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 666	5.20 €	4.81 €	4.14 €
sphere										
	Ø 5 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 677	5.36 €	4.96 €	4.30 €
	Ø 6 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 678	5.72 €	5.31 €	4.60 €
cone										
	Ø 6 x 10 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 680	5.36 €	4.96 €	4.30 €
tree with pointed end										
	Ø 3 x 6 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	0 542 679	4.26 €	3.94 €	3.38 €



Why rustproof shanks?

These points have shanks made of rustproof steel. They are mainly used in the food and chemical industry.

Blowing pen

A must for every workplace!

Possibly the smallest blowing pen in the world. It weighs a mere 20 g and regulates the compressed air perfectly. The small aperture of 3 mm ensures that the air really only goes where it should. A must for every workplace!

Blowing pen	For direct connection to a rapid coupling system. Dimensions: Ø12.5 x 108 mm Weight: 20 g	Price from Order No. 1 piece 0 203 200

Grinding points EKWbr

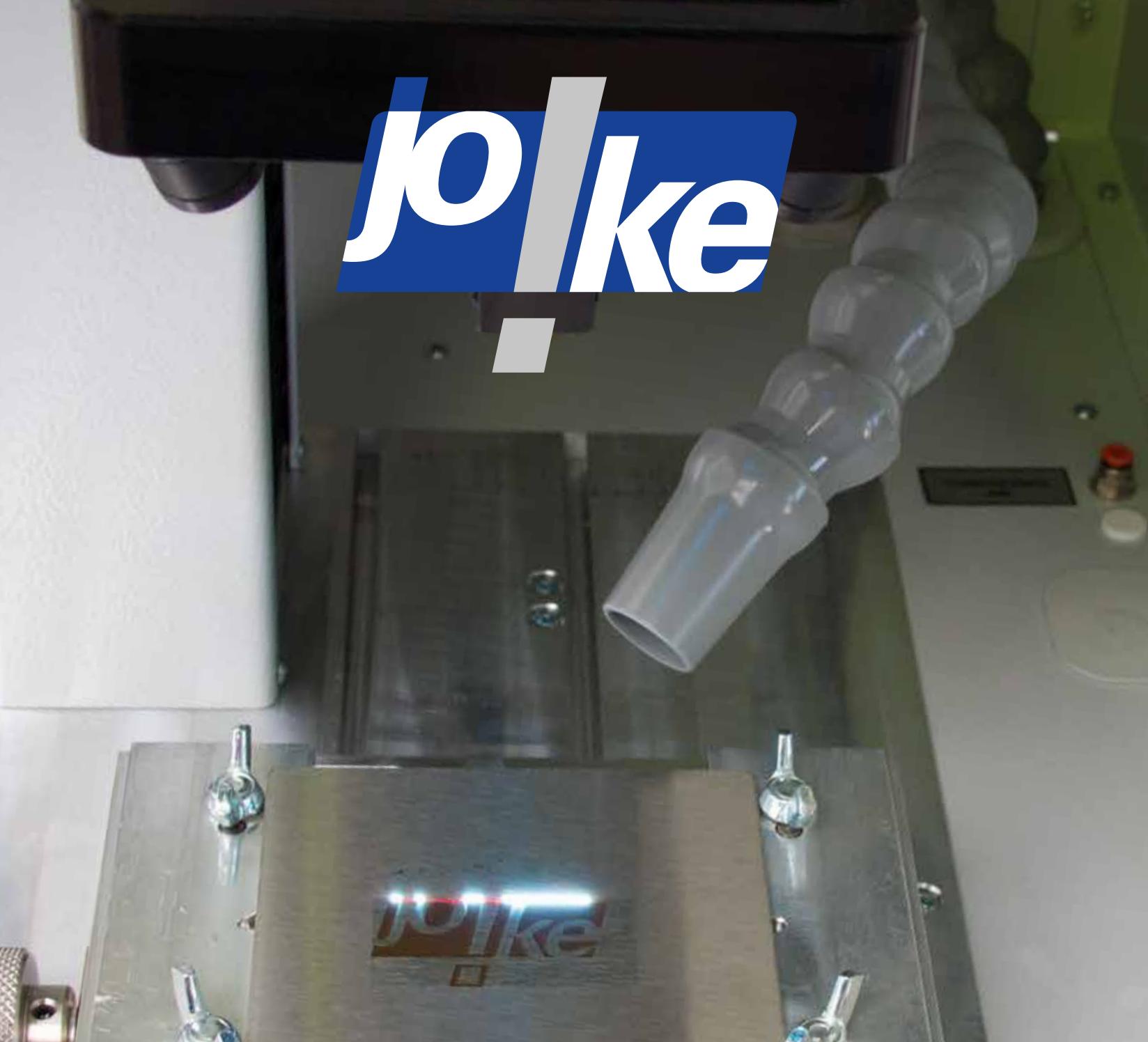
shank Ø 3 x 30 mm, hardness O/P

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
EKWbr grinding points, shank Ø 3 x 30 mm										
cylinder										
	Ø 3 x 6 mm	O/P	100	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 401			
	Ø 4 x 8 mm	O/P	80	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 402			
	Ø 5 x 10 mm	O/P	80	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 403			
	Ø 6 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 404			
	Ø 8 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 405			
	Ø 10 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 406			
	Ø 10 x 13 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 407			
	Ø 10 x 15 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 408			
	Ø 13 x 13 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 409			
	Ø 13 x 16 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 410			
wheel										
	Ø 16 x 4 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 413			
	Ø 20 x 6 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	0 542 414			

Grinding points EKW

shank Ø 3 x 40 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
EKW grinding points, shank Ø 3 x 40 mm										
cylinder										
	Ø 2 x 5 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 601			
	Ø 3 x 5 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 602			
	Ø 4 x 8 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 603			
	Ø 5 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 604			
	Ø 6 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 605			
	Ø 7 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 606			



jolke

ENESKAmarker 300

The flexible **laser marking system** achieves long-lasting and high-quality results on a wide range of materials.



Grinding points EKD shank Ø 3 x 40 mm, hardness N

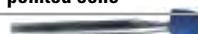
	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
EKD grinding points, shank Ø 3 x 40 mm										
cylinder										
	Ø 2 x 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 331			
	Ø 4 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 332			
	Ø 5 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 333			
	Ø 8 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 334			
pointed cylinder										
	Ø 7 x 12 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 340			
rounded cylinder										
	Ø 3 x 6 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 347			
	Ø 4 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 348			
	Ø 6 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 341			
	Ø 6 x 12 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 342			
wheel										
	Ø 10 x 2 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 336			
	Ø 10 x 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 337			
mushroom										
	Ø 10 x 2 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 338			
cone										
	Ø 5 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 339			
sphere										
	Ø 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 344			
	Ø 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 345			
	Ø 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 346			
cone										
	Ø 8 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 349			
	Ø 10 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 350			

matching set

	Price from	
	Order No.	1 set
Set of grinding points EKD		
Content: 18 pieces	0 542 330	

Grinding points Blue Stones

shank Ø 3 x 40 mm, hardness QU

Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
							1 piece	20 pieces	50 pieces
Blue Stones grinding points, shank Ø 3 x 40 mm									
cylinder									
	Ø 2 x 5 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 778		
	Ø 3 x 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 779		
	Ø 4 x 8 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 780		
	Ø 5 x 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 781		
	Ø 5 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 782		
	Ø 6 x 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 783		
	Ø 6 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 784		
	Ø 8 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 785		
	Ø 10 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 786		
wheel									
	Ø 8 x 1.6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 788		
	Ø 13 x 3 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 789		
	Ø 13 x 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 790		
tree with pointed end									
	Ø 3 x 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 774		
	Ø 5 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 773		
sphere									
	Ø 3 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 775		
	Ø 5 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 776		
	Ø 6 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 777		
rounded arch									
	Ø 6 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 772		
pointed cone									
	Ø 6 x 10 mm	QU	120	Ø 3 x 40 mm	50 m/s	10 pieces	0 542 771		

 matching set

Set of grinding points Blue Stones	Grit size	Order No.	Price from
			1 set
			
Content: 19 pieces	K 120	0 542 770	

Grinding points Blue Stones

shank Ø 6 x 40 mm, hardness QU

	Head dimensions	Hardness	Grit size	Shank dimensions	V_c	Packing quantity	Order No.	Price from		
								1 piece	20 pieces	50 pieces
Blue Stones grinding points, shank Ø 6 x 40 mm										
cylinder										
	Ø 8 x 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 813			
	Ø 10 x 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 815			
	Ø 10 x 20 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 816			
sphere										
	Ø 8 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 818			
	Ø 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 819			
	Ø 13 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 820			
tree with pointed end										
	Ø 6 x 13 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 822			
cone										
	Ø 8 x 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	0 542 824			



Set of grinding points Blue Stones



Contents: 8 pieces:
Contains one of each of the
mounted points listed above

K 120 **0 542 810**

Price from
Grit size Order No. 1 set

Grinding points NORTON

shank Ø 3 / 6 x 40 mm, soft

Suitable for all metals, ideal for softer materials such as aluminium. Perfect in postprocessing for 3D printed aluminium parts

	Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from		
									1 piece	20 pieces	50 pieces
NORTON grinding points, shank Ø 3 mm											
cylinder											
	Ø 6 x 12 mm	soft	fine	grey	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 911			
	Ø 10 x 12 mm	soft	fine	grey	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 910			
	Ø 20 x 25 mm	soft	fine	grey	Ø 6 x 40 mm	50 m/s	10 pieces	0 571 912			

Compact discs VORTEX Unitized for manual and machine use

Compact discs VORTEX Unitized

A new dimension in deburring and uniform finishing – particularly on materials that are difficult to process.

The patented grit of these discs results in an up to twice as high, very aggressive stock removal in comparison to conventional discs, with improved results on the workpiece.

The advantages at a glance:

- more rapid stock removal, shortened throughput times, optimised quality
- cool cut
- maximum service lives: consistent stock removal performance from the beginning to the end of the disc
- usable for a wide range of shapes and contours

Bonding	Dimensions	Drilling dimension	Order No.	Price from	
				1 piece	10 pieces
Compact discs VORTEX Unitized					
soft	Ø 75 x 3 mm	6.3 mm	0 545 681		
hard	Ø 50 x 6 mm	6.3 mm	0 545 680		
	Ø 75 x 3 mm	6.3 mm	0 545 682		
	Ø 75 x 12 mm	6.3 mm	0 545 683		
	Ø 150 x 6 mm	25.4 mm	0 545 684		

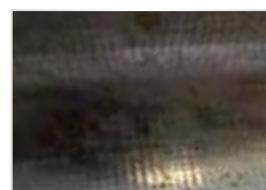
⚙ Accessories / spare parts

for bore dimensions	Shank dimensions	Type	Max. disc size	Price from		
				Order No.	1 piece	10 pieces
CRATEX® grinding wheel holder						
	Ø 1/4" / Ø 6.3 mm	Ø 6 x 40 mm	32	0 545 297		



removing of milling traces from 1.2379

before



after



Grinding wheels VORTEX Rapid with quick change system

Patented grain technology combined with improved synthetic resin system prevents rapid clogging. Up to 8 x longer lifetime than other surface finishing discs.

Suitable for the following materials:
stainless steel, carbon steels, aluminium

	Dimensions	Grit size	Packing quantity	Price from		
				Order No.	1 pack	3 packs
Grinding wheels VORTEX Rapid						
	Ø 50 mm	medium	25 pieces	0 545 697		
	Ø 75 mm	medium	25 pieces	0 545 698		



⚙ Accessories / spare parts

	Dimensions	Order No.	Price from	
			1 piece	3 pieces
Grinding disc holder TR				
	Ø 50 mm	0 545 699		
	Ø 75 mm	0 545 700		



Grinding points VORTEX shank Ø 3 x 40 mm, hard

VORTEX®-blue grinding points

The grinding points are ideally suited for processing hard materials that are difficult to machine, such as titanium, Inconel, etc. The patented high performance grit is ideal for rapid stock removal and reduces processing times.

The following versions are available:

- Wheel • Cylinder • Ball

Packaging unit: 10 pieces | Colour: blue

Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	1 piece	20 pieces	50 pieces
VORTEX®-blue grinding points, shank Ø 3 x 40 mm											
wheel											
Ø 25 x 3 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 904				
Ø 30 x 3 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 900				
cylinder											
Ø 5 x 12 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 901				
Ø 6 x 13 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 902				
Ø 10 x 12 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 903				
sphere											
Ø 6 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 926				
Ø 8 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 927				
Ø 10 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	0 571 928				



Set of grinding points VORTEX®-blue

The set consists of the following five coarse-grit, hard grinding points with a shank Ø 3 x 40 mm:

- Wheel, Ø 25 x 3 mm (order no. 0 571 904)
- Wheel, Ø 30 x 3 mm (order no. 0 571 900)
- Cylinder, Ø 5 x 13 mm (order no. 0 571 901)
- Cylinder, Ø 6 x 13 mm (order no. 0 571 902)
- Cylinder, Ø 10 x 12 mm (order no. 0 571 903)



Price from

Order No.

1 set

Set of grinding points VORTEX®-blue

Grinding points VORTEX shank Ø 6 x 40 mm, hard

VORTEX®-blue grinding points

The grinding points are ideally suited for processing hard materials that are difficult to machine, such as titanium, Inconel, etc. The patented high performance grit is ideal for rapid stock removal and reduces processing times.

The following versions are available:

- Wheel
- Cylinder

Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	
							1 piece	20 pieces	50 pieces
VORTEX®-blue grinding points, shank Ø 6 x 40 mm									
cylinder									
	Ø 10 x 20 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	0 571 920	
	Ø 13 x 20 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	0 571 921	
	Ø 20 x 25 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	0 571 922	



Set of grinding points VORTEX® blue

The set consists of the following three coarse-grit, hard grinding points with a shank Ø 6 x 40 mm:

0 571 925

- Cylinder, Ø 10 x 20 mm (order no. 0 571 920)
- Cylinder, Ø 13 x 20 mm (order no. 0 571 921)
- Cylinder, Ø 20 x 25 mm (order no. 0 571 922)



Fibre-laminated grinding and polishing points

shank Ø 3 x 40 mm

Fibre-laminated grinding and polishing points

These fibre-laminated grinding points produce excellent surfaces with high stock removal. The tools do not clog, offer a very good service life, grind and polish simultaneously and are vibration-free. They are ideal for hard chromium plated steels and have proved their worth with all difficult steels in aeronautical, motor and plant construction. The points are available in two bonding strengths and different grit sizes:

Hard: Aggressive for high stock removal and fine surfaces.

Soft: Polishing with low stock removal and deburring.

Vmax 30 m/s

	Head dimensions	Bonding	Grit size	Shank dimensions	Order No.	Price from			
							1 piece	10 pieces	20 pieces
Fibre-laminated grinding points, corundum, shank Ø 3 x 40 mm									
cylinder									
	Ø 6 x 6 mm	hard	80	Ø 3 x 40 mm	0 545 611				
		soft	80	Ø 3 x 40 mm	0 545 612				
		soft	180	Ø 3 x 40 mm	0 545 613				
	Ø 6 x 13 mm	hard	80	Ø 3 x 40 mm	0 545 614				
		soft	80	Ø 3 x 40 mm	0 545 615				
		soft	180	Ø 3 x 40 mm	0 545 616				
	Ø 10 x 19 mm	hard	54	Ø 3 x 40 mm	0 545 617				
		hard	80	Ø 3 x 40 mm	0 545 618				
		soft	80	Ø 3 x 40 mm	0 545 619				
		soft	180	Ø 3 x 40 mm	0 545 620				
	Ø 13 x 13 mm	hard	80	Ø 3 x 40 mm	0 545 621				
		soft	80	Ø 3 x 40 mm	0 545 622				
		soft	180	Ø 3 x 40 mm	0 545 623				
sphere									
	Ø 6 mm	hard	80	Ø 3 x 40 mm	0 545 658				
	Ø 6.5 mm	soft	80	Ø 3 x 40 mm	0 545 647				
	Ø 8 mm	hard	80	Ø 3 x 40 mm	0 545 659				
	Ø 13 mm	soft	80	Ø 3 x 40 mm	0 545 609				
		hard	80	Ø 3 x 40 mm	0 545 627				
		soft	180	Ø 3 x 40 mm	0 545 610				
pointed cone									
	Ø 10 x 19 mm	hard	54	Ø 3 x 40 mm	0 545 605				
		soft	80	Ø 3 x 40 mm	0 545 607				
		hard	80	Ø 3 x 40 mm	0 545 606				
		soft	180	Ø 3 x 40 mm	0 545 608				
cone									
	Ø 13 x 19 mm	hard	54	Ø 3 x 40 mm	0 545 601				
		soft	80	Ø 3 x 40 mm	0 545 603				
		hard	80	Ø 3 x 40 mm	0 545 602				
		soft	180	Ø 3 x 40 mm	0 545 604				
sphere									
	Ø 13 mm	hard	54	Ø 3 x 40 mm	0 545 626				

Fibre-laminated grinding and polishing points shank Ø 3 x 40 mm

 matching set

		Price from	
	Grit size	Order No.	1 set
Set of grinding points, fibre-laminated			
	This range contains following seven hard bonded fibre-laminated polishing points in grit size 80, shank dimensions 3 x 40mm:	K 80	0 545 695
<ul style="list-style-type: none">• Cylinder, Ø 6 x 6 mm (order no. 0 545 611)• Cylinder, Ø 6 x 13 mm (order no. 0 545 614)• Cylinder, Ø 10 x 19 mm (order no. 0 545 618)• Cylinder, Ø 13 x 13 mm (order no. 0 545 621)• Sphere, Ø 13 mm (order no. 0 545 627)• Pointed Cone, Ø 10 x 19 mm (order no. 0 545 606)• Cone, Ø 13 x 19 mm (order no. 0 545 602)			
These polishing points are suitable for fine surfaces due to a high material removal.			
	This range contains following seven soft bonded fibre-laminated polishing points in grit size 80, shank dimensions 3 x 40 mm:	K 80	0 545 690
<ul style="list-style-type: none">• Cylinder, Ø 6 x 6 mm (order no. 0 545 612)• Cylinder, Ø 6 x 13 mm (order no. 0 545 615)• Cylinder, Ø 10 x 19 mm (order no. 0 545 619)• Cylinder, Ø 13 x 13 mm (order no. 0 545 622)• Sphere, Ø 13 mm (order no. 0 545 609)• Pointed Cone, Ø 10 x 19 mm (order no. 0 545 607)• Cone, Ø 13 x 19 mm (order no. 0 545 603)			
These polishing points are suitable for polishing aluminium and for deburring due to a low material removal.			



1
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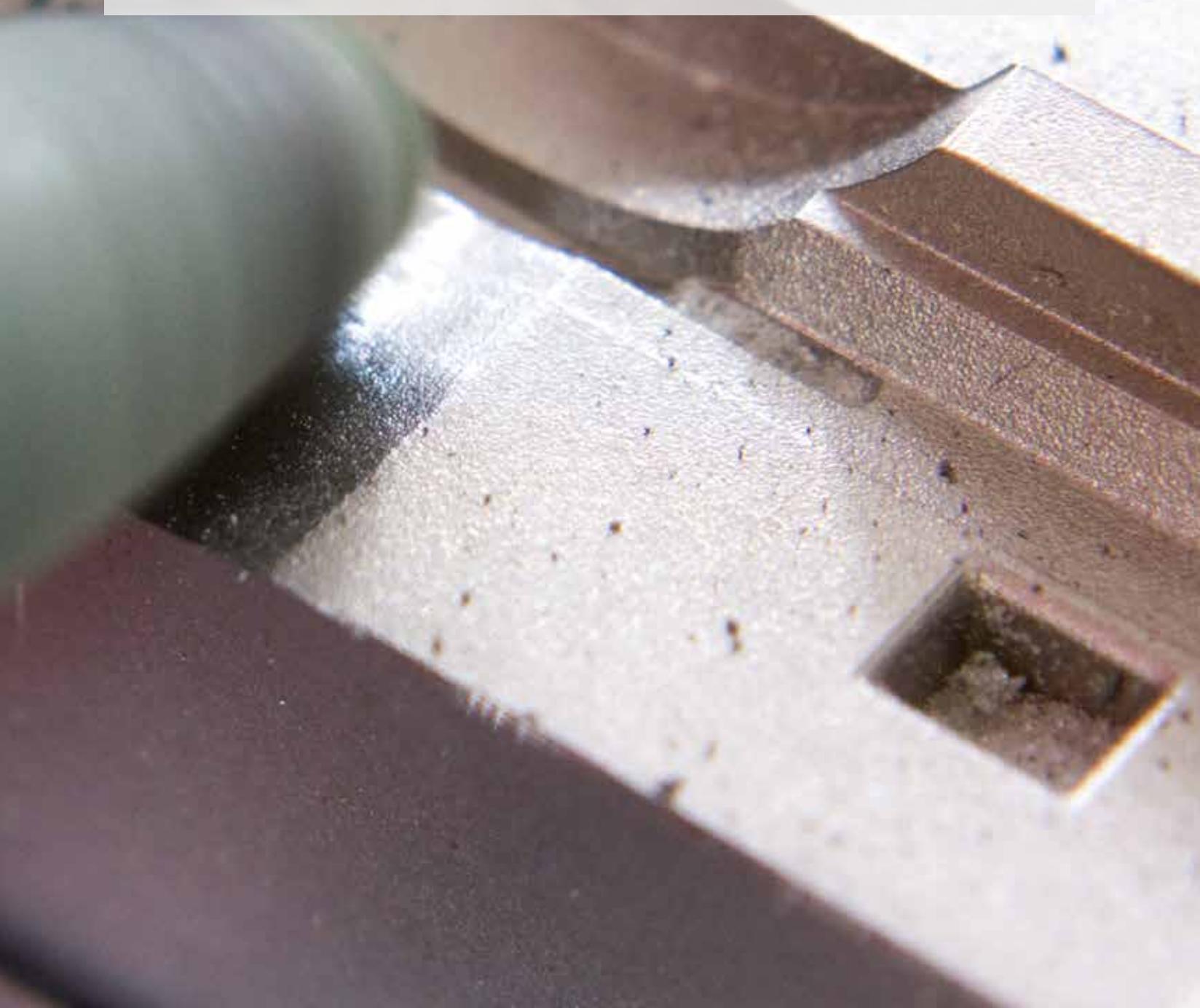
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Rubber-bonded grinding tools

- | | | | |
|------------|---------------------------------------|------------|-------------------------------------|
| 209 | Rubber-bonded polishing points | 215 | Rubber-bonded grinding tools |
| | | | CERA Sticks |
| 212 | Elastic polishing points | 216 | Tool system CRATEX® |
| | | | |
| 214 | Elastic grinding files | | |

Rubber-bonded tools are the right choice wherever the highest demands are placed on the polished section and the latter's dimensional stability. A wide selection of these can be found with us: polishing points on a shank (rubber-bonded, elastic and fibrelaminated), rubber-bonded grinding discs, in addition to compact discs and of course the CRATEX® tool system, which has been tried and trusted for decades.



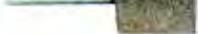
Rubber-bonded polishing points series 700

hard rubber bonding • shank Ø 3 x 30 mm

Rubber-bonded polishing points series 700

Thanks to their hard rubber bond and corundum grit combination, these fine grinding and polishing tools with hard rubber bonding are particularly suited for very fine grinding, equally for cast iron, hardened or unhardened, alloy or nonalloy steels as well as all other materials to be ground. These tools do not clog, do not smear and deliver high efficiency with medium grinding pressure.

Cutting speed Vmax: 50 m/s

	Head dimensions		Shank dimensions		Price from		
					1 piece	20 pieces	50 pieces
Rubber-bonded polishing points series 700, shank Ø 3 x 30 mm							
hard rubber bonding							
cylinder							
	Ø 4 x 8 mm	100	Ø 3 x 30 mm	0 544 701			
	Ø 5 x 10 mm	100	Ø 3 x 30 mm	0 544 702			
	Ø 6 x 10 mm	100	Ø 3 x 30 mm	0 544 703			
	Ø 7 x 10 mm	100	Ø 3 x 30 mm	0 544 704			
	Ø 8 x 10 mm	100	Ø 3 x 30 mm	0 544 705			
	Ø 10 x 10 mm	100	Ø 3 x 30 mm	0 544 706			
	Ø 10 x 13 mm	100	Ø 3 x 30 mm	0 544 707			
	Ø 10 x 16 mm	100	Ø 3 x 30 mm	0 544 708			
	Ø 13 x 3 mm	100	Ø 3 x 30 mm	0 544 712			
	Ø 13 x 13 mm	100	Ø 3 x 30 mm	0 544 709			
	Ø 13 x 16 mm	100	Ø 3 x 30 mm	0 544 710			
	Ø 16 x 4 mm	100	Ø 3 x 30 mm	0 544 713			
	Ø 16 x 16 mm	100	Ø 3 x 30 mm	0 544 715			
	Ø 20 x 6 mm	100	Ø 3 x 30 mm	0 544 714			

 matching set

	Grit size	Order No.	Price from
			1 set
Rubber-bonded polishing points series 700, shank Ø 3 mm, 14 pieces			
			
Set contains all head sizes 1x each	100	0 544 700	

Rubber-bonded polishing points series 720

soft rubber bonding

Rubber-bonded polishing points series 720

The special features of the soft rubber bond of the series 720 is an extremely soft cut, high surface quality and very low stock removal of the corundum grit. The outstanding elasticity of the soft rubber bond results in a relatively low cutting speed for the vibration-free operation. **Cutting speed Vmax: 15 m/s**

Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
					1 piece	20 pieces	50 pieces
Rubber-bonded polishing points series 720, shank Ø 3 x 30 mm & 3 x 60 mm							
soft rubber bonding							
sphere							
	Ø 5 mm	120	red	Ø 3 x 30 mm	0 544 760		
		120	red	Ø 3 x 60 mm	0 544 727		
	Ø 8 mm	120	red	Ø 3 x 30 mm	0 544 767		
		120	red	Ø 3 x 60 mm	0 544 726		
	Ø 10 mm	120	red	Ø 3 x 30 mm	0 544 768		
	Ø 10 mm	120	red	Ø 3 x 60 mm	0 544 725		
	Ø 13 mm	120	red	Ø 3 x 30 mm	0 544 719		
cylinder							
	Ø 4 x 8 mm	80	grey	Ø 3 x 30 mm	0 544 731		
		120	red	Ø 3 x 30 mm	0 544 751		
		220	brown	Ø 3 x 30 mm	0 544 771		
	280	green	Ø 3 x 30 mm	0 544 791			
	400	white	Ø 3 x 30 mm	0 544 930			
	600	light pink	Ø 3 x 30 mm	0 544 931			
	Ø 5 x 10 mm	80	grey	Ø 3 x 30 mm	0 544 732		
		120	red	Ø 3 x 30 mm	0 544 752		
		220	brown	Ø 3 x 30 mm	0 544 772		
	280	green	Ø 3 x 30 mm	0 544 792			
	Ø 6 x 10 mm	80	grey	Ø 3 x 30 mm	0 544 733		
		120	red	Ø 3 x 30 mm	0 544 753		
		220	brown	Ø 3 x 30 mm	0 544 773		
	280	green	Ø 3 x 30 mm	0 544 793			
	400	white	Ø 3 x 30 mm	0 544 933			
	600	light pink	Ø 3 x 30 mm	0 544 934			
	Ø 8 x 10 mm	80	grey	Ø 3 x 30 mm	0 544 734		
		120	red	Ø 3 x 30 mm	0 544 754		
		220	brown	Ø 3 x 30 mm	0 544 774		
	280	green	Ø 3 x 30 mm	0 544 794			
	400	white	Ø 3 x 30 mm	0 544 936			
	600	light pink	Ø 3 x 30 mm	0 544 937			
	Ø 10 x 10 mm	80	grey	Ø 3 x 30 mm	0 544 735		
		120	red	Ø 3 x 30 mm	0 544 755		
		220	brown	Ø 3 x 30 mm	0 544 775		
		280	green	Ø 3 x 30 mm	0 544 795		
	Ø 13 x 13 mm	80	grey	Ø 3 x 30 mm	0 544 736		
		120	red	Ø 3 x 30 mm	0 544 756		
		220	brown	Ø 3 x 30 mm	0 544 776		
		280	green	Ø 3 x 30 mm	0 544 796		
	Ø 13 x 16 mm	80	grey	Ø 3 x 30 mm	0 544 737		
		120	red	Ø 3 x 30 mm	0 544 757		
		220	brown	Ø 3 x 30 mm	0 544 777		
		280	green	Ø 3 x 30 mm	0 544 797		

Rubber-bonded polishing points series 720 soft rubber bonding

Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
					1 piece	20 pieces	50 pieces
	Ø 16 x 16 mm	80	grey	Ø 3 x 30 mm	0 544 738		
		120	red	Ø 3 x 30 mm	0 544 758		
		220	brown	Ø 3 x 30 mm	0 544 778		
		280	green	Ø 3 x 30 mm	0 544 798		

 matching set

Rubber-bonded polishing points series 720, 8 pieces, shank Ø 3 x 30 mm	Set contains all head sizes 1x each	Grit size	Order No.	Price from
				1 set
		80	0 544 730	
		120	0 544 750	
		220	0 544 770	
		280	0 544 790	

Rubber-bonded polishing points series 720 Soft rubber bonding

Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from
					1 piece
					20 pieces
Rubber-bonded polishing points series 720, shank Ø 6 x 40 mm					
Soft rubber bonding					
cylinder					
	Ø 8 x 16 mm	80	grey	Ø 6 x 40 mm	0 544 741
		120	red	Ø 6 x 40 mm	0 544 761
		220	brown	Ø 6 x 40 mm	0 544 781
		280	green	Ø 6 x 40 mm	0 544 801
	Ø 10 x 20 mm	80	grey	Ø 6 x 40 mm	0 544 742
		120	red	Ø 6 x 40 mm	0 544 762
		220	brown	Ø 6 x 40 mm	0 544 782
		280	green	Ø 6 x 40 mm	0 544 802
	Ø 13 x 20 mm	80	grey	Ø 6 x 40 mm	0 544 743
		120	red	Ø 6 x 40 mm	0 544 763
		220	brown	Ø 6 x 40 mm	0 544 783
		280	green	Ø 6 x 40 mm	0 544 803
	Ø 16 x 20 mm	80	grey	Ø 6 x 40 mm	0 544 744
		120	red	Ø 6 x 40 mm	0 544 764
		220	brown	Ø 6 x 40 mm	0 544 784
		280	green	Ø 6 x 40 mm	0 544 804
	Ø 16 x 32 mm	120	red	Ø 6 x 40 mm	0 544 765
		80	grey	Ø 6 x 40 mm	0 544 745
		220	brown	Ø 6 x 40 mm	0 544 785
		280	green	Ø 6 x 40 mm	0 544 805
	Ø 20 x 20 mm	80	grey	Ø 6 x 40 mm	0 544 746
		120	red	Ø 6 x 40 mm	0 544 766
		220	brown	Ø 6 x 40 mm	0 544 786
		280	green	Ø 6 x 40 mm	0 544 806
sphere					
	Ø 13 mm	120	red	Ø 6 x 40 mm	0 544 769

Elastic polishing points

shank Ø 2.35 x 40 mm

Elastic polishing points

These points are available with silicon carbide or diamond as abrasive. These points are highly suitable for working on hard and tough materials, such as titanium or ceramic. They leave a matt finish with excellent roughness values on materials. Regardless of the various bonds, these points can be easily shaped.

