

Transforming
surfaces
...and beyond

NORTON

SAINT-GOBAIN

CATALOG #7362

FULL-LINE STOCK CATALOG
ABRASIVE PRODUCTS FOR
THE INDUSTRIAL MARKET



BECAUSE **RIGHT CHOICES** MATTER™


SAINT-GOBAIN

Transforming
surfaces
...and beyond

Our Mission

We offer powerful, precise, user-friendly solutions, which enable our customers to cut, shape and finish all materials even in the most complex and challenging applications. By working closely with end-users and our grinding expert partners, we design and provide customized solutions to secure the best option for performance, cost and safety.

Our Expertise

Norton is the leading brand of Saint-Gobain Abrasives, with more than 135 years of experience in manufacturing abrasives.

We are committed to providing access to our expert's knowledge whenever you need it. Whether it is through our [Process Solutions Program \(PSP\)](#), ongoing training programs, or through on-line expert articles and white papers you can stay up-to-date with Norton where and when you need it.

Bring us your grinding challenges, we have solutions!

Our Commitment

You be the final judge in performance! We are so confident of the superior performance of our abrasive products, as recommended for specific applications, that we invite in-plant tests against any other brand of abrasive product on the market. Contact your Norton Representative to find out more about our No Risk test policy or visit nortonabrasives.com



Why Tiers Matter

At Norton we believe in delivering right choices that matter. Our abrasives are classified in BEST, BETTER, and GOOD performance/price tiers to help you choose the right product for your specific application every time.

BEST

Our BEST tier products are designed for the customer who is seeking the highest productivity at the lowest total cost.

BETTER

Our BETTER tier products provide an excellent blend of performance and price.

GOOD

And, our GOOD tier products promise the highest quality you expect from the Norton name with a low initial price.

If you need help determining the right tier for your specific needs, don't hesitate to contact us directly or reach out to your Norton sales representative.

Go Further

Visit our website at nortonabrasives.com for a more comprehensive outline of products, safety and application information. We continually update it with our most current information.

Connect with us:



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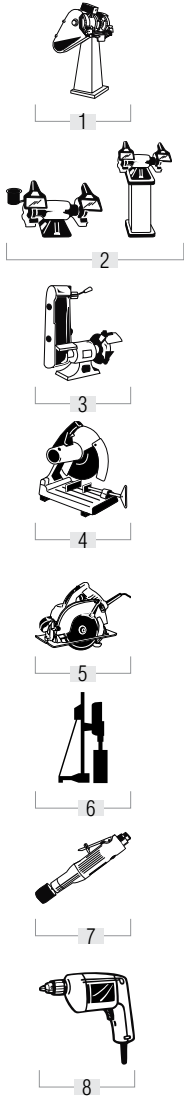
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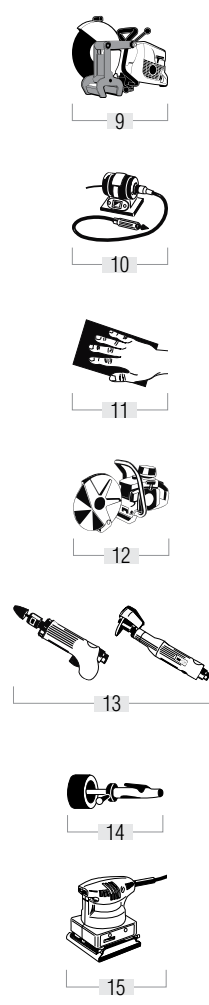
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Easy-to-Follow Page Guide Key Questions to Simplify Product Selection

Am I in the right section?

- A** Product
- B** Category overview
- C** General attributes
- D** Correct machine use

How do I narrow choices?

- E** Product design variations

How do I match my end-user needs?

- F** Application recommendations
- G** Best/Better/Good performance color coding
- H** Full application / grit guide

How do I match or upgrade from a competitive product?

- I** Cross reference guide

COATED & NON-WOVEN ABRASIVES
Flap Discs

A Product image showing a worker using a flap disc.

B Flap Disc Shapes: Type Z7 Flat - The Best Choice for Finishing. Type Z9 Convolute - The Best Choice for Aggressive Disk Removal.







E Abrasive Flap Densities: Standard Density, High Density.

F Backing Plate Materials: All flap discs are a combination of abrasive flap wheel in a rigid backing plate.

COATED & NON-WOVEN ABRASIVES
Flap Discs

F Materials-to-Product Recommendation Guide: Table with columns for Material, Flap Disc, Best Fit, and Best Price.

I Cross Reference Guide: Table for matching products from different manufacturers.

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COATED & NON-WOVEN ABRASIVES Flap Discs

BLAZE R80P CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain looks 50% - 200% longer than other flap discs on stainless steel, cast-iron, chrome, titanium and other hard-to-cut materials.
- 3-angled abrasive flap with a wide, flat and rounded leading edge. High resistance to grain shedding, and long resistance while providing a cool, non-sparking cut.
- High strength fiberglass back on Type 27 High Density is available. High weight, and abrasive retention. Back flange glazes backing plate on Type 27 Quick Turn allows for removability of the plate.

BLUEFIRE R860 ZIRCONIA ALUMINA

- High performance zirconia alumina abrasive for aggressive cut and long life, with up to 20% longer life than competitive zirconia alumina products.
- Proprietary 3-angled flap with wide, flat and rounded leading edge and rounded backing on diameter.
- High strength fiberglass back on Type 27 and Type 29 High Density is available. High weight, and abrasive retention. Back flange glazes backing plate on Type 27 Quick Turn allows for removability of the plate.
- Available in 2-disc packages - a ideal for maintenance, small jobs, or carrying to a job site.

METAL R828 ZIRCONIA ALUMINA

- Durable zirconia alumina abrasive grain provides good cut rate with wide consistent finish.
- Proprietary 3-angled flap with wide, flat and rounded leading edge and rounded backing on diameter.
- Good choice for coarse grinding, deburring, and stock removal.

BlueFire R860

BlueFire R860 Zirconia Alumina flap discs are designed for aggressive cutting and long life in a wide range of materials.



COATED & NON-WOVEN ABRASIVES Flap Discs

Disc Color	Material	Grain	Backing	Flap Disc	Flap Disc	Flap Disc	Flap Disc
N	Non-Woven	Alumina	Fiberglass	Flap Disc	Flap Disc	Flap Disc	Flap Disc
M	Metal	Zirconia Alumina	Fiberglass	Flap Disc	Flap Disc	Flap Disc	Flap Disc
J	Jet	Ceramic Alumina	Fiberglass	Flap Disc	Flap Disc	Flap Disc	Flap Disc
K	Key	Alumina	Fiberglass	Flap Disc	Flap Disc	Flap Disc	Flap Disc
L	Lead	Zirconia Alumina	Fiberglass	Flap Disc	Flap Disc	Flap Disc	Flap Disc

Industrial Market - Full-Line

What are the Leading Products by Tier?

J Tiers by color-coding: Best, Better, Good
K Features and benefits
L New, improved, and/or expanded offering

How Do I Find the Right Product for the job?


M Visual identification
N Key product attributes
O Full specification and product number

PLAY IT SAFE


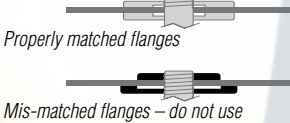


— AT THE WHEEL —





Visit our newly updated safety website for safety guides, safety data sheets, videos and lots of additional safety resources at nortonsga.us/safety

 **WARNING**

Improper use of abrasive products might cause grinding wheel breakage and serious injury. Comply with ANSI B7.1, OSHA and Safety Guide furnished with package. Don't overspeed, abuse, or drop wheel. Always use a guard, personal protective equipment and proper mounting procedures.

<div style="text-align: center;">  <p>Speeds</p> <p>Check machine spindle speed and speed listed on machine against safe maximum operating speed marked on the grinding wheel. Do not overspeed the wheel.</p> </div>	<div style="text-align: center;">  <p><i>Properly matched flanges</i></p>  <p><i>Mis-matched flanges – do not use</i></p> <p>Flanges</p> <p>When mounting most grinding wheels, use flanges of equal diameter and bearing surface. For exceptions, see ANSI B7.1.</p> </div>	<div style="text-align: center;">  <p>Safety Gloves</p> <p>Grinding applications are conducted in harsh environments. The use of proper fitting gloves is recommended.</p> </div>
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<div style="text-align: center;">  <p>Wheel Guard</p> <p>Always use the wheel guard as supplied by the machine manufacturer, in the proper position.</p> </div>	<div style="text-align: center;">  <p>Do Not Use Damaged Wheel</p> <p>Always check each wheel for cracks or damage before use. Never use a damaged wheel.</p> </div>	<div style="text-align: center;">  <p>Eye/Face Protection</p> <p>Always wear government-approved face and eye protection when using abrasive products.</p> </div>	<div style="text-align: center;">  <p>Hearing Protection</p> <p>Use of abrasive products can create elevated sound levels. Hearing protection must be worn where required.</p> </div>
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<div style="text-align: center;">  <p>safety.uama.org</p> <p>Safety Guides, SDS and Wheel Warning Messages</p> <p>Before using any abrasive materials, READ:</p> <ul style="list-style-type: none"> The Safety Guides Wheel Warning Messages Safety Data Sheets (SDS) <p>All Norton products provide information pertaining to safe use. Please take the time to read it carefully. Contact suppliers of the workpiece and abrasive materials for copies of the SDS if one is not readily available. Norton abrasives SDS can be obtained on nortonsga.us/safety</p> </div>	<div style="text-align: center;">  <p>Dust Protection</p> <p>Exposure to dust generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury. Use dust capture or local exhaust as stated in the SDS. Wear government-approved respiratory protection and eye and skin protection. Failure to follow this warning can result in serious lung damage and/or physical injury.</p> <p>This is a general dust warning and does not cover specific situations. For more information, refer to the SDS dust warning provided with your products, and workpiece.</p> </div>
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Please see [pages 359 - 368](#) for additional safety information

when the going
gets rough
**RELY ON
NORTON INNOVATION**

For stock removal, rough blending,
cleaning castings and welds...Norton
depressed center wheels are
constructed to tackle the demanding
work of all material types.





Depressed center wheels may also be referred to as raised hub wheels or by their shape designation of "Type", with Type 27 being the most popular. The depressed center design allows the flange/lock nut to recess within the wheel so that it can be used for various grinding and cutting applications. Depressed center wheels are designed to handle the most severe right angle grinding applications from heavy stock removal to rough blending. More recently, depressed center wheels have been designed to increase the utility of the tool for cut-off applications. While large right angle grinders (7" & 9") have been around for many years, small or mini grinders that handle 4", 4-1/2", 5", and 6" wheels have made this machine, and wheel category, the most popular in power tools.

