44001 Set of Burrs, HSS Quality (Shank Ø 6 mm)

HSS

LUKAS

Use
For steel and cast steel, alloyed and unalloyed.
Quality
HSS.

Note:
Burr shapes see cat.-no. 44002.

	Set contents
2	**Burrs cylindrical** 6 x 16 / 12 x 25 mm,
1	**Burr helical** 12 x 25 mm,
2	**Burrs spherical** 4 x 3 / 12 x 10 mm,
1	**Burr tear-drop** 12 x 20 mm,
1	**Burr pointed arc** 12 x 30 mm,
1	**Burr flame-shaped** 12 x 30 mm,
1	**Burr lobed** 6 x 20 mm,
1	**Burr pointed taper** 6 x 18 mm.

44001

	Serration	Cutting speed m/min	Type	44001	...
10-piece	3	60 - 180	in the case		201

44002 HSS Burrs (Shank Ø 6 mm)

HSS

LUKAS

Type
Serration 3.
Use
For steel and cast steel, alloyed and unalloyed.
Recommended working speed v_c = 60-180 m/min.

Quality
HSS.

Note:
Available on request:
***Serration 1** = for light metals (long-chipping), light metal alloys, lead, tin, plastics, (theromoplastics & thermosets), fibre, rubber wood.*

***Serration 2** = for light metals (short-chipping), bronze, copper, electrolytic copper, red brass, bronze, zinc, magnesium alloys (electron).*
***Serration 5** = for fine processing of steel and cast steel, alloyed and unalloyed as well as non-lubricating non-ferrous metals.*

ZYA (6 x 16) ZYA (10 x 13) ZYA (12 x 25) ZYA (16 x 25) WRC (6 x 20) WRC (12 x 25)

KUD (4,5 x 4) KUD (8 x 7) KUD (12 x 10) KUD (16 x 14) TRE (16 x 25) SPG (6 x 18)

SPG (12 x 30) SPG (16 x 30) B (12 x 30) beam (6 x 20) KEL (10 x 20) STM (10 x 20) STM (12 x 30)

Serration 1

Serration 2
with chip breaker

44002

Serration 3
with chip breaker

Serration 5

Shape	Head diameter Ø x -length mm	Overall length mm		44002	...
Cylindrical (ZYA)	6 x 16	56			103
Cylindrical (ZYA)	10 x 13	53			105
Cylindrical (ZYA)	12 x 25	65			106
Cylindrical (ZYA)	16 x 25	65			107
Helical (WRC)	6 x 20	60			116
Helical (WRC)	12 x 25	65			119
Spherical (KUD)	4,5 x 4	60			123
Spherical (KUD)	8 x 7	60			126
Spherical (KUD)	12 x 10	60			128
Spherical (KUD)	16 x 14	60		#	129

Shape	Head diameter Ø x -length mm	Overall length mm		44002	...
Tear-drop (TRE)	16 x 25	60			132
Pointed arc (SPG)	6 x 18	58			133
Pointed arc (SPG)	12 x 30	70			136
Pointed arc (SPG)	16 x 30	70			137
Flame-shaped (B)	12 x 30	70		#	140
Lobbed	6 x 20	60			143
Round taper (KEL)	10 x 20	60		#	145
Pointed taper (SKM)	10 x 20	60			152
Pointed taper (SKM)	12 x 30	70			154

Info HSS burrs cat.-no. 44007 - 44044

PFERD

Use recommendations

- HSS burrs must be used at low speeds as compared with carbide burrs.
- For application situations where high speeds are not available.
- For soft materials, HSS burrs are the economical alternative to hard metal burrs.
- The ductility of the -high-performance, high-speed steel (HSS) results in high stability of the tooth cutting edges.

Material groups			Processing case	Serration	Cutting speed
Steel and cast steel materials	Untempered, non heat-treated steels to 1200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, unalloyed steels, case-hardened steels, cast steel	Coarse machining = high stock removal	2	60 - 80 m/min
			Fine machining e.g. deburring	3	60 - 80 m/min
				3	80 - 100 m/min
				5	60 - 80 m/min
	Rust and acid-resistant steels	Austenitic and ferritic high-grade steels	Coarse machining = high stock removal	1	60 - 80 m/min
			Fine machining e.g. deburring	1	80 - 100 m/min
				2	60 - 80 m/min
Non-ferrous metals	Soft non-ferrous metals	Al alloys, brass, copper, zinc	Coarse machining = high stock removal	Al	200 - 300 m/min
				1	200 - 300 m/min
			Fine machining e.g. deburring	2	200 - 250 m/min
Cast iron materials		Grey cast iron, nodular graphite cast iron	Coarse machining = high stock removal	2	60 - 80 m/min
				3	60 - 80 m/min
			Fine machining e.g. deburring	3	80 - 100 m/min
				5	80 - 100 m/min
Others / plastics		Fibre-reinforced thermoplastics and thermoset plastics, rubber, wood	Coarse machining = high stock removal	Al	200 - 300 m/min
				1	200 - 300 m/min
			Fine machining e.g. deburring	1	250 - 300 m/min
				2	200 - 250 m/min

Example:
HSS burr, serration 2,
tool diameter 12 m.
Coarse machining of untempered,
non heat-treated steels.
Cutting speed: 60 - 80 m/min
Rotational speed range: 1,600 - 2,200 rpm

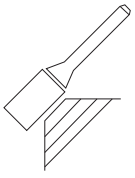
	Cutting speeds m/min					
Ø mm	60	80	100	200	250	300
	rational speed rpm					
1.6	12,000	16,000	19,900	39,800	49,800	59,700
2.3	8,400	11,100	13,900	27,700	34,600	41,600
3.2	6,000	8,000	10,000	19,900	24,900	29,900
4.0	4,800	6,400	8,000	16,000	19,900	23,900
5.0	3,900	5,100	6,400	12,800	16,000	19,100
6.0	3,200	4,300	5,400	10,700	13,300	16,000
7.0	2,800	3,700	4,600	9,100	11,400	13,700
8.0	2,400	3,200	4,000	8,000	10,000	12,000
10.0	2,000	2,600	3,200	6,400	8,000	9,600
12.0	1,600	2,200	2,700	5,400	6,700	8,000
14.0	1,400	1,900	2,300	4,600	5,700	6,900
16.0	1,200	1,600	2,000	4,000	5,000	6,000

44007 - 44010 HSS Burrs Cylindrical (ZYAS)

HSS

PFERD

With face-cutting serration.

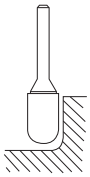

44007 - 44010

Head Ø x -length mm	Total length mm	Shank Ø mm	Serration 1 44007	...	Serration 2 44008	...	Serration 3 44009	...	Serration 5 44010	...
6 x 16	60	6		202	#	202		202	#	202
10 x 13	53	6		204	#	204		204		
12 x 25	65	6		206		206		206	#	206
16 x 25	65	6				207		207		

44012 - 44014 HSS Burrs, Helical (WRC)

HSS

PFERD



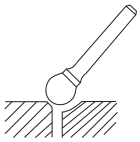

44012 - 44014

Head Ø x -length mm	Total length mm	Shank Ø mm	Serration 1 44012	...	Serration 2 44013	...	Serration 3 44014	...
6 x 16	60	6		202	#	202		202
8 x 20	60	6						203
12 x 25	65	6	#	205		205		205

44019 HSS Burrs, Spherical (KUD)

HSS

PFERD



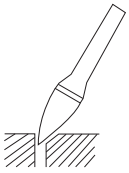

44019

Head Ø x -length mm	Overall length mm	Shank Ø mm	Serration 3 44019	...
8 x 7	55	6		203
12 x 10	51	6		205
16 x 14	54	6	#	206

44027 - 44030 HSS Burrs, Pointed Arc (SPG)

HSS

PFERD




44027 - 44030

Head Ø x -length mm	Total length mm	Shank Ø mm	Serration 1 44027	...	Serration 2 44028	...	Serration 3 44029	...	Serration 5 44030	...
6 x 18	60	6	#	201		201		201	#	201
12 x 30	70	6		204		204		204		
16 x 30	70	6						205		

44034 HSS Burrs, Flame-Shaped (B)

HSS

PFERD

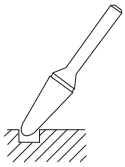

44034

Head Ø x -length mm	Overall length mm	Shank Ø mm	Serration 3 44034	...
12 x 30	70	6		202

44038 - 44039 HSS Burrs, Rounded Taper (KEL)

HSS

PFERD



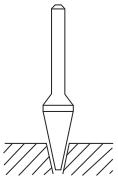
44038 - 44039

Head Ø x -length mm	Total length mm	Shank Ø mm	Serration 2 44038	...	Serration 3 44039	...
10 x 20	60	6	#	201	#	201

44043 - 44044 HSS Burrs, Pointed Taper (STM)

HSS

PFERD



44043 - 44044

Head Ø x -length mm	Total length mm	Shank Ø mm	Serration 2 44043	...	Serration 3 44044	...
10 x 20	60	6		202		202
12 x 25	65	6		203	#	203

Info (Solid) carbide burrs cat.-no. 44093 - 44226

VHM

ATORN®

Type
With straight shank, right-hand helix, right-hand cut.

Serration 2
Recommended cutting speed
Vc = 400 - 800 m/min.

Serration 3 (Al)
Recommended cutting speed
Vc = 600 - 960 m/min.

Serration 5
Increased tooth angle especially for heavy-duty applications, e.g. in the foundry industry, shipyards and in heavy industry.
Recommended cutting speed
Vc = 500 - 960 m/min.
Advantage over serration 6: 40% longer service life.

Serration 6
Multi-purpose use, maximum machining.
Recommended cutting speed
Vc = 500 - 960 m/min.

Serration 6 (TiAlN)
Like serration 6, however longer service life through TiAlN coating.

Note:
Additional dimensions, serration (e.g. diamond tipped serration) and other types (e.g. double-end cutter or burrs with extra long shank) available on request.

Warning:
Always comply with the recommended **cutting speed or working speed** (insufficient rpm is the most frequent cause of tooth break)! Just as important is the selection of the **right shape** (see application diagrams for cat.-no. 44102 **cont.) and the size of the burr.** In order to avoid stronger vibrations, **max. 33%** of the cutting edges should remove stock simultaneously.

Head Ø mm	Working speed max.	Working speed recommended
2	100,000	50,000 - 80,000
3	100,000	50,000 - 75,000
4	100,000	50,000 - 75,000
6	70,000	35,000 - 53,000
8	55,000	28,000 - 42,000
10	50,000	25,000 - 38,000
12	40,000	20,000 - 30,000
15	30,000	15,000 - 23,000
20	20,000	10,000 - 15,000
25	15,000	7,000 - 11,000

Serration	2	3 (Al)	5	6	6 (TiAlN)
					
Application range					
Aluminium, Al alloys	-	x	-	-	-
Bronze, copper, brass	x	-	-	-	-
Carbon	-	-	-	-	-
Fibreglass	-	x	-	-	-
Cast iron	x	-	x	x	x
Hard rubber	-	x	-	-	-
HSS-E (Co)	x	-	-	x	x
Plastics	-	x	-	-	-
Magnesium, alloys	-	-	-	-	-
Stainless steels	x	-	-	x	x
Weld seams	x	-	x	x	x
High-strength steels	x	-	-	x	x
Steel, nickel-chromium	x	-	-	x	x
Titanium alloys	x	-	-	x	x
Zinc alloys	-	x	-	-	-

Burrs with extra-long shank available on request

44093 Solid carbide burrs set (shank Ø 3 mm)

VHM

ATORN®

Type
Dimensions = Head Ø x head length mm.

	Set contents 44093 101
	Serration 2
1	**Burr cylindrical** 3 x 12 mm,
1	**Burr helical** 3 x 12 mm,
1	**Burr spherical** 3 x 3 mm,
1	**Burr tear-drop** 3 x 6 mm,
1	**Burr round arc** 3 x 12 mm,
1	**Burr pointed arc** 3 x 12 mm,
1	**Burr flame-shaped** 3 x 6 mm,
1	**Burr round taper** 3 x 12 mm,
1	**Burr pointed taper** 3 x 11 mm,
1	**Burr angled** 3 x 3 mm.

	Set contents 44093 102
	Serration 2
of each 2	**Burrs cylindrical** 3 x 12 mm,
of each 2	**Burrs helical** 3 x 12 mm,
of each 2	**Burrs spherical** 3 x 3 mm,
of each 2	**Burrs tear-drop** 3 x 6 mm,
of each 2	**Burrs round arc** 3 x 12 mm,
	Serration 6
of each 2	**Burrs cylindrical** 3 x 12 mm,
of each 2	**Burrs helical** 3 x 12 mm,
of each 2	**Burrs spherical** 3 x 3 mm,
of each 2	**Burrs tear-drop** 3 x 6 mm,
of each 2	**Burrs round arc** 3 x 12 mm.

Contents	Serration	Type	44093	...
10-piece	2	in case		101
20-piece	2 und 6	in case		102

44093 101

44096 Solid Carbide/Carbide Burr Set (Shank Ø 6 mm)

VHM

ATORN®

Type
Dimensions = Head Ø x head length mm.

	Set contents 44096 101
	Serration 3 (aluminium)
1	**Burr cylindrical** 12 x 25 mm,
1	**Burr helical** 12 x 25 mm,
1	**Burr round arc** 12 x 25 mm,
1	**Burr round taper** 12 x 28 mm.

	Set contents 44096 104
	Serration 6
1	**Burr cylindrical** 6 x 18 mm,
1	**Burr helical** 6 x 18 mm,
1	**Burr spherical** 6 x 6 mm,
1	**Burr tear-drop** 6 x 10 mm,
1	**Burr round arc** 6 x 18 mm,
1	**Burr pointed arc** 6 x 18 mm.

	Set contents 44096 107
	Serration 5
1	**Burr cylindrical** 12 x 25 mm,
1	**Burr helical** 12 x 25 mm,
1	**Burr round arc** 12 x 25 mm,
1	**Burr pointed arc** 12 x 25 mm,
1	**Burr round taper** 12 x 28 mm.

	Set contents 44096 105
	Serration 6
1	**Burr cylindrical** 12 x 25 mm,
2	**Burrs helical** 10 x 20 / 12 x 25 mm,
1	**Burr spherical** 12 x 12 mm,
1	**Burr tear-drop** 10 x 15 mm,
2	**Burrs round arc** 10 x 20 / 12 x 25 mm,
1	**Burr pointed arc** 10 x 20 mm.