Recommended Speed: 5,000 – 10,000 rpm

Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from
						1 piece
						10 pieces
Elastic polishing points, shank Ø 2.35 x 40 mm						
Diamond polishing points, medium bond						
pointed						
	Ø 4 x 13 mm	medium / K 150 fine / K 240	pink light grey	Ø 2.35 x 40 mm	10000 1/min	0 542 914 0 542 915
silicone polishing points, soft bond						
cylinder						
	Ø 6 x 11.5 mm	coarse / K 80 medium / K 150 fine / K 240	white black light blue	Ø 2.35 x 40 mm	10000 1/min	0 542 904 0 542 905 0 542 906
pointed						
	Ø 4.5 x 12 mm	coarse / K 80 medium / K 150 fine / K 240	white black light blue	Ø 2.35 x 40 mm	10000 1/min	0 542 901 0 542 902 0 542 903
technical polishing points, hard bond						
cylinder						
	Ø 10 x 12 mm	very coarse coarse medium	blue grey red brown	Ø 2.35 x 40 mm	10000 1/min	0 542 910 0 542 911 0 542 912
pointed						
	Ø 3.3 x 7.5 mm	very coarse coarse medium	blue grey red brown	Ø 2.35 x 40 mm	10000 1/min	0 542 907 0 542 908 0 542 909

Elastic polishing points

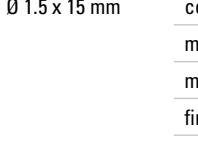
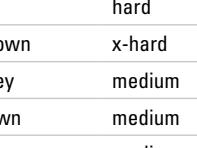
shank Ø 3 x 30 mm

Set includes:	Order No.	Price from		
		1 set	5 set	10 set
SET – Elastic grinding- and polishing points, shank-Ø 3 x 30 mm, 10 pieces				
				
2 x cyl., Ø 5x15mm, grit 80 2 x cyl., Ø 5x15mm, grit 120 2 x cyl., Ø 5x15mm, grit 220 2 x cyl., Ø 5x15mm, grit 320 1 x cyl., Ø 4x13mm, diamond grit 1000 1 x cyl., Ø 4x13mm, diamond grit 3000	0 544 800			

Elastic polishing points joke FlexPol with holder shank Ø 2.35 x 30 mm

These elastic polishers with silicon carbide in plastic rubber bond are ideal for processing hard and tough materials in hard to reach places. The points are available in five different diameters and six grit sizes each. Independently of the various bond strengths, these points can be profiled very well. The points are suitable for both rotating and linear applications. Handling the points is very easy with the right holder. By simply turning the holder, you can clamp the flexi-polishers and change them equally quickly.

Recommended rotational speed: 15,000 rpm • Max. rotational speed: 30,000 rpm

Dimensions	Grit size	Colour	Bonding	Packing quantity	Order No.	Price from 1 pack
Elastic polishing points joke FlexPol						
	Ø 1.5 x 15 mm	coarse	blue	hard	10 pieces	0 542 942-10
		medium	dark brown	x-hard	10 pieces	0 542 941-10
		medium	dark grey	medium	10 pieces	0 542 943-10
		fine	red brown	medium	10 pieces	0 542 944-10
		x-fine	green	medium	10 pieces	0 542 945-10
		xx-fine	yellow	medium	10 pieces	0 542 946-10
	Ø 2 x 20 mm	coarse	blue	hard	10 pieces	0 542 952-10
		medium	dark brown	x-hard	10 pieces	0 542 951-10
		medium	dark grey	medium	10 pieces	0 542 953-10
		fine	red brown	medium	10 pieces	0 542 954-10
		x-fine	green	medium	10 pieces	0 542 955-10
		xx-fine	yellow	medium	10 pieces	0 542 956-10
	Ø 3 x 23 mm	coarse	blue	hard	10 pieces	0 542 962-10
		medium	dark brown	x-hard	10 pieces	0 542 961-10
		medium	dark grey	medium	10 pieces	0 542 963-10
		fine	red brown	medium	10 pieces	0 542 964-10
		x-fine	green	medium	10 pieces	0 542 965-10
		xx-fine	yellow	medium	10 pieces	0 542 966-10
	Ø 4 x 26 mm	coarse	blue	hard	10 pieces	0 542 972-10
		medium	dark brown	x-hard	10 pieces	0 542 971-10
		medium	dark grey	medium	10 pieces	0 542 973-10
		fine	red brown	medium	10 pieces	0 542 974-10
		x-fine	green	medium	10 pieces	0 542 975-10
		xx-fine	yellow	medium	10 pieces	0 542 976-10
	Ø 5 x 28 mm	coarse	blue	hard	10 pieces	0 542 982-10
		medium	dark brown	x-hard	10 pieces	0 542 981-10
		medium	dark grey	medium	10 pieces	0 542 983-10
		fine	red brown	medium	10 pieces	0 542 984-10
		x-fine	green	medium	10 pieces	0 542 985-10
		xx-fine	yellow	medium	10 pieces	0 542 986-10

Accessories / spare parts



Dimensions	Order No.	Price from 1 piece	3 pieces	5 pieces
Holder for joke FlexPol, shank Ø 2.35 x 30 mm				
Ø 1.5 mm	0 542 940			
Ø 2 mm	0 542 950			
Ø 3 mm	0 542 960			
Ø 4 mm	0 542 970			
Ø 5 mm	0 542 980			

Elastic grinding files joke PU-DIA

Rubber-bonded grinding files joke PU-DIA

Synthetic diamond grits bonded in polyurethane (PU). Excellent stock removal performance on hardened surfaces and also the correct medium of choice for removing erosion structures. Owing to the elastic bond, these tools also adapt very well to the widest array of contours without any risk of breaking. Two dimensions in each of six grit sizes as standard (others on request!).

Use: wet/dry with water, fluid or oil.

Tip: make your own grinding files. The joke Pu-Dia's can be simply cut to size and adapted.



Dimensions	Grit size	Colour	Order No.	Price from	1 piece	5 pieces
Elastic grinding files joke PU-DIA						
rectangular						
10 x 10 x 100 mm	D 3	green	0 545 801			
	D 9	red	0 545 802			
	D 15	brown	0 545 803			
	D 30	mahogany	0 545 804			
	D 40	purple	0 545 805			
	D 60	orange	0 545 806			
20 x 20 x 100 mm	D 3	green	0 545 811			
	D 9	red	0 545 812			
	D 15	brown	0 545 813			
	D 30	mahogany	0 545 814			
	D 40	purple	0 545 815			
	D 60	orange	0 545 816			

Polishing point set, soft elastomer shank Ø 2.35 x 30 mm

	Grit size		Shank dimensions	Packing quantity	Price from			
					Order No.	1 set	20 set	50 set
Polishing point set, soft elastomer								
Set – silicone polishers consisting of 1 piece each:		SiC 240	green	Ø 2.35 - 30 mm	12 pieces	0 544 855		
Wheel:	head dim. 10 x 2 mm							
Mushroom:	head dim. 10 x 2 mm							
Cylinder:	head dim. 10 x 4 mm							
Cylinder:	head dim. 6 x 10 mm							
Trapezium (open):	head dim. 9 x 6 mm							
Trapezium (closed):	head dim. 8 x 6 mm							
	SiC 400	grey	Ø 2.35 - 30 mm	12 pieces	0 544 856			
Barrel:	head dim. 6 x 6 mm							
Sphere:	head dim. Ø 8 mm							
Cone:	head dim. 6 x 6 mm							
Tree:	head dim. 6 x 6 mm							
Tree with pointed end:	head dim. 6 x 12 mm							
Tree:	head dim. 6 x 15 mm							

Storage in a plastic box.

Lapping and polishing rubber for self-made tools

Dimensions	Grit size	Type	Order No.	Price from 1 piece	20 pieces
Lapping and polishing rubber for self-made tools					
stick					
Ø 6 x 200 mm	120	SG-6	0 544 951		
Ø 10 x 200 mm	120	SG-100	0 544 956		



Rubber-bonded grinding tools CERA Sticks

Rubber-bonded grinding tools CERA Sticks

A rubber tool on a handle - or modern: stick. Highly practical in any case, since firstly handy and secondly adapting optimally to the contours to be processed. This qualifies the sticks above all for uneven surfaces in addition to places which are difficult to reach. For deburring work, removal of annealing colours, for chamfering ...

available separately in different grit sizes or as a set in the practical plastic box.

Coating dimensions	Grit size	Colour	Order No.	Price from 1 piece
Rubber-bonded grinding tool with handle CERA Stick				
50 x 12 x 6 mm	# 46	grey	0 544 581	
50 x 12 x 6 mm	# 80	red	0 544 582	
50 x 12 x 6 mm	# 120	blue	0 544 583	
50 x 12 x 6 mm	# 220	yellow	0 544 584	
50 x 12 x 6 mm	# 320	violet	0 544 585	



matching set

Set CERA Sticks in plastic box	Content: 1 stick in each grit size	Order No.	Price from 1 pack
		0 544 580	

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Tool system CRATEX® Sets

The assortment for tool and mould makers. The bond is made of chemical rubber. In contrast to hard grinding wheels, the CRATEX® bond has a unique cushioned action ensuring soft, smooth and free cutting. With harder materials, CRATEX® yields a clean, polishable cut, free from corrugation and discolouration. CRATEX® grinds and polishes soft materials and plastics without tearing. It resists clogging and smearing and does not result in any glassy points.

CRATEX® can be used for dry and wet grinding. The tools are insensitive to all common grinding cooling media and rust protectors and to oil. Even more gentle work can be achieved in conjunction with polishing pastes.

Typical applications:

Smoothing and polishing of casting moulds, dies and other production tools, smoothing of edges on punched or sheared parts or glass, lapping of welded seams after rough grinding: sharpening of cutting dies, deburring and smoothing of plastic workpieces, reworking injection channels; polishing of moulds.

The advantages at a glance:

- flexible and adaptable
- clean, discolouration-free polished section
- for all metals, non-ferrous metals and plastics
- grinding, polishing, deburring and smoothing
- four different grit sizes

CRATEX® tools are available in four standard grit sizes, which each have a different colour for ease of differentiation:

(C) Coarse – dark green – grit size 40

For coarse grinding and deburring. Cuts rapidly without clogging. CRATEX® C is used for soft materials such as brass, copper and aluminium and leaves a clean, smooth surface after rough casting.

(M) Medium – dark brown – grit size 90

For light deburring and for general finishing, yielding a surface quality between preliminary grinding and polishing. CRATEX® M is recommended for the working states following rough grinding of brass, copper, aluminium and stainless steel, etc. It is eminently suitable for polishing of moulds and for performing general finishing work.

(F) Fine – light brown – grit size 120

A fine, needle-sharp grit size for polishing. A clean, polished surface is achieved very rapidly using this grit size. Particularly suitable for highalloyed steels, gold and other noble metals, for which a good surface is required.

(XF) Extra fine – light green – grit size 240

A microfine grit for achievement of a high gloss polish or final polishing on all metals.



Maximum cutting speeds and best operating speeds

For most efficient results and good surface quality, operating speeds must not exceed the maximum safety speeds mentioned in the instruction sheets of the relevant CRATEX® tools. The maximum cutting speed must never be exceeded.

The rpm values for small CRATEX® wheels up to Ø 25 mm are based on a protruding shank length between 10 and 15 mm. If the protruding shank length exceeds 15 mm, the speed must be reduced by 20 % per 5 mm.

Tool system CRATEX® Sets

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	Price from	
	Order No.	1 set
CRATEX® Set 778, 68 pieces	0 545 291	
 A clear plastic storage case with four compartments containing various CRATEX points and mounting shanks. Several additional points and shanks are scattered outside the case.		

	Price from	
	Order No.	1 set
CRATEX® Set 777, 84 pieces	0 545 292	
 A clear plastic storage case with four compartments containing various CRATEX wheels, points, and mounting shanks. Several additional wheels, points, and shanks are scattered outside the case.		

Tool system CRATEX® rubber-bonded abrasives for shank-mounting

Shape	Dimensions	Grit size	Type	Matching receptacles	Order No.	Price from	
						1 piece	20 pieces
CRATEX® rubber-bonded abrasive for shank mounting							
wheel, tapered	Ø 16 x 2.5 mm	C-coarse 40	2	21, 22, 23, 25	0 545 005		
	Ø 16 x 2.5 mm	M-medium 90	2	21, 22, 23, 25	0 545 006		
	Ø 16 x 2.5 mm	F-fine 120	2	21, 22, 23, 25	0 545 007		
	Ø 16 x 2.5 mm	XF-extra fine 240	2	21, 22, 23, 25	0 545 008		
	Ø 25 x 3 mm	C-coarse 40	5	21, 22, 23, 25	0 545 009		
	Ø 25 x 3 mm	M-medium 90	5	21, 22, 23, 25	0 545 010		
	Ø 25 x 3 mm	F-fine 120	5	21, 22, 23, 25	0 545 011		
	Ø 25 x 3 mm	XF-extra fine 240	5	21, 22, 23, 25	0 545 012		
point, cylindrical shape	Ø 6 x 12.5 mm	C-coarse 40	4	11, 12	0 545 017		
	Ø 6 x 12.5 mm	M-medium 90	4	11, 12	0 545 018		
	Ø 6 x 12.5 mm	F-fine 120	4	11, 12	0 545 019		
	Ø 6 x 12.5 mm	XF-extra fine 240	4	11, 12	0 545 020		
	Ø 6 x 22 mm	C-coarse 40	6	11, 12	0 545 021		
	Ø 6 x 22 mm	M-medium 90	6	11, 12	0 545 022		
	Ø 6 x 22 mm	F-fine 120	6	11, 12	0 545 023		
	Ø 6 x 22 mm	XF-extra fine 240	6	11, 12	0 545 024		
point, bullet-shape	Ø 7 x 25 mm	C-coarse	8	11, 12	0 545 029		
	Ø 7 x 25 mm	M-medium 90	8	11, 12	0 545 030		
	Ø 7 x 25 mm	F-fine 120	8	11, 12	0 545 031		
	Ø 7 x 25 mm	XF-extra fine 240	8	11, 12	0 545 032		
	Ø 9.5 x 16 mm	C-coarse 40	10	11, 12	0 545 033		
	Ø 9.5 x 16 mm	M-medium 90	10	11, 12	0 545 034		
	Ø 9.5 x 16 mm	F-fine 120	10	11, 12	0 545 035		
	Ø 9.5 x 16 mm	XF-extra fine 240	10	11, 12	0 545 036		
	Ø 9.5 x 25 mm	C-coarse 40	11	13, 14	0 545 037		
	Ø 9.5 x 25 mm	M-medium 90	11	13, 14	0 545 038		
	Ø 9.5 x 25 mm	F-fine 120	11	13, 14	0 545 039		
	Ø 9.5 x 25 mm	XF-extra fine 240	11	13, 14	0 545 040		
	Ø 12.5 x 22 mm	C-coarse 40	15	13, 14	0 545 041		
	Ø 12.5 x 22 mm	M-medium 90	15	13, 14	0 545 042		
	Ø 12.5 x 22 mm	F-fine 120	15	13, 14	0 545 043		
	Ø 12.5 x 22 mm	XF-extra fine 240	15	13, 14	0 545 044		

Tool system CRATEX® rubber-bonded abrasives for shank-mounting

Shape	Dimensions	Grit size	Type	Matching receptacles	Price from		
					Order No.	1 piece	20 pieces
	$\varnothing 16 \times 2.3 \text{ mm}$	C-coarse 40	53	21, 22, 23, 25	0 545 073		
	$\varnothing 16 \times 2.3 \text{ mm}$	M-medium 90	53	21, 22, 23, 25	0 545 074		
	$\varnothing 16 \times 2.3 \text{ mm}$	F-fine 120	53	21, 22, 23, 25	0 545 075		
	$\varnothing 16 \times 2.3 \text{ mm}$	XF-extra fine 240	53	21, 22, 23, 25	0 545 076		
	$\varnothing 16 \times 3 \text{ mm}$	C-coarse 40	54	21, 22, 23, 25	0 545 077		
	$\varnothing 16 \times 3 \text{ mm}$	M-medium 90	54	21, 22, 23, 25	0 545 078		
	$\varnothing 16 \times 3 \text{ mm}$	F-fine 120	54	21, 22, 23, 25	0 545 079		
	$\varnothing 16 \times 3 \text{ mm}$	XF-extra fine 240	54	21, 22, 23, 25	0 545 080		
	$\varnothing 22 \times 3 \text{ mm}$	C-coarse 40	74	21, 22, 23, 25	0 545 085		
	$\varnothing 22 \times 3 \text{ mm}$	M-medium 90	74	21, 22, 23, 25	0 545 086		
	$\varnothing 22 \times 3 \text{ mm}$	F-fine 120	74	21, 22, 23, 25	0 545 087		
	$\varnothing 22 \times 3 \text{ mm}$	XF-extra fine 240	74	21, 22, 23, 25	0 545 088		
	$\varnothing 22 \times 4.5 \text{ mm}$	C-coarse 40	76	21, 22, 23, 25	0 545 089		
	$\varnothing 22 \times 4.5 \text{ mm}$	M-medium 90	76	21, 22, 23, 25	0 545 090		
	$\varnothing 22 \times 4.5 \text{ mm}$	F-fine 120	76	21, 22, 23, 25	0 545 091		
	$\varnothing 22 \times 4.5 \text{ mm}$	XF-extra fine 240	76	21, 22, 23, 25	0 545 092		
	$\varnothing 25 \times 3 \text{ mm}$	C-coarse 40	80	21, 22, 23, 25	0 545 101		
	$\varnothing 25 \times 3 \text{ mm}$	M-medium 90	80	21, 22, 23, 25	0 545 102		
	$\varnothing 25 \times 3 \text{ mm}$	F-fine 120	80	21, 22, 23, 25	0 545 103		
	$\varnothing 25 \times 3 \text{ mm}$	XF-extra fine 240	80	21, 22, 23, 25	0 545 104		
	$\varnothing 16/6 \times 25 \text{ mm}$	M-medium 90	1340	31	0 545 118		
	$\varnothing 16/6 \times 25 \text{ mm}$	F-fine 120	1340	31	0 545 119		

Tool system CRATEX® rubber-bonded grinding wheels for elastic grinding

Dimensions	Drilling dimension	Grit size	Type	Rotation speed max.	Order No.	Price from 1 piece
CRATEX® Rubber-bonded grinding wheels						
$\varnothing 38 \times 3 \text{ mm}$	3 mm	M-medium 90	152	15000 1/min	0 545 302	
$\varnothing 38 \times 9.5 \text{ mm}$	6 mm	M-medium 90	156	15000 1/min	0 545 314	
$\varnothing 50 \times 3 \text{ mm}$	6 mm	C-coarse 40	202	10500 1/min	0 545 321	
	6 mm	F-fine 120	202	10500 1/min	0 545 323	
$\varnothing 50 \times 4.5 \text{ mm}$	6 mm	M-medium 90	203	10500 1/min	0 545 326	
$\varnothing 50 \times 6 \text{ mm}$	6 mm	C-coarse 40	204	10500 1/min	0 545 329	
	6 mm	F-fine 120	204	10500 1/min	0 545 331	
$\varnothing 75 \times 6 \text{ mm}$	6 mm	M-medium 90	304	7000 1/min	0 545 358	
$\varnothing 125 \times 6 \text{ mm}$	25 mm	XF-extra fine 240	504	4200 1/min	0 545 408	

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Tool system CRATEX® mounting shanks and grinding wheel holders

	for bore dimensions	Shank dimensions	Type	Order No.	Price from
					1 piece 10 pieces
CRATEX® mounting shanks					
	Ø 2 mm	Ø 2.35 mm	11	0 545 271	
	Ø 2 mm	Ø 3 mm	12	0 545 272	
	Ø 3 mm	Ø 3 mm	13	0 545 273	
	Ø 3 mm	Ø 6 mm	14	0 545 274	

Tool system CRATEX® mounting shanks and grinding wheel holders

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from
						1 piece 10 pieces
CRATEX® grinding wheel holder						
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	0 545 279	
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275	
	Ø 1.5 – 1.8 mm	Ø 3 x 40/30 mm	24	Ø 38 x 3 mm	0 545 278	
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276	
	Ø 1/8" / Ø 3.2 mm	Ø 3 x 40/30 mm	28	Ø 38 x 5.5 mm	0 545 296	
	Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	0 545 280	
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277	
	Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	0 545 281	
	Ø 3 mm	Ø 6 x 40 mm	33	Ø 45 x 6 mm	0 545 269	
	Ø 6 mm	Ø 6 x 25 mm	41	Ø 75 x 9.5 mm	0 545 282	
	Ø 6 mm	Ø 6 x 40 mm	42	Ø 75 x 20 mm	0 545 283	
	Ø 1/4" / Ø 6.3 mm	Ø 6 x 30 mm	31	Ø 75 x 25 mm	0 545 284	
	Ø 1/4" / Ø 6.3 mm	Ø 6 x 40 mm	32	Ø 75 x 20 mm	0 545 297	

Tool system CRATEX® rubber-bonded sticks for hand (filing machine) use

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	Dimensions	Grit size	Type	Order No.	Price from
					1 piece 10 pieces
CRATEX® rubber-bonded sticks					
square					
	6 x 6 x 150 mm	C-coarse 40	6202	0 545 171	
		M-medium 90	6202	0 545 172	
		F-fine 120	6202	0 545 173	
		XF-very fine 240	6202	0 545 174	
	12.5 x 12.5 x 150 mm	C-coarse 40	6404	0 545 175	
		M-medium 90	6404	0 545 176	
		F-fine 120	6404	0 545 177	
		XF-very fine 240	6404	0 545 178	
	18 x 18 x 150 mm	C-coarse 40	6606	0 545 179	
		M-medium 90	6606	0 545 180	
		F-fine 120	6606	0 545 181	
		XF-very fine 240	6606	0 545 182	
round					
	Ø 4.8 x 150 mm	M-medium 90	036	0 545 228	
		F-fine 120	036	0 545 229	
		C-coarse 40	046	0 545 231	
	Ø 6 x 150 mm	M-medium 90	046	0 545 232	
		F-fine 120	046	0 545 233	
		XF-very fine 240	046	0 545 234	
	Ø 9.5 x 150 mm	M-medium 90	066	0 545 240	
		F-fine 120	066	0 545 241	
		XF-very fine 240	066	0 545 242	
	Ø 12.5 x 150 mm	C-coarse 40	086	0 545 243	
		M-medium 90	086	0 545 244	
		F-fine 120	086	0 545 245	
		XF-very fine 240	086	0 545 246	
	Ø 16 x 150 mm	M-medium 90	0106	0 545 248	
		F-fine 120	0106	0 545 249	
	Ø 18 x 150 mm	C-coarse 40	0126	0 545 251	
		M-medium 90	0126	0 545 252	
		F-fine 120	0126	0 545 253	
	Ø 25 x 150 mm	F-fine 120	0166	0 545 261	
rectangular					
	25 x 3 x 150 mm	C-coarse 40	6801	0 545 191	
		M-medium 90	6801	0 545 192	
		F-fine 120	6801	0 545 193	
	25 x 6 x 150 mm	C-coarse 40	6802	0 545 199	
		M-medium 90	6802	0 545 200	
		F-fine 120	6802	0 545 201	
	25 x 9.5 x 150 mm	C-coarse 40	6803	0 545 203	
		M-medium 90	6803	0 545 204	
		F-fine 120	6803	0 545 205	
		XF-very fine 240	6803	0 545 206	

Grinding and polishing stones

223 joke stones

228 Gesswein® stones

238 Boride® stones

246 Bench stones

249 Holder for grinding and polishing stones

**joke****Gesswein®****Boride®**

Type	Page	Tool steel	Steels	Erosion structures	Stainless steel	Aluminium	Non-ferrous metals	Carbide metals
FD	223	◆						
JB 1	224	◆	◆	◆				
JB 2	225	◆	◆	◆				
C-AS	226	◆	◆	◆	◆	◆	◆	
Royal S	227	◆	◆	◆				
EDM BLUE	228	◆	◆	◆				
OT	229	◆	◆	◆				
EDM	230	◆	◆	◆				
DIEMAKER	231	◆	◆			◆	◆	
MOLDMAKER	233	◆	◆		◆	◆	◆	
ULTRASOFT	234	◆	◆	◆	◆	◆	◆	
PREMIUM WHITE	235	◆	◆		◆	◆	◆	
G2	236	◆	◆		◆			
SUPER FINE	236	◆	◆		◆	◆	◆	
GP-STONE	237	◆	◆	◆				
CS-HD	238	◆	◆	◆				
T2	239	◆		◆	◆			
Orange EDM	240	◆	◆	◆				
AO	241	◆	◆	◆				
Golden Star	242	◆	◆					
AM-2	243	◆	◆		◆	◆	◆	
RO-MED	244	◆	◆	◆				
RASP	245	◆	◆	◆	◆	◆	◆	
CS-M	246	◆	◆					

Grinding and polishing stones joke FD

These ceramic oxide stones consist of mixed crystals of outstanding hardness. The main component is aluminium oxide. This crystal occurs naturally as ruby, hence the name "ruby stones" or "dugusit".

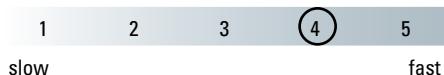
The stones are free of bonding agents, absolutely dimensionally stable and low-wear. Ideal for manual use and in ultrasonic polishing systems. Tip: well suited for carbide metal processing and very fine finishing after grinding.



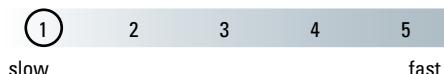
Bonding



Stock removal



Wear



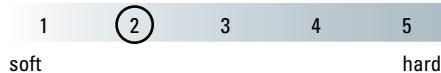
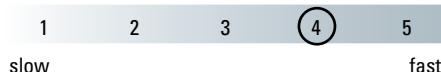
Application

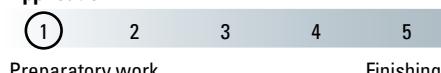


Dimensions	Grit size	Type	Order No.	Price from 1 piece
Grinding and polishing stones, joke FD				
crossing				
4 x 1.5 x 100 mm	fine	FD	0 401 570	
triangular				
2 x 50 mm	fine	FD	0 401 566	
3 x 100 mm	fine	FD	0 401 567	
4 x 100 mm	fine	FD	0 401 586	
	medium	FD	0 401 587	
5 x 1.5 x 100 mm	fine	FD	0 401 571	
6 x 100 mm	fine	FD	0 401 588	
	medium	FD	0 401 589	
8 x 100 mm	fine	FD	0 401 590	
	medium	FD	0 401 591	
square				
1 x 50 mm	fine	FD	0 401 568	
2 x 100 mm	fine	FD	0 401 569	
4 x 100 mm	fine	FD	0 401 592	
	medium	FD	0 401 593	
6 x 100 mm	fine	FD	0 401 594	
	medium	FD	0 401 595	
8 x 100 mm	fine	FD	0 401 596	
	medium	FD	0 401 597	
round				
Ø 1 x 50 mm	fine	FD	0 401 563	
Ø 2 x 100 mm	fine	FD	0 401 564	
Ø 3 x 100 mm	fine	FD	0 401 565	
Ø 4 x 100 mm	fine	FD	0 401 580	
	medium	FD	0 401 581	
Ø 6 x 100 mm	fine	FD	0 401 582	
	medium	FD	0 401 583	
Ø 8 x 100 mm	fine	FD	0 401 584	
	medium	FD	0 401 585	
halfround				
Ø 4 x 100 mm	fine	FD	0 401 562	
rectangular				
3 x 0.3 x 50 mm	fine	FD	0 401 561	
6 x 3 x 100 mm	fine	FD	0 401 576	
	medium	FD	0 401 577	
8 x 6 x 100 mm	fine	FD	0 401 578	
	medium	FD	0 401 579	

Grinding and polishing stones joke JB1

These grinding and polishing stones are made of pink highgrade corundum in a soft bond. They can be used dry. When used without oil, the grinding residues are simply removed with a brush. The JB1 grinding and polishing stones are suitable for both soft and hard materials and are used, for example, on milled or ground surfaces and contours.


Bonding

Stock removal

Wear

Application


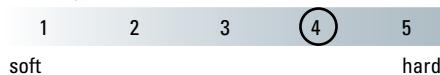
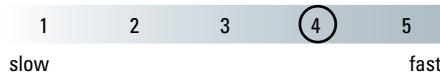
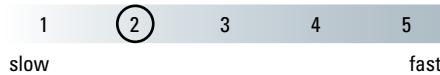
Grinding and polishing stone oil (fluid) for all grinding and polishing stones

The oil/fluid suitable for all grinding and polishing stones. Very economical to use and practically odourless. The use of this fluid prevents clogging of stones during processing. The grinding tools cut better, producing a brilliant, uniform surface.

Content	Order No.	Price from
	1 piece	5 pieces
Grinding and polishing stone oil (fluid)		
1 litre		0 401 870
5 litres		0 401 870-5

Grinding and polishing stones joke JB2

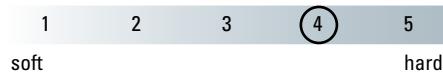
These stones of sulphured high-grade corundum are particularly suitable for grinding eroded surfaces and contours. The hard bond guarantees a very high edge strength for the stones and at the same time prevents excessive clogging. The additional use of abrasive stone oil (fluid) is recommended.

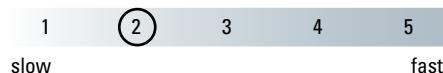
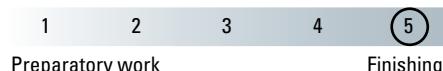

Bonding

Stock removal

Wear

Application


Dimensions	Grit size	Type	Order No.	Price from 1 piece	Price from 12 pieces	Price from 60 pieces
Grinding and polishing stones joke JB2						
rectangular						
6 x 3 x 150 mm	180	JB2	0 401 821			
	320	JB2	0 401 826			
	600	JB2	0 401 841			
13 x 3 x 150 mm	180	JB2	0 401 822			
	320	JB2	0 401 827			
13 x 6 x 150 mm	120	JB2	0 401 813			
	180	JB2	0 401 823			
	320	JB2	0 401 828			
	600	JB2	0 401 843			
20 x 10 x 150 mm	120	JB2	0 401 814			
	320	JB2	0 401 829			

Grinding and polishing stones joke C-AS

joke C-AS stones are made from white high-grade corundum with sulphured graphite to prevent tearing on the surface. The bond is hard and therefore edge-stable. Use with a fluid or file oil is recommended.


Bonding

Stock removal

Wear

Application


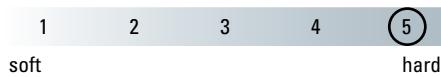
Dimensions	Grit size	Type	Order No.	1 piece	12 pieces	60 pieces	Price from
Grinding and polishing stones, joke C-AS							
square							
6 x 6 x 125 mm	220	C-AS	0 414 023				
	320	C-AS	0 414 024				
	400	C-AS	0 414 025				
	600	C-AS	0 414 026				
	800	C-AS	0 414 027				
	1000	C-AS	0 414 028				
	1200	C-AS	0 414 029				
rectangular							
12 x 3 x 125 mm	220	C-AS	0 414 033				
	320	C-AS	0 414 034				
	400	C-AS	0 414 035				
	600	C-AS	0 414 036				
	800	C-AS	0 414 037				
	1000	C-AS	0 414 038				
	1200	C-AS	0 414 039				
12 x 6 x 125 mm	220	C-AS	0 414 043				
	320	C-AS	0 414 044				
	400	C-AS	0 414 045				
	600	C-AS	0 414 046				
	800	C-AS	0 414 047				
	1000	C-AS	0 414 048				
	1200	C-AS	0 414 049				

Grinding and polishing stones joke Royal S

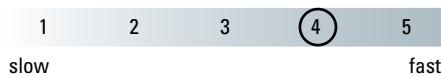
These aluminium oxide grinding stones with a special oil impregnation have very good dry running properties and a very hard bond. The stones are used for finishing soft and hard metals. The very mild microsection makes it possible to achieve optimum surfaces up to superfinish. Contours can be retained easily.