- Applications:** Grinding, stock removal, edge chamfering, beveling, weld blending, and cutting-off
- Size Range:** 2" – 9"
- Thickness Range:** .040" – 1/4"
- Grit Range:** 24 – 46 grits for stock removal;
60, 80 grits for blending and finishing
- Abrasive Grain:** Ceramic Alumina, Diamond, Zirconia Alumina, Aluminum Oxide, Silicon Carbide
- Mounting Options:** Plain hole (3/8", 5/8" and 7/8") and mount (5/8"-11)
- Shape:** Type 27, Type 28, Type 29
- Machine Used:**



RIGHT ANGLE GRINDER

How to Pick the Right Wheel

DEPRESSED CENTER WHEEL DESCRIPTION CODES			
BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free
■ = Aluminum	■ = Foundry	■ = Stainless	■ = Steel / Metal

DESCRIPTION CODE DEFINITIONS	
BLANK = All Purpose	Where an excellent blend of cut rate and life is needed.
FC = Fast Cut	Where fast stock removal is needed, or the application only allows for low-pressure or under-horsepowered grinders.
HD = Heavy Duty	Triple reinforced for the most aggressive foundry applications
INOX/SS = Contaminate Free	Contain <0.1% iron, sulfur or chlorine for rust-free and corrosion-free results. Will not contaminate stainless steel.

How to Pick the Right Mount

Most wheel sizes come with a plain hole or a discard mount option. While the plain hole has a small, initial cost advantage, the discard mount can provide a labor cost advantage with the quicker wheel change.

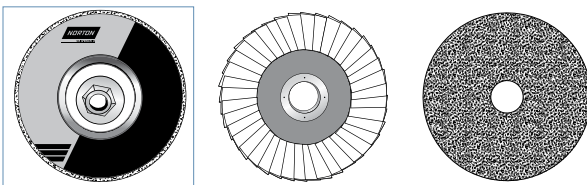


Mini-Mount Hub

Our unique mini-mount hub used on 4-1/2" and 5" depressed center wheels provides up to 30% more wheel life because the hub covers just a small surface area, providing maximum grinding area exposure and usage.

Standard throw-away hub size

Why Choose Depressed Center Wheels?



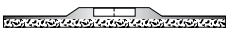

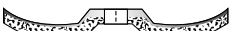
Depressed Center Wheels vs. Flap Discs or Fiber Discs

- Up to 5X life over flap discs, less downtime and inventory
- Up to 100X life over fiber discs, less downtime and inventory
- Rigidity for severe operations and high power grinders
- 1/8" wheels can be used for cutting and grinding
- Can be used to grind inside corners at outer edge of wheel



How To Mount a Depressed Center Wheel:
Mounted Hub vs No Hub
nortonsga.us/7hc5m

Type-To-Application Recommendation Guide

Wheel Type/Thickness	Applications	90° ANGLE	30° ANGLE	15° ANGLE
 <p>TYPE 27</p> <p>Type 27 wheels are essentially straight wheels that have a “depressed center/ raised hub”. Different types of fiberglass reinforcement mesh give the product stability for use on the periphery, on the face, or a combination of the two.</p>				
.040", .045", and 1/16" Type 27/42 RightCut	Cutting only, where fast cutting and low kerf loss are desired	◆		
3/32" and .125" Type 27/42	For tough cutting and notching applications where stability is important; cutting and cleaning burr-free narrow root pass welds	◆		
1/8" Type 27	For multiple applications ranging from cutting-off, notching and light-duty side grinding	◆	◆	
1/8" Pipe Notcher Type 27	2-1/2 pieces of reinforcement; durable face grinding; root pass grinding without removing pipe material	◆	◆	
1/8" Type 27 Flexible	For light stock/blending/finishing/polishing		◆	
.140" and 1/8" Type 27 Foundry Notchers	Triple-reinforced for grinding steel and dirty/scale-covered castings; removing and cleaning gates and risers	◆	◆	
1/4" Type 27	For light- to heavy-duty grinding on the bottom/face of the wheel		◆	
1/4" Type 27 Foundry Snaggers	Designed for cleaning parting lines, pads and slag		◆	
1/4" Type 27 Heavy-Duty Foundry	Triple-reinforced for the most aggressive foundry applications		◆	
 <p>TYPE 28</p> <p>Type 28 wheels are constructed with a downward angle built into the grinding section to facilitate a flatter grinding angle. These wheels can only be used on the face and never on the periphery for cutting-off.</p>				
1/4" Type 28	Smooth, gouge-free grinding at shallow angles			◆
 <p>TYPE 29</p> <p>Type 29 wheels are constructed with an upward angle built into the grinding section to provide full face contact for light stock removal and blending operations. These wheels can only be used on the face and never on the periphery for cutting-off.</p>				
1/8" Type 29 Flexible, AVOS	Polishing and blending applications			◆

Material/Application-To-Product Recommendation Guide

	BEST Quantum3	BETTER BlueFire	Norton for Aluminum	GOOD Gemini	Metal
CUTTING					
Mild Carbon / High Tensile Steel	◆	◆		◆	◆
Stainless Steel / Alloys	◆	◆		◆	◆
Contaminate Free*		◆ FC/INOX/SS		◆ INOX/SS	
Cast Iron	◆			◆	
Aluminum / Bronze / Brass			◆		
NOTCHING					
Mild Carbon / High Tensile Steel	◆	◆		◆	◆
Stainless Steel / Alloys	◆	◆		◆ INOX/SS	
Contaminate Free*		◆ FC/INOX/SS		◆ INOX/SS	
Cast Iron	◆	◆ Foundry		◆	
Aluminum / Bronze / Brass			◆		
GRINDING					
Mild Carbon / High Tensile Steel	◆	◆		◆	
Stainless Steel / Alloys	◆	◆		◆	
Contaminate Free*	◆	◆ FC/INOX/SS		◆ INOX/SS	
Cast Iron		◆ Foundry		◆	
Gray Iron	◆	◆ Foundry		◆	
Aluminum / Bronze / Brass			◆		
BLENDING					
Mild Carbon / High Tensile Steel				◆ Flexible	
Stainless Steel / Alloys				◆ Flexible	
Aluminum / Bronze / Brass			◆	◆ Flexible	
Fiberglass / Plastic				◆	

Typical Steel, Stainless Steel, Cast Iron Products: Angle Iron, Bar Stock, Ductile Pipe, Channel Iron, Decking, Rebar, I-Beams, Rail Steel, Studs, Tubing, and Welds
* For use in nuclear and food industry applications that require contaminant free (<0.1% iron, sulfur or chlorine)

Cross Reference Guides

Type 27 and 28 – 1/8" and 1/4"

NORTON	TOTAL PERFORMANCE						INITIAL PRICE	SPECIALTY	
	BEST	BETTER		GOOD			BETTER		
	Quantum3	BlueFire	BlueFire FC/INOX/SS	Gemini	Gemini Fast Cut	Gemini SS	Metal	BlueFire Foundry	Norton ALU
3M	Cubitron II	Silver, High Perform., Green Corps	-	-	-	-	-	-	-
Arc	-	-	-	Predator A24R	-	-	-	-	-
Bullard	TA24S	ZA24R Competitor	ZA24R	A24R	A24N	A46Q	A24R CompetitorC24R	-	AL36N
Camel	-	-	ZA24T	A24R	Ultra A24-N-BF, A24T Super Quickie Cut	WA24S	A24N, R&T Fast CutC24R	-	A30N, Fast Cut
DeWalt	XP Ceramic	XP, HP	-	-	-	HP SS	Metal	-	-
Flexovit	Flexon ZA24P, ZA30T, Flexon ZA20Q	Metalhog, AXT24S	-	High Perform. A24/30T	High Performance A30S, Specialist A30Q & R	Free Grind A30Q	High Perform. C24/30P	Flexon ZA16U	HP Aluminum
Metabo	M-Calibur	ZA24T	-	A24R & T	A24N	A360	C24N	-	A36M
Pearl	-	-	Z24T	Premium Metal A24S, Redline Max A/WA24S	Premium Metal A24R, Redline Max A/WA24R	WA24R, SRT24	Silver Line A24R & Silver Line C24S	-	D.A. Series AL24M
Pferd	SG-Elastic Ceramic C024Q	ZA SGP, ZAT SGP, SG-Elastic	ZA R SGP, Z-SG	A-PS, A-SG	-	A-SG INOX, A-PS INOX	S-SG, Masonry	-	A-SG ALU
Sait	The Ultimate Grind, Saitech Ultimate Perform, Saitech Attacker, Pipeline	Z24R Z-Tech	Stainless	A24R, A24Turbo	A24N	XA24Q	A24T, C24N	CA24R - Foundry	A46N-ALU
Tyrolit	-	ZA24P-BFX	ZA24N-BFX	A30S & Q-BFX	A30R-BFX	A30-BF INOX	A30-BF	ZZA24R-BFX	A36N-BFX WA46-BF
Walter	-	Allsteel XX, Allsteel	Double-X	HP	-	Stainless	-	-	A30 Zip ALU
Weiler	Tiger Ceramic	Tiger Zirc, Tiger LL	Tiger Inox	Wolverine A24R	-	-	Wolverine A24N	-	Tiger ALU 24R

Type 27 – Flexible 1/8"

	GOOD
NORTON	Gemini Flexible
Bullard	Flexlite AC
Camel	FGF, Special Wheel
Flexovit	Flexcel
Metabo	Z-Plus
Pearl	Flexible AC
Pferd	SG-Flex
Sait	Challenger II
Walter	Flexcut





Best choice for stainless and carbon steel applications; efficiently grinds and cuts a variety of materials from alloys to gray iron

QUANTUM3 CERAMIC ALUMINA

- 100% next-generation, uniquely-shaped, ceramic alumina abrasive grain and tough new bond system result in 5-6 times the life of aluminum oxide wheels and up to 100% increase in performance and life over competitive ceramic wheels
- Significantly increase production, for the lowest total grinding cost of any wheel in the market place today
- Better operator control, improved comfort, and exceptional finished part quality with a more robust, sharper, yet smoother cutting action; wheels don't grab or dig



Best for metal plate, pipe, tubing, cast iron, carbon and mild steel, foundry and welding applications, and ceramics

DIALAST DIAMOND WHEELS

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for exceptional wheel life; less blade changes reduce downtime and labor costs
- Environmentally friendly design generates minimal dust for less clean-up and safer working conditions



Better choice for stainless steel, carbon steel, alloys and gray iron

BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- A blend of the most advanced zirconia alumina and premium aluminum oxide abrasives delivers 2 to 3 times the life of aluminum oxide wheels
- Broad utility; from light-to heavy-pressure applications
- Engineered specifically to deliver fast cut rate; excellent blend of performance and price

Better choice for aluminum



NORTON FOR ALUMINUM

- Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- Non-loading, specially designed bond, allowing fast, free-cutting with long-lasting performance
- Contaminant free, no need for waxes or lubricants

Good choice for steel and ferrous metals as well as specialty applications



GEMINI ALUMINUM OXIDE

- Upgraded with a new premium aluminum oxide grain for 15% faster cut rate
- High-performance bond and wheel hardness are designed for fast cut and up to 60% more life and metal removed per wheel
- Good choice for grinding 400 series stainless and hard and soft carbon steel applications including heavy stock removal, weld repairs, flashing, multi-pass welding for pipe fitting, and notching

Good choice for steel/ferrous metal applications with low initial price



METAL ALUMINUM OXIDE

- Durable bond and wheel hardness are designed to provide an good mix of cut rate and life
- Good choice when low initial price is needed for small jobs or newer operators
- Metal (Aluminum Oxide) engineered for all steel/ferrous materials



TIER:	BEST	GOOD
TRADENAME:	NORZON PLUS	GEMINI
SHAPE:	Type 27	Type 27
ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
1/8" (5/32") – Pipe Notching – Type 27				
4-1/2 x 1/8 (5/32) x 5/8-11	13,580	10		662533 70272
4-1/2 x 1/8 (5/32) x 7/8	13,580	25		662533 70271
5 x 1/8 (5/32) x 5/8-11	12,225	10		662533 70273
5 x 1/8 (5/32) x 7/8	12,225	25		662528 42038
6 x 1/8 (5/32) x 5/8-11	10,185	10		662528 41193
7 x 1/8 (5/32) x 5/8-11	8,600	10	662529 39184	662533 70274
9 x 1/8 (5/32) x 5/8-11	6,600	10	662530 49066	662533 70275

Pipe Notchers are to be used for cutting/notching only.