	Set contents 44096 102
	Serration 6
1	**Burr cylindrical** 10 x 20 mm,
1	**Burr helical** 10 x 20 mm,
1	**Burr round arc** 10 x 20 mm,
1	**Burr pointed arc** 10 x 20 mm.

	Set contents 44096 108
	Serration 6
2	**Burrs cylindrical** 10 x 20 / 12 x 25 mm,
2	**Burrs helical** 10 x 20 / 12 x 25 mm,
1	**Burr spherical** 12 x 10 mm,
1	**Burr tear-drop** 10 x 16 mm,
1	**Burr round arc** 12 x 25 mm,
2	**Burrs pointed arc** 10 x 20 / 12 x 25 m,
1	**Burr round taper** 12 x 30 mm.

	Set contents 44096 103
	Serration 6
1	**Burr cylindrical** 12 x 25 mm,
1	**Burr helical** 12 x 25 mm,
1	**Burr round arc** 12 x 25 mm,
1	**Burr pointed arc** 12 x 25 mm.

	Set contents 44096 106
	Serration 6 TiAlN
1	**Burr cylindrical** 10 x 20 mm,
1	**Burr helical** 12 x 25 mm,
1	**Burr round arc** 12 x 25 mm,
1	**Burr pointed arc** 10 x 20 mm,
1	**Burr round taper** 12 x 28 mm.

Contents	Serration	Coating	Type	44096	...
4-piece	(Al) 3	-	in case		101
5-piece	5	-	in case		107
4-piece	6	-	in case		102
4-piece	6	-	in case	#	103
6-piece	6	-	in case		104
8-piece	6	-	in case		105
10-piece	6	-	in case		108 NEW
5-piece	6	TiAlN	in case		106

44096 107

44096 105

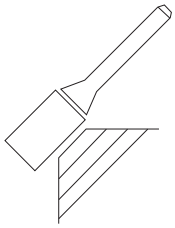
44096 106

44102 - 44106 Solid Carbide / Carbide Burrs, Cylindrical (ZYA)

VHM

ATORN®

44102 - 44106



		Serration 2		Serration 3 (Al)		Serration 6	
Head Ø x -length mm	Shank Ø mm	44102	...	44103	...	44106	...
3 x 14	3		102				102
6 x 5	3	#	103			#	103
6 x 12	3		104				104
6 x 18	6		106	#	106		106
8 x 20	6		107	#	107		107
10 x 20	6		109		109		109
12 x 25	6		113	#	113		113
15 x 25	6		114	#	114		114
15 x 25	8	#	121	#	121	#	121

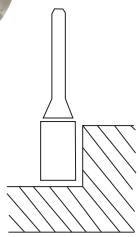
44115 - 44117 Solid Carbide / Carbide Burrs, Cylindrical (ZYA-S)

VHM

ATORN®

With face-cutting serration.

44115 - 44117



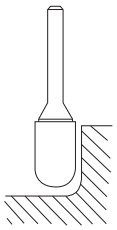
		Serration 5		Serration 6		Serration 6/TiAlN	
Head Ø x -length mm	Shank Ø mm	44115	...	44116	...	44117	...
6 x 18	6				106		
8 x 20	6				107		
10 x 20	6				109		109
12 x 25	6		112		112		

44122 - 44127 Solid Carbide / Carbide Burrs, Helical (WRC)

VHM

ATORN®

44122 - 44127



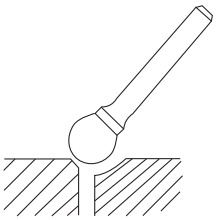
		Serration 2		Serration 3 (Al)		Serration 5		Serration 6		Serration 6/TiAlN	
Head Ø x -length mm	Shank Ø mm	44122	...	44123	...	44125	...	44126	...	44127	...
2 x 11	3	#	101						101		
3 x 12	3		102						102		
6 x 12	3		104						104		
6 x 18	6		106		106				106		
8 x 20	6		107						107		
10 x 20	6		108	#	108				108		
12 x 25	6		111		111		111		111		111
15 x 25	6								113		
12 x 25	8								118		
15 x 25	8							#	120		

44132 - 44136 Solid Carbide / Carbide Burrs, Spherical (KUD)

VHM

ATORN®

44132 - 44136



		Serration 2		Serration 3 (Al)		Serration 6	
Head Ø x -length mm	Shank Ø mm	44132	...	44133	...	44136	...
3 x 3	3		102				102
4 x 4	3		103				103
6 x 6	3		104				104
6 x 6	6		106				106
8 x 8	6		107				107
10 x 10	6	#	108		108		108
12 x 12	6		109	#	109		109
15 x 15	6		110	#	110		110

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

44142 - 44146 Solid Carbide / Carbide Burrs, Tear-Drop (TRE)

VHM

ATORN®

Head Ø x -length mm	Shank Ø mm	Serration 2		Serration 3 (Al)		Serration 6	
		44142	...	44143	...	44146	...
3 x 6	3	#	101			#	101
6 x 10	3	#	102			#	102
6 x 10	6	#	103				103
8 x 15	6	#	104				104
10 x 15	6	#	105				105
12 x 20	6		106	#	106		106
15 x 25	6	#	107				107
15 x 25	8	#	111	#	111		

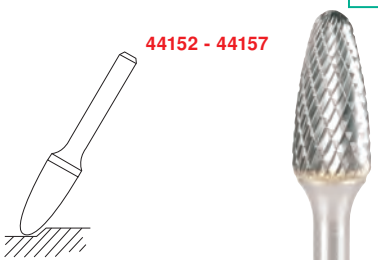
44142 - 44146

44152 - 44157 Solid Carbide / Carbide Burrs, Round Arc (RBF)

VHM

ATORN®

44152 - 44157



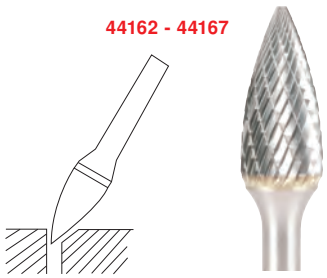
Head Ø x -length mm	Shank Ø mm	Serration 2		Serration 3 (Al)		Serration 5		Serration 6		Serration 6/TiAlN	
		44152	...	44153	...	44155	...	44156	...	44157	...
3 x 8	3	#	101						101		
3 x 12	3		102						102		
6 x 12	3		103						103		
6 x 18	6		104						104		
8 x 20	6	#	105	#	105				105		
10 x 20	6		106	#	106				106		
12 x 25	6		108		108		108		108	#	108
15 x 25	6	#	110	#	110				110		
12 x 25	8		116	#	116			#	116		

44162 - 44167 Solid Carbide / Carbide Burrs, Pointed Arc (SPG)

VHM

ATORN®

44162 - 44167



Head Ø x -length mm	Shank Ø mm	Serration 2			Serration 5		Serration 6		Serration 6/TiAlN	
		44162	...	44165	...	44166	...	44167	...	
3 x 6	3	#	101				101			
3 x 12	3		102				102			
6 x 12	3		103				103			
6 x 18	6		104				104			
8 x 20	6	#	105				105			
10 x 20	6	#	106				106		106	
12 x 25	6		108		108		108			
15 x 25	6		110			#	110			
12 x 25	8					#	116			

44172 - 44176 Solid Carbide / Carbide Burrs, Flame-Shaped (H)

VHM

ATORN®

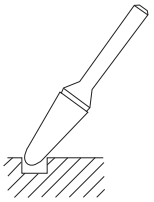
44172 - 44176

Head Ø x -length mm	Shank Ø mm	Serration 2		Serration 6	
		44172	...	44176	...
3 x 6	3		101		101
8 x 20	6	#	102		102
12 x 32	6	#	103		103
15 x 35	8	#	107	#	107

44182 - 44187 Solid Carbide / Carbide Burrs, Rounded Taper (KEL)

VHM

ATORN®



44182 - 44187

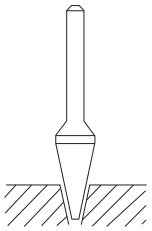
		Serration 2		Serration 3 (Al)		Serration 5		Serration 6		Serration 6/TiAlN	
Head Ø x -length mm	Shank Ø mm	44182	...	44183	...	44185	...	44186	...	44187	...
3 x 12	3		101						101		
6 x 18	6	#	103						103		
10 x 26	6		105	#	105				105		
12 x 28	6		106	#	106		106		106		106
15 x 33	6	#	107	#	107				107		

44192 - 44196 Solid Carbide / Carbide Burrs, Countersink (STM)

VHM

ATORN®

44192 - 44196



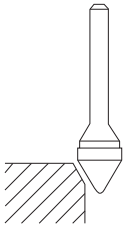
		Serration 2		Serration 6	
Head Ø x -length mm	Shank Ø mm	44192	...	44196	...
3 x 8	3		101	#	101
3 x 11	3		102		102
3 x 15	3		103		103
6 x 12	3		104		104
6 x 20	6		105		105
10 x 20	6		106		106
12 x 25	6	#	107		107
16 x 25	6	#	108		108

44202 - 44206 Solid Carbide / Carbide Burrs, Countersink 60° (KSJ)

VHM

ATORN®

44202 - 44206



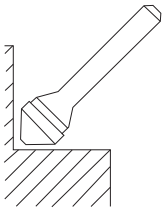
		Serration 2		Serration 6	
Head Ø x -length mm	Shank Ø mm	44202	...	44206	...
3 x 2,5	3	#	101		101
6 x 4	6	#	102	#	102
10 x 8	6	#	103		103
12 x 11	6	#	104	#	104
15 x 14	6		105	#	105

44212 - 44216 Solid Carbide / Carbide Burrs, Countersink 90° (KSK)

VHM

ATORN®

44212 - 44216



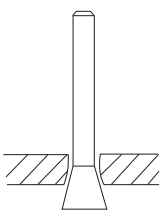
		Serration 2		Serration 6	
Head Ø x -length mm	Shank Ø mm	44212	...	44216	...
3 x 1,5	3	#	101		101
6 x 3	6	#	102		102
10 x 5	6		103		103
12 x 6	6	#	104		104
15 x 8	6		105		105

44222 - 44226 Solid Carbide / Carbide Angle Burrs (WKN)

VHM

ATORN®

44222 - 44226



		Serration 2		Serration 6	
Head Ø x -length mm	Shank Ø mm	44222	...	44226	...
3 x 4	3	#	101		101
6 x 6	3	#	102		102
10 x 10	6				104
12 x 12	6	#	105		

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

PFERD

With PFERD carbide burrs materials of almost any strength can be machined. This is possible through the optimal match of tooth shape, number of teeth, angle of twist, angle of rake and concentricity. The precise concentricity of PFERD carbide burrs
- protects the operator's health during the work procedure,
- reduces wear of the drive unit,
- allows chatter-free work,
- prevents chatter marks.

The high dimensional stability of the carbide burrs enables
- use on robots and
- multiple re-sharpenings.

Implementation principle:
The harder the material, the finer the serration.

Note:
Other dimensions and serrations, as well as carbide burrs with special shank shapes and -lengths and special serrations available on request.

Serration aluminium | **Serration 1** | **Serration 3 PLUS** | **Serration 4** | **Serration 5**

Material groups			Processing case	Serration	Cutting speed
Steel and cast steel materials	Untempered, non heat-treated steels to 1200 N/mm² (<38 HRC)	Construction steels, carbon steels, tool steels, unalloyed steels, case-hardened steels, cast steel	Coarse machining = high stock removal	1	600 - 900 m/min
				3PLUS	450 - 600 m/min
	Tempered, heat-treated steels over 1200 N/mm² (>38 HRC)	Tool steels, tempered steels, alloy steels, cast steels	Coarse machining = high stock removal	3PLUS	250 - 350 m/min
				4	250 - 350 m/min
				5	400 m/min
Stainless steels	Rust and acid-resistant steels	Austenitic and ferritic high-grade steels	Coarse machining = high stock removal	1	300 - 450 m/min
				3PLUS	250 - 350 m/min
			Fine machining e.g. deburring	4	250 - 350 m/min
				5	350 - 450 m/min
Non-ferrous metals	Soft non-ferrous metals	Al alloys, brass, copper, zinc	Coarse machining = high stock removal	Al	600 - 900 m/min
				1	600 - 900 m/min
			Fine machining e.g. deburring	Al	800 - 900 m/min
	Hard non-ferrous metals	Bronze, titanium/titanium alloys, extremely hard Al alloys (high Si-proportion)	Coarse machining = high stock removal	4	250 - 350 m/min
	Materials with very high-temperature strength	Nickel-based alloys, Ni-Co alloys (jet engine and turbine construction)	Coarse machining = high stock removal	3PLUS	300 - 450 m/min
				4	300 - 450 m/min
			Fine machining e.g. deburring	5	350 - 500 m/min
Cast iron materials		Grey cast iron, nodular graphite cast iron	Coarse machining = high stock removal	1	600 - 900 m/min
				3PLUS	450 - 600 m/min
Others / plastics		Fibre-reinforced thermoplastics and thermoset plastics, hard rubber	Coarse machining = high stock removal	Al	500 - 900 m/min
			Fine machining e.g. deburring	Al	500 - 900 m/min

Example:
Carbide burr, serration 3 PLUS,
tool diameter 12 m.
Coarse machining of untempered,
non heat-treated steels.
Cutting speed: 450 - 600 m/min
Rotational speed range: 12,000 - 16, 000 rpm

	Cutting speeds m/min							
Ø mm	250	300	350	400	450	500	600	900
	rotational speed rpm							
2	40,000	48,000	56,000	64,000	72,000	80,000	95,000	143,000
3	27,000	32,000	37,000	42,000	48,000	53,000	64,000	95,000
4	20,000	24,000	28,000	32,000	36,000	40,000	48,000	72,000
6	13,000	16,000	19,000	21,000	24,000	27,000	32,000	48,000
8	10,000	12,000	14,000	16,000	18,000	20,000	24,000	36,000
10	8,000	10,000	11,000	13,000	14,000	16,000	19,000	29,000
12	7,000	8,000	9,000	11,000	12,000	13,000	16,000	24,000
16	5,000	6,000	7,000	8,000	9,000	10,000	12,000	18,000
20	4,000	5,000	6,000	6,000	7,000	8,000	10,000	14,000
25	3,000	4,000	4,000	5,000	6,000	6,000	8,000	11,000

Carbide Burrs

44233 Sets of Burrs, Carbide Quality (Shank Ø 3 mm)

HM

PFERD

Type
Dimensions = Head Ø x head length mm.