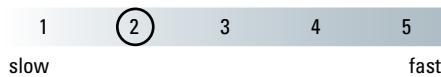
Bonding



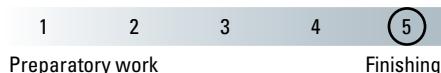
Stock removal



Wear



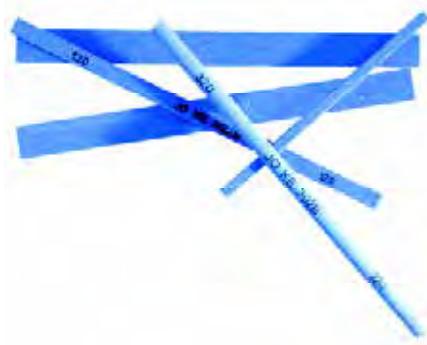
Application



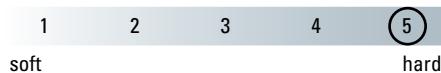
Dimensions	Grit size	Type	Order No.	1 piece	12 pieces	60 pieces
Grinding and polishing stones, joke Royal S						
square						
6 x 6 x 150 mm	320	Royal S	0 401 862			
	400	Royal S	0 401 863			
	600	Royal S	0 401 864			
	800	Royal S	0 401 865			
	1000	Royal S	0 401 866			
rectangular						
6 x 3 x 150 mm	320	Royal S	0 401 831			
	400	Royal S	0 401 836			
	600	Royal S	0 401 846			
	800	Royal S	0 401 851			
	1000	Royal S	0 401 856			
13 x 3 x 150 mm	320	Royal S	0 401 832			
	400	Royal S	0 401 837			
	600	Royal S	0 401 847			
	800	Royal S	0 401 852			
	1000	Royal S	0 401 857			
13 x 6 x 150 mm	320	Royal S	0 401 833			
	400	Royal S	0 401 838			
	600	Royal S	0 401 848			
	800	Royal S	0 401 853			
	1000	Royal S	0 401 858			

Grinding and polishing stones Gesswein® EDM BLUE

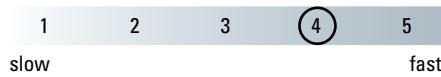
Premium aluminium oxide stones. The hardest Gesswein® stones. Ideal for use with hand-filing machines and ultrasonic polishing systems. As these stones are a lot harder than the EDM series, they are better suited for the quick removal of hard erosion skin. Optimum results in conjunction with fluid.



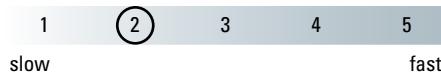
Bonding



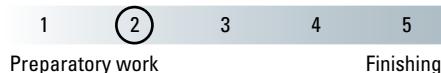
Stock removal



Wear



Application



Dimensions	Grit size	Type	Order No.	Price from
				1 piece 12 pieces 60 pieces
Grinding and polishing stones Gesswein® EDM BLUE				
square				
4 x 4 x 100 mm	120	EDM BLUE 61	0 401 601	
	180	EDM BLUE 62	0 401 602	
	220	EDM BLUE 622	0 401 603	
	320	EDM BLUE 63	0 401 604	
	400	EDM BLUE 64	0 401 605	
	600	EDM BLUE 66	0 401 606	
6 x 6 x 150 mm	120	EDM BLUE 6122	0 401 613	
	180	EDM BLUE 6182	0 401 614	
	220	EDM BLUE 6202	0 401 615	
	320	EDM BLUE 6302	0 401 616	
	400	EDM BLUE 6402	0 401 617	
	600	EDM BLUE 6602	0 401 618	
round				
Ø 6 x 150 mm	120	EDM BLUE E122	0 401 637	
	180	EDM BLUE E182	0 401 638	
	320	EDM BLUE E302	0 401 639	
rectangular				
6 x 3 x 150 mm	120	EDM BLUE 6121	0 401 607	
	180	EDM BLUE 6181	0 401 608	
	220	EDM BLUE 6201	0 401 609	
	320	EDM BLUE 6301	0 401 610	
	400	EDM BLUE 6401	0 401 611	
	600	EDM BLUE 6601	0 401 612	
13 x 1.6 x 150 mm	120	EDM BLUE 6120	0 401 619	
	180	EDM BLUE 6180	0 401 620	
	220	EDM BLUE 6200	0 401 621	
	320	EDM BLUE 6300	0 401 622	
	400	EDM BLUE 6400	0 401 623	
	600	EDM BLUE 6600	0 401 624	
13 x 3 x 150 mm	120	EDM BLUE 6123	0 401 625	
	180	EDM BLUE 6183	0 401 626	
	220	EDM BLUE 6203	0 401 627	
	320	EDM BLUE 6303	0 401 628	
	400	EDM BLUE 6403	0 401 629	
	600	EDM BLUE 6603	0 401 630	
13 x 6 x 150 mm	120	EDM BLUE 6124	0 401 631	
	180	EDM BLUE 6184	0 401 632	
	220	EDM BLUE 6204	0 401 633	
	320	EDM BLUE 6304	0 401 634	
	400	EDM BLUE 6404	0 401 635	
	600	EDM BLUE 6604	0 401 636	

Grinding and polishing stones

Gesswein® OT

These hard white aluminium oxide stones are ideal for fine work on both hard and soft metals and in particular for the finishing of slots and points that are difficult to reach. A sophisticated oil impregnation ensures that the OT stones do not clog up and an excellent grinding pattern is achieved.



Bonding

1	2	3	4	5
soft				hard

Stock removal

1	2	3	4	5
slow				fast

Wear

1	2	3	4	5
slow				fast

Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from
				1 piece 12 pieces 60 pieces
Grinding and polishing stones, Gesswein® OT				
square				
4 x 4 x 100 mm	120	OT 51	0 401 276	
	220	OT 52	0 401 277	
	320	OT 53	0 401 278	
	400	OT 54	0 401 279	
	600	OT 56	0 401 280	
4 x 4 x 150 mm	120	OT 51	0 401 202	
	220	OT 52	0 401 203	
	320	OT 53	0 401 204	
	400	OT 54	0 401 205	
	600	OT 56	0 401 206	
6 x 6 x 150 mm	120	OT 5102	0 401 286	
	220	OT 5202	0 401 287	
	320	OT 5302	0 401 288	
	400	OT 5402	0 401 289	
	600	OT 5602	0 401 290	
rectangular				
6 x 3 x 150 mm	120	OT 5101	0 401 281	
	220	OT 5201	0 401 282	
	320	OT 5301	0 401 283	
	400	OT 5401	0 401 284	
	600	OT 5601	0 401 285	
13 x 3 x 150 mm	120	OT 5103	0 401 291	
	220	OT 5203	0 401 292	
	320	OT 5303	0 401 293	
	400	OT 5403	0 401 294	
	600	OT 5603	0 401 295	
	800	OT 5803	0 401 254	
	1200	OT 5903	0 401 255	
13 x 6 x 150 mm	120	OT 5104	0 401 296	
	220	OT 5204	0 401 297	
	320	OT 5304	0 401 298	
	400	OT 5404	0 401 299	
	600	OT 5604	0 401 300	
	800	OT 5804	0 401 256	
	1200	OT 5904	0 401 257	
25 x 13 x 150 mm	120	OT	0 401 641	
	220	OT	0 401 642	
	320	OT	0 401 643	
	400	OT	0 401 644	
	600	OT	0 401 645	

Grinding and polishing stones

Gesswein® EDM

The cutting effect of these stones makes them ideal for processing of moulds manufactured by electroerosion. The sharp and easy-cutting premium aluminium oxide strips the extremely hard surface layer that remains after electroerosion in a very short time. EDM stones are very hard and therefore dimensionally stable and do not clog. Further surface refinement can be achieved with the subsequent use of finer grit sizes of DF quality.


Bonding

1	2	3	4	5
soft				hard

Stock removal

1	2	3	4	5
slow				fast

Wear

1	2	3	4	5
slow				fast

Application

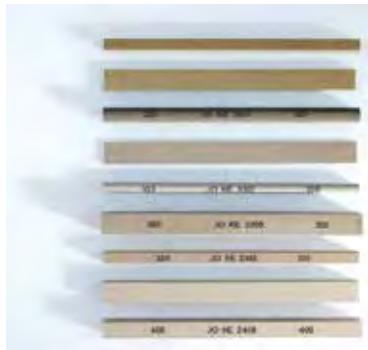
1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from	1 piece	12 pieces	60 pieces
Grinding and polishing stones, Gesswein® EDM							
square							
4 x 4 x 100 mm	180	EDM 62	0 401 002				
	220	EDM 622	0 401 755				
	320	EDM 63	0 401 003				
	400	EDM 64	0 401 710				
	600	EDM 66	0 401 711				
6 x 6 x 150 mm	120	EDM 6122	0 401 010				
	180	EDM 6182	0 401 011				
	220	EDM 6202	0 401 752				
	320	EDM 6302	0 401 012				
	400	EDM 6402	0 401 716				
	600	EDM 6602	0 401 717				
10 x 10 x 150 mm	120	EDM 6128	0 401 019				
	180	EDM 6188	0 401 020				
	320	EDM 6308	0 401 021				
round							
Ø 6 x 150 mm	120	EDM 122	0 401 264				
	180	EDM 182	0 401 265				
	320	EDM 302	0 401 266				
	400	EDM 402	0 401 722				
	220	EDM 222	0 401 750				
rectangular							
6 x 3 x 150 mm	120	EDM 6121	0 401 007				
	180	EDM 6181	0 401 008				
	220	EDM 6201	0 401 751				
	320	EDM 6301	0 401 009				
	400	EDM 6401	0 401 714				
	600	EDM 6601	0 401 715				
13 x 1.6 x 150 mm	120	EDM 6120	0 401 004				
	180	EDM 6180	0 401 005				
	320	EDM 6300	0 401 006				
	400	EDM 6400	0 401 712				
13 x 3 x 150 mm	120	EDM 6123	0 401 013				
	180	EDM 6183	0 401 014				
	220	EDM 6203	0 401 753				
	320	EDM 6303	0 401 015				
	400	EDM 6403	0 401 718				
	600	EDM 6603	0 401 719				
13 x 6 x 150 mm	120	EDM 6124	0 401 016				
	180	EDM 6184	0 401 017				
	220	EDM 6204	0 401 708				
	320	EDM 6304	0 401 018				
	400	EDM 6404	0 401 720				
	600	EDM 6604	0 401 721				
40 x 25 x 150 mm	120	EDM	0 401 273				
	180	EDM	0 401 274				
	320	EDM	0 401 275				

Grinding and polishing stones

Gesswein® DIEMAKER

The original "diemaker stones". Medium hard aluminium oxide combined with a semi-soft bond results in a DF stone quality with high dimensional stability and existing contours are therefore easily rectified. They are mainly used for cutting and punching tools, but are also very suitable for mould and tool making.



Bonding

1	2	3	4	5
soft				hard

Stock removal

1	2	3	4	5
slow				fast

Wear

1	2	3	4	5
slow				fast

Application

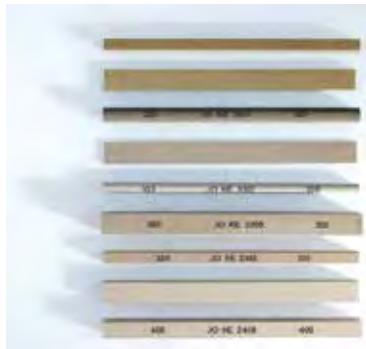
1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from
				1 piece 12 pieces 60 pieces
Grinding and polishing stones Gesswein® DIEMAKER				
triangular				
10 x 10 x 10 x 150 mm	150	DIEMAKER 2198	0 401 249	
	220	DIEMAKER 2298	0 401 250	
	320	DIEMAKER 2398	0 401 251	
	400	DIEMAKER 2498	0 401 252	
square				
4 x 4 x 100 mm	150	DIEMAKER 0010	0 401 786	
	220	DIEMAKER 2	0 401 141	
	320	DIEMAKER 3	0 401 142	
	400	DIEMAKER 4	0 401 143	
	600	DIEMAKER 6	0 401 144	
	800	DIEMAKER 8	0 401 145	
	900	DIEMAKER 9	0 401 146	
6 x 6 x 150 mm	150	DIEMAKER 2102	0 401 748	
	220	DIEMAKER 2202	0 401 158	
	320	DIEMAKER 2302	0 401 159	
	400	DIEMAKER 2402	0 401 160	
	600	DIEMAKER 2602	0 401 161	
	900	DIEMAKER 2902	0 401 162	
10 x 10 x 150 mm	150	DIEMAKER 2108	0 401 757	
	220	DIEMAKER 2208	0 401 163	
	320	DIEMAKER 2308	0 401 164	
	400	DIEMAKER 2408	0 401 165	
	600	DIEMAKER 2608	0 401 166	
	900	DIEMAKER 2908	0 401 167	
13 x 13 x 150 mm	150	DIEMAKER 2105	0 401 789	
	220	DIEMAKER 2205	0 401 183	
	320	DIEMAKER 2305	0 401 184	
	400	DIEMAKER 2405	0 401 185	
25 x 25 x 150 mm	150	DIEMAKER 2106	0 401 237	
	220	DIEMAKER 2206	0 401 238	
round				
Ø 6 x 150 mm	220	DIEMAKER 3202	0 401 188	
	320	DIEMAKER 3302	0 401 189	
	400	DIEMAKER 3402	0 401 190	
	600	DIEMAKER 3602	0 401 191	
	900	DIEMAKER 3902	0 401 192	
Ø 10 x 150 mm	220	DIEMAKER 3208	0 401 193	
	320	DIEMAKER 3308	0 401 194	
	400	DIEMAKER 3408	0 401 195	
	600	DIEMAKER 3608	0 401 196	

2 Grinding and polishing stones

Gesswein® DIEMAKER

The original "DIEMAKER stones". Medium hard aluminium oxide combined with a semi-soft bond results in a DF stone quality with high dimensional stability and existing contours are therefore easily rectified. They are mainly used for cutting and punching tools, but are also very suitable for mould and tool making.



Bonding



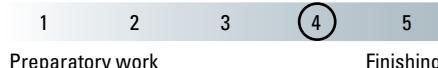
Stock removal



Wear



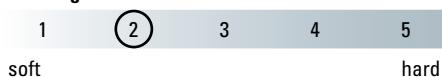
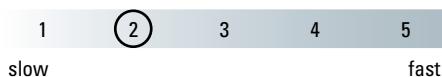
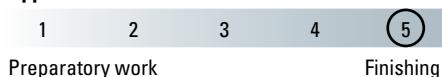
Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
rectangular						
6 x 1,6 x 100 mm	220	DIEMAKER 2210	0 401 148			
	320	DIEMAKER 2310	0 401 149			
	400	DIEMAKER 2410	0 401 150			
	600	DIEMAKER 2610	0 401 151			
6 x 3 x 150 mm	150	DIEMAKER 2101	0 401 242			
	220	DIEMAKER 2201	0 401 153			
	320	DIEMAKER 2301	0 401 154			
	400	DIEMAKER 2401	0 401 155			
	600	DIEMAKER 2601	0 401 156			
	900	DIEMAKER 2901	0 401 157			
13 x 1,6 x 150 mm	220	DIEMAKER 2200	0 401 168			
	320	DIEMAKER 2300	0 401 169			
	400	DIEMAKER 2400	0 401 170			
	600	DIEMAKER 2600	0 401 171			
13 x 3 x 150 mm	150	DIEMAKER 2103	0 401 705			
	220	DIEMAKER 2203	0 401 173			
	320	DIEMAKER 2303	0 401 174			
	400	DIEMAKER 2403	0 401 175			
	600	DIEMAKER 2603	0 401 176			
	900	DIEMAKER 2903	0 401 177			
13 x 6 x 150 mm	150	DIEMAKER 2104	0 401 747			
	220	DIEMAKER 2204	0 401 178			
	320	DIEMAKER 2304	0 401 179			
	400	DIEMAKER 2404	0 401 180			
	600	DIEMAKER 2604	0 401 181			
	900	DIEMAKER 2904	0 401 182			
25 x 12 x 150 mm	150	DIEMAKER 2107	0 401 231			
	220	DIEMAKER 2207	0 401 232			
	320	DIEMAKER 2307	0 401 233			
	400	DIEMAKER 2407	0 401 234			
	600	DIEMAKER 2607	0 401 235			

Grinding and polishing stones Gesswein® MOLDMAKER / MOLDMAKER PLUS

These stones produce a semi-gloss surface. As abrasive for these stones, silicon carbide or Premium silicon carbide is used. The soft bonding results in fast cutting action and largely prevents clogging. Since these stones easily adapt to the required profile, they are ideal for outlines and radii.

**Bonding****Stock removal****Wear****Application**

Dimensions	Grit size	Type	Order No.	Price from
				1 piece 12 pieces 60 p.
Grinding and polishing stones Gesswein® MOLDMAKER				
square				
6 x 6 x 100 mm	220	MOLDMAKER 202	0 401 089	
	320	MOLDMAKER 302	0 401 090	
	400	MOLDMAKER 402	0 401 091	
	600	MOLDMAKER 602	0 401 092	
6 x 6 x 150 mm	220	MOLDMAKER 1202	0 401 109	
	320	MOLDMAKER 1302	0 401 110	
	400	MOLDMAKER 1402	0 401 111	
	600	MOLDMAKER 1602	0 401 112	
13 x 13 x 150 mm	220	MOLDMAKER 1205	0 401 101-1	
	320	MOLDMAKER 1305	0 401 102-1	
	400	MOLDMAKER 1405	0 401 103-1	
	600	MOLDMAKER 1605	0 401 104-1	
rectangular				
6 x 3 x 100 mm	220	MOLDMAKER 201	0 401 085	
	320	MOLDMAKER 301	0 401 086	
	400	MOLDMAKER 401	0 401 087	
	600	MOLDMAKER 601	0 401 088	
6 x 3 x 150 mm	220	MOLDMAKER 1201	0 401 105	
	320	MOLDMAKER 1301	0 401 106	
	400	MOLDMAKER 1401	0 401 107	
	600	MOLDMAKER 1601	0 401 108	
13 x 3 x 150 mm	220	MOLDMAKER 1203	0 401 113	
	320	MOLDMAKER 1303	0 401 114	
	400	MOLDMAKER 1403	0 401 115	
	600	MOLDMAKER 1603	0 401 116	
13 x 6 x 100 mm	220	MOLDMAKER 204	0 401 097	
	320	MOLDMAKER 304	0 401 098	
	400	MOLDMAKER 404	0 401 099	
	600	MOLDMAKER 604	0 401 100	
13 x 6 x 150 mm	220	MOLDMAKER 1204	0 401 117	
	320	MOLDMAKER 1304	0 401 118	
	400	MOLDMAKER 1404	0 401 119	
	600	MOLDMAKER 1604	0 401 120	
Grinding and polishing stones Gesswein® MOLDMAKER PLUS				
square				
4 x 4 x 100 mm	220	MOLDMAKER PLUS 1020P	0 401 766	
	320	MOLDMAKER PLUS 1030P	0 401 767	
	400	MOLDMAKER PLUS 1040P	0 401 768	
	600	MOLDMAKER PLUS 1060P	0 401 769	
	800	MOLDMAKER PLUS 1080P	0 401 770	
6 x 6 x 150 mm	800	MOLDMAKER PLUS 1802P	0 401 774	
rectangular				
6 x 3 x 150 mm	800	MOLDMAKER PLUS 1801P	0 401 772	
13 x 3 x 150 mm	800	MOLDMAKER PLUS 1803P	0 401 776	
13 x 6 x 150 mm	100	MOLDMAKER PLUS 1104P	0 401 125	
	150	MOLDMAKER PLUS 1154P	0 401 123	
	800	MOLDMAKER PLUS 1804P	0 401 778	
	1200	MOLDMAKER PLUS 2004P	0 401 779	

2

3

4

5

6

7

Grinding and polishing stones

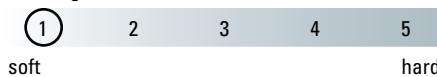
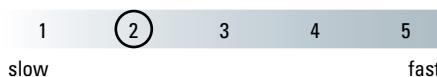
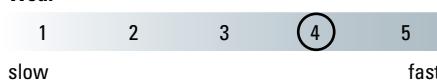
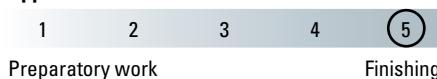
Gesswein® Hybrid test set

	Price from Order No.	1 set
Hybrid test set Gesswein®		
 <p>20 stones (dimensions: 6 x 6 x 150 mm), 1 piece each in grit size 220, 320, 400, 600: • DIEMAKER • EDM • GP • MOLDMAKER • OT</p>	0 401 140	

Grinding and polishing stones

Gesswein® ULTRASOFT

The abrasive used for the Super-Soft version is white aluminium oxide. The very soft bond allows for a quick adaption of these stones and prevents clogging. Perfectly suited for processing aluminium, beryllium, brass, bronze and stainless steel. These stones can be quickly and easily shaped.


Bonding

Stock removal

Wear

Application


Dimensions	Grit size	Type	Order No.	Price from	1 piece	12 pieces	60 pieces
Grinding and polishing stones Gesswein® ULTRASOFT							
square							
6 x 6 x 150 mm	120	ULTRASOFT 7102	0 401 724				
	320	ULTRASOFT 7302	0 401 725				
	600	ULTRASOFT 7602	0 401 726				
	1200	ULTRASOFT 7002	0 401 727				
rectangular							
13 x 3 x 150 mm	120	ULTRASOFT 7103	0 401 728				
	320	ULTRASOFT 7303	0 401 729				
	600	ULTRASOFT 7603	0 401 730				
	1200	ULTRASOFT 7003	0 401 731				
13 x 6 x 150 mm	120	ULTRASOFT 7104	0 401 732				
	320	ULTRASOFT 7304	0 401 733				
	600	ULTRASOFT 7604	0 401 734				
	1200	ULTRASOFT 7004	0 401 735				
25 x 13 x 150 mm	120	ULTRASOFT 7107	0 401 736				
	320	ULTRASOFT 7307	0 401 737				

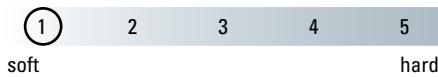
Grinding and polishing stones Gesswein® PREMIUM WHITE

The medium-hard PREMIUM WHITE stones are ideally suited for all work on tool steels and have good dimensional stability.

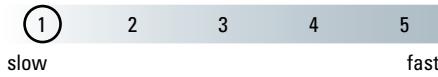
Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	60 pieces
Grinding and polishing stones Gesswein® PREMIUM WHITE						
square						
6 x 6 x 150 mm	600	PREMIUM WHITE 802	12 pieces	0 401 131-1		
rectangular						
6 x 3 x 150 mm	600	PREMIUM WHITE 801	12 pieces	0 401 130-1		
13 x 3 x 150 mm	600	PREMIUM WHITE 803	12 pieces	0 401 132-1		
13 x 6 x 150 mm	600	PREMIUM WHITE 804	12 pieces	0 401 133-1		



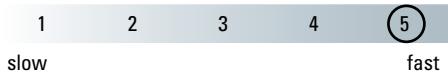
Bonding



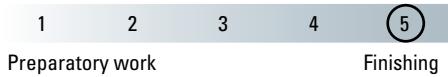
Stock removal



Wear



Application



Grinding and polishing stones

Gesswein® G2

NEW!

Gesswein® G2 stones

Very good all-round stone with rapid stock removal and high dimensional stability.

Contains brown aluminium oxide, with tough, blocky abrasive grit. The special impregnation results in good self-lubrication and high load-bearing capacity of the polishing stones. G2 - Stones create a smooth and silky finish on the surface.



Bonding



Stock removal



Wear



Application



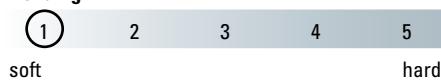
Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	Price from 60 pieces
Grinding and polishing stones Gesswein® G2						
square						
6 x 6 x 150 mm	150	G2	12 pieces	0 416 030		
	220	G2	12 pieces	0 416 031		
	320	G2	12 pieces	0 416 032		
	400	G2	12 pieces	0 416 033		
	600	G2	12 pieces	0 416 034		
	800	G2	12 pieces	0 416 035		
	1200	G2	12 pieces	0 416 036		
rectangular						
13 x 6 x 150 mm	150	G2	12 pieces	0 416 010		
	220	G2	12 pieces	0 416 011		
	320	G2	12 pieces	0 416 012		
	400	G2	12 pieces	0 416 013		
	600	G2	12 pieces	0 416 014		
	800	G2	12 pieces	0 416 015		
	1200	G2	12 pieces	0 416 016		
6 x 3 x 150 mm	150	G2	12 pieces	0 416 020		
	220	G2	12 pieces	0 416 021		
	320	G2	12 pieces	0 416 022		
	400	G2	12 pieces	0 416 023		
	600	G2	12 pieces	0 416 024		
	800	G2	12 pieces	0 416 025		
	1200	G2	12 pieces	0 416 026		
13 x 3 x 150 mm	150	G2	12 pieces	0 416 037		
	220	G2	12 pieces	0 416 038		
	320	G2	12 pieces	0 416 039		
	400	G2	12 pieces	0 416 040		
	600	G2	12 pieces	0 416 041		
	800	G2	12 pieces	0 416 042		
	1200	G2	12 pieces	0 416 043		
25 x 6 x 150 mm	150	G2	12 pieces	0 416 050		
	220	G2	12 pieces	0 416 051		
	320	G2	12 pieces	0 416 052		
	400	G2	12 pieces	0 416 053		
	600	G2	12 pieces	0 416 054		
	800	G2	12 pieces	0 416 055		
	1200	G2	12 pieces	0 416 056		

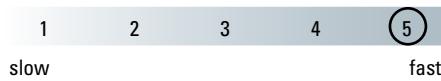
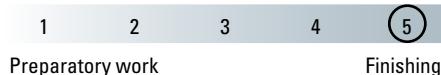
Grinding and polishing stones Gesswein® SUPER FINE

These stones are recommended for an extra-fine surface finish on the workpiece. They are made of levigated alumina in grit size finer than 1200. These stones are guaranteed not to scratch and are eminently suitable for polishing with a diamond compound.



Dimensions	Grit size	Type	Order No.	Price from	1 piece	12 pieces	60 pieces
Grinding and polishing stones Gesswein® SUPER FINE							
square							
4 x 4 x 100 mm	1200	SUPER FINE 12	0 401 210				
6 x 6 x 150 mm	1200	SUPER FINE 9002	0 401 212				
rectangular							
6 x 3 x 150 mm	1200	SUPER FINE 9001	0 401 211				
13 x 3 x 150 mm	1200	SUPER FINE 9003	0 401 213				
13 x 6 x 150 mm	1200	SUPER FINE 9004	0 401 214				


Bonding

Stock removal

Wear

Application


Grinding and polishing stones

Gesswein® GP – General Purpose

The polishing stone GP from Gesswein® is ideally suited for both eroded and machined surfaces of all tool steels and hardened steels. Owing to its special, medium-hard bond made of extra sharp, white aluminium oxide particles, it guarantees high stock removal with simultaneously low wear and a high level of dimensional stability. Grinding stone oil (fluid) is also recommended for processing.


Bonding

1	2	(3)	4	5
soft				hard

Stock removal

1	2	3	(4)	5
slow				fast

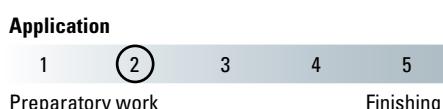
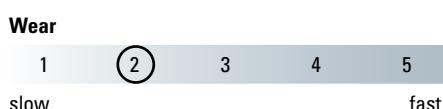
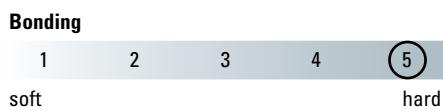
Wear

1	(2)	3	4	5
slow				fast

Application

1	2	3	4	(5)
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from
					1 piece
					60 pieces
Grinding and polishing stones Gesswein® GP – General Purpose					
square					
4 x 4 x 100 mm	150	GP	12 pieces	0 405 101	
	320	GP	12 pieces	0 405 100	
	150	GP	12 pieces	0 405 118	
	180	GP	12 pieces	0 405 119	
	220	GP	12 pieces	0 405 120	
	320	GP	12 pieces	0 405 121	
	400	GP	12 pieces	0 405 122	
	600	GP	12 pieces	0 405 123	
	800	GP	12 pieces	0 405 124	
	1200	GP	12 pieces	0 405 125	
rectangular					
6 x 3 x 150 mm	150	GP	12 pieces	0 405 110	
	180	GP	12 pieces	0 405 111	
	220	GP	12 pieces	0 405 112	
	320	GP	12 pieces	0 405 113	
	400	GP	12 pieces	0 405 114	
	600	GP	12 pieces	0 405 115	
	800	GP	12 pieces	0 405 116	
	1200	GP	12 pieces	0 405 117	
	150	GP	12 pieces	0 405 126	
	180	GP	12 pieces	0 405 127	
13 x 3 x 150 mm	220	GP	12 pieces	0 405 128	
	320	GP	12 pieces	0 405 129	
	400	GP	12 pieces	0 405 130	
	600	GP	12 pieces	0 405 131	
	800	GP	12 pieces	0 405 132	
	1200	GP	12 pieces	0 405 133	
	150	GP	12 pieces	0 405 134	
	180	GP	12 pieces	0 405 135	
	220	GP	12 pieces	0 405 136	
	320	GP	12 pieces	0 405 137	
13 x 6 x 150 mm	400	GP	12 pieces	0 405 138	
	600	GP	12 pieces	0 405 139	
	800	GP	12 pieces	0 405 140	
	1200	GP	12 pieces	0 405 141	



Grinding and polishing stones Boride® CS-HD

Extremely hard stones made of silicon carbide for the pretreatment in hard moulds (> 47 HRC). Can be used manually or in a handfiling machine, dry or with a fluid.

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from
Grinding and polishing stones Boride® CS-HD					1 piece
					60 pieces
rectangular					
6 x 3 x 150 mm	120	CS-HD	12 pieces	0 410 861	
	150	CS-HD	12 pieces	0 410 862	
	220	CS-HD	12 pieces	0 410 864	
	320	CS-HD	12 pieces	0 410 866	
	400	CS-HD	12 pieces	0 410 867	
	600	CS-HD	12 pieces	0 410 868	
13 x 6 x 150 mm	120	CS-HD	12 pieces	0 410 901	
	150	CS-HD	12 pieces	0 410 903	
	220	CS-HD	12 pieces	0 410 904	
	320	CS-HD	12 pieces	0 410 906	
	400	CS-HD	12 pieces	0 410 907	
	600	CS-HD	12 pieces	0 410 908	



Grinding and polishing stones Boride® T2

These stones are perfect for high-alloyed tools and high-grade steels. Thanks to their own impregnation, these stones work very efficiently and produce a semi matt surface on the workpiece. Can be used manually or in a handfiling machine, with a fluid.

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from
Grinding and polishing stones Boride® T2					1 piece
					60 pieces
rectangular					
6 x 3 x 150 mm	150	T2	12 pieces	0 409 952	
	220	T2	12 pieces	0 409 954	
	320	T2	12 pieces	0 409 956	
	400	T2	12 pieces	0 409 957	
	600	T2	12 pieces	0 409 958	
13 x 6 x 150 mm	150	T2	12 pieces	0 409 932	
	220	T2	12 pieces	0 409 934	
	320	T2	12 pieces	0 409 936	
	400	T2	12 pieces	0 409 937	
	600	T2	12 pieces	0 409 938	

2 Grinding and polishing stones

Boride® Orange EDM

The EDM orange grinding and polishing stones in aluminium oxide have been developed for the removal of erosion layers. The bonding allows rapid adaptation to the contour with good dimensional stability. Good stock removal. Can be used manually or in a handfiling machine, either dry or with a fluid.



Bonding



Stock removal



Wear



Application



Dimensions	Grit size	Type	Packing quantity	Price from				
				Order No.	1 piece			
Grinding and polishing stones Boride® Orange EDM								
square								
6 x 6 x 150 mm	120	Orange EDM	12 pieces	0 409 372				
	180	Orange EDM	12 pieces	0 409 373				
	220	Orange EDM	12 pieces	0 409 374				
	320	Orange EDM	12 pieces	0 409 376				
	400	Orange EDM	12 pieces	0 409 377				
	600	Orange EDM	12 pieces	0 409 378				
rectangular								
6 x 3 x 150 mm	120	Orange EDM	12 pieces	0 409 332				
	180	Orange EDM	12 pieces	0 409 333				
	220	Orange EDM	12 pieces	0 409 334				
	320	Orange EDM	12 pieces	0 409 336				
	400	Orange EDM	12 pieces	0 409 337				
	600	Orange EDM	12 pieces	0 409 338				
13 x 3 x 150 mm	120	Orange EDM	12 pieces	0 409 342				
	180	Orange EDM	12 pieces	0 409 343				
	220	Orange EDM	12 pieces	0 409 344				
	320	Orange EDM	12 pieces	0 409 346				
	400	Orange EDM	12 pieces	0 409 347				
	600	Orange EDM	12 pieces	0 409 348				
13 x 6 x 150 mm	120	Orange EDM	12 pieces	0 409 382				
	180	Orange EDM	12 pieces	0 409 383				
	220	Orange EDM	12 pieces	0 409 384				
	320	Orange EDM	12 pieces	0 409 386				
	400	Orange EDM	12 pieces	0 409 387				
	600	Orange EDM	12 pieces	0 409 388				

Grinding and polishing stones

Boride® AO

Very aggressive allround stones in aluminium oxide for all steels in tool and mould building. These grinding stones have a semi-hard bonding and are oil impregnated, so that they do not clog easily. AO stones are dimensionally stable and offer a good cutting performance. High stock removal rates with milling and erosion structures. Can be used manually or in a hand-filing machine, always with a fluid.