See Type 27 .040" – 1/4" Foundry, Type 28, Type 27 Flexible, and Type 29 Blending Wheels at the end of this section.



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	QUANTUM3	BLUEFIRE	GEMINI	METAL
SHAPE:	Type 27	Type 27	Type 27	Type 27
ABRASIVE:	Ceramic Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
1/8" – Cutting / Notching / Light Grinding – Type 27					
4 x 1/8 x 3/8	15,280	25		662528 43178	662528 42016
4 x 1/8 x 5/8	15,280	25			662528 42017
4-1/2 x 1/8 x 5/8-11	13,580	10	662528 39423	662528 43211	662528 43590
	13,580	10		662528 43191 FC/INOX/SS	662528 43609
4-1/2 x 1/8 x 7/8	13,580	25	662528 39424	662528 43212	662528 43591
	13,580	25		662528 43190 FC/INOX/SS	662528 43611
5 x 1/8 x 5/8-11	12,225	10	662528 39425	662528 43215	662528 43615
5 x 1/8 x 7/8	12,225	25	662528 39426	662528 43216	662528 43596
	12,225	25		662528 43194 FC/INOX/SS	662528 43616
6 x 1/8 x 5/8-11	10,185	10	662528 39427	662528 43199 FC/INOX/SS	662528 33965
6 x 1/8 x 7/8	10,185	20	662528 39428	662528 43202	662528 01864
	10,185	20		662528 43198 FC/INOX/SS	
7 x 1/8 x 5/8-11	8,600	10	662528 39429	662528 43233	662529 39259
	8,600	10		662528 43183 FC/INOX/SS	076607 02678
7 x 1/8 x 7/8	8,600	20	662528 39430	662528 43234	662529 39207
	8,600	25*			076607 75956 5-Pk
9 x 1/8 x 5/8-11	6,600	10	662528 39431	662528 43244	662530 48983
	6,600	10		662528 43187 FC/INOX/SS	
9 x 1/8 x 7/8	6,600	20	662528 39432	662528 43245	662530 48994

* 5-wheel Job Packs; wheels are packed 5 wheels/Pack, with 5 Job Packs/carton. Order per each wheel in standard package quantities of 25. Order in multiples of 25.

DEPRESSED CENTER WHEEL DESCRIPTION CODES

BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free
■ = Aluminum	■ = Foundry	■ = Stainless	■ = Steel / Metal



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	QUANTUM3	BLUEFIRE	GEMINI	METAL
SHAPE:	Type 27	Type 27	Type 27	Type 27
ABRASIVE:	Ceramic Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
1/4" – Grinding – Type 27						
3 x 1/4 x 3/8	18,000	25			662528 42179	
4 x 1/4 x 3/8	15,280	25	662533 71180	662528 43179	662528 42018	
4 x 1/4 x 5/8	15,280	25	662533 71181	662528 43177		662528 42011
	15,280	25			662528 42019	
4-1/2 x 1/4 x 5/8-11	13,580	10	662533 70793	662528 43213	662528 43593	662528 43605
	13,580	10		662528 43193 FC/INOX/SS	662528 43585 FC	
	13,580	40				662528 19559
4-1/2 x 1/4 x 7/8	13,580	25	662533 70794	662528 43214	662528 43594	662528 43607
	13,580	25		662528 43192 FC/INOX/SS	662528 43584 FC	
	13,580	25			662528 42033 INOX/SS	
	13,580	50				662528 36796
5 x 1/4 x 5/8-11	12,225	10	662533 70795	662528 43217	662528 43597	662528 43613
	12,225	10		662528 43197 FC/INOX/SS		
5 x 1/4 x 7/8	12,225	25	662533 70796	662528 43218	662528 43598	662528 43614
	12,225	25			662528 42040 INOX/SS	
6 x 1/4 x 5/8-11	10,185	10	662533 70797	662528 43224	662528 32390	
6 x 1/4 x 7/8	10,185	20	662533 70798	662528 43203	662528 01865	
7 x 1/4 x 5/8-11	8,600	10	662533 70799	662528 43235	662529 40147 FC	662529 12633
	8,600	10		662528 43185 FC/INOX/SS	662529 40148	
7 x 1/4 x 7/8	8,600	20	662533 70800	662528 43236	662529 40098	
	8,600	25*				076607 75936 5-Pk
9 x 1/4 x 5/8-11	6,600	10	662533 70801	662528 43246	662530 49105 FC	
	6,600	10			662530 49104	
	6,600	25*				076607 75938 5-Pk
9 x 1/4 x 7/8	6,600	20	662533 70802	662528 43247	662530 49077 FC	
	6,600	20		662528 43188 FC/INOX/SS	662530 48991	

* 5-wheel Job Packs; wheels are packed 5 wheels/Pack. with 5 Job Packs/carton. Order per each wheel in standard package quantities of 25. Order in multiples of 25.

See 1/4 inch thick Type 27 Foundry and Type 28 Wheels on the next page.






TIER:	BETTER	BETTER
TRADENAME:	NORTON FOR ALUMINUM	NORTON FOR ALUMINUM
SHAPE:	Type 27	Type 27
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
MATERIAL:	ALUMINUM	ALUMINUM

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
1/4" – Grinding – Type 27				
4 x 1/4 x 5/8	15,280	25		662528 49366
4-1/2 x 1/4 x 7/8	13,580	25		662528 49373
4-1/2 x 1/4 x 5/8-11	13,580	10		662528 49374
5 x 1/4 x 7/8	12,225	25		662528 49375
6 x 1/4 x 7/8	12,225	20		662528 49376
7 x 1/4 x 7/8	8,600	20		662528 49377
7 x 1/4 x 5/8 - 11	8,600	10		662528 49378
9 x 1/4 x 5/8-11	6,600	10		662528 49379
1/8" Cutting / Notching / Grinding– Type 27				
4-1/2 x 1/8 x 7/8	13,580	25		662528 49380
4-1/2 x 1/8 x 5/8-11	13,580	10		662528 49381





TIER:	BEST	BEST	BEST	BETTER	GOOD
TRADENAME:	QUANTUM3	DIALAST	DIALAST	BLUEFIRE	GEMINI
SHAPE:	Type 28	Type 29	Reversible	Type 28	Type 28
ABRASIVE:	Ceramic Alumina	Diamond	Diamond	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
1/4" – Grinding – Type 28 							
7 x 1/4 x 5/8-11	8,600	10	662533 70803			662528 43229	662529 40149
7 x 1/4 x 7/8	8,600	20					662529 40095
9 x 1/4 x 5/8-11	6,600	10	662533 70804			662528 43237	662530 49106
9 x 1/4 x 7/8	6,600	20	662533 70805				662530 49081
Light Grinding – Type 29 							
4-1/2 x 5/8-11	13,600	1		662533 70009			
5 x 5/8-11	12,225	1		662533 70010			
6 x 5/8-11	10,200	1		662533 70011			
7 x 5/8-11	8,600	1		662533 70012			
1/4" – Grinding – Reversible Grinding Disc 							
4-1/2 x 1/4 x 5/8-11	13,600	1			662533 70019		
7 x 1/4 x 5/8-11	8,600	1			662533 70020		



TIER:	BEST	BEST	BETTER
TRADENAME:	QUANTUM3	DIALAST	BLUEFIRE
SHAPE:	Type 27	Type 27	Type 27
ABRASIVE:	Ceramic Alumina	Diamond	Zirconia Alumina/ Silicon Carbide
MATERIAL:	FOUNDRY	FOUNDRY	FOUNDRY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
.140", 1/8" – Cutting / Notching / Lt. Grinding – Type 27 					
4-1/2 x 1/8 x 5/8-11	13,580	10			662528 43206
4-1/2 x 1/8 x 7/8	13,580	25			662528 43204
7 x .140 x 5/8-11	8,600	1		662533 70014	
7 x 1/8 x 5/8-11	8,600	10			662528 43232
7 x 1/8 x 7/8	8,600	20			662529 15526
9 x .140 x 5/8-11	6,600	1		662533 70015	
9 x 1/8 x 5/8-11	6,600	10			662528 43240
9 x 1/8 x 7/8	6,600	20			662528 43238
1/4" – Grinding – Type 27 					
4 x 1/4 x 3/8	15,280	25			662528 43181
4 x 1/4 x 5/8	15,280	25			662528 43180
4-1/2 x 1/4 x 5/8-11	13,580	10			662528 43207
4-1/2 x 1/4 x 7/8	13,580	25			662528 43205
7 x 1/4 x 5/8-11	8,600	10			662528 43231
7 x 1/4 x 7/8	8,600	20			662528 43230
9 x 1/4 x 5/8-11	6,600	10	662533 70849 HD		
	6,600	10			662528 43261 HD
9 x 1/4 x 7/8	6,600	20	662533 70848 HD		
	6,600	20			662528 43260 HD

All Norton foundry wheels are designed and reinforced to withstand the most aggressive foundry applications.

DEPRESSED CENTER WHEEL DESCRIPTION CODES

BLANK = All Purpose FC = Fast Cut HD = Heavy Duty INOX/SS = Contaminant Free
 ■ = Aluminum ■ = Foundry ■ = Stainless ■ = Steel / Metal

Blending Wheels

Gemini Flexible

Type 27 wheel features a unique pattern with square grooves that prevent loading and promote cooling, this Gemini Flexible grinding wheel polishes your aluminum, hard carbon steel and soft carbon steel projects effectively and efficiently without gouging. 7/8 arbor wheels are sold with a back plate included for safety.

The Gemini Type 29 blending wheel is ideal for larger blending jobs and has a raised bump surface pattern to promote cool grinding, ideal for aluminum. The shape allows for a flatter grind and higher contact area. Can also be used to blend stainless, hard, and soft carbon steel.