	Set contents
4	**Burrs cylindrical** 2 x 10 / 3 x 13 / 6 x 7 / 6 x 13 mm,
1	**Burr flame-shaped** 3 x 7 mm,
2	**Burrs helical** 2 x 10 / 3 x 13 mm,
1	**Burr angled** 3 x 7 mm,
2	**Burrs tear-drop** 3 x 7 / 6 x 10 mm,
1	**Burr spherical** 4 x 3 mm,
1	**Burr pointed taper** 6 x 13 mm,
2	**Burrs round arc** 3 x 7 / 6 x 13 mm,
1	**Burr pointed arc** 3 x 7.

44233

Contents	Serration	Type	44233	...
15-piece	5	in transparent box		101

44234 Sets of Burrs, Carbide Quality (Shank Ø 6 mm)

HM

PFERD

Type
High chip removal capacity thanks to aggressive teeth geometry, long service life.
Dimensions = Head Ø x head length mm.
Use
For structural steel, structural steel, non-ferrous metals For quick, aggressive metal cutting applications on surfaces and in solid stock. Special gripping capacity in edge use, e.g. when deburring. Exceptionally well suited for working on welds.

	Set contents
2	**Burrs cylindrical** 6 x 16 / 12 x 25 mm,
2	**Burrs spherical** 10 x 9 / 12 x 10 mm,
2	**Burrs helical** 6 x 18 / 12 x 25 mm,
2	**Burrs pointed arc** 6 x 18 / 12 x 25 mm,
1	**Burr round arc** 6 x 18 mm,
1	**Burr round taper** 12 x 30 mm.

44234

Contents	Serration	Cutting speed m/min	Type	44234	...
10-piece	Combi cut	450 - 700	in plastic box		101

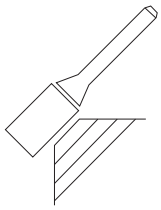
44238 - 44240 Carbide Burrs, Cylindrical (ZYA)

HM

PFERD

ISO 7755/2+DIN 8033-2.

44238 - 44240



			Serration 3 Plus		Serration 4		Serration 5	
Head Ø x -length mm	Shank Ø mm	Total length mm	44238	...	44239	...	44240	...
6 x 16	6	55		106		106	#	106
8 x 20	6	60		107	#	107		
10 x 20	6	60	#	109		109		
12 x 25	6	65		111	#	111		
16 x 25	6	65	#	113	#	113		

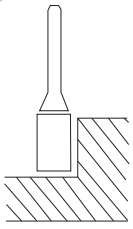
44243 - 44245 Carbide Burrs, Cylindrical (ZYA-S)

HM

PFERD

ISO 7755/2+DIN 8033-2.
With face-cutting serration.

44243 - 44245



			Serration 3 Plus		Serration 5	
Head Ø x -length mm	Shank Ø mm	Total length mm	44243	...	44245	...
2 x 10	3	40		101	#	101
3 x 13	3	43		102		102
4 x 13	6	55	#	103	#	103
6 x 13	3	43		105		105
6 x 16	6	55		106		106
8 x 20	6	60		107		
10 x 20	6	60		109		
12 x 25	6	65		111		

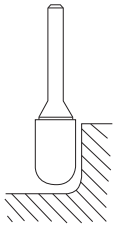
44250 - 44252 Carbide Burrs, Helical (WRC)

HM

PFERD

ISO 7755/3+DIN 8033-3.

44250 - 44252



			Serration 3 Plus		Serration 4		Serration 5	
Head Ø x -length mm	Shank Ø mm	Total length mm	44250	...	44251	...	44252	...
2 x 10	3	40	#	101	#	101		
3 x 13	3	43		102		102		102
6 x 13	3	43		104	#	104	#	104
6 x 16	6	55		105		105	#	105
8 x 20	6	60		107	#	107		
10 x 20	6	60		109		109		
12 x 25	6	65		113		113		

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= partly extent in stock.

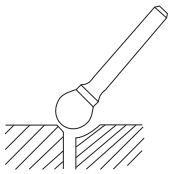
44257 - 44259 Carbide Burrs, Spherical (KUD)

HM

PFERD

ISO 7755/4+DIN 8033-8.

44257 - 44259



Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 3 Plus 44257	...	Serration 4 44258	...	Serration 5 44259	...
3 x 2	3	33		101	#	101		101
4 x 3	3	34		102	#	102	#	102
6 x 5	3	35		104	#	104		104
6 x 5	6	45	#	105	#	105		105
8 x 7	6	47		106	#	106	#	106
10 x 9	6	49	#	107	#	107		
12 x 10	6	51	#	108	#	108		

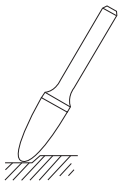
44263 - 44265 Carbide Burrs, Round Arc (RBF)

HM

PFERD

DIN 8033-10.

44263 - 44265



Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 3 Plus 44263	...	Serration 5 44265	...
6 x 13	3	43		102		102

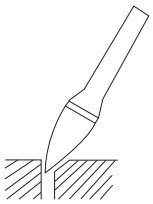
44268 - 44270 Carbide Burrs, Pointed Arc (SPG)

HM

PFERD

ISO 7755/7+DIN 8033-9.

44268 - 44270



Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 3 Plus 44268	...	Serration 4 44269	...	Serration 5 44270	...
3 x 13	3	43		102	#	102		102
6 x 13	3	43		103		103		103
6 x 18	6	55		104	#	104		104
10 x 20	6	60	#	105	#	105		
12 x 25	6	65	#	107	#	107		
16 x 25	6	70	#	111	#	111		

44272 - 44273 Carbide Burrs, Flame-Shaped (B)

HM

PFERD

44272 - 44273

Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 3 Plus 44272	...	Serration 5 44273	...
6 x 13	3	43				102
12 x 30	6	70		104		

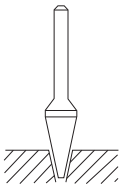
44283 - 44285 Carbide Burrs, Pointed Taper (STM)

HM

PFERD

ISO 7755/11+DIN 8033-4.

44283 - 44285



Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 3 Plus 44283	...	Serration 5 44285	...
6 x 13	3	43		103		103
6 x 18	6	55		104		104
10 x 20	6	60		105		
12 x 25	6	65		106		

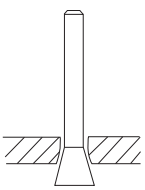
44289 Carbide Angle Burrs (WKN)

HM

PFERD

ISO 7755/12+DIN 8033-7.
With face-cutting serration.

44289



Head Ø x -length mm	Shank Ø mm	Total length mm	Serration 5 44289	...
3 x 7	3	37		101

44293 - 44294 Carbide Burrs for GRP and CFRP

HM

PFERD

Use
For the processing of
- GRP (glass-fibre reinforced plastics)
- CFRP (carbon-fibre reinforced plastics)

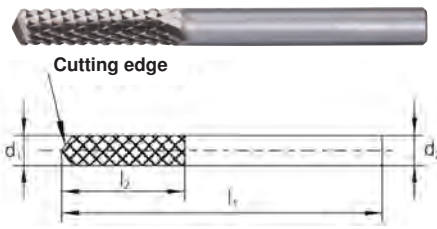
Serration FVK
Coarse metal cutting applications = high stock removal
Preferred for edging and contour milling of fibre-reinforced plastics GRP and CFRP, suitable for hard rubber and thermoplastics. Can be used on machine tools and manual implementation due to the high concentricity.

Serration FVKS
Fine machining = less material removal
Similar to serration FVK. Due to the special tooth design, suitable for use on machines and robots with high feed rates, quite milling behaviour, generates a smooth cut edge.

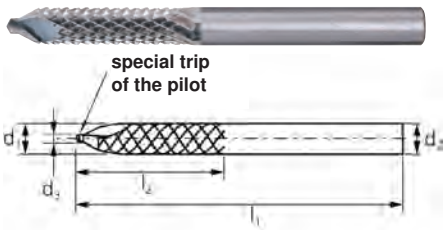
44293
Use
The special **cutting edge of the drill bit (BS)** enables plunging into solid material, i.e. drilling and milling in one work step.

44294
Use
The special **tip of the pilot drill bit (ZBS)** enables plunging into solid material, i.e. drilling and milling in one work step. It is especially suited for manual use. The tip of the pilot drill bit allows safe pre-drilling under virtually all surface conditions.

44293



44294



Serration	d_2 mm	d_3 mm	$d_1 \times l_2$ mm	l_1 mm	speed RPM at 500 m/min*	speed RPM at 900 m/min*	with BS 44293	...	with ZBS 44294	...
FVK	6	-	6 x 25	65	27.000	48.000	#	101		
FVK	6	2,5	6 x 30	65	27.000	48.000			#	101
FVK	8	-	8 x 25	65	20.000	36.000	#	102		
FVK	8	3,0	8 x 30	65	20.000	36.000			#	102
FVKS	6	-	6 x 25	65	27.000	48.000	#	201		
FVKS	6	2,5	6 x 30	65	27.000	48.000			#	201
FVKS	8	-	8 x 25	65	20.000	36.000	#	202		
FVKS	8	3,0	8 x 30	65	20.000	36.000			#	202

*Cutting speed

44299 Extensions for drive spindles

PFERD

Use
- With spindle extensions, the shanks of grinding and milling tools can be extended
- They enable use on hard-to-reach places
- The extension for drive spindles is clamped into the collet of the machine (compressed air or electric drive) or into the handpiece of the flexible shaft
- Spindle extensions are an economical alternative to special manufacturing of burrs and grinding points with long shaft

Safety advice:
Attention! When using spindle extensions, the relevant safety regulations and the accident prevention regulations must be complied with.
For tasks with large shaft lengths it is strictly necessary to introduce the tool into the workpiece (e.g. bores, tubes, channels or grooves) before switching on the drive unit. Under no circumstances should the extension with tool run free outside of the workpiece.

There is increased danger if this instruction is not complied with! Under unfavourable boundary conditions there is a possibility of snapping off the extension with clamped in tool. **The extension is only for suitable for manual** use in conjunction with suitable compressed air/electrical drive units or flexible shaft handpieces for tools with **standard shanks.** In combination with a appropriate tool that is approved for the speed, it is accommodated in the chatter-free collet of the devices. It must not be clamped in on the transition radius under any circumstances.
The clamping in of a second extension or of tools with over-long shanks is prohibited.

44299 101

44299 102

44299 103

44299 104

44299 105

44299 106

44299 107

Max. permissible speed RPM	Trunnion mount (motor/handpiece) Ø mm	Tool-receptacle mm	total-length mm	Trunnion mount Length mm	Spindle Ø max. mm	incl. collet chuck Ø mm	44299	...
44.000	8	3	78	30	9,5	3	#	101
20.000	SPG 6	6	104	Special	12,0	6	#	102
20.000	8	6	120	30	12,0	6	#	103
20.000	SPG 6	6	129	Special	12,0	6	#	104
20.000	8	6	144	30	12,0	6	#	105
10.000	6	3	150	30	11,5	-	#	106
10.000	8	6	150	30	13,5	-		107

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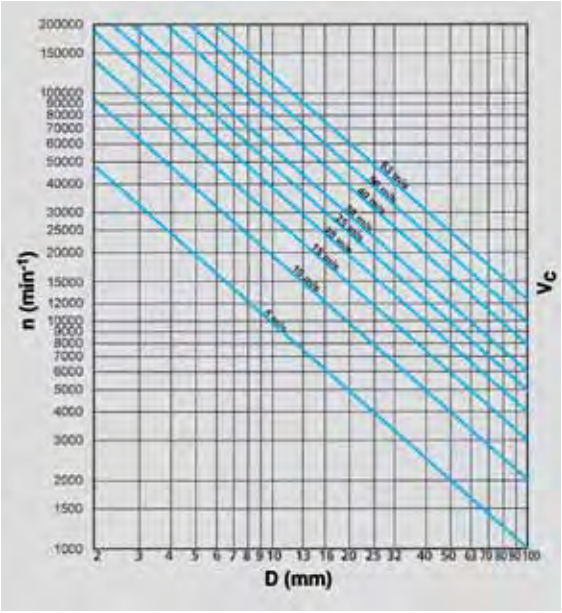
= partly extent in stock.

Info — Grinding points EN 12413 cat.-no. 44300 - 44355

The grinding points are characterised by constant, superior material removal performance and long service life and achieve a high surface quality on the workpiece. The precise concentricity prevents chatter marks, enables quiet operation, reduces the load of drive system and ensures an improved protection of the operator's safety and health. The grinding points are especially suited for the shown applications (see table), because of grit type, grit size, hardness and bonding. They can be used universally for **grinding edges and surfaces**.

Abrasive	**Special corundum (NDW)**	**White corundum (EK)**	**Corundum mix (HK)**
for material of	**hardened**	**Steel, cast-iron**	**Steel, cast-iron, non-ferrous metals**
	Tool steel		**Plastics (hard) GRP**
Grit (from - to)	Fine (grit 100)	Fine (grit 46-100) to	
		Coarse (grit 24-60)*	Coarse (grit 24-60)
Hardness	Hard/very hard	Medium	Soft/medium
Bonding	Ceramic	Ceramic	Ceramic/artificial resin
V = m/s (edge grinding)	approx. 10-30	approx. 25-40	approx. 30-50
V = m/s (surface grinding)	approx. 10-30	approx. 15-25	approx. 25-35
Use	Grinding	Grinding	Grinding
Cat.-no.	44300 - 44304	44305 - 44342	44350 - 44355

*The larger the grinding point, the coarser the grit
V = m/s: Recommended peripheral speed in m/s



Recommended peripheral speeds
In the diagram, the peripheral speeds are represented by the blue diagonal lines.
The perpendicular line appropriate for the tool meets the diagonal line for the specified peripheral speed. From this point the rpm for the grinding tool and machine are read out in rpm in the horizontal line on the left edge.
Example:
- grinding point Ø 20 mm,
- recommended peripheral speed 15 - 40 m/s,
- rpm: 14,000 - 38,000 rpm.

For materials that are difficult to machine, **lower peripheral speeds are** recommended, because lower speeds increase the abrasive capacity of the grinding point.

n = rpm
D = tool diameter
Vc = peripheral speed

44300 — Mounted Grinding Point Assortment NDW (Shank Ø 3 mm)

LUKAS

Type
Dimensions = Ø x height. Outstanding dimensional stability, high edge strength, optimal machining values, long service life.

Use
For die and tool making, especially suitable for fine-grinding and deburring, edge working, hardened steel.
Quality
Composition:
N = brown corundum,
D = high-grade corundum dark-red,
W = single-crystal corundum white.