Bonding

1	2	3	4	5
soft				hard

Stock removal

1	2	3	4	5
slow				fast

Wear

1	2	3	4	5
slow				fast

Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	Price from 60 pieces
Grinding and polishing stones Boride® AO						
round						
Ø 10 x 140 mm	150	AO	12 pieces	0 410 692		
	220	AO	12 pieces	0 410 694		
	320	AO	12 pieces	0 410 696		
	400	AO	12 pieces	0 410 697		
rectangular						
6 x 3 x 150 mm	120	AO	12 pieces	0 410 531		
	150	AO	12 pieces	0 410 532		
	220	AO	12 pieces	0 410 534		
	320	AO	12 pieces	0 410 536		
	400	AO	12 pieces	0 410 537		
	600	AO	12 pieces	0 410 538		
13 x 3 x 150 mm	120	AO	12 pieces	0 410 541		
	150	AO	12 pieces	0 410 542		
	220	AO	12 pieces	0 410 544		
	320	AO	12 pieces	0 410 546		
	400	AO	12 pieces	0 410 547		
	600	AO	12 pieces	0 410 548		
13 x 6 x 150 mm	120	AO	12 pieces	0 410 581		
	150	AO	12 pieces	0 410 582		
	220	AO	12 pieces	0 410 584		
	320	AO	12 pieces	0 410 586		
	400	AO	12 pieces	0 410 587		
	600	AO	12 pieces	0 410 588		
25 x 13 x 150 mm	120	AO	12 pieces	0 410 621		
	150	AO	12 pieces	0 410 622		
	220	AO	12 pieces	0 410 624		
	320	AO	12 pieces	0 410 626		
	400	AO	12 pieces	0 410 627		
	600	AO	12 pieces	0 410 628		

Grinding and polishing stones

Boride® Golden Star

The Golden Star is a premium corundum stone which, owing to its specially developed treatment, leaves a silky smooth finish. Excellent for eroded and milled surfaces. The stone is of moderate hardness and achieves rapid stock removal. The stone is used dry; even better results are achieved in conjunction with fluid.



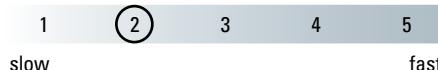
Bonding



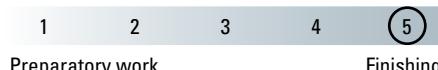
Stock removal



Wear



Application



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	Price from 60 pieces
Grinding and polishing stones Boride® Golden Star						
rectangular						
6 x 3 x 150 mm	150	Golden Star	12 pieces	0 407 811		
	180	Golden Star	12 pieces	0 407 812		
	220	Golden Star	12 pieces	0 407 813		
	320	Golden Star	12 pieces	0 407 814		
	400	Golden Star	12 pieces	0 407 815		
	600	Golden Star	12 pieces	0 407 816		
	800	Golden Star	12 pieces	0 407 817		
	1000	Golden Star	12 pieces	0 407 818		
13 x 3 x 150 mm	150	Golden Star	12 pieces	0 407 821		
	180	Golden Star	12 pieces	0 407 822		
	220	Golden Star	12 pieces	0 407 823		
	320	Golden Star	12 pieces	0 407 824		
	400	Golden Star	12 pieces	0 407 825		
	600	Golden Star	12 pieces	0 407 826		
	800	Golden Star	12 pieces	0 407 827		
	1000	Golden Star	12 pieces	0 407 828		
13 x 6 x 150 mm	150	Golden Star	12 pieces	0 407 851		
	180	Golden Star	12 pieces	0 407 852		
	220	Golden Star	12 pieces	0 407 853		
	320	Golden Star	12 pieces	0 407 854		
	400	Golden Star	12 pieces	0 407 855		
	600	Golden Star	12 pieces	0 407 856		
	800	Golden Star	12 pieces	0 407 857		
	1000	Golden Star	12 pieces	0 407 858		

Grinding and polishing stones

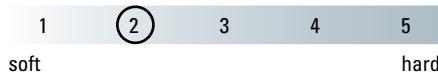
Boride® AM-2

These universal AM-2 grinding and polishing stones in aluminium oxide are used for all types of steel in mould and tool building. Owing to the uniform stock removal with a fine grinding pattern, the AM-2 abrasive stone is also very suitable for all non-ferrous metals, aluminium, copper and high-chrome and high-nickel steels. The semi-hard stones are used with fluid up to the very fine finishing stage with K 900.

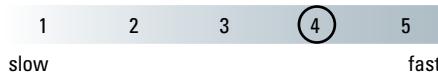
Tip: When processing aluminum, work should be performed from 320 onwards with an abrasive cloth.



Bonding



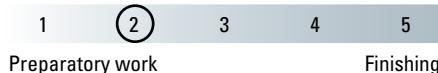
Stock removal



Wear



Application



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	Price from 60 pieces
Grinding and polishing stones Boride® AM-2						
square						
6 x 6 x 150 mm	100	AM-2	12 pieces	0 410 270		
	150	AM-2	12 pieces	0 410 272		
	180	AM-2	12 pieces	0 410 273		
	220	AM-2	12 pieces	0 410 274		
	280	AM-2	12 pieces	0 410 275		
	320	AM-2	12 pieces	0 410 276		
	400	AM-2	12 pieces	0 410 277		
	600	AM-2	12 pieces	0 410 278		
	900	AM-2	12 pieces	0 410 279		
rectangular						
6 x 3 x 150 mm	100	AM-2	12 pieces	0 410 230		
	150	AM-2	12 pieces	0 410 232		
	180	AM-2	12 pieces	0 410 233		
	220	AM-2	12 pieces	0 410 234		
	280	AM-2	12 pieces	0 410 235		
	320	AM-2	12 pieces	0 410 236		
	400	AM-2	12 pieces	0 410 237		
	600	AM-2	12 pieces	0 410 238		
	900	AM-2	12 pieces	0 410 239		
13 x 3 x 150 mm	100	AM-2	12 pieces	0 410 240		
	150	AM-2	12 pieces	0 410 242		
	180	AM-2	12 pieces	0 410 243		
	220	AM-2	12 pieces	0 410 244		
	280	AM-2	12 pieces	0 410 245		
	320	AM-2	12 pieces	0 410 246		
	400	AM-2	12 pieces	0 410 247		
	600	AM-2	12 pieces	0 410 248		
	900	AM-2	12 pieces	0 410 249		
13 x 6 x 150 mm	100	AM-2	12 pieces	0 410 280		
	150	AM-2	12 pieces	0 410 282		
	180	AM-2	12 pieces	0 410 283		
	220	AM-2	12 pieces	0 410 284		
	280	AM-2	12 pieces	0 410 285		
	320	AM-2	12 pieces	0 410 286		
	400	AM-2	12 pieces	0 410 287		
	600	AM-2	12 pieces	0 410 288		
	900	AM-2	12 pieces	0 410 289		
25 x 13 x 150 mm	100	AM-2	12 pieces	0 410 320		
	150	AM-2	12 pieces	0 410 322		
	180	AM-2	12 pieces	0 410 323		
	220	AM-2	12 pieces	0 410 324		
	280	AM-2	12 pieces	0 410 325		
	320	AM-2	12 pieces	0 410 326		
	400	AM-2	12 pieces	0 410 327		

Grinding and polishing stones

Boride® RO-MED

These grinding and polishing stones have been especially developed for use in large moulds and are therefore only available in large grit sizes. They offer particularly fast and aggressive stock removal. Thanks to their medium-hard bond, they adapt quickly to the geometry.



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 piece	Price from 60 pieces
Grinding and polishing stones Boride® RO-MED						
rectangular						
25 x 13 x 200 mm	80	RO-MED	12 pieces	0 410 970		
	100	RO-MED	12 pieces	0 410 971		
	150	RO-MED	12 pieces	0 410 972		
	220	RO-MED	12 pieces	0 410 974		


Bonding

Stock removal

Wear

Application


Fluid for grinding and polishing stones

Boride® Bori Lube 10

	Content	Order No.	Price from 1 piece
Fluid Boride®			
Experience improved cutting performance and cleaning with original Boride® abrasive stone fluid. Our recommendation for all our grinding and polishing stones.	3.8 l	0 409 046	



Grinding and polishing stones

Boride® RASP

The RASP stones from Boride® are now also available from joke and are manufactured from the finest quality aluminium dioxide. This universal stone is optimally suited for most tool steels, aluminium and even EDM surfaces. They are often used for cutting and finishing, but the stones can also cope with surface lapping. RASP stones are of very high quality, are durable and readily adapt to your workpiece. Owing to its special composition, it is to be used wet and dry.



Bonding

1	2	3	(4)	5
soft				hard

Stock removal

1	2	3	4	(5)
slow				fast

Wear

1	2	(3)	4	5
slow				fast

Application

(1)	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from
					1 piece
					60 pieces
Grinding and polishing stones Boride® RASP					
square					
6 x 6 x 150 mm	150	RASP	12 pieces	0 407 892	
	220	RASP	12 pieces	0 407 893	
	320	RASP	12 pieces	0 407 894	
	400	RASP	12 pieces	0 407 895	
	600	RASP	12 pieces	0 407 896	
	900	RASP	12 pieces	0 407 897	
	1200	RASP	12 pieces	0 407 898	
13 x 13 x 150 mm	150	RASP	12 pieces	0 407 926	
	220	RASP	12 pieces	0 407 927	
	320	RASP	12 pieces	0 407 928	
	400	RASP	12 pieces	0 407 929	
	600	RASP	12 pieces	0 407 930	
	900	RASP	12 pieces	0 407 931	
	1200	RASP	12 pieces	0 407 932	
rectangular					
6 x 3 x 150 mm	150	RASP	12 pieces	0 407 869	
	220	RASP	12 pieces	0 407 879	
	320	RASP	12 pieces	0 407 880	
	400	RASP	12 pieces	0 407 881	
	600	RASP	12 pieces	0 407 882	
	900	RASP	12 pieces	0 407 883	
	1200	RASP	12 pieces	0 407 884	
13 x 3 x 150 mm	150	RASP	12 pieces	0 407 885	
	220	RASP	12 pieces	0 407 886	
	320	RASP	12 pieces	0 407 887	
	400	RASP	12 pieces	0 407 888	
	600	RASP	12 pieces	0 407 889	
	900	RASP	12 pieces	0 407 890	
	1200	RASP	12 pieces	0 407 891	
13 x 6 x 150 mm	150	RASP	12 pieces	0 407 899	
	220	RASP	12 pieces	0 407 920	
	320	RASP	12 pieces	0 407 921	
	400	RASP	12 pieces	0 407 922	
	600	RASP	12 pieces	0 407 923	
	900	RASP	12 pieces	0 407 924	
	1200	RASP	12 pieces	0 407 925	

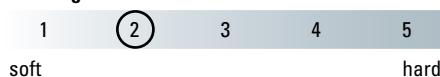
Grinding and polishing stones

Boride® CS-M

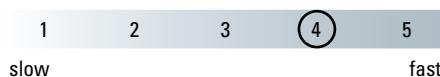
The medium-soft bond of these premium silicon carbide stones allows high stock removal rates without clogging. CS-M stones are generally used with a fluid, either manually or with a hand-filing machine.



Bonding



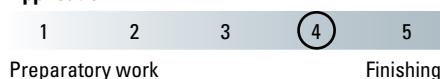
Stock removal



Wear



Application



Bench stones

These stones can be used on both sides and are available in aluminium oxide or silicon carbide. Combination of K 120 and 320.

	Design	Dimensions	Grit size	Order No.	Price from 1 piece
Bench stones					
rectangular					
	Aluminium oxide	25 x 50 x 200 mm	# 120 / 320	0 401 754	
	silicon carbide	25 x 50 x 150 mm	# 120 / 320	0 401 758	

Grinding and polishing stones

Boride® Test sets

Our Boride® test sets are ideal for trying out these products. Without minimum order, you can easily send an order for 5 grinding and polishing stones respectively in different grit sizes.

	Price from Order No.	1 set
Test set Boride® Golden Star		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 407 800
Test set Boride® Golden Star		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 320, 400, 600, 800, 1000	0 407 820
Test set Boride® Orange EDM		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 409 300
Test set Boride® T2		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 409 900

Grinding and polishing stones

Boride® Test sets

Our Boride® test sets are ideal for trying out these products. Without minimum order, you can easily send an order for 5 grinding and polishing stones respectively in different grit sizes.

		Price from	
		Order No.	1 set
Test set Boride® AM-2		5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 410 390
Test set Boride® AO		5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 410 500
Test set Boride® CS-M		5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 410 700
Test set Boride® CS-HD		5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	0 410 850

Holders for grinding and polishing stones for hand and machine use

		Price from				
	Shank dimensions	Packing quantity	Order No.	1 piece	1 set	1 pack
Tool holder A						
	with rapid clamping for grinding stones 4 x 4 mm		0 401 215			
Tool holder B						
	for receiving grinding stones 4 x 4, 6 x 6 or 6 x 3 mm		0 401 216			
Tool holder, single						
	for grinding stones 6 x 13 mm		0 401 228			
Tool holder, double						
	for receiving stones 1.6 x 13, 6 x 6 or 6 x 3 mm		0 401 227			
Tool holder range						
	for receiving grinding stones 4 x 4, 6 x 6 or 6 x 3 mm on both sides (3 pieces, blue, red, black)	3 pieces	0 401 500			
Tool holder for lapping sticks						
	head pivotable through 90°, for receiving tool up to 10 x 10 mm	Ø 3 x 35 mm	0 411 291			
	for receiving tool up to 8 mm high	Ø 3.5 x 30 mm	0 411 292			
	for receiving tool up to 8 mm high	Ø 6 x 30 mm	0 411 201			
Holder for grinding files						
	clamping height up to 11 mm	Ø 4 x 50 mm	0 401 959			
Tool holder Premium, mini						
	clamping range: height up to 8 mm, hardened finish, high-strength clamping plate	Ø 3 mm	0 401 951			
Tool holder Premium, medium						
	clamping range: height 6 mm, hardened finish. Shank and body manufactured from a piece of high-strength clamping plate. With recess for 6 mm flat and round stones.	Ø 3 mm	0 401 972			
Tool holder with counter-clamping						
	sturdy holder for clamping round and flat tools up to max. 3 mm. All solid carbide (VHM) round rods (see articles: 2 012 498 and 2 012 499) are used as a clamping shank for handpieces and/or hand-filing machines and are simply clamped and screwed to the rear of the holder.		0 750 710			

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Holders for grinding and polishing stones for hand and machine use

	Shank dimensions	Packing quantity	Order No.	Price from
			1 piece	1 set
				1 pack
VHM round rod head Ø 3 mm, length 50 mm	head Ø 3 mm, length 50 mm		2 012 498	
				
VHM round rod head Ø 6 mm, length 50 mm	head Ø 6 mm, length 50 mm		2 012 499	
				
Tool carrier, 30 x 9 x 2 mm (pack: 10 pieces)	without tool	10 pieces	0 411 009	
				
Toggle rod for tool carrier, length 140 mm	for tool carrier, shank Ø 3 mm, length 140 mm	Ø 3 mm	0 411 008	
				



Tool holder system with counter clamping

An ergonomically designed handle, which can be used with eight different inserts. The lock nut fixes the insert and therefore clamps the inserted tools. Available as single pieces on demand or in a set with eight "completely equipped" handles.

Dimensions	Price from Order No. 1 piece
Tool holder handle, without lock nut	0 401 981
	
Tool holder lock nut	0 401 982
	
Tool holder insert	
3 x 6 mm	0 401 984
3 x 13 mm	0 401 983
4 x 4 mm	0 401 985
6 x 6 mm	0 401 986
6 x 13 mm	0 401 987
10 x 10 mm	0 401 988
Ø 6 mm	0 401 989
Ø 10 mm	0 401 990

matching set

Price from Order No. 1 set
Tool holder set
The set contains 8 complete handles with inserts for the following tools:
flat: 3 x 6 mm, 3 x 13 mm and 6 x 13 mm,
square: 3 x 4 mm, 3 x 13 mm and 10 x 13 mm,
round: Ø 6 mm and Ø 10 mm





Ceramic-fibre tools

The ceramic-fibre files from joke are highly versatile tools. They are above all used wherever you get bogged down with conventional tools, for example at highly filigree spots such as slots, ribs and ridges, etc. Ideal for removing erosion structures. Very good results are achieved during use as lapping and polishing tools in conjunction with diamond compounds. They can be used manually (e.g. in special file holders, see page 260) or with the aid of a hand-filing machine. Ceramic-fibre files make a perfect team in conjunction with ultrasonic polishing systems.

In this case however, we recommend the special HT-140 or the particularly heat-resistant Ultra-HT files, which with greater heat resistance also withstand very high output ratings, without proverbially "burning away". With the mini ceramic files, you can process even the most filigree areas; the soft files are highly adaptable owing to the rubbery bond and do not leave any scratches whatsoever. You will also find a matching selection of holders available from us for convenient manual use of the files. The range is rounded off by the ceramicfibre files and brushes on a shank.



Five facts about the joke ceramic-fibre files

1. The files are no. 1 when it comes to heat resistance (an upper temperature limit higher by 30 °C in comparison!)
2. The joke files and the ENESKAsonic system have been optimally adapted to one another!
3. Specially developed polishing fibres allow maximum stock removals and absolutely uniform finishing quality!
4. A combination of polishing fibres and a special bond prevent splintering at the tip!
5. Integrated development and production from the initial fibre to the finished product guarantee consistent product quality and constant optimisation!

253 Ceramic-fibre files
joke ULTRA-HT

254 Ceramic-fibre files
joke HT-140

256 Ceramic-fibre files
NEW Super Stone

263 Diamond ceramic-fibre files

264 Ceramic-fibre files
joke Mini

264 Ceramic-fibre files
joke Soft

265 Set: Holder +
ceramic-fibre files

266 Holders for
ceramic-fibre files

267 Ceramic-fibre files on a shank

268 Ceramic-fibre brushes

269 Ceramic-fibre brushes
Cross Hole

270 Crystal fibre cutting disc
Cristone

Ceramic-fibre files joke Ultra-HT

Heat-resistant up to 200 °C!

These files are heat-resistant up to 200 °C and therefore optimally suitable for the high-performance ultrasonic polishing systems. Even under high loads, the ceramic-fibre files remain break-resistant and do not get clogged up during processing.



Dimensions	Grit size	Colour	Order No.	Price from 1 piece	5 pieces	10 pieces
Ceramic-fibre files joke Ultra-HT						
flat						
1 x 4 x 100 mm	# 120 / 110 µm	violet	0 424 601			
	# 220 / 50 µm	dark brown	0 424 611			
	# 400 / 30 µm	orange	0 424 641			
	# 800 / 20 µm	blue	0 424 621			
	# 1200 / 10 µm	red	0 424 631			
1 x 6 x 100 mm	# 120 / 110 µm	violet	0 424 602			
	# 220 / 50 µm	dark brown	0 424 612			
	# 400 / 30 µm	orange	0 424 642			
	# 800 / 20 µm	blue	0 424 622			
	# 1200 / 10 µm	red	0 424 632			
1 x 10 x 100 mm	# 120 / 110 µm	violet	0 424 603			
	# 220 / 50 µm	dark brown	0 424 613			
	# 400 / 30 µm	orange	0 424 643			
	# 800 / 20 µm	blue	0 424 623			
	# 1200 / 10 µm	red	0 424 633			
2 x 4 x 100 mm	# 120 / 110 µm	violet	0 424 604			
	# 220 / 50 µm	dark brown	0 424 614			
	# 400 / 30 µm	orange	0 424 644			
	# 800 / 20 µm	blue	0 424 624			
	# 1200 / 10 µm	red	0 424 634			
2 x 6 x 100 mm	# 120 / 110 µm	violet	0 424 605			
	# 220 / 50 µm	dark brown	0 424 615			
	# 400 / 30 µm	orange	0 424 645			
	# 800 / 20 µm	blue	0 424 625			
	# 1200 / 10 µm	red	0 424 635			
2 x 10 x 100 mm	# 120 / 110 µm	violet	0 424 606			
	# 220 / 50 µm	dark brown	0 424 616			
	# 400 / 30 µm	orange	0 424 646			
	# 800 / 20 µm	blue	0 424 626			
	# 1200 / 10 µm	red	0 424 636			



2 Ceramic-fibre files joke HT-140

The advantages at a glance:

- unbreakable files
- very high heat resistance
- developed specifically for ultrasonic systems
- perfect for ribs and ridges
- files do not splinter



Dimensions	Grit size	Colour	Order No.	Price from 1 piece	5 pieces	10 pieces
0.5 x 4 x 150 mm	# 220 / 50 µm	dark brown	0 406 160-2			
	# 300 / 40 µm	light brown	0 406 110-2			
	# 400 / 30 µm	orange	0 406 120-2			
	# 600 / 25 µm	black	0 406 170-2			
	# 800 / 20 µm	blue	0 406 180-2			
	# 1000 / 15 µm	white	0 406 140-2			
	# 1200 / 10 µm	red	0 406 100-2			
1 x 1 x 100 mm	# 1500	yellow	0 406 371			
	# 2000	cream	0 406 381			
	# 3000	pink	0 406 391			
1 x 2 x 100 mm	# 1500	yellow	0 406 372			
	# 2000	cream	0 406 382			
	# 3000	pink	0 406 392			
1 x 4 x 100 mm	# 1500	yellow	0 406 373			
1 x 4 x 150 mm	# 120 / 110 µm	violet	0 406 211			
	# 220 / 50 µm	dark brown	0 406 161-2			
	# 300 / 40 µm	light brown	0 406 111-2			
	# 400 / 30 µm	orange	0 406 121-2			
	# 600 / 25 µm	black	0 406 171-2			
	# 800 / 20 µm	blue	0 406 181-2			
	# 1000 / 15 µm	white	0 406 141-2			
1 x 6 x 100 mm	# 1200 / 10 µm	red	0 406 101-2			
	# 1500	yellow	0 406 374			
	# 120 / 110 µm	violet	0 406 212			
	# 220 / 50 µm	dark brown	0 406 162-2			
	# 300 / 40 µm	light brown	0 406 112-2			
	# 400 / 30 µm	orange	0 406 122-2			
	# 600 / 25 µm	black	0 406 172-2			
1 x 6 x 150 mm	# 800 / 20 µm	blue	0 406 182-2			
	# 1000 / 15 µm	white	0 406 142-2			
	# 1200 / 10 µm	red	0 406 102-2			
	# 1500	yellow	0 406 375			
	# 120 / 110 µm	violet	0 406 213			
	# 220 / 50 µm	dark brown	0 406 163-2			
	# 300 / 40 µm	light brown	0 406 113-2			
1 x 10 x 100 mm	# 400 / 30 µm	orange	0 406 123-2			
	# 600 / 25 µm	black	0 406 173-2			
	# 800 / 20 µm	blue	0 406 183-2			
	# 1000 / 15 µm	white	0 406 143-2			
	# 1200 / 10 µm	red	0 406 103-2			

Ceramic-fibre files joke HT-140

Dimensions	Grit size	Colour	Order No.	Price from
				1 piece
				5 pieces
				10 pieces
2 x 6 x 150 mm	# 120 / 110 µm	violet	0 406 214	
	# 220 / 50 µm	dark brown	0 406 164-2	
	# 300 / 40 µm	light brown	0 406 114-2	
	# 400 / 30 µm	orange	0 406 124-2	
	# 600 / 25 µm	black	0 406 174-2	
	# 800 / 20 µm	blue	0 406 184-2	
	# 1000 / 15 µm	white	0 406 144-2	
	# 1200 / 10 µm	red	0 406 104-2	
Ø 2.35 x 100 mm	# 220 / 50 µm	grey	0 406 200-2	
	# 300 / 40 µm	light brown	0 406 201-2	
	# 400 / 30 µm	orange	0 406 202-2	
	# 600 / 25 µm	black	0 406 203-2	
	# 800 / 20 µm	blue	0 406 204-2	
	# 1200 / 10 µm	red	0 406 206-2	
Ø 2.35 x 150 mm	# 300 / 40 µm	light brown	0 406 342	
	# 400 / 30 µm	orange	0 406 243	
	# 600 / 25 µm	dark brown	0 406 244	
	# 800 / 20 µm	blue	0 406 245	
	# 1000 / 15 µm	white	0 406 246	
	# 1200 / 10 µm	red	0 406 247	
Ø 3 x 100 mm	# 220 / 50 µm	grey	0 406 190-2	
	# 300 / 40 µm	light brown	0 406 191-2	
	# 400 / 30 µm	orange	0 406 192-2	
	# 600 / 25 µm	black	0 406 193-2	
	# 800 / 20 µm	blue	0 406 194-2	
	# 1000 / 15 µm	white	0 406 195-2	
Ø 3 x 150 mm	# 220 / 50 µm	grey	0 406 251	
	# 300 / 40 µm	light brown	0 406 352	
	# 400 / 30 µm	orange	0 406 253	
	# 600 / 25 µm	black	0 406 254	
	# 800 / 20 µm	blue	0 406 255	
	# 1000 / 15 µm	white	0 406 256	
# 1200 / 10 µm	red	0 406 257		



There is even more to it!

Please let us know your special requests regarding ceramic-fibre files. We can make almost anything possible. For further information, please contact

Markus Abstoss:
Tel. +49 (0)2204/839-0
m.abstoss@joke.de

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Ceramic-fibre files NEW Super Stone

The advantages at a glance:

- unbreakable files
- very high heat resistance
- developed specifically for ultrasonic systems
- perfect for ribs and ridges
- files do not splinter



Dimensions	Grit size	Colour	Order No.	Price from
				1 piece
				5 pieces
				10 pieces
0.5 x 4 x 50 mm	# 120 / 110 µm	green	0 424 571-1	
	# 180 / 80 µm	gold	0 424 572-1	
	# 300 / 40 µm	light brown	0 424 573-1	
	# 400 / 30 µm	orange	0 424 574-1	
	# 600 / 25 µm	dark brown	0 424 575-1	
	# 800 / 20 µm	blue	0 424 576-1	
	# 1000 / 15 µm	white	0 424 577-1	
	# 1200 / 10 µm	red	0 424 578-1	
0.5 x 1 x 100 mm	# 80 / 150 µm	violet	0 426 810	
	# 120 / 110 µm	green	0 426 001	
	# 180 / 80 µm	gold	0 426 101	
	# 300 / 40 µm	light brown	0 426 201	
	# 400 / 30 µm	orange	0 426 301	
	# 600 / 25 µm	dark brown	0 426 401	
	# 800 / 20 µm	blue	0 426 501	
	# 1000 / 15 µm	white	0 426 601	
	# 1200 / 10 µm	red	0 426 701	
0.5 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 839	
0.5 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 840	
	# 120 / 110 µm	green	0 426 031	
	# 180 / 80 µm	gold	0 426 131	
	# 300 / 40 µm	light brown	0 426 231	
	# 400 / 30 µm	orange	0 426 331	
	# 600 / 25 µm	dark brown	0 426 431	
	# 800 / 20 µm	blue	0 426 531	
	# 1000 / 15 µm	white	0 426 631	
	# 1200 / 10 µm	red	0 426 731	
0.5 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 841	
	# 120 / 110 µm	green	0 426 032	
	# 180 / 80 µm	gold	0 426 132	
	# 300 / 40 µm	light brown	0 426 232	
	# 400 / 30 µm	orange	0 426 332	
	# 600 / 25 µm	dark brown	0 426 432	
	# 800 / 20 µm	blue	0 426 532	
	# 1000 / 15 µm	white	0 426 632	
	# 1200 / 10 µm	red	0 426 732	

Ceramic-fibre files NEW Super Stone

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Dimensions	Grit size	Colour	Order No.	Price from
				1 piece 5 pieces 10 pieces
0.5 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 842	
	# 120 / 110 µm	green	0 426 033	
	# 180 / 80 µm	gold	0 426 133	
	# 300 / 40 µm	light brown	0 426 233	
	# 400 / 30 µm	orange	0 426 333	
	# 600 / 25 µm	dark brown	0 426 433	
	# 800 / 20 µm	blue	0 426 533	
	# 1000 / 15 µm	white	0 426 633	
	# 1200 / 10 µm	red	0 426 733	
0.5 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 843	
	# 120 / 110 µm	green	0 426 034	
	# 180 / 80 µm	gold	0 426 134	
	# 300 / 40 µm	light brown	0 426 234	
	# 400 / 30 µm	orange	0 426 334	
	# 600 / 25 µm	dark brown	0 426 434	
	# 800 / 20 µm	blue	0 426 534	
	# 1000 / 15 µm	white	0 426 634	
	# 1200 / 10 µm	red	0 426 734	
0.8 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 844	
0.8 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 845	
0.8 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 846	
0.8 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 847	
0.8 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 848	
1 x 2 x 100 mm	# 120 / 110 µm	green	0 426 012	
	# 180 / 80 µm	gold	0 426 112	
	# 300 / 40 µm	light brown	0 426 212	
	# 400 / 30 µm	orange	0 426 312	
	# 600 / 25 µm	dark brown	0 426 412	
	# 800 / 20 µm	blue	0 426 512	
	# 1000 / 15 µm	white	0 426 612	
	# 1200 / 10 µm	red	0 426 712	
1 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 850	
	# 120 / 110 µm	green	0 426 041	
	# 180 / 80 µm	gold	0 426 141	
	# 300 / 40 µm	light brown	0 426 241	
	# 400 / 30 µm	orange	0 426 341	
	# 600 / 25 µm	dark brown	0 426 441	
	# 800 / 20 µm	blue	0 426 541	
	# 1000 / 15 µm	white	0 426 641	
	# 1200 / 10 µm	red	0 426 741	

Ceramic-fibre files NEW Super Stone

Dimensions	Grit size	Colour	Order No.	1 piece	5 pieces	Price from 10 pieces
1 x 4 x 100 mm	# 120 / 110 µm	green	0 426 013			
	# 180 / 80 µm	gold	0 426 113			
	# 300 / 40 µm	light brown	0 426 213			
	# 400 / 30 µm	orange	0 426 313			
	# 600 / 25 µm	dark brown	0 426 413			
	# 800 / 20 µm	blue	0 426 513			
	# 1000 / 15 µm	white	0 426 613			
	# 1200 / 10 µm	red	0 426 713			
1 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 851			
	# 120 / 110 µm	green	0 426 042			
	# 180 / 80 µm	gold	0 426 142			
	# 300 / 40 µm	light brown	0 426 242			
	# 400 / 30 µm	orange	0 426 342			
	# 600 / 25 µm	dark brown	0 426 442			
	# 800 / 20 µm	blue	0 426 542			
	# 1000 / 15 µm	white	0 426 642			
1 x 6 x 100 mm	# 120 / 110 µm	green	0 426 014			
	# 180 / 80 µm	gold	0 426 114			
	# 300 / 40 µm	light brown	0 426 214			
	# 400 / 30 µm	orange	0 426 314			
	# 600 / 25 µm	dark brown	0 426 414			
	# 800 / 20 µm	blue	0 426 514			
	# 1000 / 15 µm	white	0 426 614			
	# 1200 / 10 µm	red	0 426 714			
1 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 852			
	# 120 / 110 µm	green	0 426 043			
	# 180 / 80 µm	gold	0 426 143			
	# 300 / 40 µm	light brown	0 426 243			
	# 400 / 30 µm	orange	0 426 343			
	# 600 / 25 µm	dark brown	0 426 443			
	# 800 / 20 µm	blue	0 426 543			
	# 1000 / 15 µm	white	0 426 643			
1 x 10 x 100 mm	# 120 / 110 µm	green	0 426 015			
	# 180 / 80 µm	gold	0 426 115			
	# 300 / 40 µm	light brown	0 426 215			
	# 400 / 30 µm	orange	0 426 315			
	# 600 / 25 µm	dark brown	0 426 415			
	# 800 / 20 µm	blue	0 426 515			
	# 1000 / 15 µm	white	0 426 615			
	# 1200 / 10 µm	red	0 426 715			
1 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 853			
	# 120 / 110 µm	green	0 426 044			
	# 180 / 80 µm	gold	0 426 144			
	# 300 / 40 µm	light brown	0 426 244			
	# 400 / 30 µm	orange	0 426 344			
	# 600 / 25 µm	dark brown	0 426 444			
	# 800 / 20 µm	blue	0 426 544			
	# 1000 / 15 µm	white	0 426 644			
	# 1200 / 10 µm	red	0 426 744			