TIER:	GOOD	GOOD
TRADENAME:	GEMINI FLEXIBLE	GEMINI FLEXIBLE
SHAPE:	Type 27	Type 29
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
MATERIAL:	ALUMINUM	ALUMINUM
	STEEL/METAL	STAINLESS
	STEEL/METAL	STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	GRIT	PART #	PART #
1/8", 1/4" – Blending – Type 27 and 29					
2 x 1/8 x 3/8	30,560	25	60	662528 35632*	
4 x 1/8 x 5/8	15,280	20	36	662435 29721#	
4-1/2 x 1/8 x 5/8-11	12,000	10	36		662528 42203
4-1/2 x 1/8 x 7/8	12,000	25	36	662528 30424#	662528 42204
5 x 1/8 x 7/8	12,225	25	36		662528 42205
7 x 1/8 x 5/8-11	8,600	10	36	662529 39024	662529 17052

*Norton Metal, 5 wheels per display pack; 5 display packs per standard package.

These wheels are packed 20 per box, and must be used with this specific back plate. Two back plates are included in each box.



Depressed Center Adapter Kit

This reusable adapter kit contains everything you need to mount depressed center wheels and saucers with 7/8" center holes on to portable right angle or vertical shaft grinders. Adapter hubs are threaded for mounting on to standard 5/8"-11 NCRH spindles.

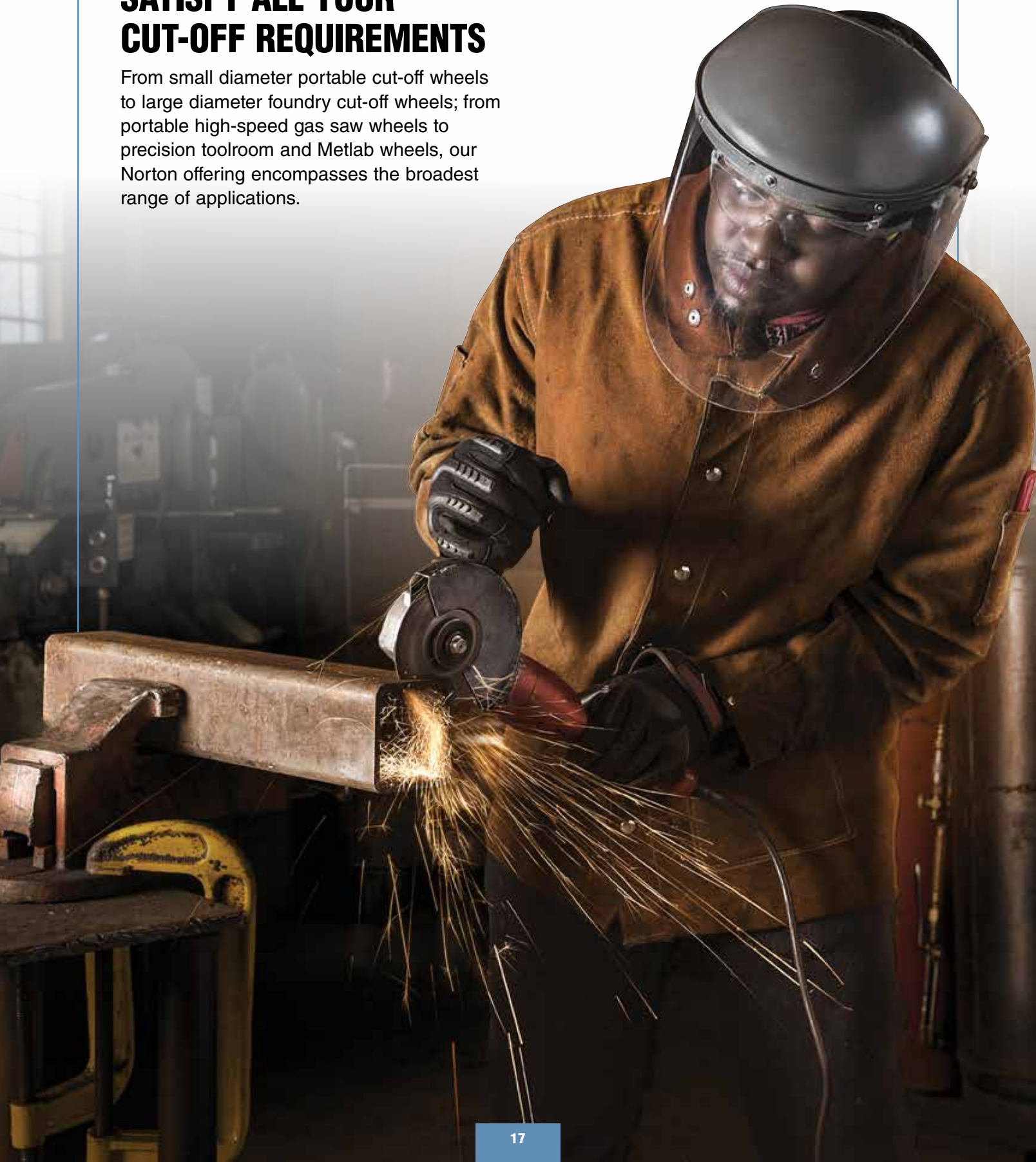
KIT NO.	WHEEL DIAMETER	WHEEL THICKNESS	PART #	STD. PKG.
114	7" thru 9"	1/16" thru 1/4"	076607 89275	1

DEPRESSED CENTER WHEEL DESCRIPTION CODES

BLANK = All Purpose	FC = Fast Cut	HD = Heavy Duty	INOX/SS = Contaminant Free
■ = Aluminum	■ = Foundry	■ = Stainless	■ = Steel / Metal

no short cuts taken here
**SATISFY ALL YOUR
CUT-OFF REQUIREMENTS**

From small diameter portable cut-off wheels to large diameter foundry cut-off wheels; from portable high-speed gas saw wheels to precision toolroom and Metlab wheels, our Norton offering encompasses the broadest range of applications.

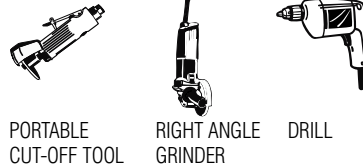


Small Diameter Reinforced Cut-off



The Norton small diameter cut-off wheel line consists of Type 01/41 straight and Type 27/42 depressed center cut-off wheels from 1-1/2" to 9" diameters. These wheels come in ultra thin .035" for quick burn-free and burr-free cutting to .125" for more durable applications. All are reinforced for the demanding nature of portable cut-off.

- Applications:** Cutting sheet metal, cutting pipe, and metal fabrication
- Size Range:** 1-1/2" - 9" diameter
- Thickness Range:** .035", .040", .045", .050", .060", 1/16", .090", 3/32" and .125"
- Abrasive Grain:** Ceramic Alumina / Zirconia Alumina, Zirconia Alumina / Aluminum Oxide, Aluminum Oxide, Silicon Carbide, Diamond
- Shape:** Type 01/41 Straight and Type 27/42 Depressed Center
- Machine Used:**



PORTABLE CUT-OFF TOOL RIGHT ANGLE GRINDER DRILL

How to Pick the Right Wheel Type

DEPRESSED CENTER WHEEL DESCRIPTION CODES

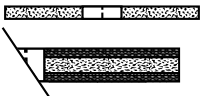

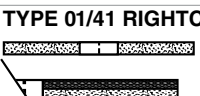

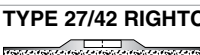

BLANK = All Purpose **INOX/SS** = Contaminant Free **LL** = Long Life **1-2-3** = Cutting/Notching/Grinding

■ = Aluminum ■ = Stainless ■ = Steel / Metal

DESCRIPTION CODE DEFINITIONS

BLANK = All Purpose	Where an excellent blend of cut rate and life is needed
ALU = Aluminum	Specially formulated bond for reduced loading and surface contamination while cutting aluminum and soft materials
INOX/SS = Contaminant Free	Contain <0.1% iron, sulfur or chlorine for rust-free and corrosion-free results. Will not contaminate stainless steel
LL = Long Life	Where durability is needed due to severe application, and when horsepower of the grinder allows for heavy pressure
RightCut = Cutting-off Only	RightCut wheels for cutting only, provide noticeably longer life and faster cut rate versus competitive wheels, and less pressure is required for first cut
1-2-3 = Cutting/Notching/Grinding	Can be used in cutting, notching and grinding applications

Type-to-Application Recommendation Guide

Wheel Type/Thickness	Applications	
TYPE 01/41 	Type 01/41 straight cut-off wheels are designed for portable cut-off tool applications. All are supplied with full fiberglass reinforcing.	
.035, .040, .060, and 1/16 .125	Where fast cutting and low kerf loss are desired For tough cutting and notching applications where stability is important	◆ ◆
TYPE 01/41 RIGHTCUT 	Type 01/41 RightCut straight cut-off wheels are designed for use on right angle grinder cut-off applications. All are supplied with full fiberglass reinforcing.	
.035, .040, .045, .050, 1/16 3/32	Where fast cutting and low kerf loss are desired For tough cutting and notching applications where stability is important	◆ ◆
TYPE 27/42 RIGHTCUT 	Type 27/42 RightCut depressed center cut-off wheels are designed for use on right angle grinder cut-off applications. Their depressed center shape provides a recess for the hub, which allows flush cutting. All are supplied with full fiberglass reinforcing.	
.040, .045, 1/16 3/32, .125	Where fast cutting and low kerf loss are desired For tough cutting and notching applications where stability is important	◆ ◆

Small Diameter Reinforced Cut-off

Material-To-Product Recommendation Guide

	BEST	BETTER	GOOD	
	Quantum3	BlueFire	Gemini	Metal
Mild Carbon / High Tensile Steel	◆	◆		◆
Stainless Steel / Alloys	◆	◆	◆	
Contaminate Free*			◆ INOX/SS	
Cast Iron	◆	◆	◆	

* For use in nuclear and food industry applications that require contaminant free (<0.1% iron, sulfur or chlorine)

Cross Reference Guides

Type 01/41 .035" - .125" Reinforced Cut-off Wheels for Portable Cut-off Tools



		TOTAL PERFORMANCE ←			→ INITIAL PRICE	
	BEST	BETTER	GOOD			
NORTON	NorZon Plus	BlueFire	Gemini Free Cut	Gemini Long Life	Metal	
Bullard	—	ZA46T, ZA60T	TA36T	TA46T, TA60T	A36T, A60T Comp.	
Camel	—	ZA60-TBF	A36 RBF	A60 RBF	Fast Cut RBF	
DeWalt	XP extended performance	—	HP metal	—	Metal	
Flexovit	Flexon Fast Cut A46, 60	—	High Perf Fast Grind A36	High Perf Fast Cut A36, 46, 60	—	
Metabo	—	—	Original Slicer	Original Slicer LL	—	
Pearl	—	SRT, Zirconia	—	Premium	Silver Line	
Pferd	—	—	—	—	PSF-A	
Sait	Saittech	—	A60S	A24R, A36T, A60T	—	
Walter	—	—	A24 ZIP	A60 ZIP	—	
Weiler	Tiger Ceramic	Tiger Zirc	—	Tiger	Wolverine A60T, A36T	

Type 01/41 and Type 27/42 .035" - .125" Reinforced Cut-off Wheels for Right Angle Grinders