44300

	Set contents
4	**Grinding points cylindrical** 4 x 8 / 6 x 10 / 8 x 10 / 10 x 13 mm,
2	**Grinding points pointed arc** 5 x 10 / 8 x 10 mm,
3	**Grinding points spherical** 4 x 4 / 6 x 6 / 8 x 8 mm,
1	**Grinding point helical** 10 x 13 mm.

Contents	Shank length mm	Cutting speed m/s	Type	44300	...
10-piece	50	10 - 30	in the case		101

Grinding points

44301 - 44304 Grinding Points NDW (Shank Ø 3 mm)

LUKAS

Type
Extraordinary stability, great edge strength, perfect operation width, long service life, recommended working speed 10-30 m/s Length of shank 50 mm.
Use
For die and tool making, especially suitable for fine-grinding and deburring, edge working, hardened steel.

Quality
Composition:
N = normal corundum,
D = high-grade corundum, dark-red
W = single crystal carborundum, white.

44301
Cylindrical.

44303
Spherical.

44302
Pointed arc.

44304
Helical.

44301 44303


44302 44304


Ø x height mm	Cylindrical 44301	...	Pointed arc 44302	...	Spherical 44303	...	Helical 44304	...
4 x 4						101		
4 x 8		102						
5 x 10				101				
6 x 6						102		
6 x 10		103						
8 x 8						103		
8 x 10		105		102				
10 x 13		108						101

44305 Mounted Grinding Point Assortment EK (Shank Ø 3 mm)

PFERD

Type
Dimensions = Ø x height.
Quality
High-grade carborundum, pink.

	Set contents
11	**Grinding points cylindrical** 4 x 8 / 5 x 10 / 5 x 10 / 6 x 13 / 8 x 2 / 8 x 10 / 8 x 10 / 10 x 13 / 13 x 3 / 16 x 4 / 16 x 4 mm,
2	**Grinding points pointed arc** 3 x 6 / 8 x 16 mm,
1	**Grinding point helical** 5 x 10 mm,
1	**Grinding point spherical** Ø 5 mm.

44305

Contents	Grit	Type	44305	...
15-piece	Fine	in box		101

44310 - 44315 Grinding Points EK (Shank Ø 3 mm)

LUKAS

44310
Cylindrical.

44315
Spherical.

Quality
High-grade carborundum, pink.

44310 44315


Ø x height mm	Ø mm	Cylindrical 44310	...	Spherical 44315	...
4 x 8	-		105		
5 x 10	-		106		
6 x 10	-		107		
8 x 16	-		109		
-	6				101
-	8				102
-	13				104

44317 Mounted Grinding Points, Cylindrical EK (Shank Ø 3 mm)

PFERD

Quality
High-grade carborundum, pink.

44317

Ø x height mm	Grit		44317	...
4 x 8	coarse 60	10 pcs.		104
4 x 8	Fine 100	10 pcs.		105
5 x 10	coarse 60	10 pcs.	#	106
5 x 10	Fine 100	10 pcs.		107
6 x 13	coarse 60	10 pcs.		109
6 x 13	fine 100	10 pcs.		110
8 x 16	Coarse 46	10 pcs.		115
8 x 16	Fine 80	10 pcs.		116

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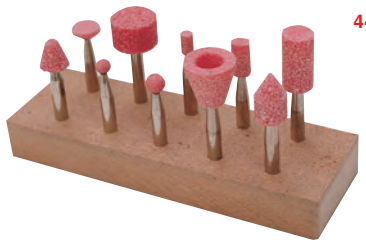
= partly extent in stock.

44320 Mounted Grinding Points Assortment EK (Shank Ø 6 mm)

LUKAS

Type
Dimensions = Ø x height.
Quality
High-grade carborundum, pink.

	Set contents
5	**Grinding points cylindrical** 5 x 10 / 8 x 16 / 13 x 3 / 13 x 25 / 20 x 13 mm,
1	**Grinding point pointed taper** 13 x 13 mm,
2	**Grinding points spherical** Ø 6 / 8 mm,
1	**Grinding point cupped, conical** 20 x 19,5 mm,
1	**Grinding point centre 60°** 13 x 20 mm.



44320

Contents	Type	44320 ...
10-piece	in wooden stand	101

44322 Mounted Grinding Points Assortment EK (Shank Ø 6 mm)

PFERD

Type
Dimensions = Ø x height.
Quality
High-grade carborundum, pink.

	Set contents
5	**Grinding points cylindrical** 10 x 13 / 13 x 20 / 20 x 6 / 20 x 13 / 20 x 25 mm,
1	**Grinding point spherical** Ø 16 mm,
1	**Grinding point helical** 20 x 25 mm,
1	**Grinding point pointed arc** 13 x 20 mm,
2	**Grinding points taper** 20 x 20 / 20 x 32 mm.

44322

Contents	Grit	Type	44322 ...
10-piece	Coarse	in box	101

44325 Mounted Grinding Points, Cylindrical Point EK (Shank Ø 6 mm)

LUKAS

Quality
High-grade carborundum, pink.

44325

Ø x height mm	44325 ...
4 x 8	103
5 x 10	104
6 x 10	105
8 x 16	107
10 x 20	111
10 x 32	112
13 x 3	# 114
13 x 20	116

Ø x height mm	44325 ...
13 x 25	# 117
16 x 4	# 119
16 x 20	121
16 x 32	122
16 x 40	# 123
20 x 6	124
20 x 40	129
25 x 10	131

Ø x height mm	44325 ...
25 x 32	134
32 x 8	135
32 x 20	136
32 x 40	138
40 x 10	139
40 x 20	140
50 x 10	142
50 x 20	143

44326 Cylindrical grinding points SiC-aluminium (Shank Ø 6 mm)

LUKAS

Use
Especially for machining non-ferrous metal.
For deburring, cleaning, rework, and finishing.
Through its special micro-structure design, maximum service life is achieved and it prevents the pores from clogging. The grinding points have a special impregnation which promotes self-sharpening.
Quality
Silicon carbide, green.

44326

Ø x height mm	Grit	44326 ...
10 x 13	80	# 106
10 x 20	80	107
13 x 32	80	# 109

Ø x height mm	Grit	44326 ...
16 x 32	80	# 111
20 x 20	80	112
20 x 40	80	# 114

Ø x height mm	Grit	44326 ...
40 x 20	80	# 116

44327 Mounted Grinding Points, Cylindrical Point EK (Shank Ø 6 mm)

PFERD

Quality
High-grade carborundum, pink.

44327

Ø x height mm	Grit	44327 ...
4 x 8	Coarse 60	# 103
4 x 8	Fine 100	# 104
5 x 10	Coarse 60	# 105
5 x 10	Fine 100	106
6 x 13	coarse 60	107
6 x 13	Fine 100	108
8 x 16	Coarse 46	114
8 x 16	Fine 80	115

Ø x height mm	Grit	44327 ...
10 x 20	Coarse 46	120
10 x 20	Fine 80	# 121
10 x 32	Coarse 46	124
10 x 32	Fine 80	# 125
13 x 3	Coarse 60	# 126
13 x 3	Fine 100	# 127
13 x 20	Coarse 46	# 131
13 x 20	Fine 80	# 132

Ø x height mm	Grit	44327 ...
13 x 25	Coarse 46	# 133
13 x 25	Fine 80	134
16 x 4	Coarse 46	# 138
16 x 4	Fine 80	# 139
16 x 20	Coarse 30	143
16 x 20	Fine 60	144
16 x 32	Coarse 30	145
16 x 32	Fine 60	146

44330 Tapered Grinding Points, EK (Shank Ø 6 mm)

LUKAS

Quality
High-grade carborundum, pink.

44330

Ø x height mm	44330 ...	Ø x height mm	44330 ...
16 x 32	102	20 x 40	106
20 x 32	105	25 x 70	107

44331 Taper grinding points SiC-aluminium (Shank Ø 6 mm)

LUKAS

Application
Especially for machining non-ferrous metal.
For deburring, cleaning, rework, and finishing.
Through its special micro-structure design, maximum service life is achieved and it and prevents loading. The grinding points have a special impregnation which promotes self-sharpening.

Quality
Silicon carbide, green.

44331

Ø x height mm	Grit	44331 ...	Ø x height mm	Grit	44331 ...
16 x 32	80	102	20 x 40	80	106

44332 Tapered Grinding Points, EK (Shank Ø 6 mm)

PFERD

Quality
High-grade carborundum, pink.

44332

Ø x height mm	Grit	44332 ...	Ø x height mm	Grit	44332 ...
16 x 45	Coarse 46	108	20 x 40	Coarse 30	114
16 x 45	Fine 80	109	20 x 40	Fine 60	115
20 x 32	Coarse 30	112	25 x 70	Coarse 30	120
20 x 32	Fine 60	113			

44335 Mounted Grinding Points, Ball Point EK (Shank Ø 6 mm)

LUKAS

Quality
High-grade carborundum, pink.

44335

Ø mm	44335 ...	Ø mm	44335 ...
6	101	20	106
8	102	25	107
13	104	32	# 108

44337 Mounted Grinding Points, Ball Point EK (Shank Ø 6 mm)

PFERD

Quality
High-grade carborundum, pink.

44337

Ø mm	Grit	44337 ...	Ø mm	Grit	44337 ...
5	Coarse 60	# 102	20	Coarse 30	112
5	Fine 100	# 103	20	Fine 60	113
8	Coarse 46	# 104	25	Coarse 30	# 114
8	Fine 80	# 105	25	Fine 60	# 115
13	Coarse 46	108	32	Coarse 24	# 116
13	Fine 80	# 109	32	Fine 46	117

44340 Conical Cup Grinding Points EK (Shank Ø 6 mm)

LUKAS

Quality
High-grade carborundum, pink.

44340

Greatest Ø x height mm	44340 ...	Greatest Ø x height mm	44340 ...
20 x 20	# 101	32 x 29	# 103
25 x 24	102	40 x 36	# 104

44342 Conical Cup Grinding Points EK (Shank Ø 6 mm)

PFERD

Quality
High-grade carborundum, pink.

44342

Ø x height mm	Grit	44342 ...	Ø x height mm	Grit	44342 ...
20 x 16	Coarse 30	101	32 x 25	Coarse 24	# 105
20 x 16	Fine 60	# 102	32 x 25	Fine 46	# 106
25 x 20	Coarse 30	# 103			

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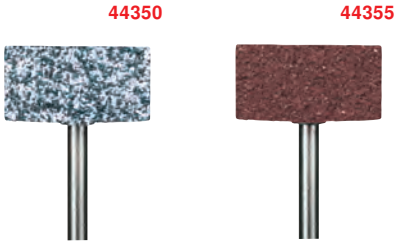
44350 - 44355 Mounted Grinding Points, Cylinder Point (Shank Ø 6 mm)

PFERD

44350
AWN/H soft
Type
Ceramic bonding.
Use
Soft grinding, very good performance.
Quality
Carborundum composite (white/blue).

44355
ADW/L medium
Type
Synthetic resin bonding.
Use
High removal rates, stays open, universal implementation. Ideal for universal implementation on stainless steel (INOX).
Quality
Carborundum composite (dark brown).



Head Ø x Head height mm	Grit	AWN/H soft 44350	...	ADW/L medium 44355	...
8 x 16	Coarse 46			#	150
10 x 20	Coarse 46		166		
10 x 32	Coarse 46			#	168
16 x 32	Coarse 30	#	199		199
20 x 25	Coarse 30	#	220		
20 x 40	Coarse 30				222

Head Ø x Head height mm	Grit	AWN/H soft 44350	...	ADW/L medium 44355	...
25 x 25	Coarse 30	#	234		
25 x 32	Coarse 30				237
32 x 16	Coarse 24				244
32 x 32	Coarse 24		246		
40 x 20	Coarse 24				253
50 x 25	Coarse 24				258

Info Grinding points AWCO hardness J cat.-no. 44357 - 44363

PFERD

Grinding points with **hardness J** are manufactured of a ceramic binding and a mixture of abrasive grit consisting of white corundum and blue ceramic sintered corundum.
In the combination of friable, sharp-edged white corundum and the self-sharpening effect of the micro-crystalline sintered corundum, the soft bond enables extremely high material removal rates with an excellent service life.

Hardness J is ideally **suited for use on titanium materials**, nickel alloys and cobalt-based alloys, as well as for machining hardened structural steelwork parts and build-up welds.

Advantages
- Cooler grind due to the friability of the grit mixture
- High removal rates with good service life
- Self-sharpening effect of the sintered corundum guarantees constant material removal rates

Abrasive	**White corundum ceramic grit (AWCO)**	**Bonding**	Ceramic
for material of	**Steel, cast-iron, non-ferrous metals**	**Cutting speed m/s**	approx. 30-50
Grit (from - to)	Fine (grit 46-100) to	**Use**	Grinding
Hardness	Medium	**Cat.-no.**	44357 - 44363

44357 - 44358 Cylindrical Grinding Points AWCO hardness J (shank Ø 3 and 6 mm)

PFERD

Quality
White corundum and ceramic grit.

Ø x height head mm	Grit	Ø x length shank mm	Max. permissible speed RPM	Shank Ø 3 mm 44357	...
3 x 6	80	3 x 30	206.100		101
3 x 6	100	3 x 30	206.100		102
4 x 8	80	3 x 30	175.100	#	103
4 x 8	100	3 x 30	175.100		104
5 x 10	80	3 x 30	130.700	#	105
5 x 10	100	3 x 30	130.700		106
6 x 13	60	3 x 30	93.600		107
6 x 13	80	3 x 30	93.600		108
6 x 13	100	3 x 30	93.600		109

Ø x height head mm	Grit	Ø x Length shank mm	Max. permissible speed RPM	Shank Ø 6 mm 44358	...
8 x 16	46	6 x 40	119.300	#	101
8 x 16	80	6 x 40	119.300		102
10 x 13	46	6 x 40	95.400		103
10 x 13	80	6 x 40	95.400		104
13 x 25	46	6 x 40	73.400		105
13 x 25	80	6 x 40	73.400		106
16 x 20	46	6 x 40	59.600	#	107
16 x 20	60	6 x 40	59.600	#	108
16 x 32	46	6 x 40	51.200		109
16 x 32	60	6 x 40	51.200	#	110
20 x 25	46	6 x 40	47.700		111
20 x 25	60	6 x 40	47.700		112
32 x 32	46	6 x 40	25.700	#	113
40 x 20	46	6 x 40	23.800	#	114

continuation

44359 - 44360 Spherical Grinding Points AWCO hardness J (shank Ø 3 and 6 mm)

continuation

PFERD

Quality
White corundum and ceramic grit.