Ceramic-fibre files NEW Super Stone

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Dimensions	Grit size	Colour	Order No.	Price from
				1 piece 5 pieces 10 pieces
1.5 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 854	
1.5 x 2 x 100 mm	# 120 / 110 µm	green	0 426 017	
	# 180 / 80 µm	gold	0 426 117	
	# 300 / 40 µm	light brown	0 426 217	
	# 400 / 30 µm	orange	0 426 317	
	# 600 / 25 µm	dark brown	0 426 417	
	# 800 / 20 µm	blue	0 426 517	
	# 1000 / 15 µm	white	0 426 617	
	# 1200 / 10 µm	red	0 426 717	
1.5 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 855	
	# 120 / 110 µm	green	0 426 046	
	# 180 / 80 µm	gold	0 426 146	
	# 300 / 40 µm	light brown	0 426 246	
	# 400 / 30 µm	orange	0 426 346	
	# 600 / 25 µm	dark brown	0 426 446	
	# 800 / 20 µm	blue	0 426 546	
	# 1000 / 15 µm	white	0 426 646	
	# 1200 / 10 µm	red	0 426 746	
1.5 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 856	
	# 120 / 110 µm	green	0 426 047	
	# 180 / 80 µm	gold	0 426 147	
	# 300 / 40 µm	light brown	0 426 247	
	# 400 / 30 µm	orange	0 426 347	
	# 600 / 25 µm	dark brown	0 426 447	
	# 800 / 20 µm	blue	0 426 547	
	# 1000 / 15 µm	white	0 426 647	
	# 1200 / 10 µm	red	0 426 747	
1.5 x 6 x 100 mm	# 120 / 110 µm	green	0 426 019	
	# 180 / 80 µm	gold	0 426 119	
	# 300 / 40 µm	light brown	0 426 219	
	# 400 / 30 µm	orange	0 426 319	
	# 600 / 25 µm	dark brown	0 426 419	
	# 800 / 20 µm	blue	0 426 519	
	# 1000 / 15 µm	white	0 426 619	
	# 1200 / 10 µm	red	0 426 719	
1.5 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 857	
	# 120 / 110 µm	green	0 426 048	
	# 180 / 80 µm	gold	0 426 148	
	# 300 / 40 µm	light brown	0 426 248	
	# 400 / 30 µm	orange	0 426 348	
	# 600 / 25 µm	dark brown	0 426 448	
	# 800 / 20 µm	blue	0 426 548	
	# 1000 / 15 µm	white	0 426 648	
	# 1200 / 10 µm	red	0 426 748	

Ceramic-fibre files NEW Super Stone

Dimensions	Grit size	Colour	Order No.	Price from
				1 piece 5 pieces 10 pieces
1.5 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 858	
	# 120 / 110 µm	green	0 426 049	
	# 180 / 80 µm	gold	0 426 149	
	# 300 / 40 µm	light brown	0 426 249	
	# 400 / 30 µm	orange	0 426 349	
	# 600 / 25 µm	dark brown	0 426 449	
	# 800 / 20 µm	blue	0 426 549	
	# 1000 / 15 µm	white	0 426 649	
	# 1200 / 10 µm	red	0 426 749	
2 x 4 x 100 mm	# 120 / 110 µm	green	0 426 022	
	# 180 / 80 µm	gold	0 426 122	
	# 300 / 40 µm	light brown	0 426 222	
	# 400 / 30 µm	orange	0 426 322	
	# 600 / 25 µm	dark brown	0 426 422	
	# 800 / 20 µm	blue	0 426 522	
	# 1000 / 15 µm	white	0 426 622	
	# 1200 / 10 µm	red	0 426 722	
2 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 860	
	# 120 / 110 µm	green	0 426 051	
	# 180 / 80 µm	gold	0 426 151	
	# 300 / 40 µm	light brown	0 426 251	
	# 400 / 30 µm	orange	0 426 351	
	# 600 / 25 µm	dark brown	0 426 451	
	# 800 / 20 µm	blue	0 426 551	
	# 1000 / 15 µm	white	0 426 651	
	# 1200 / 10 µm	red	0 426 751	
2 x 6 x 100 mm	# 120 / 110 µm	green	0 426 023	
	# 180 / 80 µm	gold	0 426 123	
	# 300 / 40 µm	light brown	0 426 223	
	# 400 / 30 µm	orange	0 426 323	
	# 600 / 25 µm	dark brown	0 426 423	
	# 800 / 20 µm	blue	0 426 523	
	# 1000 / 15 µm	white	0 426 623	
	# 1200 / 10 µm	red	0 426 723	
2 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 861	
	# 120 / 110 µm	green	0 426 052	
	# 180 / 80 µm	gold	0 426 152	
	# 300 / 40 µm	light brown	0 426 252	
	# 400 / 30 µm	orange	0 426 352	
	# 600 / 25 µm	dark brown	0 426 452	
	# 800 / 20 µm	blue	0 426 552	
	# 1000 / 15 µm	white	0 426 652	
	# 1200 / 10 µm	red	0 426 752	

Ceramic-fibre files NEW Super Stone

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Dimensions	Grit size	Colour	Order No.	Price from
				1 piece 5 pieces 10 pieces
2 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 862	
	# 120 / 110 µm	green	0 426 053	
	# 180 / 80 µm	gold	0 426 153	
	# 300 / 40 µm	light brown	0 426 253	
	# 400 / 30 µm	orange	0 426 353	
	# 600 / 25 µm	dark brown	0 426 453	
	# 800 / 20 µm	blue	0 426 553	
	# 1000 / 15 µm	white	0 426 653	
	# 1200 / 10 µm	red	0 426 753	
3 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 863	
3 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 864	
3 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 865	
	# 120 / 110 µm	green	0 426 056	
	# 180 / 80 µm	gold	0 426 156	
	# 300 / 40 µm	light brown	0 426 256	
	# 400 / 30 µm	orange	0 426 356	
	# 600 / 25 µm	dark brown	0 426 456	
	# 800 / 20 µm	blue	0 426 556	
	# 1000 / 15 µm	white	0 426 656	
	# 1200 / 10 µm	red	0 426 756	
3 x 6 x 100 mm	# 120 / 110 µm	green	0 426 028	
	# 180 / 80 µm	gold	0 426 128	
	# 300 / 40 µm	light brown	0 426 228	
	# 400 / 30 µm	orange	0 426 328	
	# 600 / 25 µm	dark brown	0 426 428	
	# 800 / 20 µm	blue	0 426 528	
	# 1000 / 15 µm	white	0 426 628	
	# 1200 / 10 µm	red	0 426 728	
3 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 866	
	# 120 / 110 µm	green	0 426 057	
	# 180 / 80 µm	gold	0 426 157	
	# 300 / 40 µm	light brown	0 426 257	
	# 400 / 30 µm	orange	0 426 357	
	# 600 / 25 µm	dark brown	0 426 457	
	# 800 / 20 µm	blue	0 426 557	
	# 1000 / 15 µm	white	0 426 657	
	# 1200 / 10 µm	red	0 426 757	
3 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 867	
	# 120 / 110 µm	green	0 426 058	
	# 180 / 80 µm	gold	0 426 158	
	# 300 / 40 µm	light brown	0 426 258	
	# 400 / 30 µm	orange	0 426 358	
	# 600 / 25 µm	dark brown	0 426 458	
	# 800 / 20 µm	blue	0 426 558	
	# 1000 / 15 µm	white	0 426 658	
	# 1200 / 10 µm	red	0 426 758	

Ceramic-fibre files NEW Super Stone

Dimensions	Grit size	Colour	Order No.	Price from
				1 piece 5 pieces 10 pieces
1 x 1 x 100 mm	# 120 / 110 µm	green	0 426 011	
	# 180 / 80 µm	gold	0 426 111	
	# 300 / 40 µm	light brown	0 426 211	
	# 400 / 30 µm	orange	0 426 311	
	# 600 / 25 µm	dark brown	0 426 411	
	# 800 / 20 µm	blue	0 426 511	
	# 1000 / 15 µm	white	0 426 611	
	# 1200 / 10 µm	red	0 426 711	
1 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 849	
	# 120 / 110 µm	green	0 426 040	
	# 180 / 80 µm	gold	0 426 140	
	# 300 / 40 µm	light brown	0 426 240	
	# 400 / 30 µm	orange	0 426 340	
	# 600 / 25 µm	dark brown	0 426 440	
	# 800 / 20 µm	blue	0 426 540	
	# 1000 / 15 µm	white	0 426 640	
2 x 2 x 100 mm	# 120 / 110 µm	green	0 426 021	
	# 180 / 80 µm	gold	0 426 121	
	# 300 / 40 µm	light brown	0 426 221	
	# 400 / 30 µm	orange	0 426 321	
	# 600 / 25 µm	dark brown	0 426 421	
	# 800 / 20 µm	blue	0 426 521	
	# 1000 / 15 µm	white	0 426 621	
	# 1200 / 10 µm	red	0 426 721	
2 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 859	
	# 120 / 110 µm	green	0 426 050	
	# 180 / 80 µm	gold	0 426 150	
	# 300 / 40 µm	light brown	0 426 250	
	# 400 / 30 µm	orange	0 426 350	
	# 600 / 25 µm	dark brown	0 426 450	
	# 800 / 20 µm	blue	0 426 550	
	# 1000 / 15 µm	white	0 426 650	
Ø 2.35 x 50 mm	# 1200 / 10 µm	red	0 426 750	
	# 120 / 110 µm	green	0 428 001	
Ø 2.35 x 100 mm	# 120 / 110 µm	green	0 428 002	
	# 180 / 80 µm	gold	0 428 102	
	# 300 / 40 µm	light brown	0 428 202	
	# 400 / 30 µm	orange	0 428 302	
	# 600 / 25 µm	dark brown	0 428 402	
	# 800 / 20 µm	blue	0 428 502	
	# 1000 / 15 µm	white	0 428 602	
	# 1200 / 10 µm	red	0 428 702	
Ø 2.35 x 150 mm	# 120 / 110 µm	green	0 428 003	
	# 180 / 80 µm	gold	0 428 103	
	# 300 / 40 µm	light brown	0 428 203	
	# 400 / 30 µm	orange	0 428 303	
	# 600 / 25 µm	dark brown	0 428 403	
	# 800 / 20 µm	blue	0 428 503	
	# 1000 / 15 µm	white	0 428 603	
	# 1200 / 10 µm	red	0 428 703	

Ceramic-fibre files NEW Super Stone

Dimensions	Grit size	Colour	Order No.	Price from
				1 piece
				5 pieces
				10 pieces
	Ø 3 x 100 mm	# 120 / 110 µm	green	0 428 005
		# 180 / 80 µm	gold	0 428 105
		# 300 / 40 µm	light brown	0 428 205
		# 400 / 30 µm	orange	0 428 305
		# 600 / 25 µm	dark brown	0 428 405
		# 800 / 20 µm	blue	0 428 505
		# 1000 / 15 µm	white	0 428 605
		# 1200 / 10 µm	red	0 428 705
	Ø 3 x 150 mm	# 120 / 110 µm	green	0 428 006
		# 180 / 80 µm	gold	0 428 106
		# 300 / 40 µm	light brown	0 428 206
		# 400 / 30 µm	orange	0 428 306
		# 600 / 25 µm	dark brown	0 428 406
		# 800 / 20 µm	blue	0 428 506
		# 1000 / 15 µm	white	0 428 606
		# 1200 / 10 µm	red	0 428 706

Diamond ceramic-fibre files



Take the long-established ceramic fibre-files and blend additional diamond grits into the binder. You then have this sensible further development. Owing to the additional diamond grits among the individual fibres and above all around the circumference of the files, the latter can be used over their entire length. The result is a fine, very uniform grinding pattern with good stock removal.

Tip: very well suited for use with ultrasonic polishing systems.

Dimensions	Total length	Grit size	Colour	Order No.	Price from
					1 piece
					5 pieces
Diamond ceramic-fibre files					
flat					
	1 x 4 x 100 mm	100	# 200 / 70 µm	black	0 406 080
		100	# 400 / 30 µm	blue/green	0 406 051
		100	# 800 / 20 µm	grey	0 406 052
		100	# 1200 / 15 µm	moss green	0 406 053
	1 x 6 x 100 mm	100	# 200 / 70 µm	black	0 406 081
		100	# 400 / 30 µm	blue/green	0 406 054
		100	# 800 / 20 µm	grey	0 406 055
		100	# 1200 / 15 µm	moss green	0 406 056
	1 x 10 x 100 mm	100	# 200 / 70 µm	black	0 406 082
		100	# 400 / 30 µm	blue/green	0 406 057
		100	# 800 / 20 µm	grey	0 406 058
		100	# 1200 / 15 µm	moss green	0 406 059
round					
	Ø 3 x 100 mm	100	# 200 / 70 µm	black	0 406 089
		100	# 400 / 30 µm	grey	0 406 090
		100	# 600 / 25 µm	moss green	0 406 091

Ceramic-fibre files joke Mini for filigree processing!



These tiny little things are optimal for working on the smallest scale by hand. The right holders make for convenient handling.

Dimensions	Grit size	Colour	Packing quantity	Order No.	Price from
					1 pack
					3 packs
Ceramic-fibre files joke Mini					
flat					
	0.5 x 0.5 x 50 mm	# 800 / 20 µm	blue	3 pieces	0 424 952
		# 1200 / 10 µm	red	3 pieces	0 424 951
	0.9 x 0.9 x 50 mm	# 800 / 20 µm	blue	3 pieces	0 424 962
		# 1200 / 10 µm	red	3 pieces	0 424 961

⚙ Accessories / spare parts

		Profile	Price from
		Order No.	1 piece
holder for ceramic-fibre file Mini			
 holder for ceramic-fibre file 0.5 x 0.5 mm			
		square	0 424 950
Holder for ceramic-fibre file Mini			
 holder for ceramic-fibre file 0.9 x 0.9 mm			
		square	0 424 960

Ceramic-fibre files joke Soft soft and adjustable!

Ideal for deburring eroded electrodes made of copper and the processing of stainless steel and aluminium. Due to the rubber bond these files are soft and adaptable. They do not cause any scratches, as a result of which for example the electrode is not damaged during processing. Error rate, costs and processing time are reduced. The files wear very evenly and produce a shiny surface. Suitable for raising a shine on tool steel from 50 HRC. Only suitable for manual use!

Dimensions	Grit size	Colour	Order No.	Price from
				1 piece
				5 pieces
Ceramic-fibre files joke Soft				
flat				
2 x 6 x 100 mm	# 1200 / 10 µm	white	0 424 981	
round				
Ø 3 x 100 mm	# 1200 / 10 µm	white	0 424 982	



Set of holder + ceramic-fibre files for manual use

Set of holder + ceramic-fibre files

With this set, the suitable ceramic-fibre files are already included with the handy holder.

The ideal combination for filigree, narrow and difficult to access places in addition to very fine details on the workpiece.

The very light holder lies securely in the hand and allows you extremely comfortable work. The practical rotary lock secures the inserted files and makes changing tools child's play.

Set including holder plus three files. Other suitable files available (see table!).



		Price from Order No. 1 set
Set of holder + ceramic-fibre files		
	The set consists of 1 x holder with protective cap and 1 x ceramic file 0.5 x 4 x 50 mm respectively in grit size # 120/110 µm, # 300/40 µm and # 800/20 µm	0 424 600

⚙️ Accessories / spare parts

	Dimensions	Grit size	Colour	Order No.	1 piece	5 pieces	10 pieces
Spare files							
	0.5 x 4 x 50 mm	# 120 / 110 µm	green	0 424 571-1			
		# 180 / 80 µm	gold	0 424 572-1			
		# 300 / 40 µm	light brown	0 424 573-1			
		# 400 / 30 µm	orange	0 424 574-1			
		# 600 / 25 µm	dark brown	0 424 575-1			
		# 800 / 20 µm	blue	0 424 576-1			
		# 1000 / 15 µm	white	0 424 577-1			
		# 1200 / 10 µm	red	0 424 578-1			

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Holders for ceramic-fibre files for manual use

Practical plastic holders facilitating the manual use of ceramic-fibre files. Available in various different widths and as metal holder for round files.

	Tool support	Profile	Packing quantity	Order No.	Price from 1 set	Price from 1 piece
Holders for ceramic-fibre files						
	Holder for files of 1 mm width	0.5 - 3 x 1 mm	rectangular	0 406 157		
	Holder for files of 2 mm width	0.5 - 3 x 2 mm	rectangular	0 406 154		
	Holder for files of 4 mm width	0.5 - 3 x 4 mm	rectangular	0 406 151		
	Holder for files of 6 mm width	0.5 - 3 x 6 mm	rectangular	0 406 152		
	Holder for files of 10 mm width	0.5 - 3 x 10 mm	rectangular	0 406 153		
	Set (for 4, 6 and 10 mm width)	0.5 - 3 x 4, 6 & 10 mm	rectangular	3 pieces	0 406 150	
Holder for round ceramic-fibre files						
	Holder for round ceramic-fibre files Ø 2.35 mm	Ø 2.35 mm	round	0 406 156		
	Holder for round ceramic-fibre files Ø 3 mm	Ø 3 mm	round	0 406 155		
holder for ceramic-fibre file Mini						
	holder for ceramic-fibre file 0.5 x 0.5 mm		square	0 424 950		
Holder for ceramic-fibre file Mini						
	holder for ceramic-fibre file 0.9 x 0.9 mm		square	0 424 960		

Ceramic-fibre files on a shank shank Ø 3 x 30 mm

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These ceramic-fibre files offer a secure grip in the shank. They are economical and efficient to use, as there are no more left-overs. These tools can be used for a wide range of applications: They are ideal for use in ultrasonic polishing systems and short-stroke hand-filing machines. Good results are also achieved when used in rotating handpieces with up to 50,000 rpm.



Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from			
					1 piece	5 pieces	10 pieces	
Ceramic-fibre files on a shank, shank Ø 3 x 30 mm								
round								
 <i>n_{max} 50.000 1/min</i>	Ø 1 x 9 mm	# 300 / 40 µm	light brown	Ø 3 x 30 mm	0 425 105			
		# 400 / 30 µm	orange	Ø 3 x 30 mm	0 425 110			
		# 600 / 25 µm	dark brown	Ø 3 x 30 mm	0 425 115			
		# 800 / 20 µm	blue	Ø 3 x 30 mm	0 425 120			
		# 1200 / 10 µm	red	Ø 3 x 30 mm	0 425 130			
		# 180 / 80 µm	gold	Ø 3 x 30 mm	0 425 101			
		# 300 / 40 µm	light brown	Ø 3 x 30 mm	0 425 106			
		Ø 1.5 x 9 mm	# 400 / 30 µm	orange	Ø 3 x 30 mm	0 425 111		
		# 600 / 25 µm	dark brown	Ø 3 x 30 mm	0 425 116			
		# 800 / 20 µm	blue	Ø 3 x 30 mm	0 425 121			
		# 1000 / 15 µm	white	Ø 3 x 30 mm	0 425 126			
		# 1200 / 10 µm	red	Ø 3 x 30 mm	0 425 131			
		# 180 / 80 µm	gold	Ø 3 x 30 mm	0 425 102			
		# 300 / 40 µm	light brown	Ø 3 x 30 mm	0 425 107			
		Ø 2 x 9 mm	# 400 / 30 µm	orange	Ø 3 x 30 mm	0 425 112		
			# 1000 / 15 µm	white	Ø 3 x 30 mm	0 425 127		
		# 1200 / 10 µm	red	Ø 3 x 30 mm	0 425 132			
		# 180 / 80 µm	gold	Ø 3 x 30 mm	0 425 100			
		# 1000 / 15 µm	white	Ø 3 x 30 mm	0 425 125			

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Crystal-fibre-brushes shank Ø 3 x 30 mm



These crystal fibre brushes on shank are made of bundled crystal fibers. Through frontal application, these tools achieve their best results and thus remove erosion structures, burrs and much more.

	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	5 pieces	10 pieces
Crystal-fibre-brushes, shank Ø 3 x 30 mm								
	Ø 5 x 20 mm	# 150	green	Ø 3 x 30 mm	0 406 430			
	Ø 5 x 20 mm	# 200	pink	Ø 3 x 30 mm	0 406 431			
	Ø 5 x 20 mm	# 400	violet	Ø 3 x 30 mm	0 406 432			
	Ø 5 x 20 mm	# 600	orange	Ø 3 x 30 mm	0 406 433			
	Ø 5 x 20 mm	# 800	blue	Ø 3 x 30 mm	0 406 434			
	Ø 5 x 20 mm	# 1000	white	Ø 3 x 30 mm	0 406 435			

Ceramic-fibre brushes shank Ø 3 x 30 mm

max 12.000 1/min



In these tools, individual ceramic-fibres are grouped together to form a brush. This allows effective work with the fibre tips. Excellent properties in eliminating erosion structures and for deburring aluminium, brass etc.

Tip: the additional use of diamond compound considerably improves the working result.

	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from		
							1 piece	5 pieces	10 pieces
Ceramic-fibre brushes, shank Ø 3 x 30 mm									
	Ø 5 x 20 mm	# 1200 / 10 µm	red	Ø 3 x 30 mm	12000 1/min	0 406 200			
	Ø 5 x 20 mm	# 1000 / 15 µm	white	Ø 3 x 30 mm	12000 1/min	0 406 240			

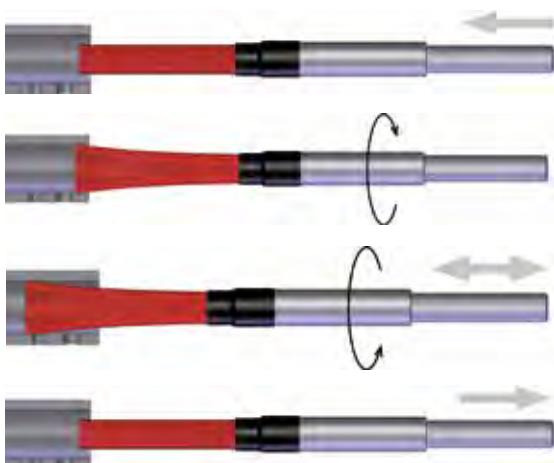
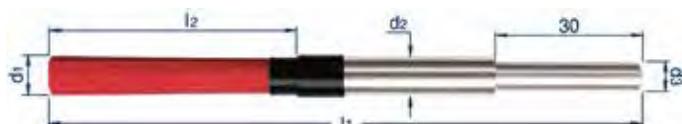


Ceramic-fibre brushes Cross-Hole

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- High-tech material made of special Al_2O_3 ceramic
- The centrifugal force generated by rotation guides the grinding tips of the fibre rods on the crossways bores and efficiently removes fine burrs of up to 0.1 mm
- Burrs are thoroughly removed without damaging the bores
- A fibre rod consists of approx. 1,000 individual fibres, each with a diameter of approx. 10 μm and optimum crystalline structure for the grinding process; the tip consists of approx. 1,000 high-density cutting edges
- The self-sharpening action of the cutting edges at the fibre ends ensures a high level of grinding ability. The constantly acting cutting edges ensure a stable and continuous cutting performance.
- Versatile in use, e.g. in processing centres, special machines, drilling machines and robots and many others
- High elasticity and flexibility ensure optimum adaptation to the workpiece
- Long service lives for markedly higher productivity and lower costs

for bore dimensions	Head dimensions	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from		
						1 piece	3 pieces	5 pieces
Ceramic-fibre brushes Cross-Hole								
3,5 - 5 mm	$\emptyset 3.5 \times 50$ mm	$\emptyset 3 \times 30$ mm	120 mm	20000 1/min	0 406 291			
5 - 8 mm	$\emptyset 3 \times 50$ mm	$\emptyset 3 \times 30$ mm	120 mm	14000 1/min	0 406 292			
	$\emptyset 3 \times 50$ mm	$\emptyset 4 \times 30$ mm	170 mm	12000 1/min	0 406 293			
8 - 10 mm	$\emptyset 5 \times 50$ mm	$\emptyset 6 \times 30$ mm	120 mm	14000 1/min	0 406 294			
	$\emptyset 5 \times 50$ mm	$\emptyset 6 \times 30$ mm	170 mm	12000 1/min	0 406 295			
10 - 14 mm	$\emptyset 7 \times 50$ mm	$\emptyset 6 \times 30$ mm	120 mm	14000 1/min	0 406 296			
	$\emptyset 7 \times 50$ mm	$\emptyset 8 \times 30$ mm	170 mm	12000 1/min	0 406 297			
14 - 20 mm	$\emptyset 11 \times 60$ mm	$\emptyset 12 \times 30$ mm	130 mm	14000 1/min	0 406 320			



Functional principle

1. Approach movement

With the shaft stationary, the tool is inserted into the bore in front of the position to be deburred.

2. Switch on the working shaft

Set the shaft in motion in the bore in the clockwise direction immediately in front of the crossways bore to be deburred.

3. Backwards and forwards movement

Guide the fibre rods in front of and behind the crossways bores. In rearwards motion, we additionally recommend a change in the shaft rotation direction.

4. Withdrawal from the bore

Shaft rotation must be stopped before the tool is removed from the bore.

Note:

For an optimum deburring result, repeat the four working stages from the other side of the main bore.

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Crystal fibre cutting disc Cristone

for hardened steel and carbide metal

Extremely stable, unbreakable, high cutting performance. These are the crystal fibre cutting discs from joke. Use dry or with diamond pastes or fluids.

Dimensions	Drilling dimension	Grit size	Colour	Rotation speed max.	Order No.	Price from
						1 piece
						5 pieces
Crystal fibre cutting disc Cristone						
Ø 19 x 0.8 mm	1.6 mm	150	green	50000 1/min	0 425 200	
Ø 19 x 0.8 mm	1.6 mm	200	pink	50000 1/min	0 425 201	
Ø 19 x 0.8 mm	1.6 mm	400	violet	50000 1/min	0 425 202	
Ø 19 x 0.8 mm	1.6 mm	600	orange	50000 1/min	0 425 203	
Ø 19 x 0.8 mm	1.6 mm	800	blue	50000 1/min	0 425 204	
Ø 19 x 0.8 mm	1.6 mm	1000	white	50000 1/min	0 425 205	
Ø 22 x 0.8 mm	1.6 mm	150	green	45000 1/min	0 425 206	
Ø 22 x 0.8 mm	1.6 mm	200	pink	45000 1/min	0 425 207	
Ø 22 x 0.8 mm	1.6 mm	400	violet	45000 1/min	0 425 208	
Ø 22 x 0.8 mm	1.6 mm	600	orange	45000 1/min	0 425 209	
Ø 22 x 0.8 mm	1.6 mm	800	blue	45000 1/min	0 425 210	
Ø 22 x 0.8 mm	1.6 mm	1000	white	45000 1/min	0 425 211	

Crystal fibre cutting disc Cristone

for hardened steel and carbide metal



Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from
						1 piece
						10 pieces
CRATEX® grinding wheel holder						
		Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	0 545 279
		Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275
		Ø 1.5 – 1.8 mm	Ø 3 x 40/30 mm	24	Ø 38 x 3 mm	0 545 278
		Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276
		Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	0 545 280
		Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277
		Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	0 545 281

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Crystal fibre brush insert Cristone®

Dimensions	Grit size	Colour	Rotation speed max.	Order No.	Price from
					1 piece 3 pieces
Crystal fibre brush insert Cristone®					
Ø 6 x 30 mm	# 150	green	12000 1/min	0 406 440	
	# 200	pink	12000 1/min	0 406 446	
	# 400	violet	12000 1/min	0 406 452	
	# 600	orange	12000 1/min	0 406 458	
	# 800	blue	12000 1/min	0 406 464	
	# 1000	white	12000 1/min	0 406 470	
	# 1200	red	12000 1/min	0 406 476	
Ø 15 x 50 mm	# 150	green	7200 1/min	0 406 441	
	# 200	pink	7200 1/min	0 406 447	
	# 400	violet	7200 1/min	0 406 453	
	# 600	orange	7200 1/min	0 406 459	
	# 800	blue	7200 1/min	0 406 465	
	# 1000	white	7200 1/min	0 406 471	
	# 1200	red	7200 1/min	0 406 477	
Ø 25 x 75 mm	# 150	green	6000 1/min	0 406 442	
	# 200	pink	6000 1/min	0 406 448	
	# 400	violet	6000 1/min	0 406 454	
	# 600	orange	6000 1/min	0 406 460	
	# 800	blue	6000 1/min	0 406 466	
	# 1000	white	6000 1/min	0 406 472	
	# 1200	red	6000 1/min	0 406 478	
Ø 40 x 75 mm	# 150	green	3600 1/min	0 406 443	
	# 200	pink	3600 1/min	0 406 449	
	# 400	violet	3600 1/min	0 406 455	
	# 600	orange	3600 1/min	0 406 461	
	# 800	blue	3600 1/min	0 406 467	
	# 1000	white	3600 1/min	0 406 473	
	# 1200	red	3600 1/min	0 406 479	
Ø 60 x 75 mm	# 150	green	2400 1/min	0 406 444	
	# 200	pink	2400 1/min	0 406 450	
	# 400	violet	2400 1/min	0 406 456	
	# 600	orange	2400 1/min	0 406 462	
	# 800	blue	2400 1/min	0 406 468	
	# 1000	white	2400 1/min	0 406 474	
	# 1200	red	2400 1/min	0 406 480	
Ø 100 x 75 mm	# 150	green	1400 1/min	0 406 445	
	# 200	pink	1400 1/min	0 406 451	
	# 400	violet	1400 1/min	0 406 457	
	# 600	orange	1400 1/min	0 406 463	
	# 800	blue	1400 1/min	0 406 469	
	# 1000	white	1400 1/min	0 406 475	
	# 1200	red	1400 1/min	0 406 481	



Crystal fibre brush insert Cristone®

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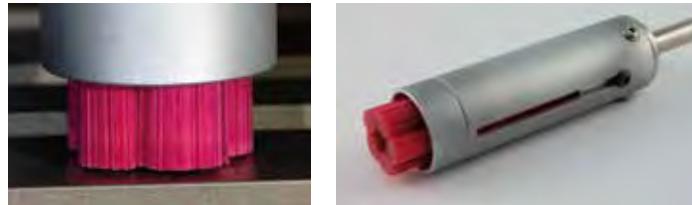
Use:

Optimum tools for the surface finishing process, fine polishing of precision components and smoothing uneven edges.

- Fibre brushes wear out over time and work less flexibly, resulting in higher grinding force.
- The flexibility is adjusted by varying the bristle length in the holder.
- Can be used for example in CNC processing machines, robots, etc.