		TOTAL PERFORMANCE ←			→ INITIAL PRICE		→ SPECIALTY	
	BEST	BETTER	GOOD			BETTER	GOOD	
NORTON	Quantum3 .045"	Quantum3 1/16"	BlueFire	Gemini Free Cut	Gemini	Metal	Norton For Aluminum	Gemini INOX/SS
3M	—	Cubitron II .045	Silver	—	—	—	—	—
Bullard	—	—	ZA60T	SGA60U	TA46T, TA60T, TA60U	A46T, A60T Comp.	AL46N	—
Camel	—	—	ZA Quickie Cut	A36-S-BF	Super Quickie Cut	Quickie Cut	A46 Quickie Cut	A60-T-BF, WA60R, Quickie Cut
DeWalt	XP Ceramic 0.040	XP Ceramic 1/16", XP Ceramic 0.045	XP	—	HP	Metal	—	—
Flexovit	—	—	—	Razorblade A60SST	Razorblade A24T, 30V, 36T	—	Razorblade A30Q	—
Klingspor	—	—	—	—	A960TZ, Kronenflex edge	A46TZ	—	—
Metabo	Slicer Limited Edition .040	M-Calibur 1/16	Super Slicer	—	Slicer-Plus, Original Slicer LL	Original Slicer	—	—
Pearl	—	—	Redline Max Slimcut	—	Slimcut	Slimcut Pro-V, Silverline	—	—
Pferd	SG Elastic, SG Plus 1mm	SG Plus 1.6, SG Elastic 1.6	—	—	—	PS-Forte	SG-ALU	—
Sait	—	The Ultimate Ceramic Cutoff .045, Saittech	Z-tech	SAIT.M.X	Sait .045, The Ultimate Cutoff	—	A46N	XA46R
Tyrolit	—	Cerabond	—	—	—	—	—	—
Walter	Zip One	—	Zip+ Xtra	A-30-ZIP	A-60-ZIP	—	A-60-ZIP-ALU	A60-SS-ZIP
Weiler	Tiger Zirc Ultra Cut 1mm, Tiger INOX UltraCut 1mm	Tiger Ceramic .045, Tiger Zirc .045, Tiger INOX .045	—	—	Tiger	Wolverine	—	—

Small Diameter Reinforced Cut-off

SAFETY

Dangerous Pairing: Die Grinders and Cut-off Wheels

While die grinders and cut-off tools may look similar, they are not interchangeable. Small diameter cut-off wheels can be used only on portable cut-off tools. Several crucial differences exist between the two handheld machines.

- Small diameter cut-off wheels must be used on portable cut-off tools with guards for the safety of the operator and bystanders. Also, portable cut-off tool guards prevent use of an oversized wheel.
- These cut-off wheels must be mounted between proper flanges on portable cut-off tools as described in the national safety standard for abrasive wheels, ANSI B7.1. Die grinders make use of a collet for mounting.
- All cut-off wheels must be used at or below their maximum operating speed, marked clearly on the side of the wheel. Die grinders operate above cut-off wheel speeds. Excessive speed can result in breakage and serious personal injury.



It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Measure Your Wheel's Thickness

Why should you measure your wheel thickness? Many competitors market their wheels as .045", but they are truly thicker. Norton Quantum3 RightCut wheels are true to size so you can pick the right wheel for the job whether you need precision cutting or rugged durability. Compare our 1/16" Quantum3 with competitive 0.045" ceramic cut-off wheels and you will see the longest life and fastest cut on the market.



It is the user's responsibility to refer to and comply with ANSI B7.1

Norton Quantum3 RightCut Wheels

The Norton Quantum3 RightCut is our top tier cut-off wheel, available in 0.045" and 1/16" thickness. If you want speed of cut and work on thin or hollow materials, the 0.045" will get you there with comfort. If you are cutting thicker materials and life of the wheel is important, then the 1/16" is ideal. Whatever your pick is, experience the extra-smooth cutting action, thanks to our premium ceramic grain.



Norton Quantum3 RightCut: 0.045" versus 1/16"

How to match the wheel to the application

5" x 1/16" x 7/8"
125 x 1.6 x 22mm

5" x .045" x 7/8"
125 x 1.2 x 22mm

PRODUCT	1/16" (LONGEST LIFE)	0.045" (FAST CUTTING)
Abrasive:	Ceramic	Ceramic
Target application:	Thick metals and/or aggressive-style cutting	Thin metals and/or light-style cutting
Strengths:	Long lasting, durable, aggressive easy feel, versatile across applications and metals	Fast cutting, smooth easy feel, precise and maneuverable, reduced burrs

Small Diameter Reinforced Cut-off



Best choice for stainless steel and carbon steel applications

QUANTUM3 CERAMIC ALUMINA

- 100% advanced ceramic alumina grain with a special shape for comfort and performance guaranteeing 7X the life of aluminum oxide wheels and 3X the life of zirconia alumina wheels
- Unique bond system prevents premature grain release maximizing wheel life
- Available in type 01 straight and type 27 depressed center cut-off wheels from 4-1/2 inch to 6 inch diameters



Best for metal plate, pipe, tubing, cast iron, carbon and mild steel, foundry and welding applications, and ceramics

DIALAST DIAMOND WHEELS

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for exceptional wheel life; less blade changes reduces downtime and labor costs
- Environmentally-friendly grinding for minimal dust, less clean-up and safer working conditions



Better choice for stainless steel, carbon steel, alloys and gray iron

BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- A blend of the most advanced zirconia alumina and premium aluminum oxide abrasives delivers 2 to 3 times the life of aluminum oxide wheels
- Ultra-thin side reinforcing for maximum cut rate with minimum kerf loss; ideal when precise, thin cut is desired
- Broad utility from light-to heavy-pressure applications



Better choice for aluminum

NORTON FOR ALUMINUM

- Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- Non-loading, specially designed bond, allowing fast, free-cutting with long-lasting performance
- Contaminant free, no need for waxes or lubricants



Good, versatile choice for steel and ferrous metals

GEMINI ALUMINUM OXIDE

- Quality aluminum oxide for consistent performance at an economical price
- Designed for portable cut-off tool applications where a fast cut and minimum material loss are desired
- Durable bond designed for fast cut while retaining excellent wheel life



Good choice for grinding alloys, metals, steels, and ferrous metals

METAL ALUMINUM OXIDE

- Quality aluminum oxide abrasive for quick cutting action
- Resin bond provides free cutting action with long life
- Good choice when low initial price is needed for small jobs or newer operators

Small Diameter Reinforced Cut-off



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	NORZON PLUS	BLUEFIRE	GEMINI	METAL
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
.035", .040", .060", 1/16" and .125" Type 01/41 – Cut-off						
2 x .035 x 1/8	30,560	25			662434 11392	
2 x .035 x 1/4	30,560	25			662434 11393	
2 x .035 x 3/8	30,560	25			662434 11394	
2 x 1/16 x 1/4	30,560	25			662434 11395	
2 x 1/16 x 3/8	30,560	25			662434 11396	
2 x .125 x 1/4	30,560	25			662434 11402	
2 x .125 x 3/8	30,560	25			662434 11403	
2-1/2 x 1/16 x 1/4	30,560	25			662435 10640	
2-1/2 x 1/16 x 3/8	30,560	25			662435 10641	
3 x .035 x 1/4	25,465	25	662435 10668		662435 10627	
3 x .035 x 3/8	25,465	25	662435 10669	662528 43174	662435 10628	076607 89451
3 x 1/16 x 1/4	25,465	25	662435 10670		662435 10645	
3 x 1/16 x 3/8	25,465	25	662435 10671	662528 43175	662435 10647	662528 35553
3 x .125 x 1/4	25,465	25			662435 10650	
3 x .125 x 3/8	25,465	25	662435 10673		662435 10651	
4 x .035 x 1/4	19,100	25			662435 10629	
4 x .035 x 3/8	19,100	25	662435 10675	662528 43173	662435 10630	076607 89453
4 x 1/16 x 1/4	19,100	25			662435 10654	
4 x 1/16 x 3/8	19,100	25	662435 10677	662528 43171	662435 10655	
4 x .125 x 1/4	19,100	25			662435 10658	
4 x .125 x 3/8	19,100	25	662435 10680	662528 43172	662435 10659	



TIER:	BETTER
TRADENAME:	NORTON FOR ALUMINUM
SHAPE:	Type 01/41
ABRASIVE:	Aluminum Oxide
MATERIAL:	ALUMINUM
PART #	

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #
.045" Right Angle Cut-Off Type 01/41			
4-1/2 x .045 x 7/8	13,580	25	662528 49367
5 x .045 x 7/8	12,225	25	662528 49369
6 x .045 x 7/8	10,185	25	662528 49371



Drill-Mount Mandrel

Used for mounting 2" and 3" x 3/8" hole cut-off wheels on to a drill

DESCRIPTION	STD. PKG.	PART #
Drill-Mount Mandrel	1	076607 47769



CUT-OFF WHEEL DESCRIPTION CODES

BLANK = All Purpose INOX/SS = Contaminant Free LL = Long Life 1-2-3 = Cutting/Notching/Grinding
 ■ = Stainless ■ = Steel / Metal ■ = Aluminum

Small Diameter Reinforced Cut-off



TIER:	BEST	BEST	BETTER	GOOD	GOOD
TRADENAME:	QUANTUM3 RIGHTCUT	DIALAST RIGHTCUT	BLUEFIRE RIGHTCUT	GEMINI RIGHTCUT	METAL RIGHTCUT
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Ceramic Alumina	Diamond	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS	STAINLESS
	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
.035", .040", .045", .050", 1/16, and 3/32" Type 01/41 – RightCut Cut-off							
4 x .040 x 5/8	15,280	25					076607 01616
4 x .045 x 5/8	15,280	25				662435 27956	
4 x 3/32 x 5/8	15,280	25				662435 27955	
4-1/2 x .040 x 7/8	13,580	25					076607 01617
	13,580	250+					662528 40001
4-1/2 x .045 x 7/8	13,580	25	662528 38454			662528 23602	
	13,580	25				662528 41997 INOX/SS	
	13,580	250+				662528 41213	
4-1/2 x .050 x 7/8	13,580	1		662533 70016			
4-1/2 x 1/16 x 7/8	13,580	25	662528 38455		662528 43208		
4-1/2 x 3/32 x 7/8	13,580	25				662528 23599	
5 x .040 x 7/8	12,225	25					076607 01618
5 x .045 x 7/8	12,225	25	662528 38460			662528 23603	
	12,225	250+				662528 41214	
5 x .050 x 7/8	12,225	1		662533 70017			
5 x 1/16 x 7/8	12,225	25	662528 38462		662528 43209		
5 x 3/32 x 7/8	12,225	25				662528 23600	
6 x .040 x 7/8	10,185	25					076607 02757
6 x .045 x 7/8	10,185	25				662528 23604	
	10,185	25				662528 41999 INOX/SS	
	10,185	250+				662528 41215	
6 x .050 x 7/8	10,185	1		662533 70018			
6 x 1/16 x 7/8	10,185	25	662528 38465		662528 43210		
6 x 3/32 x 7/8	10,185	25				662528 23601	
7 x .045 x 7/8	8,600	25				662528 32323	
	8,600	20				662528 42000 INOX/SS	
7 x 1/16 x 7/8	8,600	1		701846 94055			
9 x .060 x 7/8	6,600	1		701846 94056			

RightCut wheels are to be used for cutting only
+ Bulk packed 250 Wheels/carton; 5 inner boxes of 50 wheels each. Order in multiples of 250 wheels.