44359 - 44360

Head Ø mm	Grit	Shank Ø x Shank length mm	Max. permissible speed RPM	Shank Ø 3 mm 44359	...
6	80	3 x 30	149.200	#	101
6	100	3 x 30	149.200	#	102
8	80	3 x 30	116.200	#	103
8	100	3 x 30	116.200	#	104

Head Ø mm	Grit	Shank Ø x Shank length mm	Max. permissible Speed RPM	Shank Ø 6 mm 44360	...
13	46	6 x 40	73.400	#	101
13	60	6 x 40	73.400	#	102
13	80	6 x 40	73.400	#	103

44361 - 44362 Pointed Arc Grinding Points AWCO hardness J (shank Ø 3 and 6 mm)

PFERD

Quality
White corundum and ceramic grit.

44361 - 44362

Head Ø x Head height mm	Grit	Shank Ø x Shank length mm	Max. permissible speed RPM	Shank Ø 3 mm 44361	...
6 x 13	80	3 x 30	107.900	#	101
6 x 13	100	3 x 30	107.900	#	102
8 x 16	60	3 x 30	72.800	#	103
8 x 16	80	3 x 30	72.800	#	104
8 x 16	100	3 x 30	72.800	#	105

Head Ø x Head height mm	Grit	Shank Ø x Shank length mm	Max. permissible speed RPM	Shank Ø 6 mm 44362	...
13 x 20	46	6 x 40	73.400	#	101
13 x 20	60	6 x 40	73.400	#	102
13 x 20	80	6 x 40	73.400	#	103

44363 Spherical Grinding Points AWCO hardness J (shank Ø 3 6 mm)

PFERD

Quality
White corundum and ceramic grit.

44363

Head Ø x Head height mm	Grit	Shank Ø x Shank length mm	Max. permissible speed RPM	Shank Ø 6 mm 44363	...
10 x 25	46	6 x 40	95.400	#	101
10 x 25	60	6 x 40	95.400		102
16 x 45	46	6 x 40	52.000	#	103
16 x 45	60	6 x 40	52.000	#	104

44364 - 44366 Poliflex® Cylindrical Fine Grinding Points

PFERD

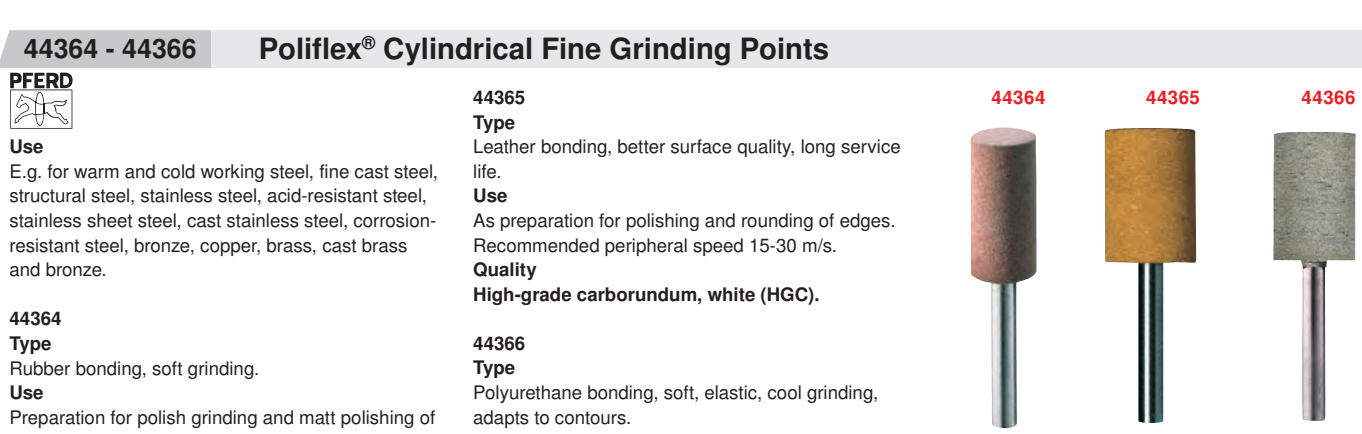
Use
E.g. for warm and cold working steel, fine cast steel, structural steel, stainless steel, acid-resistant steel, stainless sheet steel, cast stainless steel, corrosion-resistant steel, bronze, copper, brass, cast brass and bronze.

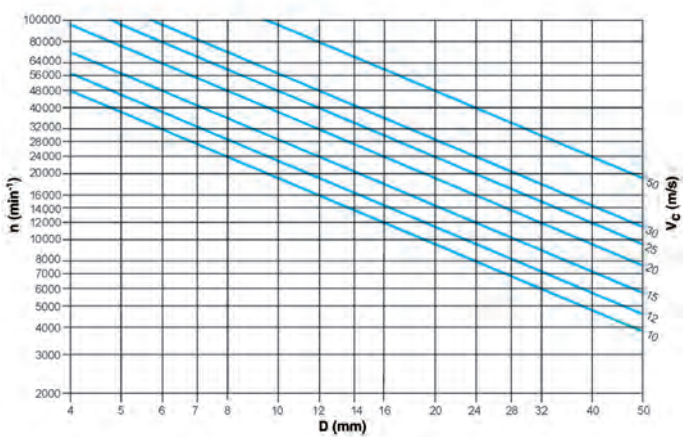
44364
Type
Rubber bonding, soft grinding.
Use
Preparation for polish grinding and matt polishing of non-ferrous metals. Also for aluminium, forgeable aluminium alloys, cast aluminium. Recommended peripheral speed 12-20 m/s.
Quality
High-grade carborundum, pink (EK).

44365
Type
Leather bonding, better surface quality, long service life.
Use
As preparation for polishing and rounding of edges. Recommended peripheral speed 15-30 m/s.
Quality
High-grade carborundum, white (HGC).

44366
Type
Polyurethane bonding, soft, elastic, cool grinding, adapts to contours.
Use
For gentle machining of surfaces, dash-dot matting, cleaning, preparation of cleaning, de-oxidising, light-duty deburring. Recommended peripheral speed < 10-15 m/s.
Quality
Silicon carbide, green (SIC).

44364 44365 44366





Working speeds for Poliflex® tools
In the diagram, the cutting speeds are represented by the diagonal lines.

Combine the diameter (perpendicular line) with the cutting speed (diagonal line). At the height of this cutting point, in the horizontal line, on the left edge, the recommended operating speed for the selected diameter of the Poliflex® tool in RPM is read out.

Example:
Poliflex® fine grinding point, high-grade carborundum, pink, 15 mm Ø,
recommended peripheral speed = < 12 - 20 m/s,
recommended rotational speed range = < 15.500 - 26.000 min^{-1}.

n = speed
D = tool diameter
Vc = peripheral speed

Head Ø x head height mm	Grit	Shank Ø mm	Shank length mm	EK pink 44364	...	EK white 44365	...	SIC green 44366	...
8 x 12	80	3	30						107
8 x 12	120	3	30		112		109		
10 x 15	120	6	40		118	#	114		
15 x 25	120	6	40		128	#	123		
20 x 30	80	6	40						111
20 x 30	120	6	40		132	#	127		
25 x 25	120	6	40	#	134	#	129		
30 x 30	120	6	40	#	136	#	131		

Info Polishing points cat.-no. 44375 - 44377

Due to the outstanding elasticity, the felt polishing points in conjunction with grinding compound (cat-no. 43141) and polishing compounds (cat.-no. 44380 - 44381), are also suitable for polishing particularly complicated shapes, such as pressure-cast and injection moulded shapes, pulling tools, pressing tools, cutting tools, cold heading dies, forging dies, bearings, spindles, rollers, calibres, etc.

Abrasive	**Felt with grinding paste**
For material of	**steel, cast-iron, non-ferrous metals**
Grit (from - to)	Micro-fine (with compound grit 1200) to very coarse (with compound grit 90)
Hardness	Very soft
V = m/s	approx. 5-10
Use	Polishing
Cat.-no.	44375 - 44377

V = m/s: Recommended peripheral speed in m/s

44375 Felt Polishing Points (Shank Ø 6 mm)

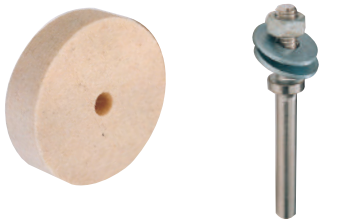
LUKAS

Use
For surface finishing of pre-ground workpieces. Usage in conjunction with special lapping compound cat.-no. 43141 and polishing paste cat.-no. 44380 - 44381.

Note:
cat.-no. 44375 120 with borehole 6 mm Ø, without mounting arbor.

44375 101-105 | 44375 107-109 | 44375 111 | 44375 118

44375 120 | 44375 126



Shape	Head Ø x Length approx. mm		44375 ...
Cylinder	10 x 15		101
Cylindrical	25 x 30		105
spherical	Ø 10		107
spherical	Ø 12		108
spherical	Ø 20	#	109

Shape	Head Ø x Length approx. mm	44375 ...
Pointed arc	12 x 20	111
Round taper	25 x 30	118
Disc	40 x 10	120
Mounting arbor	–	126

43141

44376 Felt Polishing Points (Shank Ø 3 mm)

PFERD

Use
Mainly used in the area of **high-gloss polishing** in conjunction with special lapping compound cat.-no. 43141 and polishing paste cat.-no. 44380 - 44381. Thanks to the different diameters and shapes, even complicated workpieces can be polished. Easy to profile.

44376 101-103

44376 104-106

44376 107-108

Shape	Head Ø x -length mm	Shank length mm	Rec. speed 1/min	44376 ...
Cylindrical	6 x 10	40	16.000-32.000	101
Cylindrical	8 x 10	40	12.000-24.000	102
Cylindrical	10 x 14	40	10.000-20.000	103
Pointed arc	8 x 12	40	12.000-24.000	104
Pointed arc	10 x 18	40	10.000-20.000	105
Pointed arc	12 x 18	40	8.000-16.000	106
Helical	8 x 12	40	12.000-24.000	107
Helical	10 x 14	40	10.000-20.000	108

44377 Felt Polishing Points (Shank Ø 6 mm)

PFERD

Use
Mainly used in **high-gloss polishing** in conjunction with special lapping compound cat.-no. 43141 and polishing paste cat.-no. 44380 - 44381. Thanks to the different diameters and shapes, even complicated workpieces can be polished. Easy to profile.

44377 102-104
Type
With borehole in face, therefore particularly suitable in face grinding. The borehole in the face prevents the accumulation of residue.

44377 101

44377 102-104

44377 105-108

44377 109-111

44377 112-115

44377 116

44377 117

Shape	Head Ø x -length mm	Shank length mm	Rec. speed 1/min	44377 ...
Cylindrical	10 x 14	40	10.000-20.000	101
Cylindrical	15 x 20	40	6.000-12.000	102
Cylindrical	20 x 25	40	5.000-10.000	103
Cylindrical	25 x 30	40	4.000-8.000	104
Pointed arc	10 x 18	40	10.000-20.000	105
Pointed arc	15 x 20	40	6.000-12.000	106
Pointed arc	15 x 30	40	6.000-12.000 #	107
Pointed arc	20 x 25	40	5.000-10.000	108
Helical	15 x 20	40	6.000-12.000 #	109
Helical	20 x 25	40	5.000-10.000 #	110
Helical	25 x 30	40	4.000-8.000	111
Round taper	15 x 20	40	6.000-12.000 #	112
Round taper	20 x 25	40	5.000-10.000	113
Round taper	25 x 30	40	4.000-8.000	114
Round taper	30 x 35	40	3.000-6.000	115
Tear-drop	10 x 14	40	10.000-20.000 #	116
Angled	20 x 16	40	5.000-10.000 #	117

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= partly extent in stock.

44380 Polishing Paste Bars

PFERD

Use
Use in conjunction with felt polishing points (cat-no. 44375 - 44377).

44380

Type	Use	Colour	B x T x H mm	44380	...
Pre-polishing compound	Steel + stainless Steel	green	70 x 50 x 140		101
Pre-polishing compound	Al + Messing	grey	70 x 50 x 140		102
Pre-polishing compound	Non-ferrous	brown	70 x 50 x 140		103
High-gloss polishing compound	all metals	pink	70 x 50 x 140		104
High-gloss polishing compound	plastics	beige	70 x 50 x 140		105

44381 Diamond Polishing Compounds

HW

Type
- Paste in practical dosing syringe with scale, a little goes a long way
- **High diamond proportion**
- Can also be applied as concentrate
- Grit mixture, thus better abrasion than with pure grit
- No mistaking the grit, through colouration of the compound
- Oil-soluble
- No hazardous substances

Use
Suitable for polishing
- Hard metals
- Hard case-hardened steel and chrome-steels
- Coatings that protect against wear

44381

Grit µ	Contents ml	Colour	44381	...
1 - 3	5	red	#	201
1 - 3	20	red		401
4 - 6	5	yellow	#	202
4 - 6	20	yellow	#	402
12 - 17	5	green		203
12 - 17	20	green		403
30 - 40	5	blue	#	204
30 - 40	20	blue	#	404
40 - 50	5	orange	#	205
40 - 50	20	orange	#	405

44385 - 44390 Diamond and CBN Grinding Points

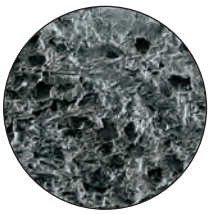
PFERD

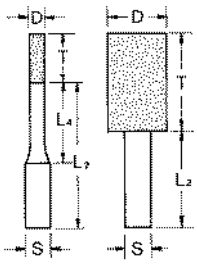
Type
Cylindrical shape, A = offset shank, N = non-offset shank. **Advantages:** Excellent service life and profile-holding properties. Short working time. Reduction of non-productive times. No thermal damage to the workpiece thanks to the low grinding temperatures. Even quality for many workpieces.

44385
Diamond Grinding Points
Use
For the processing of carbide (sintered, green compact), glass, ceramics (also engineered ceramics, coatings that protect against wear, ferrite, silicon, graphite, electro-carbons, thermosets, glass-fibre reinforced plastics, natural stone and cast stone, fire-resistant materials, among other things on internal cylindrical grinding machines and coordinate grinding machines.
Recommended peripheral speed:
wet 20 m/s, dry 15 m/s.
Quality
Grit D 126.

44390
CBN Grinding Points
Cubic boron nitride.
Use
For the processing of high-speed steels, tool steels, case-hardened steels, ball bearing steels, chrome steels, among other things on internal cylindrical grinding machines and coordinate grinding machines. **Recommended peripheral speed:** wet 30 m/s, dry 20 m/s.
Quality
Grit B 126.