Materials:

- Hardened and pre-hardened steels
- Alloyed steels
- Brass
- Aluminium alloys



Accessories / spare parts

	Dimensions	Price from	
		Order No.	1 piece 3 pieces
Holder for Cristone® bristle brush			
	Ø 6 mm	0 406 482	
	Ø 15 mm	0 406 483	
	Ø 25 mm	0 406 484	
	Ø 40 mm	0 406 485	
	Ø 60 mm	0 406 486	
	Ø 100 mm	0 406 487	



Recommended grit size

Material	Grit size	Colour
Hardened steel	# 150	
	# 200	
Steel	# 450	
Sainless steel	# 600	
Alloy steels	# 800	
Brass	# 1000	
Aluminium	# 1200	



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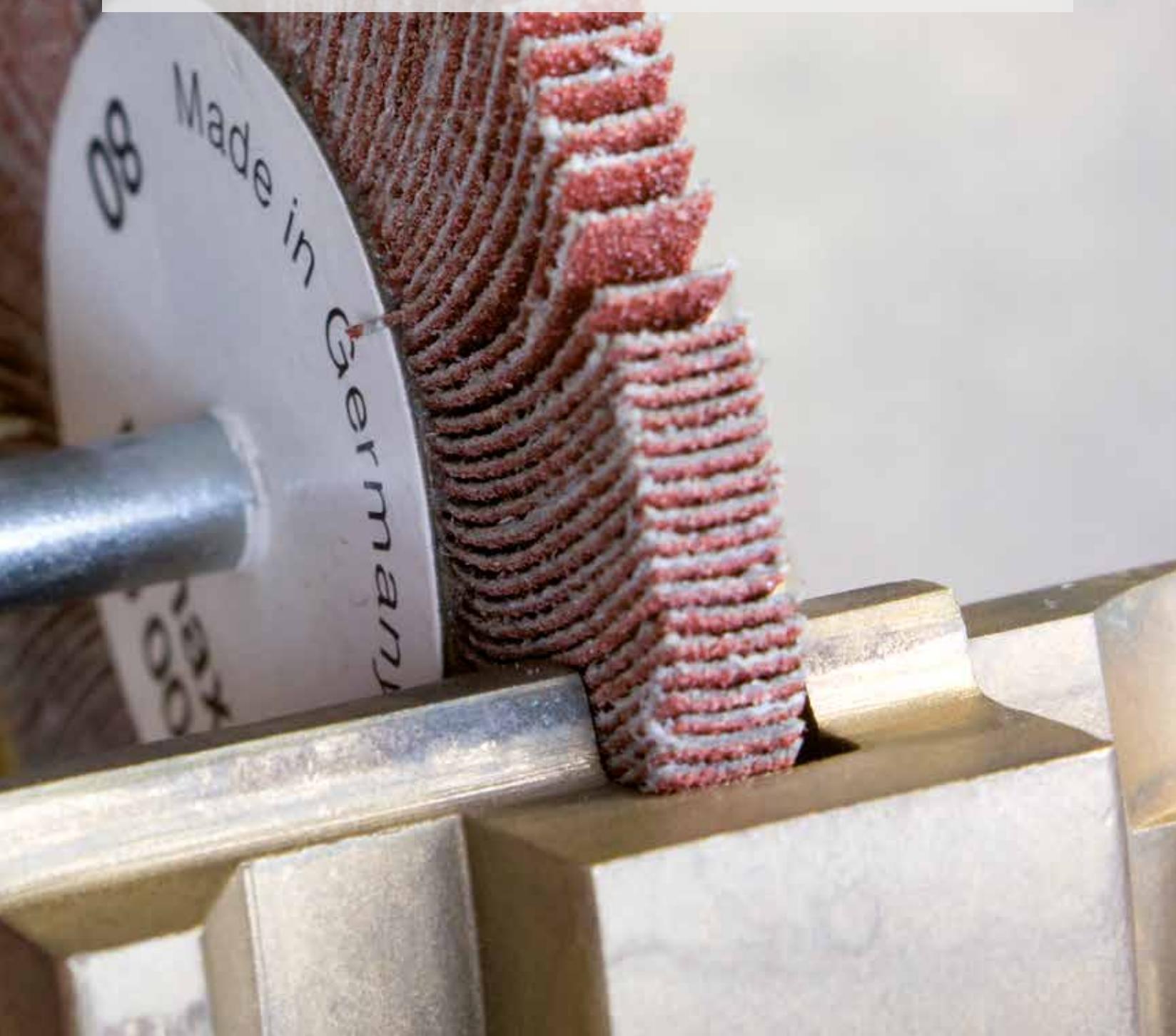
Emery and fleece tools

275 Abrasive cords and belts**292 Cup wheel discs**

Discover the entire range of abrasives and grinding tools.

276 Abrasive sleeves and caps**296 Grinding sheets**

Regardless of whether rotating on a shank, cap and sleeve-shaped, as belts, sheets, discs, emery papers and/or strips...we've got the right tool to match your grinding task!

284 Flap wheels**306 Emery sheets and strips**

MITCHELL'S Abrasive cords and belts

Corundum • Silicon carbide

The flexible abrasive cords from joke will open up a whole new world for you when processing hard to access areas. With these tools it is possible to grind, deburr and polish small holes, grooves, incisions and many further fiddly areas. The abrasive cords are rip-resistant, do not fray and are optionally impregnated with corundum or silicon carbide. They are therefore perfectly suited to your individual requirements. Use is possible with and without compounds and handling is child's play: with just a "cut" you can make the cord the length you want. The almost 15-metre long abrasive cords are delivered on a handy spool. They are available in diameters 0.3 mm to 2.4 mm and as belt in 2.4 mm width.

- Applicable to all materials
- Processing of areas difficult to reach

	Dimensions	Grit size	Type	Order No.	1 piece	3 pieces	Price from 5 pieces
Abrasive cords and belts							
Corundum							
	Ø 0.8 mm	200	54	0 531 974			
	Ø 1.0 mm	180	53	0 531 973			
	Ø 1.4 mm	120	51	0 531 972			
	Ø 1.8 mm	180	50	0 531 971			
	Ø 2.1 mm	120	49	0 531 970			
	Ø 2.4 mm	150	48	0 531 998			
	2.4 x 0.9 mm	180	56	0 531 975			
	3.2 x 0.9 mm	180	57	0 531 976			
Silicon carbide							
	Ø 0.3 mm	280	66	0 531 983			
	Ø 0.4 mm	200	60	0 531 982			
	Ø 0.5 mm	200	55	0 531 981			
	Ø 1.0 mm	180	53-S	0 531 985			



Processing tooth bases



Processing bore holes

Abrasive sleeves, caps and rubber holders jokeFlex

jokeFlex abrasive sleeves and caps

Thanks to their seamless and transition-free shape, jokeFlex abrasive sleeves and caps achieve top results. They are push-fitted on elastic, suitably shaped rubber holders. The special feature owing to the slotted shape of the rubber holder, the push-fit abrasive sleeves and caps are held securely by the rotational forces during processing. Once they are worn out, simply replace the sleeves/caps with new ones, re-using the same holder.

jokeFlex abrasive sleeves and caps run particularly true, are easy to guide and achieve a very soft grinding pattern. Particularly very well suited for fine finishing of metals, particularly steels.

Cutting speed Vmax: 40 m/s

	Inside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from
					1 pack	5 packs
Abrasive sleeves, cylinder						
Corundum						
	Ø 10 x 10 mm	0 544 601	80	10 pieces	0 544 622	
		0 544 601	150	10 pieces	0 544 621	
		0 544 601	240	10 pieces	0 544 620	
	Ø 10 x 20 mm	0 544 602	80	10 pieces	0 544 625	
		0 544 602	150	10 pieces	0 544 624	
	Ø 13 x 25 mm	0 544 604	80	10 pieces	0 544 631	
		0 544 604	150	10 pieces	0 544 630	
	Ø 15 x 10 mm	0 544 605	80	10 pieces	0 544 634	
		0 544 605	150	10 pieces	0 544 633	
	Ø 15 x 30 mm	0 544 606	60	10 pieces	0 544 639	
		0 544 606	80	10 pieces	0 544 638	
		0 544 606	150	10 pieces	0 544 637	
		0 544 606	240	10 pieces	0 544 636	
	Ø 22 x 20 mm	0 544 607	60	10 pieces	0 544 643	
		0 544 607	80	10 pieces	0 544 642	
		0 544 607	150	10 pieces	0 544 641	
		0 544 607	240	10 pieces	0 544 640	
	Ø 25 x 25 mm	0 544 608	60	10 pieces	0 544 647	
		0 544 608	80	10 pieces	0 544 646	
		0 544 608	150	10 pieces	0 544 645	
	Ø 30 x 20 mm	0 544 609	80	10 pieces	0 544 650	
		0 544 609	150	10 pieces	0 544 649	
	Ø 30 x 30 mm	0 544 610	40	10 pieces	0 544 657	
		0 544 610	60	10 pieces	0 544 656	
		0 544 610	80	10 pieces	0 544 655	
		0 544 610	150	10 pieces	0 544 654	
		0 544 610	240	10 pieces	0 544 653	
	Ø 45 x 30 mm	0 544 612	40	10 pieces	0 544 667	
		0 544 612	80	10 pieces	0 544 665	
Zirconium corundum						
	Ø 30 x 30 mm	0 544 610	36	50 pieces	0 544 870	
		0 544 610	50	50 pieces	0 544 871	
		0 544 610	60	50 pieces	0 544 872	
		0 544 610	80	50 pieces	0 544 873	

Abrasive sleeves, caps and rubber holders jokeFlex

Inside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from 1 pack	5 packs
Abrasive sleeves, conical						
Corundum						
Ø 29/22 x 30 mm	0 544 617	60	10 pieces	0 544 691		
	0 544 617	80	10 pieces	0 544 690		
	0 544 617	150	10 pieces	0 544 689		



⚙ Accessories / spare parts

Head dimensions	Shank dimensions	Order No.	Price from 1 piece	5 pieces
Rubber holder, jokeFlex				
cylinder				
Ø 10 x 10 mm	Ø 6 x 40 mm	0 544 601		
Ø 10 x 20 mm	Ø 6 x 40 mm	0 544 602		
Ø 13 x 25 mm	Ø 6 x 40 mm	0 544 604		
Ø 15 x 10 mm	Ø 6 x 40 mm	0 544 605		
Ø 15 x 30 mm	Ø 6 x 40 mm	0 544 606		
Ø 22 x 20 mm	Ø 6 x 40 mm	0 544 607		
Ø 25 x 25 mm	Ø 6 x 40 mm	0 544 608		
Ø 30 x 20 mm	Ø 6 x 40 mm	0 544 609		
Ø 30 x 30 mm	Ø 6 x 40 mm	0 544 610		
Ø 45 x 30 mm	Ø 6 x 40 mm	0 544 612		
Conical				
Ø 29/22 x 30 mm	Ø 6 x 40 mm	0 544 617		



Abrasive caps and rubber holders jokeFlex

Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	1 pack	5 packs
Abrasive caps, cylinder							
Green Corundum							
Ø 7 x 10 mm	0 544 401	80	100 pieces	0 544 421-1			
	0 544 401	150	100 pieces	0 544 422-1			
	0 544 401	320	100 pieces	0 544 423-1			
Ø 9 x 12 mm	0 544 402	80	100 pieces	0 544 424-1			
	0 544 402	150	100 pieces	0 544 425-1			
	0 544 402	320	100 pieces	0 544 426-1			
Ø 12 x 15 mm	0 544 403	80	100 pieces	0 544 427-1			
	0 544 403	150	100 pieces	0 544 428-1			
	0 544 403	320	100 pieces	0 544 429-1			
Ø 15 x 17 mm	0 544 404	80	100 pieces	0 544 430-1			
	0 544 404	150	100 pieces	0 544 431-1			
	0 544 404	320	100 pieces	0 544 432-1			
Ø 18 x 26 mm	0 544 405, 0 544 406	80	100 pieces	0 544 433-1			
	0 544 405, 0 544 406	150	100 pieces	0 544 434-1			
	0 544 405, 0 544 406	320	100 pieces	0 544 435-1			

Accessories / spare parts

Head dimensions	Shank dimensions	Order No.	Price from	1 piece	5 pieces	10 pieces
Rubber holder, jokeFlex						
cylinder						
Ø 5 x 10 mm	Ø 3 x 25 mm	0 544 401				
Ø 7 x 12 mm	Ø 3 x 25 mm	0 544 402				
Ø 10 x 15 mm	Ø 3 x 25 mm	0 544 403				
Ø 13 x 17 mm	Ø 3 x 25 mm	0 544 404				
Ø 16 x 26 mm	Ø 3 x 25 mm	0 544 405				
	Ø 6 x 40 mm	0 544 406				

Abrasive caps and rubber holders jokeFlex

Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	1 pack	5 packs
Abrasive caps, rounded cylinder							
Green Corundum							
Ø 7 x 11 mm	0 544 407	80	100 pieces	0 544 436-1			
	0 544 407	150	100 pieces	0 544 437-1			
	0 544 407	320	100 pieces	0 544 438-1			
Ø 9 x 13 mm	0 544 408	80	100 pieces	0 544 439-1			
	0 544 408	150	100 pieces	0 544 440-1			
	0 544 408	320	100 pieces	0 544 441-1			
Ø 12 x 15 mm	0 544 409	80	100 pieces	0 544 442-1			
	0 544 409	150	100 pieces	0 544 443-1			
	0 544 409	320	100 pieces	0 544 444-1			
Ø 15 x 19 mm	0 544 410	80	100 pieces	0 544 445-1			
	0 544 410	150	100 pieces	0 544 446-1			
	0 544 410	320	100 pieces	0 544 447-1			
Ø 18 x 26 mm	0 544 411, 0 544 412	80	100 pieces	0 544 448-1			
	0 544 411, 0 544 412	150	100 pieces	0 544 449-1			
	0 544 411, 0 544 412	320	100 pieces	0 544 450-1			
Ø 12 x 15 mm	0 544 409	60	100 pieces	0 544 482			

⚙ Accessories / spare parts

Head dimensions	Shank dimensions	Order No.	Price from	1 piece	5 pieces	10 pieces
Rubber holder						
rounded cylinder						
Ø 5 x 11 mm	Ø 3 x 25 mm	0 544 407				
Ø 7 x 13 mm	Ø 3 x 25 mm	0 544 408				
Ø 10 x 15 mm	Ø 3 x 25 mm	0 544 409				
Ø 13 x 19 mm	Ø 3 x 25 mm	0 544 410				
Ø 16 x 26 mm	Ø 3 x 25 mm	0 544 411				
	Ø 6 x 40 mm	0 544 412				

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Abrasive caps and rubber holders jokeFlex

Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	1 pack	5 packs
Abrasive caps, pointed cylinder							
Green Corundum							
Ø 7 x 11 mm	0 544 413	80	100 pieces	0 544 451-1			
	0 544 413	150	100 pieces	0 544 452-1			
	0 544 413	320	100 pieces	0 544 453-1			
Ø 9 x 13 mm	0 544 414	80	100 pieces	0 544 454-1			
	0 544 414	150	100 pieces	0 544 455-1			
	0 544 414	320	100 pieces	0 544 456-1			
Ø 12 x 15 mm	0 544 415	80	100 pieces	0 544 457-1			
	0 544 415	150	100 pieces	0 544 458-1			
	0 544 415	320	100 pieces	0 544 459-1			
Ø 15 x 19 mm	0 544 416	80	100 pieces	0 544 460-1			
	0 544 416	150	100 pieces	0 544 461-1			
	0 544 416	320	100 pieces	0 544 462-1			
Ø 18 x 26 mm	0 544 417, 0 544 418	80	100 pieces	0 544 463-1			
	0 544 417, 0 544 418	150	100 pieces	0 544 464-1			

⚙ Accessories / spare parts

Head dimensions	Shank dimensions	Order No.	Price from	1 piece	5 pieces	10 pieces
Rubber holder, jokeFlex						
pointed cylinder						
Ø 5 x 11 mm	Ø 3 x 25 mm	0 544 413				
Ø 7 x 13 mm	Ø 3 x 25 mm	0 544 414				
Ø 10 x 15 mm	Ø 3 x 25 mm	0 544 415				
Ø 13 x 19 mm	Ø 3 x 25 mm	0 544 416				
Ø 16 x 26 mm	Ø 3 x 25 mm	0 544 417				
Ø 16 x 26 mm	Ø 6 x 40 mm	0 544 418				

Abrasive caps and rubber holders POLICAP

	Outside dimensions		Suitable rubber holder	Grit size	Packing quantity	Order No.	
							Price from
Abrasive caps POLICAP, rounded cylinder							
Co-Cool							
Owing to the special structure of the ceramic grit in addition to the active grinding bond components, ideal for processing stainless steels (INOX) and for the high-temperature nickel and cobalt-based alloys, e.g. Inconel®, Hastelloy® frequently used in turbine construction. The active grinding additives prevent clogging and result in a cooler cut with markedly greater stock removal.	Ø 5 x 11 mm	0 544 420	80	50 pieces	NEW! 0 543 005		
	Ø 5 x 11 mm	0 544 420	120	50 pieces	NEW! 0 543 006		
	Ø 7 x 13 mm	0 544 408	80	50 pieces		0 543 000	
	Ø 7 x 13 mm	0 544 408	120	50 pieces		0 543 001	
	Ø 10 x 15 mm	0 543 030	80	50 pieces	NEW! 0 543 015		
	Ø 10 x 15 mm	0 543 030	120	50 pieces	NEW! 0 543 016		
	Ø 13 x 17 mm	0 543 031	80	50 pieces	NEW! 0 543 017		
	Ø 13 x 17 mm	0 543 031	120	50 pieces	NEW! 0 543 018		
	Ø 16 x 26 mm	0 543 032	80	50 pieces	NEW! 0 543 021		
	Ø 16 x 26 mm	0 543 032	120	50 pieces	NEW! 0 543 022		
SiC-Cool							
Ideal for processing components made of titanium and aluminium, in addition to their respective alloys. Excellent for use in aircraft and turbine construction and the correspondent maintenance. The special grit selection and the active grinding additive material in the bond allow a cool cut, reduce the workpiece temperature and prevent adhesion of the chips.	Ø 5 x 11 mm	0 544 420	80	50 pieces	NEW! 0 543 008		
	Ø 5 x 11 mm	0 544 420	150	50 pieces	NEW! 0 543 009		
	Ø 7 x 13 mm	0 544 408	80	50 pieces		0 543 010	
	Ø 7 x 13 mm	0 544 408	150	50 pieces		0 543 011	
	Ø 13 x 17 mm	0 543 031	80	50 pieces	NEW! 0 543 019		
	Ø 13 x 17 mm	0 543 031	150	50 pieces	NEW! 0 543 020		
	Ø 16 x 26 mm	0 543 032	80	50 pieces	NEW! 0 543 023		
	Ø 16 x 26 mm	0 543 032	150	50 pieces	NEW! 0 543 024		

⚙ Accessories / spare parts

	Head dimensions	Shank dimensions	Packing quantity	Order No.	1 pack	5 packs	1 piece	5 pieces	10 pieces
Rubber holder									
rounded cylinder									
	Ø 5 x 11 mm	Ø 3 x 25 mm		0 544 407					
	Ø 7 x 13 mm	Ø 3 x 25 mm		0 544 408					
	Ø 10 x 15 mm	Ø 3 x 25 mm		0 544 409					
	Ø 10 x 15 mm	Ø 3 x 30 mm	5 pieces	0 543 030					
	Ø 13 x 19 mm	Ø 3 x 25 mm		0 544 410					
	Ø 13 x 17 mm	Ø 6 x 40 mm	5 pieces	0 543 031					
	Ø 16 x 26 mm	Ø 3 x 25 mm		0 544 411					
		Ø 6 x 40 mm		0 544 412					
	Ø 16 x 26 mm	Ø 6 x 40 mm	5 pieces	0 543 032					

Abrasives caps and rubber holders jokeFlex

jokeFlex abrasive sleeves and caps

Thanks to their seamless and transition-free shape, jokeFlex abrasive sleeves and caps achieve top results. They are push-fitted on elastic, suitably shaped rubber holders. The special feature owing to the slotted shape of the rubber holder, the push-fit abrasive sleeves and caps are held securely by the rotational forces during processing. Once they are worn out, simply replace the sleeves/caps with new ones, re-using the same holder.

jokeFlex abrasive sleeves and caps run particularly true, are easy to guide and achieve a very soft grinding pattern.

Particularly very well suited for fine finishing of metals, particularly steels.

Cutting speed Vmax: 40 m/s

Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from 1 pack	5 packs
Abrasives caps, rounded cone						
Green Corundum						
Ø 7/6 x 15 mm	0 544 501	80	100 pieces	0 544 511-1		
	0 544 501	150	100 pieces	0 544 512-1		
Ø 13/11 x 25 mm	0 544 502	80	100 pieces	0 544 513-1		
	0 544 502	150	100 pieces	0 544 514-1		
Ø 18/16 x 32 mm	0 544 503	80	25 pieces	0 544 515-1		
	0 544 503	150	25 pieces	0 544 516-1		
Ø 23/21 x 40 mm	0 544 504	80	25 pieces	0 544 517-1		
	0 544 504	150	25 pieces	0 544 518-1		



Accessories / spare parts

Head dimensions	Shank dimensions	Order No.	Price from 1 piece	5 pieces	10 pieces
Rubber holder, jokeFlex					
rounded cone					
	Ø 5 / 4 x 15 mm	Ø 6 x 40 mm	0 544 501		
	Ø 11 / 9 x 25 mm	Ø 6 x 40 mm	0 544 502		
	Ø 16 / 14 x 32 mm	Ø 6 x 40 mm	0 544 503		
	Ø 21 / 19 x 40 mm	Ø 6 x 40 mm	0 544 504		

Abrasive caps and rubber holders jokeFlex

	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	1 pack	5 packs
Abrasive caps, rounded cone								
Corundum								
	Ø 6/10 x 85 mm	0 544 505	80	25 pieces	0 544 521			
		0 544 505	150	25 pieces	0 544 522			
	Ø 20/16 x 85 mm	0 544 507	80	25 pieces	0 544 525			

Accessories / spare parts

	Head dimensions	Shank dimensions	Order No.	Price from	1 piece	5 pieces	10 pieces
Rubber holder, jokeFlex							
rounded cone							
	Ø 8 / 4 x 85 mm	Ø 6 x 40 mm	0 544 505				
	Ø 18 / 14 x 85 mm	Ø 6 x 40 mm	0 544 507				

Flap wheels

Flap wheels

Large selection of flap wheels with 3 and 6 mm shanks, plus "special models" such as radially slotted flap wheels or those with a combination of abrasive cloths and fleece - for a particularly uniform microsection. The "fleece only" flap wheels are a further highlight in the range: a really super solution for very fine finishing. The cleaning grinding wheels are suitable for removing rust, weld splatters and other troublemakers from the workpiece.



You'll find here:

Flap wheels shank Ø 3 mm	page 285
Flap wheels shank Ø 6 mm	page 286
Flap wheels with fleece lamellas	page 288
Grinding wheels for cleaning	page 288



Max. rotational speed in relation to cutting speed Vmax and Ø of the tool used

Ø	15 m/s	20 m/s	25 m/s	30 m/s	35 m/s	40 m/s	45 m/s	50 m/s	55 m/s	60 m/s
10 mm	28,500	38,200	47,700	57,300	66,800	76,400	86,000	95,500	105,000	114,600
15 mm	19,100	25,400	31,800	38,200	44,600	51,000	57,300	63,700	70,000	76,400
20 mm	14,300	19,100	23,900	28,700	33,400	38,200	43,000	47,800	52,600	57,400
25 mm	11,400	15,200	19,100	22,900	26,700	30,500	34,400	38,200	42,000	45,900
30 mm	9,500	12,700	15,900	19,000	22,300	25,400	28,500	31,800	34,800	38,000
40 mm	7,100	9,600	11,900	14,300	16,700	19,100	21,500	23,800	26,200	28,600
50 mm	5,700	7,600	9,500	11,400	13,400	15,300	17,000	19,000	20,900	22,800
60 mm	4,700	6,300	7,900	9,500	11,100	12,700	14,300	15,900	17,500	19,100
75 mm	3,800	5,100	6,400	7,700	9,000	10,100	11,600	12,800	14,100	15,400
80 mm	3,500	4,700	5,900	7,100	8,360	8,360	10,700	11,900	13,100	14,300
100 mm	2,800	3,800	4,800	5,700	6,700	7,650	8,600	9,600	10,500	11,400
125 mm	2,300	3,000	3,800	4,600	5,300	6,150	6,900	7,600	8,500	9,200
150 mm	1,900	2,500	3,200	3,800	4,500	5,100	5,700	6,400	7,000	7,600
175 mm	1,600	2,200	2,700	3,300	3,800	4,350	4,950	5,400	6,050	6,600
200 mm	1,400	1,900	2,400	2,900	3,400	3,850	4,350	4,800	5,300	5,800
250 mm	1,100	1,500	1,900	2,300	2,700	3,100	3,450	3,800	4,200	4,600
300 mm	1,000	1,300	1,600	1,900	2,200	2,550	2,850	3,200	3,500	3,800

Flap wheels jokeFlex shank Ø 3 mm

For elastic grinding. The slit lamellas of jokeFlex flap wheels allows them to adapt better to the contour of the workpiece being processed. They cover a wide range of applications: from the metal-working and finishing to the rubber and plastics industry.

Cutting speed Vmax: 40 m/sec.



Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
					1 piece	10 pieces	20 pieces
Ø 10 x 10 mm	60	Ø 3 x 40 mm	76400 1/min	0 543 902			
	80	Ø 3 x 40 mm	76400 1/min	0 543 903			
	120	Ø 3 x 40 mm	76400 1/min	0 543 904			
	150	Ø 3 x 40 mm	76400 1/min	0 543 906			
	180	Ø 3 x 40 mm	76400 1/min	0 543 907			
	240	Ø 3 x 40 mm	76400 1/min	0 543 908			
	320	Ø 3 x 40 mm	76400 1/min	0 543 909			
Ø 10 x 15 mm	80	Ø 3 x 40 mm	76400 1/min	0 543 913			
	150	Ø 3 x 40 mm	76400 1/min	0 543 916			
	240	Ø 3 x 40 mm	76400 1/min	0 543 918			
	320	Ø 3 x 40 mm	76400 1/min	0 543 919			
Ø 15 x 10 mm	80	Ø 3 x 40 mm	51000 1/min	0 543 923			
	150	Ø 3 x 40 mm	51000 1/min	0 543 926			
	240	Ø 3 x 40 mm	51000 1/min	0 543 928			
	320	Ø 3 x 40 mm	51000 1/min	0 543 929			
Ø 15 x 15 mm	80	Ø 3 x 40 mm	51000 1/min	0 543 933			
	150	Ø 3 x 40 mm	51000 1/min	0 543 936			
	240	Ø 3 x 40 mm	51000 1/min	0 543 938			
	320	Ø 3 x 40 mm	51000 1/min	0 543 939			
Ø 20 x 5 mm	80	Ø 3 x 40 mm	38200 1/min	0 543 943			
	150	Ø 3 x 40 mm	38200 1/min	0 543 946			
	240	Ø 3 x 40 mm	38200 1/min	0 543 948			
	320	Ø 3 x 40 mm	38200 1/min	0 543 949			
Ø 20 x 10 mm	80	Ø 3 x 40 mm	38200 1/min	0 543 953			
	150	Ø 3 x 40 mm	38200 1/min	0 543 956			
	240	Ø 3 x 40 mm	38200 1/min	0 543 958			
	320	Ø 3 x 40 mm	38200 1/min	0 543 959			
Ø 20 x 15 mm	80	Ø 3 x 40 mm	38200 1/min	0 543 963			
	150	Ø 3 x 40 mm	38200 1/min	0 543 966			
	240	Ø 3 x 40 mm	38200 1/min	0 543 968			
	320	Ø 3 x 40 mm	38200 1/min	0 543 969			
Ø 20 x 20 mm	80	Ø 3 x 40 mm	38200 1/min	0 543 973			
	150	Ø 3 x 40 mm	38200 1/min	0 543 976			
	240	Ø 3 x 40 mm	38200 1/min	0 543 978			
	320	Ø 3 x 40 mm	38200 1/min	0 543 979			
Ø 25 x 5 mm	80	Ø 3 x 40 mm	30500 1/min	0 543 983			
	150	Ø 3 x 40 mm	30500 1/min	0 543 986			
	240	Ø 3 x 40 mm	30500 1/min	0 543 988			
	320	Ø 3 x 40 mm	30500 1/min	0 543 989			

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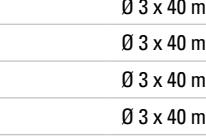
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Flap wheels jokeFlex shank Ø 3 mm

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	10 pieces	20 pieces
	Ø 25 x 10 mm	80	Ø 3 x 40 mm	30500 1/min	0 543 993			
		150	Ø 3 x 40 mm	30500 1/min	0 543 996			
		240	Ø 3 x 40 mm	30500 1/min	0 543 998			
		320	Ø 3 x 40 mm	30500 1/min	0 543 999			
	Ø 30 x 5 mm	60	Ø 3 x 40 mm	25400 1/min	0 544 222			
		80	Ø 3 x 40 mm	25400 1/min	0 544 223			
		150	Ø 3 x 40 mm	25400 1/min	0 544 226			
		240	Ø 3 x 40 mm	25400 1/min	0 544 228			
		320	Ø 3 x 40 mm	25400 1/min	0 544 229			
	Ø 30 x 10 mm	60	Ø 3 x 40 mm	25400 1/min	0 544 232			
		80	Ø 3 x 40 mm	25400 1/min	0 544 233			
		150	Ø 3 x 40 mm	25400 1/min	0 544 236			
		240	Ø 3 x 40 mm	25400 1/min	0 544 238			
		320	Ø 3 x 40 mm	25400 1/min	0 544 239			
	Ø 40 x 5 mm	60	Ø 3 x 40 mm	19100 1/min	0 544 532			
		80	Ø 3 x 40 mm	19100 1/min	0 544 533			
		150	Ø 3 x 40 mm	19100 1/min	0 544 536			
		320	Ø 3 x 40 mm	19100 1/min	0 544 539			
	Ø 40 x 10 mm	60	Ø 3 x 40 mm	19100 1/min	0 544 242			
		80	Ø 3 x 40 mm	19100 1/min	0 544 243			
		150	Ø 3 x 40 mm	19100 1/min	0 544 246			
	Ø 40 x 15 mm	80	Ø 3 x 40 mm	19100 1/min	0 544 253			
		240	Ø 3 x 40 mm	19100 1/min	0 544 258			



Two short working stages are better than a single long one!

Even if it seems tempting to complete the "job" in one single stage: at the final count you will work more efficiently with two harmonised working stages using different grit sizes (from coarse to fine)!

Consult **Markus Abstoß**:
Tel. +49 (0) 2204 / 839-0
m.abstoss@joke.de



Even more choice

Apart from the large choice of flap wheels shown here, we also offer further dimensions on request. Please contact

Markus Abstoß:
Tel. +49 (0) 2204 / 839-0
m.abstoss@joke.de

Flap wheels jokeFlex shank Ø 6 mm

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For elastic grinding. The slit lamellas of jokeFlex flap wheels allows them to adapt better to the contour of the workpiece being processed. They cover a wide range of applications: from the metal-working and finishing to the rubber and plastics industry.

Cutting speed Vmax: 40 m/sec.

Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
					1 piece	10 pieces	20 pieces
Flap wheels with lamellas, corundum, shank Ø 6 mm							
	Ø 40 x 10 mm	60	Ø 6 x 40 mm	19100 1/min	0 544 362		
		80	Ø 6 x 40 mm	19100 1/min	0 544 363		
		150	Ø 6 x 40 mm	19100 1/min	0 544 366		
		240	Ø 6 x 40 mm	19100 1/min	0 544 368		
		320	Ø 6 x 40 mm	19100 1/min	0 544 369		
	Ø 40 x 15 mm	60	Ø 6 x 40 mm	19100 1/min	0 544 372		
		80	Ø 6 x 40 mm	19100 1/min	0 544 373		
		120	Ø 6 x 40 mm	19100 1/min	0 544 374		
		150	Ø 6 x 40 mm	19100 1/min	0 544 376		
		180	Ø 6 x 40 mm	19100 1/min	0 544 377		
		240	Ø 6 x 40 mm	19100 1/min	0 544 378		
		320	Ø 6 x 40 mm	19100 1/min	0 544 379		
	Ø 50 x 5 mm	60	Ø 6 x 40 mm	15300 1/min	0 544 542		
		80	Ø 6 x 40 mm	15300 1/min	0 544 543		
		150	Ø 6 x 40 mm	15300 1/min	0 544 546		
	Ø 50 x 10 mm	60	Ø 6 x 38 mm	15300 1/min	0 544 262		
		80	Ø 6 x 40 mm	15300 1/min	0 544 263		
		150	Ø 6 x 40 mm	15300 1/min	0 544 266		
		240	Ø 6 x 40 mm	15300 1/min	0 544 268		
	Ø 60 x 5 mm	60	Ø 6 x 40 mm	12700 1/min	0 544 552		
		80	Ø 6 x 40 mm	12700 1/min	0 544 553		
		150	Ø 6 x 40 mm	12700 1/min	0 544 556		
		320	Ø 6 x 40 mm	12700 1/min	0 544 559		
	Ø 80 x 5 mm	80	Ø 6 x 40 mm	8360 1/min	0 544 563		
		150	Ø 6 x 40 mm	8360 1/min	0 544 566		
	Ø 60 x 40 mm	60	Ø 6 x 40 mm	12700 1/min	0 544 322		
		80	Ø 6 x 40 mm	12700 1/min	0 544 323		
		150	Ø 6 x 40 mm	12700 1/min	0 544 326		
		320	Ø 6 x 40 mm	12700 1/min	0 544 329		

Flap wheels, SiC shank Ø 6 mm

It is harder and more brittle than corundum. Applications include non-ferrous metals, stainless steels, ceramic and mineral materials, high-carbon steels, plastics and glass, etc.

Cutting speed Vmax: 40 m/sec.

	Head dimensions	Grit size	Shank dimensions	Packing quantity	Order No.	Price from 1 pack	5 packs	10 packs
Flap wheels, SiC, shank Ø 6 mm								
	Ø 60 x 30 mm	60 80 120	Ø 6 x 40 mm	10 pieces	0 543 686 0 543 687 0 543 688			

Flap wheels with fleece lamellas shank Ø 6 mm

Flap wheels made of combined grinding fleece/cloth, sulphur-free. The combination of grinding fleece/cloth achieves a more uniform grinding pattern with high stock removal.

Cutting speed Vmax: 40 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from 1 piece	10 pieces
Flap wheels made of combined fleece / cloth lamellas, corundum, shank Ø 6 mm							
	Ø 40 x 20 mm	medium / K 80 fine / K 150 very fine / K 240	Ø 6 x 40 mm	19100 1/min	0 543 450 0 543 451 0 543 452		
	Ø 50 x 20 mm	medium / K 80 fine / K 150 very fine / K 240	Ø 6 x 40 mm	15300 1/min	0 543 456 0 543 457 0 543 458		
	Ø 60 x 30 mm	medium / K 80 fine / K 150 very fine / K 240	Ø 6 x 40 mm	12700 1/min	0 543 462 0 543 463 0 543 464		

Cleaning flap wheels shank Ø 6 mm

The ideal solution for cleaning with simultaneous surface preparation. For aggressive removal of rust, weld splatters, coating and paint. Also very suitable for deburring.

Cutting speed Vmax: 35 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from 1 piece	5 pieces	10 pieces	20 pieces
Cleaning flap wheels, type "coarse"									
	Ø 55 x 15 mm	coarse	Ø 6 x 40 mm	14000 1/min	0 544 588				

i	Grit size fleece	Comparable to FEPA
	coarse	K 40 – 80
	medium	K 100 – 180
	fine	K 220 – 240
	very fine	K 280 – 360

Flap wheels with fleece lamellas shank Ø 3 mm

These fan-shaped grinders have radially arranged abrasive fleece lamellas and are ideal for very fine work in awkward areas. They achieve highest surface qualities.

Cutting speed Vmax: 10 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from
						1 piece
						10 pieces
Flap wheels with fleece lamellas, corundum, shank Ø 3 mm						
	Ø 20 x 20 mm	coarse	Ø 3 x 40 mm	13000 1/min	0 547 001	
		medium	Ø 3 x 40 mm	13000 1/min	0 547 002	
		fine	Ø 3 x 40 mm	13000 1/min	0 547 003	
		very fine	Ø 3 x 40 mm	13000 1/min	0 547 004	
	Ø 30 x 10 mm	coarse	Ø 3 x 40 mm	11000 1/min	0 547 009	
		medium	Ø 3 x 40 mm	11000 1/min	0 547 010	
		fine	Ø 3 x 40 mm	11000 1/min	0 547 011	
		very fine	Ø 3 x 40 mm	11000 1/min	0 547 012	
	Ø 30 x 20 mm	coarse	Ø 3 x 40 mm	11000 1/min	0 547 017	
		medium	Ø 3 x 40 mm	11000 1/min	0 547 018	
		fine	Ø 3 x 40 mm	11000 1/min	0 547 019	
		very fine	Ø 3 x 40 mm	11000 1/min	0 547 020	
	Ø 30 x 30 mm	coarse	Ø 3 x 40 mm	11000 1/min	0 547 025	
		medium	Ø 3 x 40 mm	11000 1/min	0 547 026	
		very fine	Ø 3 x 40 mm	11000 1/min	0 547 028	



Flap wheels with fleece lamellas shank Ø 6 mm

These fan-shaped grinders have radially arranged abrasive fleece lamellas and are ideal for very fine work in awkward areas. They achieve highest surface qualities.

Cutting speed Vmax: 10 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from
						1 piece
						10 pieces
Flap wheels with fleece lamellas, corundum, shank Ø 6 mm						
	Ø 40 x 20 mm	coarse	Ø 6 x 40 mm	8000 1/min	0 547 033	
		medium	Ø 6 x 40 mm	8000 1/min	0 547 034	
		fine	Ø 6 x 40 mm	8000 1/min	0 547 035	
		very fine	Ø 6 x 40 mm	8000 1/min	0 547 036	
	Ø 40 x 40 mm	medium	Ø 6 x 40 mm	8000 1/min	0 547 042	
		fine	Ø 6 x 40 mm	8000 1/min	0 547 043	
		very fine	Ø 6 x 40 mm	8000 1/min	0 547 044	
	Ø 50 x 20 mm	medium	Ø 6 x 40 mm	6500 1/min	0 547 046	
		fine	Ø 6 x 40 mm	6500 1/min	0 547 047	
		very fine	Ø 6 x 40 mm	6500 1/min	0 547 048	



Even more choice on request!

These flap wheels are available in many more sizes. Please contact **Markus Abstoss**:
Tel. +49(0)2204/839-0 • m.abstoss@joke.de

Cutting Discs POWER

	Suitable for materials	Dimensions	Drilling dimension	Design	Rotation speed max.	Packing quantity	Order No.	Price from		
								1 piece	50 pieces	100 pieces
Cutting Disc POWER										
	Aluminium	Ø 115 x 1.5 mm	22.23 mm	straight	13300 1/min	25 pieces	0 575 140			
		Ø 125 x 1.5 mm	22.23 mm	straight	12200 1/min	25 pieces	0 575 141			
	Stainless steel	Ø 115 x 1.0 mm	22.23 mm	straight	13300 1/min	25 pieces	0 575 100			
		Ø 115 x 1.5 mm	22.23 mm	straight	13300 1/min	25 pieces	0 575 102			
		Ø 125 x 1.0 mm	22.23 mm	straight	12200 1/min	25 pieces	0 575 101			
		Ø 125 x 1.5 mm	22.23 mm	straight	12200 1/min	25 pieces	0 575 103			
		Ø 125 x 2.5 mm	22.23 mm	straight	12200 1/min	25 pieces	0 575 104			
		Ø 178 x 2.5 mm	22.23 mm	straight	8600 1/min	25 pieces	0 575 105			
		Ø 230 x 1.9 mm	22.23 mm	angular	6600 1/min	25 pieces	0 575 110			
	Steel	Ø 115 x 3.0 mm	22.23 mm	angular	13300 1/min	25 pieces	0 575 131			
		Ø 125 x 1.0 mm	22.23 mm	straight	12200 1/min	25 pieces	0 575 121			
		Ø 230 x 3.0 mm	22.23 mm	angular	6600 1/min	25 pieces	0 575 132			

Grinding Discs POWER

	Suitable for materials	Dimensions	Drilling dimension	Design	Rotation speed max.	Packing quantity	Order No.	Price from		
								1 piece	50 pieces	100 pieces
Grinding Disc POWER										
	Steel	Ø 115 x 6.5 mm	22.23 mm	angular	13300 1/min	10 pieces	0 575 150			
		Ø 125 x 6.5 mm	22.23 mm	angular	12200 1/min	10 pieces	0 575 151			
		Ø 178 x 7.0 mm	22.23 mm	angular	8600 1/min	10 pieces	0 575 152			
		Ø 230 x 7.0 mm	22.23 mm	angular	6600 1/min	10 pieces	0 575 153			
	Stainless steel	Ø 115 x 6.5 mm	22.23 mm	angular	13300 1/min	10 pieces	0 575 160			
		Ø 125 x 6.5 mm	22.23 mm	angular	12200 1/min	10 pieces	0 575 161			
		Ø 178 x 7.0 mm	22.23 mm	angular	8600 1/min	10 pieces	0 575 162			

Felt polishing flap discs

Thanks to the flexible lamellas made of 70% wool felt, the felt polishing flap discs adapt ideally to the contours of the workpiece. Perfect for polishing uneven and contoured surfaces. Achieves an optimal high-gloss finish in combination with polishing compounds.

	Dimensions	Drilling dimension	Hardness	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
								1 piece	50 pieces	100 pieces
Felt polishing flap disc extra flexible										
	Ø 115 mm	22.23 mm	medium	FG27	8500 1/min	5 pieces	0 575 201			
	Ø 125 mm	22.23 mm	soft	FG27	7700 1/min	5 pieces	0 575 202			
		22.23 mm	medium	FG27	7700 1/min	5 pieces	0 575 204			
	Ø 178 mm	22.23 mm	soft	FG27	5500 1/min	5 pieces	0 575 205			

Compact grinding wheels UNITIZED

This tool is characterised by multilayer pressed grinding fleece with high, evenly distributed abrasive grit. It offers a long service life and is very hard wearing. The compact grinding disc is used for >br/> • decorative finishes on stainless steel surfaces

- levelling of surfaces after weld seam processing
- preparation of titanium and stainless steel surfaces before polishing
- preparation of aluminium, copper and brass etc. before coating.

	Dimensions	Drilling dimension	Hardness	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
									1 piece	50 pieces	100 pieces
Compact grinding wheel											
	Ø 115 mm	22.23 mm	medium	coarse	G27	11000 1/min	5 pieces	0 575 190			
	Ø 115 mm	22.23 mm	medium	medium	G27	11000 1/min	5 pieces	0 575 191			
	Ø 115 mm	22.23 mm	medium	very fine	G27	11000 1/min	5 pieces	0 575 192			

Flap Discs HYBRID • SCM • Zirconium corundum

The combination of abrasive cloth and abrasive fleece facilitates material removal and achieving a decorative surface finish in a single work step.

The hybrid grinding disc is optimally suitable for

- Removing welding seams
- Removing burrs after plasma and laser cutting
- Removing small unevennesses and surface defects
- Suitable for stainless steel, mild steel, aluminium and other alloys.

	Dimensions	Drilling dimension	Grit size	Type	Colour	Rotation speed max.	Packing quantity	Order No.	Price from		
									1 piece	50 pieces	100 pieces
Flap Disc HYBRID											
	Ø 115 mm	22.23 mm	medium	conical	red brown	13300 1/min	10 pieces	0 575 170			
	Ø 125 mm	22.23 mm	medium	conical	red brown	12200 1/min	10 pieces	0 575 171			
Flap Disc SCM											
	Ø 115 mm	22.23 mm	coarse	G27	brown	13300 1/min	10 pieces	0 575 180			
		22.23 mm	medium	G27	red brown	13300 1/min	10 pieces	0 575 181			
		22.23 mm	very fine	G27	blue	13300 1/min	10 pieces	0 575 182			
	Ø 125 mm	22.23 mm	coarse	G27	brown	12200 1/min	10 pieces	0 575 183			
		22.23 mm	medium	G27	red brown	12200 1/min	10 pieces	0 575 184			
		22.23 mm	very fine	G27	blue	12200 1/min	10 pieces	0 575 185			
	Ø 178 mm	22.23 mm	medium	G27	red brown	8600 1/min	10 pieces	0 575 187			
		22.23 mm	very fine	G27	blue	8600 1/min	10 pieces	0 575 188			
Flap Disc Zirconium corundum											
	Ø 115 mm	22.23 mm	40	conical	blue	13300 1/min	10 pieces	0 575 220			
	Ø 125 mm	22.23 mm	40	conical	blue	12200 1/min	10 pieces	0 575 230			

Cup wheel discs



Cup wheel disc with TURBO hand air grinder

These cup wheel discs are screwed onto the mandrel (Order No. 0 750 512) of the TURBO hand grinder. Thanks to the separate cup wheel disc receptacle, these tools can also be used with all commercially available rotating handpieces.

Rotation speed max.: 25000 1/min

Dimensions	Grit size	Colour	Rotation speed max.	Order No.	Price from 1 piece	Price from 10 pieces
Cup wheel discs, high-grade corundum						
Ø 30	60	brown	25000 1/min	0 530 721		
	100	brown	25000 1/min	0 530 722		
	150	brown	25000 1/min	0 530 723		



⚙ Accessories / spare parts

Dimensions	Grit size	Colour	Rotation speed max.	Order No.	Price from 1 piece
Clamping shank					
			For receiving the cup wheel discs and rubber holders on TURBO hand grinders.	0 750 512	



EKW cup wheel discs

Dimensions	Grit size	Order No.	Price from 1 piece	Price from 5 pieces
EKW cup wheel discs				
Ø 100 x 50 x 20 mm	80	0 542 751		
Hardness JOT, resin-hardened edge for grinding HSS				
max. speed 7,500 rpm				
EKW cup wheel disc – Top quality				
Ø 100 x 50 x 20 mm	80	0 542 753		
Hardness JOT, resin-hardened edge for grinding HSS, hardened steel and hard metal				
max. speed 7,500 rpm				

Nylon cut-off discs, fibre-reinforced

Nylon cut-off discs, fibre-reinforced

Much more breakproof for a high level of working safety.
Thinner discs can be selected.

This results in the following advantages:

- very small contact area
- little heat generation in the cut
- narrower cut
- less expenditure of effort
- fast separation time
- less burr formation



Use with and without coolant/lubricant!



	Dimensions	Drilling dimension	Matchingreceptacles	Rotation speed max.	Packing quantity	Order No.	Price from			
								1 pack	5 packs	10 packs
Nylon cut-off discs, fibre-reinforced										
high-grade corundum										
for hardened and unhardened steels	Ø 22 x 0.2 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 901				
	Ø 22 x 0.3 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 902				
	Ø 22 x 0.5 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 903				
	Ø 25 x 0.2 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 904				
	Ø 25 x 0.3 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 905				
	Ø 25 x 0.5 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 906				
	Ø 40 x 0.5 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 907				
	Ø 40 x 0.7 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 908				
	Ø 40 x 1.0 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 909				
silicon carbide										
for stainless steels and non-ferrous metals	Ø 22 x 0.2 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 910				
	Ø 22 x 0.3 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 911				
	Ø 25 x 0.2 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 913				
	Ø 25 x 0.3 mm	1.8 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 914				

Accessories / spare parts

	for bore dimensions	Shank dimen-	Type	Max. disc size	Order No.	Price from		
		sions					1 piece	10 pieces
CRATEX® grinding wheel holder								
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275			
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276			
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277			
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	0 545 279			

Nylon cut-off discs, fibre-reinforced

Nylon cut-off discs, fibre-reinforced

Much more breakproof for a high level of working safety. Thinner discs can be selected.

This results in the following advantages:

- very small contact area
- little heat generation in the cut
- narrower cut
- less expenditure of effort
- fast separation time
- less burr formation

	Dimensions	Drilling dimension	Matching receptacles	Rotation speed max.	Price from Order No. 1 piece
Nylon cut-off discs, fibre-reinforced					
diamond					
	for ceramic and all difficult steels in aircraft, engine and power plant construction and for implant processing	Ø 20 x 0.2 mm Ø 20 x 0.3 mm	1.8 mm	21, 22, 23, 25 21, 22, 23, 25	20000 1/min 20000 1/min
					0 544 920 0 544 921

⚙ Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max. disc size	Price from Order No. 1 piece 10 pieces
CRATEX® grinding wheel holder					
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	0 545 279

Nylon cut-off discs

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	Dimensions	Drilling dimension	Matching receptacles	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 pack	5 packs
Nylon cut-off discs								
high-grade corundum (brown)								
for hardened and unhardened steels								
	Ø 22 x 0.3 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 960		
	Ø 22 x 0.7 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 961		
	Ø 22 x 2 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 962		
	Ø 22 x 3 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 963		
	Ø 25 x 0.5 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 972		
	Ø 25 x 0.7 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 965		
	Ø 25 x 0.8 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 974		
	Ø 25 x 1 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 966		
	Ø 34 x 1.65 mm	1.5 mm	21, 22, 23, 25	10000 1/min	10 pieces	0 544 967		
	Ø 37.5 x 1.0 mm	1.5 mm	21, 22, 23, 25	10000 1/min	10 pieces	0 544 968		
	Ø 40 x 1 mm	6 mm	41	10000 1/min	10 pieces	0 544 969		
silicon carbide (grey)								
for stainless steels and non-ferrous metals								
	Ø 22 x 0.7 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 981		
	Ø 22 x 2 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 982		
	Ø 25 x 0.7 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 985		
	Ø 25 x 1 mm	1.5 mm	21, 22, 23, 25	20000 1/min	10 pieces	0 544 986		



⚙ Accessories / spare parts

	for bore dimensions					Price from	
						1 piece	10 pieces
CRATEX® grinding wheel holder							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275		
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276		
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	0 545 277		
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	0 545 279		
	Ø 6 mm	Ø 6 x 25 mm	41	Ø 75 x 9.5 mm	0 545 282		

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Abrasive discs

Abrasive discs need a firm hold, since only then do they develop their full performance. In order to provide them this hold, you can select from among three different types of fastenings for the abrasive discs on the holder:

The largest selection of grit sizes and diameters can be found among our **self-adhesive abrasive discs**. These disposable articles provide the most economical solution at the same time. In addition to the large selection in the catalogue, we also offer you many special solutions here, for example in the "soft" or SiC paper versions. Consult Markus Abstoß about the possibilities.

Very rapid abrasive disc changes are possible with our discs with Velcro fastening. In contrast to the self-adhesive version, the rubber holders can be reused in this case.

The **COMBIDISC®** system offers the best hold and a very large selection of discs. Simply screw the abrasive disc on to the rubber holder and set to work. Flying discs are finally a thing of the past with this solution. These abrasive discs are thermally more resilient and always sit centrally owing to the innovative fastener. The rubber holder can also be reused in this case too.

Self-adhesive



Velcro fastening



COMBIDISC®



298 Abrasive discs, self-adhesive

299 Abrasive discs with
Velcro fastening

304 Abrasive discs with rapid
clamping fastener
COMBIDISC®

Grinding stars Polistar Corundum

Grinding stars Polistar

Highly versatile deburring tools for processing the internal surfaces of drilling holes and pipes.
Optimally suitable for small diameters (Ø 7 to 40 mm).

Polistar can be clamped in multiple layers (offset in relation to one another) in the tool holders.

Applications:

- cleaning and fine grinding of drilling holes
- removal of annealing colours
- rounding of inlet and outlet sides for drilling holes
- removal of slight burrs

Cutting speed Vmax: 20 m/sec.



perfect for deburring of drill holes etc.

Dimensions	Grit size	Drilling dimension	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack
Grinding stars Polistar, corundum						
Ø 20 mm	60	1.6 mm	20000 1/min	25 pieces	0 570 910-0	
Ø 20 mm	80	1.6 mm	20000 1/min	25 pieces	0 570 911-0	
Ø 20 mm	120	1.6 mm	20000 1/min	25 pieces	0 570 912-0	
Ø 30 mm	60	1.6 mm	13000 1/min	25 pieces	0 570 913-0	
Ø 30 mm	80	1.6 mm	13000 1/min	25 pieces	0 570 914-0	
Ø 30 mm	120	1.6 mm	13000 1/min	25 pieces	0 570 915-0	
Ø 40 mm	60	3 mm	10000 1/min	10 pieces	0 570 904-0	
Ø 40 mm	80	3 mm	10000 1/min	10 pieces	0 570 905-0	
Ø 40 mm	120	3 mm	10000 1/min	10 pieces	0 570 906-0	
Ø 50 mm	60	3 mm	8000 1/min	10 pieces	0 570 907-0	
Ø 50 mm	80	3 mm	8000 1/min	10 pieces	0 570 908-0	
Ø 50 mm	120	3 mm	8000 1/min	10 pieces	0 570 909-0	



Accessories / spare parts

for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from 1 piece	Price from 10 pieces
CRATEX® grinding wheel holder						
	Ø 1.5 - 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	0 545 275	
	Ø 1.5 - 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	0 545 276	
	Ø 3 mm	Ø 6 x 40 mm	33	Ø 45 x 6 mm	0 545 269	

Grinding stars POLINOX Fleece

Grinding stars POLINOX

The new fleece alternative to the Polistar corundum grindings stars. Owing to the fleece trimming the POLINOX stars are particularly adaptable and therefore predestined for tight working areas: drilling holes, recesses and places which are difficult to reach. Available in packs containing 5 pieces respectively in three dimensions and three grit sizes.

Applications:

- deburring of in components made of nonferrous metals and non-ferrous heavy metals
- fine grinding on internal surfaces of stainless steel pipes
- cleaning of thread turns

Cutting speed Vmax: 20 m/sec.

	Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from
						1 pack
						4 packs
Grinding stars POLINOX, corundum						
	Ø 19 mm	medium	20000 1/min	5 pieces	0 570 991	
		very fine	20000 1/min	5 pieces	0 570 992	
	Ø 25 mm	coarse	15000 1/min	5 pieces	0 570 993	
		medium	15000 1/min	5 pieces	0 570 994	
		very fine	15000 1/min	5 pieces	0 570 995	
	Ø 38 mm	coarse	10000 1/min	5 pieces	0 570 996	
		medium	10000 1/min	5 pieces	0 570 997	
		very fine	10000 1/min	5 pieces	0 570 998	



Accessories / spare parts

	Shank dimensions	Type	Thread	Order No.	Price from
					1 piece
suitable tool holders					
	Ø 6 x 125 mm	XL	8/32-UNC	0 570 960	
	Ø 6 x 75 mm	L	8/32-UNC	0 570 965	



Grinding wheels POLINOX Fleece **NEW!**

POLINOX rounds are suitable for flexible machining of complicated tool contours and are used in peripheral grinding.

Advantages:

Optimum adaptation to the contour due to high flexibility with a very long service life.

Reach points that are difficult to access such as deep slots or recesses.

No clogging of the tool due to open structure and high flexibility of the fleece material.



	Dimensions	Drilling dimension	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from
							1 pack
							4 packs
Grinding wheels - POLINOX, corundum							
	Ø 50 x 10 mm	6 mm	100	12250 1/min	10 pieces	0 570 860	
		6 mm	280	12250 1/min	10 pieces	0 570 861	
	Ø 75 x 10 mm	6 mm	100	8150 1/min	10 pieces	0 570 862	
		6 mm	280	8150 1/min	10 pieces	0 570 863	
	Ø 100 x 10 mm	13 mm	100	6150 1/min	10 pieces	0 570 864	
		13 mm	280	6150 1/min	10 pieces	0 570 865	
	Ø 125 x 10 mm	13 mm	100	4900 1/min	10 pieces	0 570 866	
		13 mm	280	4900 1/min	10 pieces	0 570 867	
	Ø 150 x 10 mm	13 mm	100	4100 1/min	10 pieces	0 570 868	
		13 mm	280	4100 1/min	10 pieces	0 570 869	



 Accessories / spare parts

NEW! ■

	for bore dimensions	Shank dimensions	Order No.	Price from
				1 piece 5 pieces
suitable tool holders				
	Ø 6 mm	Ø 6 mm	0 545 702	
	Ø 13 mm	Ø 6 mm	0 545 703	



Abrasive discs ROTAFLEX

Silicon carbide, self-adhesive



Use with or without coolant/lubricant!

The silicon carbide abrasive discs are ideal for processing aluminium, copper, bronze, titanium, high-alloyed steels and fibre-reinforced plastics. Optimally suited for the aeronautical industry and in areas where only SiC is allowed.

Cutting speed Vmax: 13 m/sec.

Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from
						1 pack 3 packs
ROTAFLEX abrasive discs						
Ø 30 mm	80	CPC 871	8500 1/min	250 pieces	0 530 660	
	120	CPC 871	8500 1/min	250 pieces	0 530 662	
	220	CPA 871	8500 1/min	250 pieces	0 530 665	
	240	CPA 871	8500 1/min	250 pieces	0 530 666	
	320	CPA 871	8500 1/min	250 pieces	0 530 668	
	500	CPA 871	8500 1/min	250 pieces	0 530 671	
	800	CPA 871	8500 1/min	250 pieces	0 530 673	
	1000	CPA 871	8500 1/min	250 pieces	0 530 674	
	1200	CPA 871	8500 1/min	250 pieces	0 530 675	



Abrasive discs ROTAFLEx-Trizact

Corundum

The ROTAFLEx Trizact grinding sheets – a guarantee of particularly even surfaces and a perfect finish. Owing to the pyramid-shaped, uniform arrangement of identical abrasive particles on a foam-like carrier, the abrasive particles are continuously exposed during grinding. The result is reproducible and smooth surfaces with a longer service life.

Cutting speed Vmax: 13 m/sec.

Dimensions	Grit size	Packing quantity	Order No.	Price from
				1 pack
Abrasive discs ROTAFLEx-Trizact with velcro fastening				
Ø 30 mm	160	10 pieces	0 572 001	
Abrasive discs ROTAFLEx-Trizact, self-adhesive				
	160	10 pieces	0 572 101	


 Accessories / spare parts


Dimensions	Shank dimensions	Type	Suitable abrasive discs	Order No.	Price from
					1 piece 5 pieces 10 pieces
Rubber holder ROTAFLEx					
Ø 30 mm	Ø 3 x 26 mm	RK 2	R 2	0 544 104	

Abrasive discs ROTAFLEX

Corundum, with velcro fastening

Owing to the velour Velcro fastening, these abrasive discs adhere particularly well to the corresponding rubber holders. Ideal for multiple use!
Cutting speed Vmax: 20 m/sec.

Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from		
					1 pack	3 packs	5 packs
ROTAFLEX abrasive discs with Velcro fastening							
	Ø 20 mm	60	19000 1/min	100 pieces	0 544 012		
		80	19000 1/min	100 pieces	0 544 013		
		120	19000 1/min	100 pieces	0 544 014		
		150	19000 1/min	100 pieces	0 544 015		
		180	19000 1/min	100 pieces	0 544 016		
		240	19000 1/min	100 pieces	0 544 017		
		320	19000 1/min	100 pieces	0 544 018		
	Ø 30 mm	60	13000 1/min	100 pieces	0 544 032		
		80	13000 1/min	100 pieces	0 544 033		
		120	13000 1/min	100 pieces	0 544 034		
		180	13000 1/min	100 pieces	0 544 036		
		240	13000 1/min	100 pieces	0 544 037		
		320	13000 1/min	100 pieces	0 544 038		

Rubber holders with velcro fastening

Corundum, with velcro fastening

The matching rubber holders for abrasive discs with Velcro fastening. Unlike conventional stick-on discs, the rubber holder can be reused once the disc is worn out.
Cutting speed Vmax: 20 m/sec.

	Dimensions	Shank dimensions	Price from		
			Order No.	1 piece	5 pieces
Rubber holders with velcro fastening					
	Ø 18 mm	Ø 3 x 30 mm	0 544 010		
	Ø 30 mm	Ø 3 x 30 mm	0 544 020		
		Ø 6 x 40 mm	0 544 030		

Abrasive discs ROTAFLEX

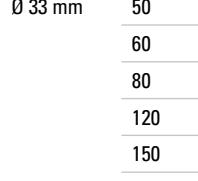
Corundum, self-adhesive

For elastic grinding in combination with the suitable rubber holders.
Cutting speed Vmax: 13 m/sec.

Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
						1 pack	5 packs	10 packs
ROTAFLEX abrasive discs								
	Ø 12 mm	50	R 0	20000 1/min	50 pieces	0 544 111		
		60	R 0	20000 1/min	50 pieces	0 544 112		
		80	R 0	20000 1/min	50 pieces	0 544 113		
		120	R 0	20000 1/min	50 pieces	0 544 114		
		150	R 0	20000 1/min	50 pieces	0 544 115		
		180	R 0	20000 1/min	50 pieces	0 544 116		
		240	R 0	20000 1/min	50 pieces	0 544 117		
		320	R 0	20000 1/min	50 pieces	0 544 118		
		400	R 0	20000 1/min	50 pieces	0 544 119		
		600	R 0	20000 1/min	50 pieces	0 544 174		

Abrasive discs ROTAFLEX

Corundum, self-adhesive

Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
						1 pack	5 packs	10 packs
	Ø 20 mm	50	R 1	12000 1/min	50 pieces	0 544 121		
	60	R 1	12000 1/min	50 pieces	0 544 122			
	80	R 1	12000 1/min	50 pieces	0 544 123			
	120	R 1	12000 1/min	50 pieces	0 544 124			
	150	R 1	12000 1/min	50 pieces	0 544 125			
	180	R 1	12000 1/min	50 pieces	0 544 126			
	240	R 1	12000 1/min	50 pieces	0 544 127			
	320	R 1	12000 1/min	50 pieces	0 544 128			
	400	R 1	12000 1/min	50 pieces	0 544 129			
	600	R 1	12000 1/min	50 pieces	0 544 175			
	Ø 33 mm	50	R 2	7500 1/min	50 pieces	0 544 131		
	60	R 2	7500 1/min	50 pieces	0 544 132			
	80	R 2	7500 1/min	50 pieces	0 544 133			
	120	R 2	7500 1/min	50 pieces	0 544 134			
	150	R 2	7500 1/min	50 pieces	0 544 135			
	180	R 2	7500 1/min	50 pieces	0 544 136			
	240	R 2	7500 1/min	50 pieces	0 544 137			
	320	R 2	7500 1/min	50 pieces	0 544 138			
	400	R 2	7500 1/min	50 pieces	0 544 139			
	600	R 2	7500 1/min	50 pieces	0 544 176			
	Ø 50 mm	50	R 3	5000 1/min	50 pieces	0 544 141		
	60	R 3	5000 1/min	50 pieces	0 544 142			
	80	R 3	5000 1/min	50 pieces	0 544 143			
	120	R 3	5000 1/min	50 pieces	0 544 144			
	150	R 3	5000 1/min	50 pieces	0 544 145			
	180	R 3	5000 1/min	50 pieces	0 544 146			
	240	R 3	5000 1/min	50 pieces	0 544 147			
	320	R 3	5000 1/min	50 pieces	0 544 148			
	400	R 3	5000 1/min	50 pieces	0 544 149			
	600	R 3	5000 1/min	50 pieces	0 544 177			

Accessories / spare parts

	Dimensions	Shank dimensions	Type	Suitable abrasive discs	Order No.	Price from		
						1 piece	5 pieces	10 pieces
Rubber holder ROTAFLEX								
	Ø 10 mm	Ø 3 x 26 mm	RK 0	R 0		0 544 101		
	Ø 18 mm	Ø 2.35 x 26 mm	RK 1	R 1		0 544 102		
		Ø 3 x 26 mm	RK 1	R 1		0 544 103		
	Ø 30 mm	Ø 3 x 26 mm	RK 2	R 2		0 544 104		
	Ø 45 mm	Ø 6 x 32 mm	RK 3	R 3		0 544 105		

Abrasive discs ROTAFLEx

Silicon carbide, self-adhesive

	Steel, cast steel	Coarse grinding of steel and cast steel	Stainless steel (INOX)	Materials with high thermal stability (Ni-Co alloy)	Hard non-ferrous metals, titanium, bronze, hardened aluminium alloys	Soft non-ferrous metals, brass, copper, aluminium alloys	Carbide metal, hard facings, glass, GRP, CRP	Cleaning, structuring, deburring	Polishing
	Corundum A universally for all metals	page 304							
	Corundum A-Forte universally, long service life, cool cut	on request!							
	Silicon carbide non-ferrous metals, titanium, aeronautical industry, SiC authorisation	on request!							
	Fleece rounds, hard universally for surface processing of many materials	page 304							
	Fleece rounds, soft universally for surface processing of many materials	page 304							
	Felt rounds polishing of larger surfaces	on request!							
	Corundum A-FLEX universally for all metals, flexibly for uneven surfaces	on request!							
	Ceramic grit CO-COOL extremely hard materials, high stock removal, long service life	on request!							
	TX rounds surface processing, deburring, particularly on INOX and aluminium	on request!							
	Cleaning rounds POLICLEAN® cleaning, removal, surface processing	on request!							

