

7 - Cutting and grinding disks



- Cutting and grinding disks 7-1 to 7-4

Cutting and grinding disks

WELDLINE is offering a range of cutting and grinding disks designed for the main applications of industrial customers

EN 12413

EN 13743

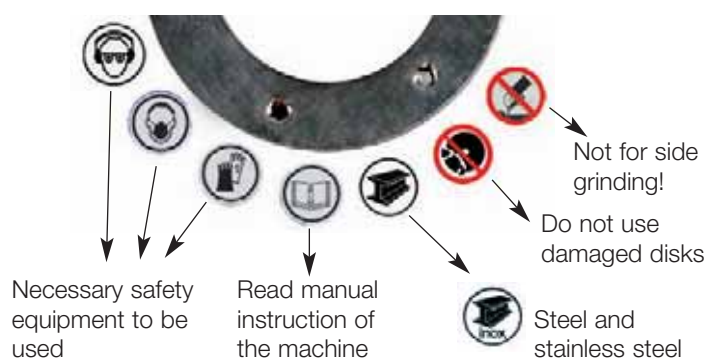


- Two extra thin cutting disks of 1 mm for steel and stainless steel.
- Flat and depressed centre, hard cutting disk range for structural steel.
- A range of hard grinding disks for structural steel.
- A range of abrasive flap disks for grinding, finishing and cleaning applications.

When buying such products, always ask for OSA certification.

The guarantee that the product complies with the safety standard and the additional requirements of the Organisation for the Safety of Abrasives

Pictograms description



Red line means maximum speed 80 m/s

Wheel diameter	Maximum revolution at 80 m/s
115 mm	13 300 rpm
125 mm	12 250 rpm
180 mm	8 500 rpm
230 mm	6 650 rpm



Cutting and grinding disks

DUCTIFLEX PRO

Top quality cutting disks for professional

A range of high quality product providing an ideal balance between performance and life duration.

Characteristics:

- Maximum speed 80 m/s
- Diameter 115 to 230 mm
- Thickness 1.0 to 3.2 mm
- Should be used within 3 years from the production date
- Design for steel, except the extra thin disks designed for steel and stainless steel



2007-111

Dimension	Shape	Use	Specification*	Unit / box	Catalogue N°
115 x 1 x 22 mm	flat	steel/stainless steel	61A 60 S7 BF	50	W 000 261 930
125 x 1 x 22 mm	flat	steel/stainless steel	61A 60 S7 BF	50	W 000 261 931
115 x 1.6 x 22 mm	flat	steel/stainless steel	61A 60 S7 BF	50	W 000 335 001
125 x 1.6 x 22 mm	flat	steel/stainless steel	61A 60 S7 BF	50	W 000 335 002
115 x 2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 932
125 x 2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 933
180 x 2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 934
230 x 2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 935
180 x 2.5 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 936
230 x 2.5 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 937
115 x 3.2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 938
180 x 3.2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 939
230 x 3.2 x 22 mm	flat	steel	A 36 S7 BF	25	W 000 261 940
115 x 2.5 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 261 941
115 x 3.2 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 335 005
125 x 2.5 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 261 942
125 x 3.2 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 335 006
180 x 2.5 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 261 943
230 x 2 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 335 003
230 x 2.5 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 261 944
230 x 3.2 x 22 mm	depressed	steel	A 36 S7 BF	25	W 000 335 004

- Extra thin wheels providing a fast and economical cutting performance on steel and stainless steel.
 - Extra long product life
 - High cutting speed
 - Specially efficient on steel bars, pipes, sheets or shaped sections
 - No need to eliminate burr after cutting
 - Less material waste
- Same quality with depressed center

- Hard cutting disks for structural steel.
- Long life duration
- Iron and structural steel cutting

Recommendations:



Cutting will be faster by using a smaller contact surface between the disk and the work piece

* Explanation of the specification: See next page



Cutting and grinding disks

DUCTIFLEX

A grinding range for standard structural steel

Characteristics:

- Steel surface cleaning, deburring, angle and corner dressing
- Very good balance between performance and price, long life product



2007-108

Dimension	Shape	Use	Specification*	Unit / box	Catalogue N°
115 x 6 x 22 mm	depressed	Standard steel	A 30 S7 BF	10	W 000 261 945
125 x 6 x 22 mm	depressed	Standard steel	A 30 S7 BF	10	W 000 261 946
180 x 6 x 22 mm	depressed	Standard steel	A 30 S7 BF	10	W 000 261 947
230 x 6 x 22 mm	depressed	Standard steel	A 30 S7 BF	10	W 000 261 948

Explanation of the specification



Abrasive type

A: Regular Aluminium oxide. For plain and low alloyed steel, cast steel and chilled cast iron
61A: Mixed Aluminium oxide. For grinding stainless steel and acid resisting steel

Grit size

16	20	22	24	30	36	40	46	54	60	70	80	90	100	120	150
Coarse				Medium						Fine					

Coarse for works without special precision, to fine for smoother surface

Hardness grade

E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S
Very soft			Soft				Medium				Hard			

Soft grade are dedicated to hard materials, hard grade to softer materials

Structure

3	4	5	6	7	8	9	10	11	12	13
Closed		Medium				Open			Very open	

Ratio between grain, bond and pore. The softer the material is the more open structure is recommended

Bond

V	B	BF
Vitrified bonded	Resinoid bonded	Glass fibre

Resinoid bond are more flexible, for dynamic and forceful use than vitrified bond
 Glass fibre increase the resistance specially for heavy usage



Cutting and grinding disks

DUCTIFLAP

Abrasive flap disks

These disks are made by cutting abrasive fabrics, then cutting as flaps and bonding them on a fiberglass or nylon backing plate by an adhesive.

Our DUCTIFLAP disks are based on Zirconia Alumina, specially design for steel, alloyed steel, non ferrous material; cast iron, wood and plastic.

We use conical disks as it's possible to use them for curve surface, for edge grinding as well as lubricious r primed surfaces.

The grits are either 40, 60 or 80 the higher the grit is, the more precise the result is.

The types are 115 x 22 mm and 125 x 22 mm.

Bonding material: synthetic resin bonding phenolic resins.

Backing plate: fibreglass or nylon (plastic).

Filler: kryolits, calcide.

Shape: flat or conical 15%.



2009-010



2009-011

Dimensions	Grit	Unit/box	Shape	
			15 % conical for fiberglass backing	Flat for nylon backing
115 x 22 mm	40	10	W 000 264 532	W 000 273 754
	60	10	W 000 264 533	W 000 273 759
	80	10	W 000 335 007	W 000 273 758
125 x 22 mm	40	10	W 000 264 535	W 000 273 757
	60	10	W 000 264 534	W 000 273 756
	80	10	W 000 335 008	W 000 273 755

Personnal protection: protect your eyes and ears, wear a dust mask, safety gloves, (safety shoes & leather apron are recommended).

Storage: in dry and well ventilated areas.

Temperature between 18 and 22 °C, relative humidity between 45 and 60%.

The speed of the machine must never exceed the maximum operating speed of the disk: 80 m/s.