44385 - 44390





D x T mm	S mm	shank-form	L_2 mm	L_4 mm	Diamond 44385	Diamond ...	CBN 44390	CBN ...
1,0 x 4	3	A	36	9		103	#	103
1,6 x 4	3	A	36	10		107	#	107
2,0 x 4	3	A	36	10		109		109
2,6 x 4	3	A	36	14		113		113
3,0 x 4	3	A	36	19		115		115
3,5 x 5	3	N	45	-		116	#	116
4,0 x 5	3	N	45	-		117		117
4,5 x 5	3	N	45	-	#	118		118
5,0 x 5	3	N	45	-		119		119

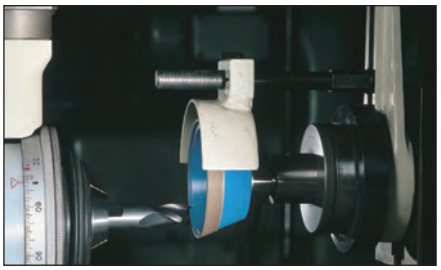
D x T mm	S mm	Shank-form	L_2 mm	L_4 mm	Diamond 44385	Diamond ...	CBN 44390	CBN ...
5,5 x 6	3	N	44	-		120	#	120
6,0 x 6	6	A	54	19	#	121		121
7,0 x 8	6	N	52	-	#	123	#	123
8,0 x 8	6	N	52	-		125	#	125
10,0 x 8	6	N	52	-	#	127		127
12,0 x 8	6	N	52	-	#	129		129
15,0 x 10	6	N	50	-		132		132
20,0 x 10	6	N	50	-		136	#	136

44502 Diamond cup grinding points

PFERD

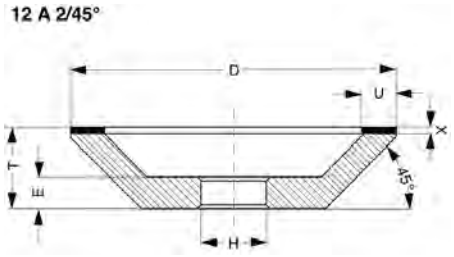
Type
Synthetic resin bonding.
Use
Particularly for grinding, (sharpening) of carbide tools on all common grinding machines. Universally suited for dry and wet grinding (wet grinding is always recommended).
Grit D 126: For finishing.
Grit D 64: For fine-grinding.
Bonding PHT:
Especially for **high-performance dry grinding,** i.e. cooler grinding, even without coolant.

Note:
Grit concentration, indicates the grit quantity in carat (ct) per volume unit (cm^3) of the abrasive coating.



44502

12 A 2/45°



D x X x U x H mm	T mm	E mm	Grit	Bond	Grit concentration	Wet grinding approx. m/s	Dry grinding approx. m/s	12 A 2/45° 44502	...
125 x 2 x 10 x 20	25	10	D 64	PHT	C 50 (2,2 ct/cm^3)	20 - 35	15 - 20		114
125 x 2 x 10 x 20	25	10	D 126	PHT	C 75 (3,3 ct/cm^3)	20 - 35	15 - 20		115

44540 Grinding machine deburring wheel Scotch-Brite™ DB-WL

3M

Type
These wheels are made of wrapped-around fibre. This guarantees a continuous release of the grits.
Extremely long service life. High cutting force.

Use
Especially suitable for deburring and rounding of edges and boreholes, milling or punching edges and for deburring taps. Suitable for all metals, also hard and ductile metals, such as stainless steel and titanium.

Note:
Reducing flanges for compact wheels see cat.-no. 44545.

44540

Type	Outer Ø x width x inner Ø mm	Speed max. RPM	44540	...
DB-WL	203 x 50,8 x 76,2	4500	#	101

44541 Grinding machine finishing wheel Scotch-Brite™ FS-WL

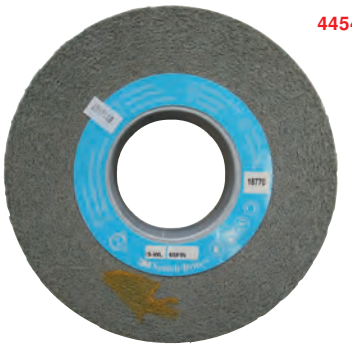
3M

Type
Wrapped-around fibre mat disc guarantees a continuous release of grits. The impregnation ensures a longer service life. The grits are evenly spread, no deviations in the surface. Gentle, adaptive application, quick cutting at low temperatures.

Use
For fine machining of stainless steel, copper, brass and aluminium.

Note:
Reducing flanges for compact wheels see cat.-no. 44545.

44541



Type	Outer Ø x width x inner Ø mm	Speed max. RPM	44541	...
FS-WL	203 x 50,8 x 76,2	4500	#	101

44545 Reducing flange for compact wheels

3M

Type
Pairs.
Use
These back plates are required for mounting compact wheels. They are suitable for all standard shank diameters. For all other shank diameters, the borehole can be drilled out.

Note:
Suitable compact wheels see cat.-no. 44540 - 44541.

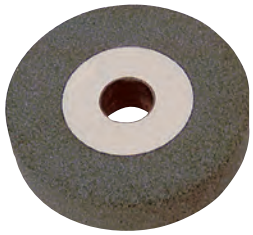
44545

Can be used for inner Ø mm	Bore of the flange mm	44545	...
76,2	13	#	101

44550 Grinding Wheels for Rough-Grinding

Type
Straight, ceramic bond, bonding type V 42, hardness 36 P.
Use
For general workshop use. For roughing standard steel, iron etc.
Quality
Normal carborundum (NK).

Note:
Grinding wheels in further dimensions available on request. For reducing the borehole Ø by means of reducing rings (cat.-no. 44560).


44550

NK/grit 36				NK/grit 36				NK/grit 36			
Disc Ø x width x Bore mm		44550	...	Disc Ø x width x Bore mm		44550	...	Disc Ø x width x Bore mm		44550	...
150 x 20 x 15			101	200 x 20 x 32	#		105	200 x 25 x 51	#		109
150 x 20 x 32			102	200 x 25 x 15	#		106	200 x 32 x 51			110
175 x 25 x 32			103	200 x 25 x 20			107	300 x 40 x 76			113
175 x 25 x 51		#	104	200 x 25 x 32			108				

44552 - 44556 Grinding Wheels for Finishing

Type
Straight, ceramic bond, bonding type V 42.

Note:
Grinding wheels in further dimensions available on request. For reducing the borehole Ø by means of reducing rings (cat.-no. 44560).

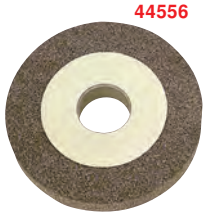
44552
Use
Hardness M. For general workshop use.
For finishing standard steel, iron, etc.
Quality
Normal carborundum (NK).

44554
Use
Hardness K. **For finish grinding** of hardened steel and high-speed steels.
Quality
High-grade carborundum (HGC).

44556
Use
Hardness Jot. **For finishing** grey cast iron, carbide, aluminium, porcelain, natural and artificial stone as well as welds.
Quality
Silicon carbide, green (SIC).

44552

44554

44556


	NK/grit 60		EK/grit 60		SIC/grit 80	
Disc Ø x width x Bore mm	44552	...	44554	...	44556	...
150 x 20 x 15		301		101		101
150 x 20 x 32		302		102		102
175 x 25 x 32		303		103		103
175 x 25 x 51		304		104		104
200 x 20 x 32	#	305		105		105
200 x 25 x 15	#	306	#	106	#	106
200 x 25 x 20		307		107		107
200 x 25 x 32		308		108		108
200 x 25 x 51		309		109		109
200 x 32 x 51		310		110		110
250 x 32 x 51	#	311		111	#	111
300 x 40 x 25	#	312	#	112	#	112
300 x 40 x 76		313		113	#	113

44560 Reducing Rings for Grinding Wheels

Type
Pairs.

Use
For reducing the borehole Ø of the grinding wheels cat.-no. 44550 44556).
2 reducing rings are needed per wheel.

44560


		Pair				Pair				Pair	
Outer Ø mm	Inner Ø mm	44560	...	Outer Ø mm	Inner Ø mm	44560	...	Outer Ø mm	Inner Ø mm	44560	...
20	12		101	32	15		103	51	32		106
20	16		102	32	16		104	76	51	#	107
				32	20		105				

44902 - 44903 See-Through Grinding Wheels

Type
Horizontally rotating. Radially orientated elongated holes ensure a see-through effect during cutting, so that the workpiece can be watched. Abrasive coating with artificial resin bond – can be used on both sides.
Quality
Abrasive high-grade carborundum with silicon carbide.

44902
Type ER
Use
For structural steel, malleable cast iron, cast steel, perhaps grey cast iron and non-metallic materials.

44903
Type EF
Use
For high-speed steels (alloyed tool steels).

44902 - 44903

Grit	Ø x thickness x bore mm	Type ER 44902	...	Type EF 44903	...
60	210 x 5 x 12	#	202	#	202
120	210 x 4 x 12	#	205		205
150	210 x 4 x 12	#	206	#	206

44600 Clamp flange Rhoducer (vibration-damping clamp flange)

RHODIUS BRAINTOOLS by Rhodius

Type
Clamping flange for retrofitting of non vibration-damped angle grinders. It has a wear-resistant coating that additionally damps vibrations through crossbars, because the clamping surface is reduced. Thus it reduces stresses for the body areas which were previously especially stressed, and thus significantly increases quality of work.

Use
For more comfort during the application and for keeping you healthy. Reduces grinding vibrations.

44600

	44600	...
Rhoducer	#	101

44601 Rough Grinding Discs (Metal)

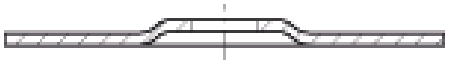
ATORN®

Type
Offset, glass fabric reinforcement, open structure. Hard disc with high machining capacity and high edge strength.

Use
For use on high-speed angle grinders. For steel and non-ferrous metal work.

NEW

44601



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44601	...
115 x 7	22,2	13.285	80	25 pcs.		201
125 x 7	22,2	12.200	80	25 pcs.		202
180 x 7	22,2	8.600	80	10 pcs.		203
230 x 7	22,2	6.600	80	10 pcs.		204

44603 Rough Grinding Discs (Metal)

HHW

Type
Offset, fibre-glass reinforcement, brown corundum. High abrasive performance and long service life. Made in Germany.

Use
For all types of metals, particularly sheet steel, structural steel and weld seams.

44603

Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44603	...
115 x 6	22,23	13.285	80	10 pcs.		101
125 x 6	22,23	12.200	80	10 pcs.		102
180 x 6	22,23	8.600	80	10 pcs.		103
230 x 6	22,23	6.600	80	10 pcs.		104

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

44606 - 44609 Rough Grinding Discs (Metal)

RHODIUS

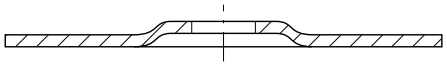
Type
Offset, glass fabric reinforcement, open structure.
Use
For machining steel with fast angle grinders.

44606
Medium-hard wheel
Type RS 2
Type
With high chip removal and and high edge strength.
Use
For the processing of of structural steels and constructions steels, unalloyed and alloyed stainless steels, as well as tool steels.

44609
Standard Universal
Type KSM
Type
Hard wheel with long life time.
Use
Universal implementation for general metal working.

44606 44609

PRO LINE ●●○ ALPHA LINE ●○○



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		medium-hard 44606	...	standard 44609	...
115 x 6	22,2	13.285	80	25 pcs.		101		101
125 x 6	22,2	12.200	80	25 pcs.		102		102
150 x 6	22,2	10.185	80	10 pcs.		103		
180 x 6	22,2	8.600	80	10 pcs.	#	104	#	104
180 x 10	22,2	8.600	80	10 pcs.	#	106		
230 x 6	22,2	6.600	80	10 pcs.			#	107

44615 - 44617 Rough Grinding Discs (Metal)

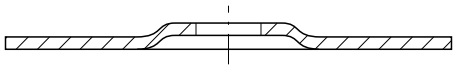
PFERD

Type
In compliance with EN 12413. Offset, fibre-reinforced artificial resin bond.

44615
Medium-hard wheel
Type A 30 P
Use
For the processing of steel and cast-iron (grey cast-iron and nodular cast iron) with high grinding capacity and good service life. For surface grinding, processing of weld seams, chamfering, deburring, fillet weld grinding.

44617
Hard wheel
Type A 24 R
Use
For the processing of steel with high grinding capacity and good service life. For surface grinding, processing of weld seams, chamfering, deburring, fillet weld grinding and back gouging.

44615 44617



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		A 30 P 44615	...	A 24 R 44617	...
115 x 4,1	22,2	13.300	80	10 pcs.				101
115 x 7,2	22,2	13.300	80	10 pcs.		101	#	102
125 x 7,2	22,2	12.200	80	10 pcs.		102		104
178 x 7,2	22,2	8.600	80	10 pcs.	#	103		106
178 x 8,3	22,2	8.600	80	10 pcs.	#	104		107
230 x 7,2	22,2	6.600	80	10 pcs.	#	105		108

44611 Rough Grinding Discs (Aluminium)

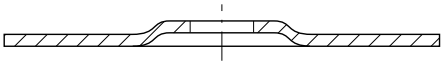
RHODIUS

Medium-hard disc
Type RS 24
Type
Offset, glass fabric reinforcement, open structure. Grinds easily, with excellent service life and extremely high removal rates. Special fillers prevent clogging of the disc.

Use
For all lubrication non-ferrous metals, such as aluminium, zinc, lead and tin and their alloys, such as bronze, bronze, gun metal. For grinding lugs, skins of a casting, welds, burrs and edges.

44611

TOP LINE ●●●



Ø x width mm	Bore Ø mm	speed max. RPM	Working speed max. m/s		44611	...
115 x 6	22,2	13.285	80	25 pcs.		101
125 x 6	22,2	12.200	80	25 pcs.		102
180 x 6	22,2	8.600	80	10 pcs.		104

44630 Rough Grinding Discs (Stainless Steel)

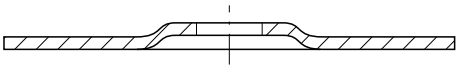
RHODIUS

Medium-hard wheel
Type RS 38
Type
Offset, glass fabric reinforcement, open structure. Grinds easily, with high removal rates and very good service life. **Free of iron and sulphur.**

Use
For corrosion and acid-resistant steel such as INOX, V2A, Coracid, Nirosta, heat-resistant cast steel (GX steel), spring steel, all types of construction and tool steel. For grinding edges, deburring, cleaning of welds.