How To Convert An Angle Grinder
for Cut Off Wheels

youtu.be/AMue0p1Gjqo

CUT-OFF WHEEL DESCRIPTION CODES			
BLANK = All Purpose	INOX/SS = Contaminant Free	LL = Long Life	1-2-3 = Cutting/Notching/Grinding
■ = Stainless	■ = Steel / Metal	■ = Aluminum	

Small Diameter Reinforced Cut-off



TIER:	BEST	BETTER	GOOD	GOOD	
TRADENAME:	QUANTUM3	BLUEFIRE	NORTON FOR ALUMINUM	GEMINI	METAL
SHAPE:	Type 27/42	Type 27/42	Type 27/42	Type 27/42	Type 27/42
ABRASIVE:	Ceramic Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS	STAINLESS	ALUMINUM	STAINLESS	STAINLESS
	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL
	PART #	PART #	PART #	PART #	PART #

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
.040, .045, 1/16" – RightCut Cut-off – Type 27/42					
4 x .045 x 5/8	15,280	25		662528 42180	076607 05249
4-1/2 x .045 x 5/8-11	13,580	10		662528 42025	662528 19549
	13,580	10		662528 41913 INOX/SS	
4-1/2 x .045 x 7/8	13,580	25		662528 42026	662528 43604
	13,580	25		662528 41912 INOX/SS	
	13,580	250		662533 70065 250-Pk	
4-1/2 x 1/16 x 5/8-11	13,580	10	662528 38457	662528 43223	
4-1/2 x 1/16 x 7/8	13,580	10		662528 43219	
	13,580	25	662528 38456		
5 x .045 x 5/8-11	12,225	10		662528 41939	
5 x .045 x 7/8	12,225	25		662528 42036	662528 43849
	12,225	25		662528 41914 INOX/SS	
	12,225	250		662533 70066 250-Pk	
5 x 1/16 x 7/8	12,225	25	662528 38464	662528 43220	
6 x .045 x 5/8-11	10,185	10		662528 30587	
6 x .045 x 7/8	10,185	25		662528 42202	662528 42015
6 x 1/16 x 5/8-11	10,185	10	662528 46246	662528 49372	
6 x 1/16 x 7/8	10,185	25	662528 38466	662528 43221	
7 x .045 x 5/8-11	8,600	10		662528 41919 INOX/SS	
7 x .045 x 7/8	8,600	20		662529 12626	
	8,600	20		662528 41918 INOX/SS	
9 x 1/16 x 5/8-11	6,600	10		662530 19115	

RightCut wheels are to be used for cutting only.

3/32", .125" – Cut-off – Type 27/42					
4-1/2 x 3/32 x 5/8-11	13,580	10		662528 41903	
	13,580	10		662528 42027 INOX/SS	
4-1/2 x 3/32 x 7/8	13,580	25		662528 41940	
	13,580	25		662528 42028 INOX/SS	
	13,580	25		662528 43582 1-2-3	
4-1/2 x .125 x 5/8-11	13,580	10		662528 43588	
4-1/2 x .125 x 7/8	13,580	25		662528 43589	
5 x 3/32 x 5/8-11	12,225	10		662528 41904	
5 x 3/32 x 7/8	12,225	25		662528 42037 INOX/SS	
	12,225	25		662528 43587	
6 x 3/32 x 5/8-11	10,185	10		662528 41905	
6 x 3/32 x 7/8	10,185	25		662528 41906	
6 x .125 x 5/8-11	10,185	10		662528 41192	
7 x 3/32 x 5/8-11	8,600	10		662528 41907	
7 x 3/32 x 7/8	8,600	20		662528 41908	
9 x 3/32 x 5/8-11	6,600	10	662528 42378		

These wheels are to be used for cutting only.

CUT-OFF WHEEL DESCRIPTION CODES

BLANK = All Purpose INOX/SS = Contaminant Free LL = Long Life 1-2-3 = Cutting/Notching/Grinding
 ■ = Stainless ■ = Steel / Metal ■ = Aluminum

Chop Saw Reinforced Cut-off



A chop saw is a light, low-horsepower portable machine. Although very similar to a compound miter saw, it is designed for cutting denser materials, like metal bar, tubing or pipe. Chop saw cut-off wheels are designed specifically for this machine with finer grit, softer grades, and reinforcement layers that match the application.

- Applications:** Cutting small-diameter metal pieces, bar stock, metal pipe, tubing, decking, cable, drywall studs, and metal plate dimensioning
- Size Range:** 10" - 16" diameter
- Thickness Range:** 3/32" and 7/64"
- Abrasive Grain:** Zirconia Alumina / Aluminum Oxide Blend, Aluminum Oxide, and Diamond
- Shape:** Type 01/41 Straight
- Reinforcement Type:** Side reinforced, centrally reinforced
- Machine Used:**



Cross Reference Guide

	TOTAL PERFORMANCE			INITIAL PRICE			SPECIALTY	
	BETTER			GOOD			GOOD	
NORTON	BlueFire Free Cut	BlueFire Rapid Cut	BlueFire Long Life	Gemini Free Cut	Gemini Rapid Cut	Gemini Long Life	Stud Cutter	Norton Aluminum
Astromax	737 FC	—	—	733,758	742, 764	733+, 744	—	—
BMC	—	—	—	Westside A36P	—	—	—	—
Bullard	ZA36T	—	—	TA36T A46T The Competitor	A36R The Competitor	A36R Ironmaster	A46T Studmaster	AL36R
Camel	—	—	ZA24-S	A36-P, WA36-P	—	A36-S	A30-R Mr. Stud	A30-N
Dewalt	—	—	XP	GP, Stainless Fabrication	—	—	Stud Cutting	—
Flexovit	—	—	—	A30R Fast Cut A30-Q Free Cut	—	A30S Long Life	A30T Drywall Stud	—
Makita	—	—	—	—	General Purpose, A-93859-5	—	—	—
Pearl	SRT36	—	—	A36P Premium, A36S, A36T	A30P Silver Line	—	A46S Stud Cutting	—
Pferd	—	—	—	A 36 K SG CHOP	PSF CHOP	—	A 36 K SG-STUD	—
Sait	Saitech Steel Worker	Z-tech	—	EZ-Chop	EZ-Chop Attacker	Iron Worker	Stud King	Aluminum
Walter	—	—	—	—	A-30	A-30-HC+	—	A30-ALU

Application-to-Product Recommendation Guide

Wheel Type/Reinforcement

TYPE 01/41 STRAIGHT SIDE-REINFORCED CUT-OFF WHEEL

Side-reinforced wheels have two full layers of reinforcing and are designed for a fast cut and the most aggressive applications. All Purpose, Free Cut, and Long Life are side reinforced.



TYPE 01/41 STRAIGHT CENTRALLY-REINFORCED CUT-OFF WHEEL

Centrally-reinforced wheels have a single layer of reinforcing with exposed rough sides for free-cutting, non-binding applications where minimal burr and burn are the key requirements. Rapid Cut wheels are centrally reinforced.



How to Pick the Right Bond Type

DESCRIPTION CODE DEFINITIONS

BLANK = All Purpose	Where an excellent blend of cut rate and life is needed
FC = Free Cut	Used when fast, burn-free cutting is desired or when cutting pieces with larger cross sections
LL = Long Life	Where durability is needed due to severe application, and when cutting parts with small cross sections
RC = Rapid Cut	Where a free cutting, non-binding wheel is needed for burn-free and burr-free cuts
STUD = High-Performance	High-performance aluminum oxide/resin bond combination designed for cleaner cuts and longer life when cutting steel studs

Chop Saw Reinforced Cut-off

Designed for cutting steel, metal studs, stainless steel, non-ferrous materials, tile, brick, plastic and much more



DIALAST DIAMOND

- A combination of high-quality diamond and advanced brazed single-layer bonding technology for extra-long life versus conventional abrasives or other vacuum-brazed diamond tools
- Retains diamond grains and wheel shape for full life with low sparks, while keeping a continuous grinding depth for exceptional wheel life; less blade changes reduce downtime and labor costs
- Environmentally-friendly grinding for minimal dust, less clean-up and safer working conditions

Better choice for Aluminum



NORTON FOR ALUMINUM

- Extra-friable and self-sharpening, allowing operators faster and aggressive grinding time
- Non-loading, specially designed bond, allowing fast, free-cutting with long-lasting performance
- Contaminant free, no need for waxes or lubricants

Better choice for steel, stainless steel and all other ferrous metals



BLUEFIRE ZIRCONIA ALUMINA / A/O BLEND

- Durable, latest generation zirconia alumina and premium aluminum oxide abrasive blend outperforms competitive chop saw zirconia wheels by 20 percent
- Delivers twice the life and cut rate of aluminum oxide wheels on difficult to cut metals
- High performance resin bond is designed for free cut and long life

Good choice for all steel and ferrous metals as well as specialty applications in aluminum



GEMINI ALUMINUM OXIDE

- Durable, versatile aluminum oxide abrasive engineered for consistent performance and economical price on chop saw cut-off machine applications
- Abrasive and bond combination designed for smooth clean cut on low HP machines
- Good choice for consistent performance at an economical price

Good choice for drywall studs



METAL ALUMINUM OXIDE

- Quality aluminum oxide abrasive designed for cutting alloys, steels and ferrous metals including 400 series stainless, soft and hard carbon steels
- Designed with finer grit and softer grades, specifically for chop saw machines that typically have lower horsepower
- Constructed with full fiberglass reinforcing; Stud Cutter version designed specifically for cutting steel studs

Chop Saw Reinforced Cut-off



TIER:	BEST	BETTER	BETTER	BETTER	GOOD	GOOD	GOOD	GOOD
TRADENAME:	DIALAST	BLUEFIRE	BLUEFIRE	NORTON FOR ALUMINUM	GEMINI	GEMINI	METAL	METAL
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Diamond	Zirconia Alumina/ Aluminum Oxide	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
REINFORCING:		Side	Central	Side	Side	Central	Side	Central
MATERIAL:	STAINLESS	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	ALUMINUM	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
Type 01/41 Straight Cut-off								
10 x 7/64 x 1	6,110	10				662531	06109 LL	
12 x 7/64 x 1	5,095	10		662528	43250	662532	07554 LL	
	5,095	5						076607
14 x 3/32 x 1	4,365	10				662533	06627 FC	662533
	4,365	10				662533	06626 LL	076607
	4,365	5 V						89405 STUD
14 x 7/64 x 1	4,365	10			662528	43254 RC	662528	49382
	4,365	10		662528	43253 LL			076607
14 x .155 x 1	5,400	1	701846	94053				
16 x 7/64 x 1	3,820	10				662534	10198 LL	
	3,820	10		662528	43257 LL			



V Vendible 2-wheel Package. Ideal for vending machinings and small jobs. 5 packs/carton. Order in multiples of 10.