Fig. shows other rapid fastener

Abrasive discs ROTAflex

Silicon carbide, self-adhesive

	Steel, cast steel	Coarse grinding of steel and cast steel	Stainless steel (INOX)	Materials with high thermal stability (Ni-Co alloy)	Hard non-ferrous metals, titanium, bronze, hardened aluminium alloys	Soft non-ferrous metals, brass, copper, aluminium alloys	Carbide metal, glass, hard material coatings, hard facings, deburring, GRP, CRP	Cleaning, structuring, deburring	Polishing
Corundum A-PLUS universally for metals, long service lives, stable carrier material	on request!								
Small fibre grinders corundum A surface and edge grind- ing, very long service lives, reinforced fibre backing	on request!								
Corundum A-COOL materials difficult to cut, such as INOX, Hastelloy, Inconel, Ni-Co	on request!								
Zirconium corundum Z for all carbide metals during coarse grinding up to grit size 36 and grit size 80	on request!								
Small fibre grinders ceramic grit CO-COOL extremely hard materials, high stock removal, rein- forced fibre backing	on request!								
Diamond grinding discs Hastelloy, Inconel, chrome, tungsten, titanium carbide, carbide metal, CRP/GRP	on request!								
Brush remove adhesive etc., cleaning of contours and edges	on request!								
mini-POLIFAN Corundum A universal coarse grinding tasks, high cutting performance									
mini-POLIFAN Zirconium corundum ZA grcoarse grinding tasks, high cutting performance	on request!								

Fig. shows other
rapid fastener

Fig. shows other
rapid fastener

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Grinding and polishing discs COMBIDISC® Corundum A

The corundum A version is suitable for universal use on metals and other materials. "Medium" version abrasive discs are recommended.

Dimensions	Grit size	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack	4 packs
Abrasive discs COMBIDISC® corundum A							
Ø 20 mm	60	20.000 1/min	35000 1/min	50 pieces	0 541 020		
	80	20.000 1/min	35000 1/min	50 pieces	0 541 021		
	120	20.000 1/min	35000 1/min	50 pieces	0 541 022		
	180	20.000 1/min	35000 1/min	50 pieces	0 541 023		
	320	20.000 1/min	35000 1/min	50 pieces	0 541 024		
	Ø 25 mm	60	15.000 1/min	26000 1/min	50 pieces	0 541 025	
Ø 25 mm	80	15.000 1/min	26000 1/min	50 pieces	0 541 026		
	120	15.000 1/min	26000 1/min	50 pieces	0 541 027		
	180	15.000 1/min	26000 1/min	50 pieces	0 541 028		
	320	15.000 1/min	26000 1/min	50 pieces	0 541 029		
Ø 38 mm	60	10.000 1/min	16000 1/min	50 pieces	0 541 031		
	80	10.000 1/min	16000 1/min	50 pieces	0 541 032		
	120	10.000 1/min	16000 1/min	50 pieces	0 541 033		
	180	10.000 1/min	16000 1/min	50 pieces	0 541 034		
	320	10.000 1/min	16000 1/min	50 pieces	0 541 035		
Ø 50 mm	60	8.000 1/min	13000 1/min	50 pieces	0 541 037		
	80	8.000 1/min	13000 1/min	50 pieces	0 541 038		
	120	8.000 1/min	13000 1/min	50 pieces	0 541 039		
	180	8.000 1/min	13000 1/min	50 pieces	0 541 040		
	320	8.000 1/min	13000 1/min	50 pieces	0 541 041		

Grinding and polishing discs COMBIDISC® Fleece rounds

The fleece rounds are universally suitable for surface processing on metals. For eliminating grinding marks, removing oxidation and for light deburring work for example. The flexibility of the fleece rounds is determined by the choice of holder hardness.

Dimensions	Grit size	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack	4 packs
Fleece rounds COMBIDISC® – hard version, corundum A							
Ø 20 mm	very fine	14,000 1/min	19000 1/min	25 pieces	0 541 110		
	coarse	11,000 1/min	15000 1/min	25 pieces	0 541 111		
	medium	11,000 1/min	15000 1/min	25 pieces	0 541 112		
	very fine	11,000 1/min	15000 1/min	25 pieces	0 541 113		
	coarse	7,000 1/min	10000 1/min	25 pieces	0 541 114		
Ø 38 mm	medium	7,000 1/min	10000 1/min	25 pieces	0 541 115		
	very fine	7,000 1/min	10000 1/min	25 pieces	0 541 116		
	coarse	5,500 1/min	7500 1/min	25 pieces	0 541 117		
	medium	5,500 1/min	7500 1/min	25 pieces	0 541 118		
	very fine	5,500 1/min	7500 1/min	25 pieces	0 541 119		
Fleece rounds COMBIDISC® – soft version, corundum A							
Ø 50 mm	medium	5,500 1/min	7500 1/min	25 pieces	0 541 130		
	fine	5,500 1/min	7500 1/min	25 pieces	0 541 131		
	very fine	5,500 1/min	7500 1/min	25 pieces	0 541 132		

Grinding and polishing discs COMBIDISC® Ceramic grit CO-COOL

Ceramic grit CO-COOL is suitable for processing unalloyed and alloyed steels, cast iron, stainless steel (INOX), titanium, nickel alloys and extra-hard materials. Consistent high performance self-sharpening ceramic grits. Fillers with an active grinding effect in the coating result in an outstanding improvement in stock removal and long stock removal periods and service lives. Furthermore, the fillers prevent clogging of the discs and ensure a cool cut. The "medium" and "hard" abrasive disc holders are particularly well suited.

	Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack	4 packs
Abrasive discs COMBIDISC® ceramic grid CO-COOL							
	Ø 38 mm	36	16000 1/min	25 pieces	0 541 091		
		60	16000 1/min	25 pieces	0 541 092		
		80	16000 1/min	25 pieces	0 541 093		
		120	16000 1/min	25 pieces	0 541 094		
	Ø 50 mm	36	13000 1/min	25 pieces	0 541 096		
		60	13000 1/min	25 pieces	0 541 097		
		80	13000 1/min	25 pieces	0 541 098		
		120	13000 1/min	25 pieces	0 541 099		



Grinding and polishing discs COMBIDISC® Felt rounds

For frontal polishing with diamond, grinding and polishing pastes on larger surfaces. Optionally, the holders can be used "soft" or "medium".

	Dimensions	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack	4 packs
Felt rounds COMBIDISC®							
	Ø 50 mm	4,000 1/min	4000 1/min	5 pieces	0 541 150		



Grinding and polishing discs COMBIDISC® Holders

	Dimensions	Design	Shank dimensions	Recommended speed	Order No.	Price from 1 piece
Grinding and polishing disc holders COMBIDISC®						
Soft abrasive disc holder	Ø 20 mm	medium	Ø 3 x 27 mm	30.000 1/min	0 541 012	
		medium	Ø 6 x 40 mm	47.500 1/min	0 541 001	
Medium abrasive disc holder	Ø 25 mm	medium	Ø 3 x 27 mm	25.000 1/min	0 541 013	
		medium	Ø 6 x 40 mm	38.000 1/min	0 541 002	
Hard abrasive disc holder	Ø 38 mm	hard	Ø 6 x 40 mm	25.000 1/min	0 541 003	
		medium	Ø 6 x 40 mm	25.000 1/min	0 541 004	
		soft	Ø 6 x 40 mm	25.000 1/min	0 541 005	
	Ø 50 mm	hard	Ø 6 x 40 mm	19.000 1/min	0 541 006	
		medium	Ø 6 x 40 mm	19.000 1/min	0 541 007	
		soft	Ø 6 x 40 mm	19.000 1/min	0 541 008	

Abrasive paper

Silicon carbide

The well-known wet abrasive paper. Owing to the very fine grit size, suitable up to the polishing stage. Use wet and dry on all steels and nonferrous metals. An insider's tip for aluminium!

	Dimensions	Grit size	Type	Packing quantity	Order No.	Price from 1 pack	Price from 5 packs
Silicon carbide abrasive paper							
	230 x 280 mm	150	991 C	50 pieces	0 401 379		
		180	991 C	50 pieces	0 401 380		
		220	991 C	50 pieces	0 401 381		
		240	991 C	50 pieces	0 401 382		
		280	991 C	50 pieces	0 401 383		
		320	991 C	50 pieces	0 401 384		
		400	991 C	50 pieces	0 401 386		
		500	991 C	50 pieces	0 401 387		
		600	991 C	50 pieces	0 401 388		
		800	991 C	50 pieces	0 401 389		
		1000	991 C	50 pieces	0 401 390		
		1200	991 C	50 pieces	0 401 391		
		1200	991 A	50 pieces	0 401 373		
		2000	991 A	50 pieces	0 401 392		
		2500	991 A	50 pieces	0 401 393		
		3000	991 A	50 pieces	0 401 394		
		5000	991 A	50 pieces	0 401 395		
		1500	991 A	50 pieces	0 401 397		
		7000	991 A	50 pieces	0 401 399		



Use with or without coolant/lubricant!



Difference between A and C grades?

The A and C grade wet abrasive papers differ in the specific weight of the base:

- A ≤ 115 g/m²
- C > 115 g/m²



Mikro-Finishing-Abrasive Paper 3M® Corundum

This microfinishing 3M® emery paper, consisting of a polyester film backing, is characterised by densely dispersed, closely calibrated corundum grit in a synthetic resin bond. This results in very fine surfaces on all metals and even on plastics.

	Dimensions	Grit size	Colour	Packing quantity	Order No.	Price from 1 piece	10 pieces	50 pieces
Mikro-Finishing-Abrasive Paper 3M®								
	216 x 280 mm	180 / 80 µm	brown	5 pieces	0 530 708			
		220 / 60 µm	black	5 pieces	0 530 709			
		320 / 40 µm	blue	5 pieces	0 530 710			
		400 / 30 µm	green	5 pieces	0 530 711			
		500 / 20 µm	red	5 pieces	0 530 712			
		800 / 15 µm	orange	5 pieces	0 530 713			
		1200 / 9 µm	light blue	5 pieces	0 530 714			



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Padded abrasive cloth MX

The somewhat different kind of abrasive. The grinding crystals are accommodated in an elastic latex layer on a fabric base. The crystals move flexibly during grinding and always optimally align themselves in relation to the surface; the stock removal level constantly remains even. The result is a completely smooth surface on almost all materials: metal, plastics, glass, wood, lacquer or stone. Practically all smooth surfaces can be superfine ground. In doing so, it is possible to work with a considerably coarser grit size than usual and markedly finer surfaces result all the same. Comparatively large grinding crystals and the flexible carrier material prevent scratches on the workpiece, since no adherence of the grinding crystals occurs as a result of dust particle accumulation.

	Grit size MX	Comparable to FEPA
180	> P 360	
240	P 800	
320	> P 1500	
360	P 2000	
400	P 2500	
600	> P 3000	
800	P 5000	
1200	> P 5000	



Use with or without
coolant/lubricant!

Dimensions	Grit size	Price from Order No.	1 piece
Padded abrasive cloth MX			
	150 x 305 mm	180	0 401 651
		240	0 401 652
		320	0 401 653
		360	0 401 654
		400	0 401 655
		600	0 401 656
		800	0 401 657
		1200	0 401 658



matching set

Set of padded abrasive cloth MX	One sheet per grit size respectively	Price from Order No.	1 set
		0 401 650	



What advantages does the "padded abrasive cloth" offer?

- up to 15 x service life
- a markedly finer polished section than with conventional abrasives
- grit size 400 corresponds to the surface roughness of grit size P 2500 in spite of the high stock removal
- delayed friction and consequently less heat generation
- large crystals
- no built-up edges



Do you need MX on the roll, as rounds or in different sheet dimensions, then please contact Markus Abstoss:

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Abrasive strips ROTAFLEx

Corundum, self-adhesive

				Price from	Dimensions	Grit size	Packing quantity	Order No.	1 pack	10 packs
Abrasive strips ROTAFLEx, corundum, self-adhesive										
					7 x 580 mm	60	10 pieces	0 401 302		
						80	10 pieces	0 401 303		
						120	10 pieces	0 401 304		
						150	10 pieces	0 401 305		
						180	10 pieces	0 401 306		
						240	10 pieces	0 401 307		
						320	10 pieces	0 401 308		
						400	10 pieces	0 401 309		
						600	10 pieces	0 401 310		
					10 x 580 mm	80	10 pieces	0 401 333		
						120	10 pieces	0 401 334		
						150	10 pieces	0 401 335		
						180	10 pieces	0 401 336		
						240	10 pieces	0 401 337		
						320	10 pieces	0 401 338		
						400	10 pieces	0 401 339		
						600	10 pieces	0 401 340		



Use with or without coolant/lubricant!

Abrasive sheets ROTAFLEx

Corundum, self-adhesive

				Price from	Dimensions	Grit size	Order No.	1 piece	10 pieces
Abrasive sheets ROTAFLEx, corundum, self-adhesive									
					210 x 580 mm	60	0 401 312		
						80	0 401 313		
						150	0 401 315		
						180	0 401 316		
						240	0 401 317		
						320	0 401 318		
						400	0 401 319		
						600	0 401 320		
					250 x 580 mm	60	0 401 322		
						80	0 401 323		
						120	0 401 324		
						150	0 401 325		
						180	0 401 326		
						240	0 401 327		
						320	0 401 328		
						400	0 401 329		
						600	0 401 330		



Use with or without coolant/lubricant!

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23
45
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Felt pads ROTAFLEX

Why should this idea of the small self-adhesive pads be restricted to grinding! We also offer a self-adhesive polishing felt in the same shape:

Dimensions	Grit size	Packing quantity	Order No.	Price from	1 pack	5 packs	10 packs
Felt tips ROTAFLEx, self-adhesive							
	20 x 10 mm	50 pieces	0 530 604				
Abrasive Pads, self-adhesive							
	20 x 10 mm	180	100 pieces	0 530 605			
	20 x 10 mm	240	100 pieces	0 530 606			
	20 x 10 mm	280	100 pieces	0 530 607			
	20 x 10 mm	320	100 pieces	0 530 608			
	20 x 10 mm	400	100 pieces	0 530 609			
	20 x 10 mm	600	100 pieces	0 530 610			
	20 x 10 mm	800	100 pieces	0 530 611			
	20 x 10 mm	1000	100 pieces	0 530 612			
	20 x 10 mm	1200	100 pieces	0 530 613			

Accessories / spare parts

Order No.	Price from	1 piece	5 pieces	10 pieces
Abrasive pad holder, 180° pivotable				
shank Ø x total length 3 x 85 mm	0 530 601			
				
Abrasive pad holder				
shank Ø x total length 3 x 65 mm	0 530 602			
shank Ø x total length 3 x 40 mm	0 530 603			
				



Grinding fleece pads and rolls

Elastic material made from unwoven nylon fibres, within which the abrasive grain is uniformly distributed. The joke grinding fleece adapts to any surface and therefore allows consistent working results throughout its entire service life. This grinding fleece is ideal for fine grinding, cleaning, and elimination of corrosion and for very fine deburring. Can be used dry or with water, fluid or oil.

Dimensions	Grit size	Design	Order No.	1 piece	3 pieces	5 pieces	Price from
Grinding fleece – rolls and pads							
115 mm x 10 m	100 - 180 / medium	Roll – corundum	0 401 430-0				
	220 - 240 / fine	Roll – corundum	0 401 431-0				
	280 - 360 / very fine	Roll – corundum	0 401 432-0				
	280 - 360 / very fine	Roll – silicon carbide	0 401 433-0				
	400 - 600 / superfine	Roll – silicon carbide	0 401 434-0				
	800 - 1500 / ultrafine	Roll – silicon carbide	0 401 435-0				
229 x 152 mm	320 - 360 / very fine	Pad – corundum	0 401 436				
	500 - 600 / superfine	Pad – silicon carbide	0 401 437				



Use with or without coolant/lubricant!

	Grit size Fleece	comparable to FEPA
coarse	K 40 - 80	
medium	K 100 - 180	
fine	K 220 - 240	
very fine	K 280 - 360	
super-fine	K 400 - 600	
ultra-fine	K 800 - 1500	

Abrasive cloth sheets Premium Corundum

One of the best abrasive cloths in the world – now available in sheet and roll form! The material can be torn to the desired length very easily and cleanly and is highly flexible, yet still has high edge stability.



What is elutriated grit application?

With the elutriated material, the abrasive is „painted“ on to the base in a „sludge“ consisting of binder and grinding grit. This results in a very fine and uniform emery surface, which is ideally suited for prepolishing.

Dimensions	Grit size	Packing quantity	Order No.	1 pack	3 packs	5 packs	Price from
Abrasive cloth sheets Premium VSM, KK 114 F, corundum							
230 x 280 mm	999 rouge	50 pieces	0 530 630				
	444 silver	50 pieces	0 530 629				
	400	50 pieces	0 530 628				
	360	50 pieces	0 530 627				
	320	50 pieces	0 530 626				
	280	50 pieces	0 530 625				
	240	50 pieces	0 530 624				
	220	50 pieces	0 530 623				
	180	50 pieces	0 530 622				
	150	50 pieces	0 530 621				
	120	50 pieces	0 530 620				
	100	50 pieces	0 530 619				
	80	50 pieces	0 530 618				



Use with or without coolant/lubricant!

Economy abrasive cloth rolls Premium Corundum

Premium abrasive cloth delivered – on 50 m rolls. Likewise very flexible, yet with high edge stability and easy to tear to the desired size.

	Width		Grit size		Price from		
					1 piece	3 pieces	5 pieces
Premium economy abrasive cloth roll, 50 m, VSM, KK 114 F and KK 511 F							
	25 mm	80	KK 114 F	0 543 851			
		120	KK 114 F	0 543 847			
		150	KK 114 F	0 543 852			
		180	KK 114 F	0 543 853			
		240	KK 114 F	0 543 854			
		320	KK 114 F	0 543 855			
		400	KK 114 F	0 543 856			
		600	KK 511 F	0 543 858			
		800	KK 511 F	0 543 859			
		999	KK 114 F	0 543 844			
	40 mm	80	KK 114 F	0 543 861			
		120	KK 114 F	0 543 848			
		150	KK 114 F	0 543 862			
		180	KK 114 F	0 543 863			
		240	KK 114 F	0 543 864			
		320	KK 114 F	0 543 865			
		400	KK 114 F	0 543 866			
		600	KK 511 F	0 543 868			
		800	KK 511 F	0 543 869			
		999	KK 114 F	0 543 845			
	50 mm	40	KK 114 F	0 543 843			
		60	KK 114 F	0 543 870			
		80	KK 114 F	0 543 871			
		100	KK 114 F	0 543 841			
		120	KK 114 F	0 543 849			
		150	KK 114 F	0 543 872			
		180	KK 114 F	0 543 873			
		240	KK 114 F	0 543 874			
		320	KK 114 F	0 543 875			
		400	KK 114 F	0 543 876			
		500	KK 511 F	0 543 877			
		600	KK 511 F	0 543 878			
		800	KK 511 F	0 543 879			
		999	KK 114 F	0 543 846			



Use with or without coolant/lubricant!



Practical:
The grit sizes 60 to 400 are supplied in a cardboard dispenser with a cutting edge.

Economy abrasive cloth rolls Standard Corundum

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Suitable for removing milling, turning and erosion structures. Good as preparation before processing with grinding stones and diamond compound.

	Width	Grit size	Order No.	Price from 1 piece	Price from 3 pieces
Standard economy abrasive cloth rolls, Starcke 641 PF, corundum, 50 m					
	25 mm	80	0 401 403-1		
		150	0 401 405-1		
		180	0 401 406-1		
		240	0 401 407-1		
		320	0 401 408-1		
		400	0 401 409-1		
	50 mm	80	0 401 413		
		120	0 401 414		
		150	0 401 415		
		180	0 401 416		
		240	0 401 417		
		320	0 401 418		
		400	0 401 419		



Abrasive band holder for Microgrinding strips and Poly-Strip

For processing narrow edges and tight slots with the Poly-Strip grinding strips. Use by hand and also in hand-filing machines.

	Dimensions	Shank dimensions	Order No.	Price from 1 piece
Holder for Poly-Strip abrasive strips				
	6 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 551	
	10 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 552	
	15 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 553	
	6 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 556	
	10 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 557	
	15 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 558	

matching set

	Price from Order No.	1 set
Poly-Strip abrasive strip holder set 2		
	contains one Poly-Strip abrasive strip holder in 50 mm length each	0 401 555

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Abrasive bands

Poly-Strip

Poly-Strip abrasive strips

This tried and trusted system always provides the right abrasive strip in the desired width and grit size. Simply pull out the required length and tear – hey presto! A tear-off edge dispenses with tedious cutting with scissors. As soon as the end of a strip is reached, the new abrasive strip can be easily inserted in the cartridge.

	Price from
	Order No.
	1 piece
Poly-Strip abrasive strips, cassette of 6	
containing 1 abrasive strip roll each 15 mm, roll length 25 m in grit size 150, 180, 240, 320, 400, 600	0 401 501



⚙ Accessories / spare parts

	Width	Grit size	Price from
			Order No.
			1 piece
Spare Poly-Strip abrasive strip roll, 25 m			
	6 mm	150	0 401 511
	6 mm	180	0 401 512
	6 mm	240	0 401 513
	6 mm	320	0 401 514
	6 mm	400	0 401 515
	6 mm	600	0 401 516
	6 mm	800	0 401 517
	6 mm	1000	0 401 518
	6 mm	1200	0 401 519
	10 mm	150	0 401 521
	10 mm	180	0 401 522
	10 mm	240	0 401 523
	10 mm	320	0 401 524
	10 mm	400	0 401 525
	10 mm	600	0 401 526
	10 mm	800	0 401 527
	10 mm	1000	0 401 528
	10 mm	1200	0 401 529
	15 mm	150	0 401 531
	15 mm	180	0 401 532
	15 mm	240	0 401 533
	15 mm	320	0 401 534
	15 mm	400	0 401 535
	15 mm	600	0 401 536



Abrasive bands and Gesswein®-Holder

These abrasive bands and their holders are a must for every professional workplace. They are tightened by means of the built-in spring and offer absolutely secure adhesion to the holder. The holder itself is made from impact-proof polypropylene and is therefore suitable even for the toughest of applications.

Dimensions	Grit size	Packing quantity	Order No.	Price from 1 pack
Abrasive bands for Gesswein®-Holder				
7 x 330 mm	120	10 pieces	0 401 460	
	240	10 pieces	0 401 461	
	320	10 pieces	0 401 462	
	400	10 pieces	0 401 463	
	600	10 pieces	0 401 464	
13 x 420 mm	120	10 pieces	0 401 465	
	240	10 pieces	0 401 466	
	320	10 pieces	0 401 467	
	400	10 pieces	0 401 426	
	600	10 pieces	0 401 428	
19 x 508 mm	120	10 pieces	0 401 468	
	240	10 pieces	0 401 469	
	320	10 pieces	0 401 470	
	400	10 pieces	0 401 427	
	600	10 pieces	0 401 429	



⚙ Accessories / spare parts



No mix-ups possible

In order to avoid mix-ups, we recommend a separate holder colour for each grit size.

For example:

K 120	Red
K 240	Blue
K 320	Green
K 400	Yellow
K 600	Black

Dimensions	Colour	Order No.	Price from 1 piece
Abrasive band holder			
7 mm	red	0 401 439	
	blue	0 401 440	
	green	0 401 441	
	yellow	0 401 442	
	black	0 401 443	
13 mm	red	0 401 444	
	blue	0 401 445	
	green	0 401 446	
	yellow	0 401 422	
	black	0 401 423	
19 mm	red	0 401 447	
	blue	0 401 448	
	green	0 401 449	
	yellow	0 401 424	
	black	0 401 425	



Micro grinding strip holders and strips

The microfinishing grinding strip holders and strips are the ideal tool for use in the metal, wood and jewellery industries as well as in all areas of very fine finishing. The holder has 3 geometrically different working areas (surface, tip, radius), which make it the ideal tool for finishing. The integrated spring ensures good pretensioning and easy changing of the strips. The individual holders are supplied with a microgrinding strip; spare strips in 8 different grit sizes in packs of 10 pieces each; 3 different sets are also available.

Dimensions	Grit size	Colour	Order No.	Price from 1 piece
Micro grinding strip holders and grinding strips, 160 x 6 mm				
	160 x 6 mm	220 / 60 µm	black	0 415 000
		270 / 50 µm	grey	0 415 001
		320 / 40 µm	red	0 415 002
		400 / 30 µm	green	0 415 003
		600 / 15 µm	orange	0 415 004
		800 / 14 µm	yellow	0 415 005
		1000 / 12 µm	white	0 415 006
		1200 / 9 µm	blue	0 415 007

Accessories / spare parts

Grit size	Packing quantity	Order No.	Price from 1 pack	3 packs	5 packs
Micro replacement grinding strips					
	220 / 60 µm	10 pieces	0 415 010		
	270 / 50 µm	10 pieces	0 415 011		
	320 / 40 µm	10 pieces	0 415 012		
	400 / 30 µm	10 pieces	0 415 013		
	600 / 15 µm	10 pieces	0 415 014		
	800 / 14 µm	10 pieces	0 415 015		
	1000 / 12 µm	10 pieces	0 415 016		
	1200 / 9 µm	10 pieces	0 415 017		

Micro grinding strip holders and strips

 matching set

		Price from	Order No.	1 set	3 set	5 set
Micro grinding strip holders and strips						
	Content: 24-piece, 4 holders incl. grinding strip (grit size 220, 270, 320, 400), 16 replacement strips (4 x grit size 220, 270, 320, 400 each)		0 415 020			
	Content: 24-piece, 4 holders incl. grinding strip (grit size 600, 800, 1000, 1200), 16 replacement strips (4 x grit size 600, 800, 1000, 1200 each)		0 415 021			
	Content: 8 holders incl. grinding strip (grit size 220, 270, 320, 400, 600, 800, 1000, 1200)		0 415 022			



Diamond tools for ultrasonic processing galvanic bonding

Diamond tools, galvanic bonding

These tools are particularly suitable for removing the hard layers caused by erosion machines, for deburring, polishing and lapping and optimally for finishing hard-to-reach corners, slits and joints. By adapting toolholders suitable for all commercial ultrasonic, lapping and polishing systems.

					Price from
	Coating dimensions	Length	Grit size	Thread	Order No.
Diamond tools for ultrasonic processing, galvanic bonding					
flat					
	4 x 1 x 15 mm	44 mm 44 mm 44 mm 37 mm 37 mm 37 mm	200 320 600 200 320 600	M6/fine M6/fine M6/fine M4 M4 M4	0 006 450 0 006 451 0 006 452 0 405 782 0 405 794 0 405 795
	5 x 1 x 40 mm	137 mm 137 mm	320 600	M6/fine M6/fine	0 006 454 0 006 455
flat / conical					
	4 x 0.4/0.8 x 15 mm	44 mm 44 mm 50 mm 50 mm 50 mm	200 320 200 320 600	M4 M4 M6/fine M6/fine M6/fine	0 405 783 0 405 815 0 006 456 0 006 457 0 006 458
round/pointed					
	Ø 3 x 15 mm	34 mm 34 mm	200 320	M4 M4	0 405 786 0 405 787

Diamond tools for ultrasonic processing Metal bonding – sintered

					Price from
	Coating dimensions	Length	Grit size	Thread	Order No.
Diamond tools for ultrasonic processing, metal bondig – sintered					
flat					
	3 x 1 x 10 mm	41 mm 41 mm	200 320	M4 M4	0 405 839 0 405 840
	5 x 1 x 10 mm	41 mm 41 mm	200 320	M4 M4	0 405 847 0 405 848
	6 x 1.5 x 25 mm	34 mm 34 mm	200 320	M4 M4	0 405 796 0 405 797

Ruby stones

Ruby stones

Using our tried and trusted joke FD ruby stones on page 217, you can easily build yourself an ultrasonic tool for very fine deburring work.

In order to do this, simply cut the stones to your desired dimensions and clamp them in the appropriate tool holder (see page 243).

Ruby stones allow you very "soft" work, but nevertheless create sharp edges. Shaping is very readily possible using diamond tools.



You can find the components here:

- Ruby stones joke FD page 223
- Tool holder page 320

Wooden and brass polishing sticks

Material	Shape	Dimensions	Packing quantity	Order No.	Price from 1 pack
Wooden and brass polishing sticks					
hard beech wood	round / cylinder	Ø 3 x 40 mm	10 pieces	0 006 611	
	flat	6 x 3 x 40 mm	10 pieces	0 006 612	
brass	round / cylinder	Ø 3 x 40 mm	5 pieces	0 006 614	

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Tool holder for ultrasonic tools for round and flat tools

Tool holder for receiving round ultrasonic tools, such as polishing sticks or ceramic-fibre files.

Tool support	Profile	Thread	Price from Order No.	1 piece
Tool holder for receiving round tools				
	d = Ø 2 mm	round	M6/fine	0 006 305
	d = Ø 3 mm	squared	M6/fine	0 006 306-E
	d = Ø 2 mm	round	M4	0 405 740
	d = Ø 3 mm	round	M4	0 405 746
	d = Ø 2 mm	round	M6	0 405 750
	d = Ø 3 mm	round	M6	0 405 751
	d = Ø 2 mm	squared	M6 x 0.75	0 405 761
	d = Ø 3 mm	squared	M6 x 0.75	0 405 762



Tool holder for ultrasonic tools for round and flat tools

These holders provide a firm grip for all flat ultrasonic tools, such as ceramic-fibre files or brass sticks.

Tool support	Profile	Thread	Price from Order No.	1 piece
Tool holder for receiving flat tools				
	squared	M4	0 405 742	
	squared	M4	0 405 743	
	squared	M4	0 405 744	
	squared	M4	0 405 745	
	squared	M6	0 405 752	
	squared	M6	0 405 753	
	squared	M6	0 405 754	
	squared	M6	0 405 755	
	squared	M6 x 0,75	0 405 764	
	squared	M6 x 0,75	0 405 765	
	squared	M6 x 0,75	0 405 766	
	squared	M6 x 0,75	0 405 767	
	squared	M6 x 0,75	0 405 768	
	squared	M6/fine	0 006 309	
	round	M6/fine	0 006 310	
	squared	M6/fine	0 006 310-E	
	squared	M6/fine	0 006 311	
	squared	M6/fine	0 006 312	

Adapters for receiving ultrasonic tools

These adapters let you use virtually all ultrasonic tools on the different systems. Find out which threads the individual systems have in the information box below.

Tool support	Design	Thread	Price from Order No.	1 piece
Adapters for receiving ultrasonic tools				
Thread M4	squared	M6	0 405 757	
Thread M6/fine	squared	M6	0 405 758	
Thread M4		M6 x 0.75	0 405 769	
Thread M6/fine		M6 x 0.75	0 405 770	
Thread M4		M8 x 1	0 405 780	
Thread M6/fine		M8 x 1	0 405 781	
Thread M4		M6/fine	0 006 900	



Overview of thread designs of common ultrasonic polishing systems

M 4 e. g. Ultramax UM 2000, Sonofile SF 1000

M 6 e. g. joke 226, UC 550, Roya

**M 6/fein
(M 6 x 0,9)** ENESKAsonic, ENESKA 2-1

M 6 x 0,75 e. g. Ultramax DF and SF, Ultraform UF 5600 and 2600,
Sonotec SF-5600 and SF 2600

M 8 x 1 e. g. Laptron, Ultramax UM 1200