44630

PROLINE ●●○



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44630	...
115 x 6	22,2	13.285	80	25 pcs.	#	101
125 x 6	22,2	12.200	80	25 pcs.		102
180 x 6	22,2	8.600	80	10 pcs.		103
230 x 6	22,2	6.600	80	10 pcs.	#	105

44619 - 44621 Rough Grinding Discs (Stainless Steel)

PFERD

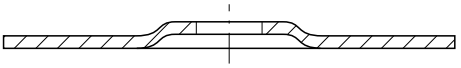
Type
In compliance with EN 12413. Offset, fibre-reinforced artificial resin bond. **Without filler materials which contain iron, sulphur, or chlorine.**

44619
Medium-hard wheel
Type A 30 M
Use
For the processing of stainless steel and materials that are difficult to machine with aggressive grinding action and good tool life. For surface grinding, processing of weld seams, chamfering, deburring, fillet weld grinding and back gouging.

44619

44621
Hard wheel
Type A 30 N
Use
For the processing of stainless steel with aggressive grinding action and good service life. For surface grinding, processing of weld seams, chamfering, deburring, fillet weld grinding and back gouging.

44621



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		A 30 M 44619	...	A 30 N 44621	...
115 x 4,1	22,2	13.300	80	10 pcs.			#	101
115 x 7,2	22,2	13.300	80	10 pcs.		101	#	103
125 x 5,2	22,2	12.200	80	10 pcs.				105
125 x 7,2	22,2	12.200	80	10 pcs.		102		106
178 x 7,2	22,2	8.600	80	10 pcs.		103		
178 x 8,3	22,2	8.600	80	10 pcs.	#	104		
230 x 7,2	22,2	6.600	80	10 pcs.		105		

44604 Rough Grinding Discs (Stainless Steel) Cubitron™ II

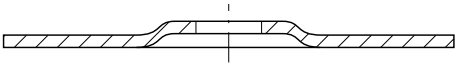
3M

Type
- Up to three times the removal capacity of conventional roughing discs
- Immediate engagement in solid material
- Expenditure of force reduced by 70% at the same removal rate
- Faster, cooler grinding and optimized grinding processes

Use
Particularly suited for structural steelwork applications (side grinding with frequent edge stress, chamfering, grinding of fillet welds, cleaning, back gouging, coarse grinding tasks and removal of weld seams.

44604

NEW



Ø x width mm	Bore Ø mm	Working speed max. m/s	44604	...
115 x 7	22,2	80		101
125 x 7	22,2	80		102
178 x 7	22,2	80		103
230 x 7	22,2	80		104

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

44660 - 44661 Cup wheels (metal / stone)

RHODIUS

Type
Conical, medium-hard.
Use
For rough grinding through finishing grinding. For use on common angle grinders.

Note:
Use special protective hood!

44660
Use
For grinding surfaces, constructions and welds. For levelling of put-together parts thanks to face-mounting. For structural steel, unalloyed and alloy steel, spring steel, tempered steel.
Quality
Normal carborundum.

44661
Use
For grinding natural and artificial stone, chamfering of edges, cleaning of grey cast iron parts and of frameworks. For concrete, refractory stones, tiles, glazed tiles, clinker, moulding sand.
Quality
Silicon carbide.

44660

PROLINE ●●○

44661

PROLINE ●●○

Grit	Greatest Ø x height mm	Hardness	Bore Ø mm	Speed max. RPM	Working speed max. m/s	Metal 44660	...	Stone 44661	...
24 (Coarse)	110/90 x 55	Q	22,2	8.680	50		201		201
36 (medium)	110/90 x 55	Q	22,2	8.680	50		202		
60 (Fine)	110/90 x 55	Q	22,2	8.680	50		203		

44705 Combination Grinding Discs 1.9 mm

RHODIUS

Type XT 35 Cross
Type
Extra-thin combination disc (1.9 mm), offset. Enables pleasant, easy and fast parting and roughing grinding with good service life. Three full fabric layers guarantee a very high stability and best safety. **Free of iron and sulphur.**

Use
Several work steps can be performed with one disc, without having to remove the machine. Extra thin cutting, deburring, bevelling, and smoothing. Suitable for corrosion and acid-resistant steel, Hardox, hardened, high-alloyed and high-strength steel, galvanised parts, steel, tool steel.

44705

BRAINTOOLS by Rhodius

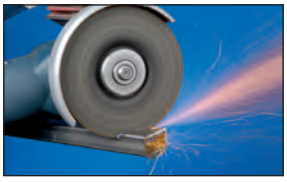
Ø x thickness mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44705	...
115 x 1,9	22,23	13.285	80	25 pcs.	#	101
125 x 1,9	22,23	12.200	80	25 pcs.	#	102

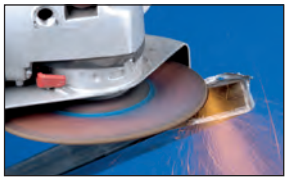
44710 Combination grinding discs

PFERD

Type
In compliance with EN 12413.
Combination grinding disc for cutting and light-duty deburring. Robust, very stable disc design. Reduces costs by reducing set-up times. Aggressive abrasive and high-quality grit bonding. Without filler materials which contain iron, sulphur, or chlorine.

Use
For cutting, light-duty deburring and light-duty surface grinding. For steel and INOX. Suitable for angle grinder of all classes.





44710

Ø x thickness mm	Speed max. 1/min		44710	...
115 x 1,9	13.300	10 pcs.		100
115 x 2,8	13.300	10 pcs.	#	101
125 x 1,9	12.200	10 pcs.		103
125 x 2,8	12.200	10 pcs.		102

Cutting-off discs

44800 - 44801 Small Free-Hand Cutting-Off Discs

PFERD

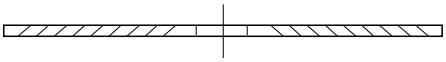
44800
Medium-hard wheel
Type
In compliance with EN 12413. Straight, fibre-reinforced, artificial resin bond. **Without filler materials which contain iron, sulphur, or chlorine.**
Use
Universal implementation for cutting steel, stainless steel, cast iron and non-ferrous materials. Especially suitable for materials with very high-temperature strength, e.g. when repairing engines in turbine construction. Also in car-body construction, for cutting sheet metal in hard-to-reach places.

Note:
With mounted clamping bolt on straight grinders can be used up to the highest permissible speed of the clamping bolt.
(Compressed-air) straight grinder see cat.-no. 91500 - 91503, 92425, 92430.

44801
Mounting bolt
Type
Shank Ø 6 or 10 mm.

Note:
When using the clamping bolt, comply with the highest permissible speed specified in the package insert.

44800 44801



Ø x width mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s	Cutting-off disc 44800	...	Mounting bolt 44801	...
30 x 1,1	6	51.000	80		101		101
40 x 1,1	6	38.200	80		103		101
50 x 2,1	6	30.600	80		107		101
65 x 2,1	10	23.500	80		112		103
70 x 2,1	10	21.800	80		116		103
76 x 2,1	10	20.100	80		121		103

44804 Free-Hand Cutting-Off Discs (Metal)

ATORN®

Type
Straight shape, thin type. Extremely hard cutting-off disc for extremely short cutting times. Smooth sides for chatter-free and almost burr-free cutting.
Use
For cutting thin-walled pipes, thin sheet metal and profiles.

44804

Ø x thickness mm	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44804	...
115 x 1,0	22,2	13.285	80	50 pcs.		101
115 x 1,5	22,2	13.285	80	50 pcs.		102
125 x 1,0	22,2	12.200	80	50 pcs.		103
125 x 1,5	22,2	12.200	80	50 pcs.		104
180 x 1,5	22,2	8.600	80	25 pcs.		106
230 x 1,9	22,2	8.600	80	25 pcs.		107

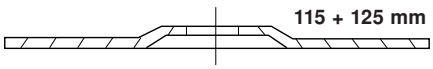
44805 Free-Hand Cutting-Off Discs (Metal)

ATORN®

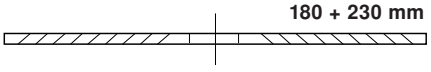
Type
Glass fabric reinforcement, open structure. Hard, with long life and cooled, fast cutting.
Use
For cutting high-strength structural steels.

44805

115 + 125 mm



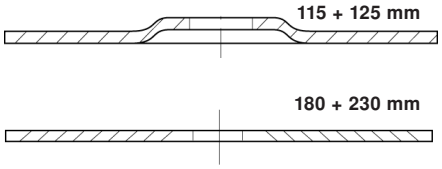
180 + 230 mm



Ø x thickness mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44805	...
115 x 3	Offset	22,2	13.285	80	25 pcs.		101
125 x 3	offset	22,2	12.200	80	25 pcs.		102
180 x 3	Straight	22,2	8.600	80	25 pcs.		103
230 x 3	Straight	22,2	6.600	80	25 pcs.		104

44803 Free-Hand Cutting-Off Discs (Metal)

Type
Cutting-off disc with good service life and fast cut.
Made in Germany.
Use
Universal implementation for cutting all metals, e.g. structural steelwork and construction steelwork, etc.



44803

Ø x width mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44803	...
115 x 3	Offset	22,23	13.285	80	25 pcs.		101
125 x 3	Offset	22,23	12.200	80	25 pcs.		102
180 x 3	Straight	22,23	8.600	80	25 pcs.		103
230 x 3	Straight	22,23	6.600	80	25 pcs.		104

44809 - 44816 Free-hand cutting-off discs (steel)

RHODIUS

Type
Glass-fibre-reinforced, open structure, hole 22,2 mm Ø, max. working speed 80 m/s.

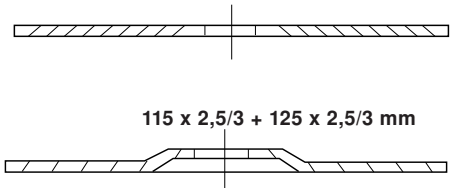
44809
Extra thin high-quality cutting-off disc
Type XT20
Type
Very hard, with extremely quick cut, very thin, very precise, chatter-free, burr-free, low-noise, cool, with extremely long service life.
Use
For cutting solid stock, of steel, tubing, profiles and sheet steels, spring steels, and tool steels.

44810
High-Performance Cutting-Off Disc
Type FT/FTK 67
Type
Very long service life and special cool cutting.
Use
For cutting sheet metal, tubing, profiles and solid steel materials. Effortlessly cuts all iron materials.

44814
Medium-hard wheel
Type KSM/KSMK
Type
With good cutting properties and high-performance standard.
Use
For universal metal working implementation.

44815
Special medium-hard
Type FT/FTK 33
Type
With long life and cooled, fast cutting.
Use
For cutting high-strength structural steels.

44816
Medium-hard cutting-off disc
Type XT/FT/FTK 24
Type
Even cuts heavy-duty materials very easily, with long service life.
Use
Ideally suited for cutting of aluminium, Al alloys, copper, brass, bronze and other lubricating non-ferrous metals



44809

44810

44814

44815

44816

Ø x thickness mm	Shape	Speed max. RPM.		XT20 44809	...	XT/FT/FTK 67 44810	...	KSM/KSMK 44814	...	FT/FTK 33 44815	...	XT/FT/FTK 24 44816	...
115 x 1,0	Straight	13.285	-		101		201						
115 x 1,5	Straight	13.285	-		102		203						103
115 x 2,5	Offset	13.285	-									#	108
115 x 3,0	offset	13.285	25 pcs.					#	108		208		
115 x 3,0	Offset	13.285	-				208						
125 x 1,0	Straight	12.200	-		103		209						
125 x 1,5	Straight	12.200	-		104		211						111
125 x 2,5	Offset	12.200	25 pcs.										116
125 x 3,0	Offset	12.200	25 pcs.				216		116		216		
150 x 1,5	Straight	10.185	25 pcs.		108								
150 x 3,0	Straight	10.185	-					#	223				
180 x 1,5	Straight	8.600	25 pcs.		105		229						
180 x 1,5	Straight	8.600	-										128
180 x 3,0	Straight	8.600	25 pcs.			#	231	#	131	#	231		
180 x 3,0	Straight	8.600	-									#	131
230 x 1,9	Straight	6.600	25 pcs.		106		237					#	137
230 x 3,0	Straight	6.600	25 pcs.				239		139			#	139
230 x 3,0	Straight	6.600	-							#	239		

Cutting-off discs

44806 - 44807 Free-Hand Cutting-Off Discs (Metal)

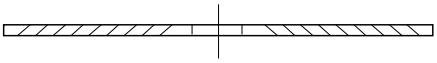
PFERD

Type
In compliance with EN 12413. Fibre-reinforced, artificial resin bond.
Use
For cutting sheet metal, tubing, profiles and solid stock made of steel.

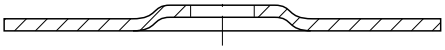
44806
Medium-hard wheel
Type A 24/46/60 P
Use
Good service life and fast cutting (universal)

44807
Hard wheel
Type A 24/30/46/60 S
Use
Thickness 1,0 mm: Quick, almost burr-free cutting (of e.g. sheet metal).
thickness 1,6/1,9/2,4/2,9 mm:
Very good service life and fast cutting (universal)

44806 44807



115 x 2,4 + 125 x 2,4 mm



Ø x thickness mm	Shape	Grit size	Bore Ø mm	speed max. RPM	Working speed max. m/s		A 24-60 P 44806	...	A 24-60 S 44807	...
115 x 1,0	Straight	60	22,2	13.300	80	25 pcs.		105		104
115 x 1,6	Straight	46	22,2	13.300	80	25 pcs.		106	#	105
115 x 2,4	Straight	30	22,2	13.300	80	25 pcs.				106
115 x 2,4	Offset	46/30	22,2	13.300	80	25 pcs.	#	107	#	107
125 x 1,0	Straight	60	22,2	12.200	80	25 pcs.		109		109
125 x 1,6	Straight	46	22,2	12.200	80	25 pcs.		110		110
125 x 2,4	Straight	46	22,2	12.200	80	25 pcs.				111
125 x 2,4	Offset	46/30	22,2	12.200	80	25 pcs.		111	#	112
178 x 1,6	Straight	46	22,2	8.600	80	25 pcs.	#	112	#	115
178 x 3,2	Straight	24	22,2	8.600	80	25 pcs.	#	113	#	116
230 x 1,9	Straight	46	22,2	6.600	80	25 pcs.		114		119
230 x 3,2	Straight	24	22,2	6.600	80	25 pcs.		115		120

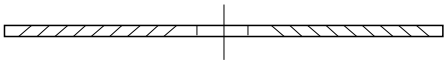
44850 Cutting-Off Discs (Metal)

PFERD

Type A 24 S SG
Type
In compliance with EN 12413. Fibre-reinforced, artificial resin bond.