CUT-OFF WHEEL DESCRIPTION CODES

BLANK = All Purpose **FC** = Free Cut **LL** = Long Life **RC** = Rapid Cut **STUD** = Stud Cutter
■ = Stainless **■** = Steel / Metal **■** = Aluminum



High-Speed Reinforced Cut-off



Norton high-speed cut-off abrasive wheels provide the industry's leading performance in all high-speed gas and electric-powered applications.

Applications:

Metalworking: steel, stainless, ductile, cast iron, rail steel and metal decking
 Non-Metal Building Materials: concrete, brick, masonry, asphalt aggregate, stone and schedule 40 and 80 PVC pipe
 Rescue and Demolition: steel, acrylic, fiberglass, rubber, glass, wood, concrete, brick and asphalt

Size Range:

12" – 16" diameter

Thickness Range:

1/8" and 5/32"

Abrasive Grain:

Aluminum Oxide, Silicon Carbide, Silicon Carbide / Aluminum Oxide Blend

Shape:

Type 01/41 Straight

Reinforcement:

Wheels are offered in standard two-layer reinforcement as well as three-layer reinforcement for higher-speed saws and heavy-duty applications.

Arbor:

Wheels are offered with patented universal arbor that accommodates both 20mm and all other machines with 1" arbors.

Machine Used:



HIGH-SPEED GAS
OR ELECTRIC SAW

Material / Application-to-Product Recommendation Guide

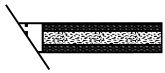
Icon		Application
	Metal	High-performance aluminum oxide grain wheels designed for general purpose cutting of all steel and stainless parts including rebar, steel pipe, structural steel, sheet metal, cable and small to medium diameter solid pieces.
	Metal Decking	High-performance aluminum oxide abrasive combined with a thicker wheel (5/32") that stands up to the sharp edges of sheet metal and roof decking.
	Ductile/Cast Iron	A special blend of silicon carbide abrasive for cutting and aluminum oxide abrasive for life, designed to cut ductile and cast iron pipe, concrete-lined water pipes, sewer construction and heavy duty PVC.
	Rescue	For ventilation, forcible entry, rescue and demolition. A versatile abrasive formula that can be used on a wide range of materials including all types of metals and masonry.
	Concrete	Coarse grit silicon carbide abrasive provides a low initial cost solution for cutting brick, block, concrete or other masonry materials. For higher-production applications that require optimum speed of cut and product life, please see our complete selection of high-speed diamond wheels in our Norton Construction diamond product line.
	Asphalt	A special blend of extra coarse silicon carbide abrasive grains provides a low initial cost solution for cutting asphalt, green concrete, asphalt over concrete, a wide range of aggregates and abrasive materials. For higher-production applications that require optimum speed of cut and product life, please see our Norton Construction diamond blade product offering in the Construction Product section of this catalog -and the complete offering in our "Diamond, Abrasives and Equipment for the Construction Market Catalog" #7719 found on nortonabrasives.com

Cross Reference Guide

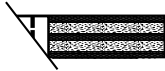
SPECIALTY

NORTON	GOOD				
	Gemini Metal	Gemini Metal Decking	Gemini Ductile	Gemini Concrete	Gemini Asphalt
Abmast	A 24 R, Kompetitor Metal	A 24 T	AC 24 R, Kompetitor Ductile Iron	C 24 R, Kompetitor Concrete	C 16 T, Kompetitor Asphalt
Bullard Blaze & Road Warrior	A24R, ZA24Q, The Competitor	TA24R	AC24R	C24R, The Competitor	CC20R
Camel	A24-R	A24-T	AC24-R	C24-R	C16-U
Flexovit	A24/30SB	A24TB	AC24SB	C30UB	C16UB
Husqvarna	Blue XHS, Blue QMS-CM, Blue EHS	Grey QMS-CM	Green QMS-CM, Green EHS	Red XHS, Red QHS-CM, Red EHS	Black QMS-AS
Pearl	SRT, Premium A36S, Silver Line A30R	—	AC30S	Premium C36S, Silver Line C24R	—
Pferd	A 24 R SG	A 24 Q SG-RAIL	AC 24 Q SG	C 24 R SG	—
Sait	A24R, A30S, XFC	Brute	Ductile	C24R	Big M.A.C, XFC
Tyrolit	A30P, A30BF	—	AC24, AC30BF	1C24, C30BF	—
Virginia Abrasives	Metal	—	Ductile	Concrete	Asphalt
Walter	A-24	—	—	—	—









How to Pick the Right Reinforcement



Two full layers of reinforcing are offered for lower power machines, and light-to-medium applications where speed of cut is the primary selection criterion.













Three full layers of reinforcing are recommended for high-speed, high-power machines where the application is heavy-duty, and durability is the primary selection criterion.

				
TIER:	GOOD	GOOD	GOOD	GOOD
TRADENAME:	GEMINI METAL HD	GEMINI METAL	GEMINI METAL DECKING	GEMINI RESCUE
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide/ Aluminum Oxide Blend
REINFORCING:	3 Layers	2 Layers	2 Layers	2 Layers
MATERIAL:				

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Type 01/41 Cut-off – for Gas & Electric-Powered Saws						
12 x 1/8 x 1" / 20mm	6,300	10	662528 36708	662528 37838		
14 x 1/8 x 1" / 20mm	5,400	10	662528 35386	662528 37841		662435 78262
14 x 5/32 x 1" / 20mm	5,400	10			662528 32521	
16 x 1/8 x 1" / 20mm	4,700	10		662528 30886		

See additional Rail Cut wheels on page 34 for larger-volume jobs.

					
TIER:	GOOD	GOOD	GOOD	GOOD	GOOD
TRADENAME:	GEMINI DUCTILE HD	GEMINI DUCTILE	GEMINI CONCRETE HD	GEMINI CONCRETE	GEMINI ASPHALT
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Silicon Carbide / Aluminum Oxide Blend	Silicon Carbide / Aluminum Oxide Blend	Silicon Carbide	Silicon Carbide	Silicon Carbide
REINFORCING:	3 Layers	2 Layers	3 Layers	2 Layers	2 Layers
MATERIAL:					

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
Type 01/41 Cut-off – for Gas & Electric-Powered Saws							
12 x 1/8 x 1" / 20mm	6,300	10		662528 37840		662528 37839	
14 x 1/8 x 1" / 20mm	5,400	10	662528 35388	662528 37843	662528 35387	662528 37842	701846 72877
16 x 1/8 x 1" / 20mm	4,700	10				701846 23029	



Universal Arbor

Two Blade Sizes in One

Our Norton patented 1"/20mm knock-out arbor fits all gas and electric high-speed saws. A 20mm bushing is pre-mounted into the 1" molded arbor hole. The wheel, with the 20mm bushing, can be mounted directly on any 20mm arbor high-speed saw. With the bushing removed, exposing the 1" arbor hole, the wheel can be mounted on any 1" arbor high-speed saw. Combining this arbor, with heavy-duty triple reinforcing results in a higher performing, extra strong, longer lasting cutting wheel. Once the 20mm bushing is removed, it cannot be replaced.

Stationary Saw Reinforced Cut-off



The Norton stationary saw reinforced cut-off wheel line consists of Type 01/41 straight 10" - 24" wheels, designed to fit on fixed-base stationary saws that are free-standing or mounted on a workbench.

- Applications:** Primary applications are cutting of all metal parts (flat stock, bars, studs, pipes, tubes, angle iron, cable), wire rope and hydraulic hose used in fabrication, construction and plant maintenance.
- Size Range:** 10" - 20" diameter
- Thickness Range:** 3/32", 1/8", 5/32", 3/16"
- Abrasive Grain:** Zirconia Alumina / Aluminium Oxide Blend, Aluminum Oxide, Silicon Carbide
- Shape:** Type 01/41 Straight
- Machine Used:**



STATIONARY SAW

Cross Reference Guide

	TOTAL PERFORMANCE		INITIAL PRICE		SPECIALITY
	BETTER	GOOD	GOOD	GOOD	GOOD
NORTON	BlueFire	Gemini Free Cut	Gemini Long Life	Gemini Rapid Cut*	Foundry Cut**
Abmast	Z 24 R3	A 30 R	—	—	AC 24 R3
Bullard	—	A30-R	A30-T	A300	—
Camel	ZA24-R	A24-R, A46-T	—	—	WA24-S
Flexovit	—	A30RB Multi Purpose	A30SB Long Life, A24TB Long Life	—	AC24PB Heavy Duty
Metabo	—	A30N, A30R	A30S, A30V	—	—
Pearl	SRT36	A30P Premium, A30Q Silver Line	A30S Premium, A36R Premium	—	—
Pferd	ZA 24 Q/R SG-HD	A 24 N/P SG-HD	A 24 Q/S SG-HD	—	—
Sait	—	A24N, A36R	A24R	—	—
Tyrolit	—	A30BF	—	—	—
Walter	—	A-24-FC	A-24-RIP	—	—

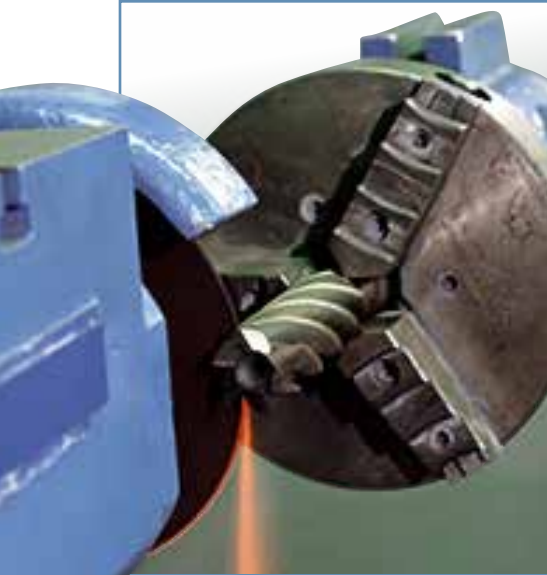
* For Burr-Free applications, please see centrally-reinforced BlueFire Rapid Cut and Gemini Rapid Cut wheels in Chop Saw cut-off wheel section or at nortonabrasives.com
 ** For Foundry and other cut-off wheels, please refer to that section of this Norton Full Line Catalog #7362 or at nortonabrasives.com



			TIER: BETTER	GOOD	GOOD
			TRADENAME: BLUEFIRE	GEMINI FREE CUT	GEMINI LONG LIFE
			SHAPE: Type 01/41	Type 01/41	Type 01/41
			ABRASIVE: Zirconia Alumina/Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
			MATERIAL: STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Type 01/41 Straight Cut-Off					
10 x 3/32 x 5/8	6,110	10	662528 43248	662531 06101 FC	662531 06102 LL
	6,110	5			
12 x 1/8 x 1	5,095	10	662528 43249		662532 07548 LL
	5,095	5			
14 x 1/8 x 1	4,365	10	662528 43251	662533 06609 FC	662533 06611 LL
	4,365	5			
16 x 5/32 x 1	3,820	10	662528 43255	662534 10183 FC	662534 10184 LL
18 x 5/32 x 1	3,015	10		662534 10185 FC	
20 x 5/32 x 1	2,710	5	662528 43258 FC	690786 09031 FC	690786 09032 LL
	2,710	5	662528 43259 LL		
20 x 3/16 x 1	2,710	5		690786 09033 FC	690786 09034 LL

CUT-OFF WHEEL DESCRIPTION CODES

BLANK = All Purpose FC = Free Cut LL = Long Life ■ = Stainless ■ = Steel / Metal



Reinforced and non-reinforced engineered cut-off wheels for cutting all types of tool steel with fixed-based cut-off machines.