Use
For cutting large cross sections of profile and solid steel and cast-iron material. **For electrically or petrol-driven manually-operated cutting grinding machines.**

44850



Ø x thickness mm	Shape	Bore Ø mm	speed max. RPM	Working speed max. m/s	44850	...
300 x 4,0	Straight	22,2	6.400	100	#	101
300 x 4,0	Straight	25,4	6.400	100	#	102
350 x 4,5	Straight	22,2	5.500	100	#	103
350 x 4,5	Straight	25,4	5.500	100	#	104

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

44825 Free-Hand Cutting-Off Discs (Stainless Steel)

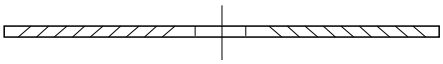
ATORN®

Type
- Very hard cutting-off disc with good cutting properties.
- In its composition, complies with the requirements specified in the work regulations for nuclear reactor construction
- Minimal burr formation, sparking and odour
- High cutting speed and long service life

Use
Cutting-off disc free of iron and sulphur, for special implementation in nuclear reactor construction, and for cutting alloyed, high-alloy, and non-rusting stainless steels, sheet metal, tubing, profiles and solid materials.

44825 303
Type
- 10 extremely thin cutting-off discs in at attractive resealable tin can

44825



44825 303

Ø x thickness mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s		Pack= pcs.	44825	...
115 x 1,0	Straight	22,2	13.285	80	50 pcs.	-		101
115 x 1,5	Straight	22,2	13.285	80	50 pcs.	-		102
125 x 1,0	Straight	22,2	12.200	80	50 pcs.	-		103
125 x 1,0	Straight	22,2	12.200	80	1 pcs.	10		303 NEW
125 x 1,5	Straight	22,2	12.200	80	50 pcs.	-		104
180 x 1,5	Straight	22,2	8.600	80	25 pcs.	-		106
230 x 1,9	Straight	22,2	6.600	80	25 pcs.	-		107

44802 Free-Hand Cutting-Off Discs (Stainless Steel)

HHW

Type
Made in Germany.
Thickness 1,0 mm: Extremely thin disc enables a fast, uniquely clean cut with minimal expenditure of force. Millimetre-precise application, vibration-free work, no thermally-induced blue colouration and no burr formation (saves rework).
Thickness 1,6 mm: Free of iron and sulphur. Do to its force-saving effect, the thin special disc, is easy on the operator and the tool. High cutting speed, long service life, almost no feathering.

Use
Thickness 1,0 mm: For thin steel sheets, steel ropes, thin-walled profiles and tubes of stainless steel and non-ferrous metals. Composite materials (GRP) Materials with very high-temperature strength.
Thickness 1,6 mm: For mild steel and stainless steel, particularly suited for steel sheets and thin-walled profiles.

44802

Ø x width mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44802	...
115 x 1,0	Straight	22,23	13.280	80	25 pcs.		101
115 x 1,6	Straight	22,23	13.280	80	25 pcs.		102
125 x 1,0	Straight	22,23	12.200	80	25 pcs.		103
125 x 1,6	Straight	22,23	12.200	80	25 pcs.		104
180 x 1,6	Offset	22,23	8.600	80	25 pcs.		105
230 x 1,9	Offset	22,23	6.600	80	25 pcs.		106

44820 Free-Hand Cutting-Off Discs (Stainless Steel)

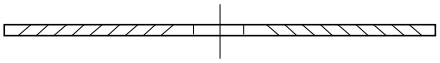
RHODIUS

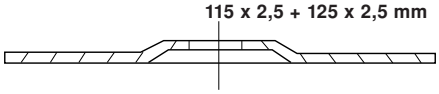
Type FT/FTK 38
Type
Very hard cutting-off disc with good cutting properties. **Free of iron and sulphur.**

Use
For cutting alloyed, high-alloy, and non-rusting stainless steels, sheet metal, tubing, profiles and solid materials.

44820 304

44820





Ø x thickness mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s		44820	...
115 x 1,0	Straight	22,2	13.285	80	50 pcs.		301
115 x 1,5	Straight	22,2	13.285	80	-		302
115 x 2,5	Offset	22,2	13.285	80	25 pcs.		303
125 x 1,0	Straight	22,2	12.200	80	-		304
125 x 1,5	Straight	22,2	12.200	80	-		305
125 x 2,5	Offset	22,2	12.200	80	25 pcs.		306
180 x 1,5	Straight	22,2	8.600	80	25 pcs.		307
180 x 3,0	Straight	22,2	8.600	80	25 pcs.		308
230 x 1,9	Straight	22,2	6.600	80	25 pcs.		309
230 x 3,0	Straight	22,2	6.600	80	25 pcs.		310

44823 Free-Hand Cutting-Off Discs (Stainless Steel)

RHODIUS

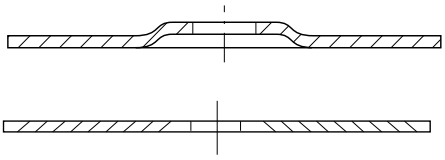
44823 100 + 107
Type XTK8
Type
Very hard, **free of iron and sulphur**, with extremely fast cut, very thin, very precise, chatter-free, burr-free, low-noise, cool.
Use
0,8 mm precision cutting-off disc for thin sheet metal.

44823 101-106 + 109
Type XT10
Type
Very hard, **free of iron and sulphur.** Extremely long service life for fewer disc changes and maximum economy. Cool, low-burr cut.
Use
For cutting solid stock, tubing, profiles and stainless sheet steel. Especially suitable for corrosion and acid-resistant steel, spring steel, tool steel.

44823 107 | 44823

Ø x thickness mm	Shape	Bore Ø mm	Speed max. RPM	44823	...
115 x 0,8	offset	22,23	13.285		100
115 x 1,0	Straight	22,23	13.285		101
115 x 1,5	Straight	22,23	13.285	#	102
125 x 0,8	offset	22,23	12.200		107
125 x 1,0	Straight	22,23	12.200		103
125 x 1,5	Straight	22,23	12.200		104
150 x 1,5	Straight	22,23	10.185		109
180 x 1,5	Straight	22,23	8.600		105
230 x 1,9	Straight	22,23	6.600		106

115 x 0,8 + 125 x 0,8 mm



44830 - 44833 Free-Hand Cutting-Off Discs (Stainless Steel)

PFERD

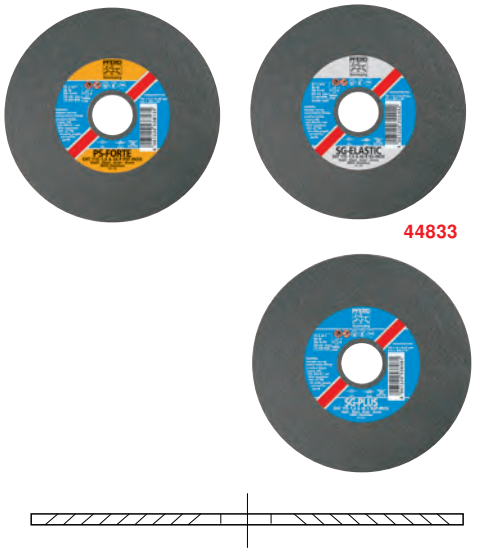
Type
In compliance with EN 12413. Fibre-reinforced, artificial resin bond. **Without filler materials which contain iron, sulphur, or chlorine.**
Use
For cutting sheet metal, tubing, profiles and solid stock made of **stainless steel.**

44830
Medium-hard wheel
Type A 24/46/60 P-INOX
Use
Thickness 1,0 mm: Fast, virtually burr-free cutting (e.g. sheet metal).
Thickness 1,6/1,9/2,4/2,5 mm: Long service life and fast cutting (universal)

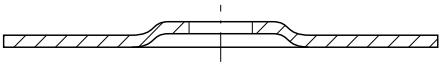
44832
Hard wheel
Type A 24/46/60 Q/R-INOX
Use
Thickness 1,0 mm: Quick, almost burr-free cutting (of e.g. sheet metal).
Thickness 1,6/1,9/2,4/2,5 mm: Very long service life and fast cutting (universal)

44833
Hard wheel
Type A 24/46/60 S-INOX
Use
Thickness 0,8/1,0/1,6 (Ø 178)/1,9 mm: Quick, almost burr-free cutting (of e.g. sheet metal).
Thickness 1,6 (Ø 115+125)/2,3 mm: Maximum service life and fast cutting (universal)
Thickness 2,2 mm: Longest service life and high lateral stability (e.g. profiled material or solid stock).

44830 | 44832 | 44833



115 x 2,2 + 125 x 2,2 mm



Ø x thickness mm	Shape	Grit size	Bore Ø mm	Speed max. RPM	Working speed max. m/s		P-INOX 44830	P-INOX ...	Q/R-INOX 44832	Q/R-INOX ...	S-INOX 44833	S-INOX ...
115 x 0,8	Straight	60	22,2	13.300	80	25 pcs.						101
115 x 1,0	Straight	60	22,2	13.300	80	25 pcs.		105		102		102
115 x 1,6	Straight	46	22,2	13.300	80	25 pcs.	#	106		103	#	103
115 x 2,2	Offset	46	22,2	13.300	80	25 pcs.					#	105
115 x 2,4	Straight	46	22,2	13.300	80	25 pcs.		107		104		
125 x 0,8	Straight	60	22,2	12.200	80	25 pcs.						155
125 x 1,0	Straight	60	22,2	12.200	80	25 pcs.		109		106		106
125 x 1,6	Straight	46	22,2	12.200	80	25 pcs.	#	110		107	#	107
125 x 2,2	Offset	46	22,2	12.200	80	25 pcs.					#	109
125 x 2,4	Straight	46	22,2	12.200	80	25 pcs.		111		108		
178 x 1,6	Straight	46	22,2	8.600	80	25 pcs.		112		109	#	110
178 x 2,3	Straight	24	22,2	8.600	80	25 pcs.					#	111
178 x 2,5	Straight	24	22,2	8.600	80	25 pcs.	#	113	#	110		
230 x 1,9	Straight	46	22,2	6.600	80	25 pcs.		114		111	#	115
230 x 2,5	Straight	24	22,2	6.600	80	25 pcs.		115	#	112		

= Sales are restricted to the packaging units mentioned in the catalogue. Purchase orders must be in units.

= partly extent in stock.

44811 Free-Hand Cutting-Off Discs (Stainless Steel Cubitron™ II

3M

Type
- Faster cut and longer service life
- Minimal annealing colours
- Thinnest cut with minimal feathering
- Fast, cool, grinding and optimised grinding processes

Use
Fast, convenient cutting of profiles, bars, and tubes, as well as stainless steel sheet, structural steel and non-ferrous metals.

44811

Ø x thickness mm	Shape	Bore Ø mm	Working speed max. m/s	44811 ...
76 x 1,0	Straight	6,35	80	101
76 x 1,0	Straight	9,53	80	102
115 x 1,0	Straight	22,20	80	103
115 x 1,6	Straight	22,20	80	104
115 x 2,5	Straight	22,20	80	105
125 x 1,0	Straight	22,20	80	106
125 x 1,6	Straight	22,20	80	107
125 x 2,0	Straight	22,20	80	108
125 x 2,5	Straight	22,20	80	109
180 x 1,6	Straight	22,20	80	110
180 x 2,0	Straight	22,20	80	111
180 x 2,5	Straight	22,20	80	112
230 x 2,5	Straight	22,20	80	113

44818 - 44819 Free-Hand Cutting-Off Discs (Stone)

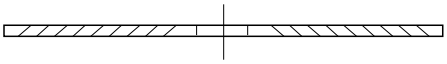
RHODIUS

Type
Glass fabric reinforcement, open structure.

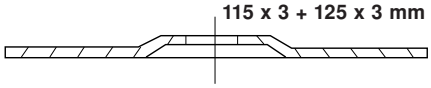
44818
Special hard type FT/FTK 44
Type
Long service life and wide application.
Use
For cutting concrete, natural and artificial stone as well as roofing tiles, granite, ceramics, clinker etc.

44819
Special hard type XT 66
Type
Very hard cutting-off disc. High cutting capacity at long service life. Smooth, precise edges. Up to 50% less dust.
Use
For tile, glazed tile, marble, window sills, steps, roofing slate, etc.
special application: Titanium.

44818 44819



115 x 3 + 125 x 3 mm



Ø x thickness mm	Shape	Bore Ø mm	Speed max. RPM	Working speed max. m/s	FT/FTK 44 44818	...	XT 66 44819	...
115 x 1,5	Straight	22,2	13.285	80			#	201
115 x 3,0	offset	22,2	13.285	80		101		
125 x 1,5	Straight	22,2	12.200	80			#	202
125 x 3,0	offset	22,2	12.200	80	#	102		
180 x 1,9	Straight	22,2	8.600	80			#	204
180 x 3,0	Straight	22,2	8.600	80	#	104		
230 x 1,9	Straight	22,2	6.600	80				205

44821 - 44822 Diamond Cutting-Off Discs

Use
For dry cuts with angle grinders. Especially for concrete, hard artificial stone, pantiles, clinker hard-baked, piping made of earthenware, piping made of clay, washed-out concrete etc.

44821
Type
Slotted edge with diamond segments.
High-performance series.

44822
Type
Smooth, closed edge.
Use
For glazed tiles, glazed clinker, thin natural stone.

44821

44822

Ø mm	Segment height mm	Segment width mm	Bore mm	44821	...	44822	...
110	5	1,9	22,23				101
125	5	1,9	22,23				102
115	10	2,2	22,23		101		
125	10	2,2	22,23		102		
180	10	2,4	22,23		103		
230	10	2,4	22,23		104		

44828 Diamond cutting-off discs (Allcut)

Type DG210 Allcut
Type
The diamond are attached directly to the pad and constantly guarantee good cutting capacity up to the point of total wear. Due to its long service life it works very economically on stone. Its performance on steel make it the perfect multi-purpose cutting-off disc. Reliable, quick, and cool cutting of various materials. High cutting speed, good machining performance, short cutting times, comfortable cutting behaviour.

Use
For dry and wet cutting. Suitable for concrete workpieces, reinforced concrete, natural stone, construction materials, steel, tiles, glazed tiles, wood, plastics, GRP.

44828

BRAINTOOLS by Rhodius

Ø mm	Segment height mm	Segment width mm	Bore mm	44828	...
115	3	2,5	22,23		101
125	3	2,5	22,23		102
150	3	2,5	22,23	#	103
180	3	2,8	22,23		104
230	3	2,8	22,23		105