Applications:

Reinforced cut-off wheels are designed to resist breakage caused by severe cross-bending and are required on any operation where the work is not securely clamped.

Non-Reinforced cut-off wheels are designed for use on fixed-based machines where the work is securely clamped, guarded, and where the wheel operates on a controlled cutting plane.

Size range:

6" – 12" diameter

Grit range:

36 – 90 grit

Abrasive grain:

Aluminum Oxide

Bond:

Resinoid, Rubber, and Shellac

Shape:

Type 01/41 Straight

Cross Reference Guide

NORTON	BETTER		
	Reinforced A60-OBNA2	Reinforced 57A364-TB25N	Non-Reinforced 57A60-M8B
Bates	A602-T-BF	A36-R-BF	-
Buffalo	A60-R-BF2	-	-
Dia. Tool	A80-SP	A46-SP	-
Radiac	A54-N6-B20	-	A54-N6-B20
Tyrolit	A60-QBF38A2	-	-

TECH TIP

- Smooth side pattern – Used when a precise thickness tolerance is needed
- Rough (R) side pattern – Abrasive particles protrude from sides of wheel

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Poor cut rate	Insufficient power used	Increase feed or pressure to full power
	Wheel too hard	Use softer grade, or thinner wheel
	Contact area too large	Reduce contact area
	Wheel too coarse	Use finer grit
	Wheel side out of truth	Check spindle runout
Non-square cuts	Work not clamped properly	Check clamp and clean to remove swarf
	Misaligned spindle bearings	Check for bearing truth and alignment
	Poor coolant distribution	Ensure equal volume of coolant to each wheel side
	Wheel is too hard	Use softer acting wheel: softer grade, or finer grit
Workpiece burn	Insufficient feed rate	Work machine to maximum power available
	Poor coolant flow	Increase volume and direct at cutting point
	Wheel is too coarse	Use finer grit or more machine power
	Wheel is too hard	Use softer grade wheel
	Wheel is running out	Check spindle and flanges
	Wheel speed is too slow	Ensure tight flanges and maximum safe operating speed being used
Poor finish	Too much burr	Use finer grit, or softer grade
	Wheel too coarse	Use finer grit

TECH TIP

- Wheels with a "W" reinforcement (reinforcement around the hole) are not considered to be truly reinforced.
- Clamp or fixture the workpiece for straightest cuts.
- Run wheels at the highest possible speed marked on the wheel and make cuts as quickly as possible. Do not overspeed wheels.
- It is recommended that a cut-off machine should have 1 horsepower for every inch of wheel diameter. For less than this, we recommend using a softer specification.
- Using a harder grade wheel increases wheel life, but it also increases burn, power required and decreases cut rate.
- Using a coarser grit wheel increases wheel life and cut rate, but it also increases burr and power required.

Better choice for cutting tool steel on fixed-based machines when work is not securely clamped



TOOLROOM REINFORCED ALUMINUM OXIDE

- Tough, versatile aluminum oxide grain for toolroom cut-off applications
- Constructed with full diameter fiberglass reinforcement on each side of wheel, to provide greatest possible resistance to side pressure and bending
- OBNA2 full side reinforced, resin bond; yields maximum cut rate and minimum kerf loss; ideal when thin cut is desired
- B25N full side reinforced, resin bond; versatile; durable, free cutting; offer greatest stiffness

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER SPEC.	PART #
Type O1/41 Straight Cut-off – Reinforced				
6 x .035 x 1-1/4	10,190	25	A60-OBNA2	662528 35055
6 x .060 x 1/2	10,190	25	A60-OBNA2	662528 35164
6 x .060 x 1/2	10,190	25	57A364-TB25N	662528 22969
6 x .060 x 1-1/4	10,190	25	A60-OBNA2	662528 35165
7 x .035 x 1/2	8,730	25	A60-OBNA2	662529 38786
7 x .035 x 1-1/4	8,730	25	A60-OBNA2	662529 38788
7 x .060 x 1/2	8,730	25	A60-OBNA2	662529 38816
7 x .060 x 1-1/4	8,730	25	A60-OBNA2	662529 38796
7 x .060 x 1-1/4	8,730	25	57A364-TB25N	662529 22676

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER SPEC.	PART #
Type O1/41 Straight Cut-off – Reinforced				
8 x .035 x 1/2	7,640	25	A60-OBNA2	662530 43014
8 x .035 x 1-1/4	7,640	25	A60-OBNA2	662530 42980
8 x .060 x 1/2	7,640	25	A60-OBNA2	662530 43009
8 x .060 x 1-1/4	7,640	25	A60-OBNA2	662530 42983
8 x .060 x 1-1/4	7,640	25	57A364-TB25N	662530 22705
10 x .060 x 5/8	6,110	25	A60-OBNA2	662531 49317
10 x .060 x 1-1/4	6,110	25	A60-OBNA2	662531 49186
12 x .060 x 1	5,095	10	A60-OBNA2	662532 61811
12 x .075 x 1	5,095	10	A60-OBNA2	662532 61910
12 x .075 x 1-1/4	5,095	10	A60-OBNA2	662532 61858

Better choice for cutting tool steel on fixed-based machines when the work is securely clamped



TOOLROOM NON-REINFORCED ALUMINUM OXIDE

- Tough, durable and versatile aluminum oxide grain for toolroom cut-off applications
- Non-reinforced, use on fixed-based machines where the work is securely clamped
- B bond (smooth sides); a mild acting resin bond for light cut-off applications
- B25 bond (smooth sides); a versatile, free-cutting, more durable resin bond; ideal for dry cutting metal in high production runs
- E7 bond (smooth sides); a shellac bond with very mild cutting action, recommended for highly critical applications where no burr, heat checks, or discoloration is permitted
- R30 bond (smooth sides); mild acting rubber bond primarily for wet, ultra-thin cutting

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER SPEC.	PART #
Type O1/41 Straight Cut-off – Non-Reinforced				
6 x .015 x 1-1/4	6,370	25	57A90-ROR30	662528 22953
6 x .020 x 1-1/4	6,370	25	57A90-ROR30	662528 22954
6 x .035 x 1-1/4	6,370	25	57A60-M8B	662528 22958
6 x .060 x 1/2	7,640	25	57A541-RB25	662528 22970
6 x .060 x 1-1/4	7,640	25	57A60-M8B	662528 22975
7 x .035 x 1-1/4	5,460	25	57A60-M8B	662529 22983
	5,460	25	57A60-O8B	662529 22986
	5,460	25	57A60-Q8B	662529 22987
7 x .035 x 1-1/4	5,460	25	57A601-PB25	662529 22988
	5,460	25	57A601-RB25	662529 22989
7 x .035 x 1-1/4	5,185	25	57A60-OE7	662529 22985
7 x .035 x 1-1/4	5,460	25	23A601-PB25	662529 38701
7 x .050 x 1-1/4	5,460	25	23A601-PB25	662529 38724*
7 x .060 x 1/2	6,550	25	57A60-O8B	662529 22672

*Exception: rough sides

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER SPEC.	PART #
Type O1/41 Straight Cut-off – Non-Reinforced				
7 x .060 x 1-1/4	6,550	25	57A46-M8B	662529 22677
	6,550	25	57A60-M8B	662529 22681
	6,550	25	57A60-O8B	662529 22684
	5,185	25	57A60-OE7	662529 22683
7 x .090 x 1-1/4	6,550	25	57A60-M8B	662529 22690
7 x .125 x 1-1/4	6,550	25	57A60-M8B	662529 22692
8 x .035 x 1-1/4	4,775	25	57A60-N8B	662530 22694
8 x .060 x 1/2	5,730	25	57A60-M8B	662530 22702
8 x .060 x 1-1/4	5,730	25	57A60-M8B	662530 22708
10 x .060 x 5/8	4,585	25	57A46-Q8BW	662531 22816
	4,585	25	57A60-M8BW	662531 22818
10 x .090 x 5/8	4,585	25	57A60-M8BW	662531 22824

Metallurgical Non-Reinforced Cut-off



The Norton metallurgical line of Type 01/41 straight cut-off wheels was developed specifically for sectioning off metal samples; burr-free cutting, minimal burn and distortion.

Applications:

Designed specifically for cutting off metal samples ranging from mild steel to super alloys on fixed-based machinery by scientists, engineers, and lab technicians.

Size range:

9" – 13.75" diameter

Cross Reference Guide

SIZE	MATERIAL CUT	NORTON		BUEHLER		LECO		STRUERS	
		SPEC.	PART #	METABRASE PART #	BUEHLERMET II PART #	PART #	PART #	PART #	AXITOM/-5 PART #
9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	Very Hard Steels (Rc 55 - 68)	ML-109	662531 17874	10-4110-010					60A24*
	Medium Steels (Rc 30 - 40)	ML-309	662531 17877	10-4116-010	10-5112-010	811-043-010			40A24*
	Soft Steels (Rc 20 - 30)	ML-409	662531 17828	10-4120-010	10-5116-010	811-049-010			30A24*
10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	Very Hard Steels (Rc 55 - 68)	ML-110	662531 17879	10-4210-010		808-673	812-231		60A25•
	Hard Steels (Rc 40 - 55)	ML-210	662531 17880	10-4212-010	10-5210-010	811-059-010	810-310-010		54A25•
	Medium Steels (Rc 30 - 40)	ML-310	662531 17881	10-4216-010	10-5212-010	811-067-010	810-310-010		40A25•
12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	Soft Steels (Rc 20 - 30)	ML-410	662531 17830	10-4220-010	10-5216-010	811-073-010			30A25•
	Very Hard Steels (Rc 55 - 68)	ML-112	662533 22151	10-4410-010		808-674	811-065-010		60A30†
	Hard Steels (Rc 40 - 55)	ML-212	662533 22152	10-4412-010	10-5410-010	811-081-010	810-311-010		50A30†
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	Very Hard Steels (Rc 55 - 68)	ML-114	662533 22863	10-4310-010		808-675	812-232		60A35□ 50A35
	Hard Steels (Rc 40 - 55)	ML-214	662533 22156	10-4312-010	10-5310-010	809-346	811-977-010		50A35□ 40A35

*Discotom/Labotom • Discotom-5/-6/Labotom-3 †Unitom/Discotom-50/-60/-65 □ Exotom/Unitom-2/-5/-50



Best choice for wet use when you want burn-free cuts and ultra-clean samples

METLAB 38A ALUMINUM OXIDE

- Quality aluminum oxide abrasive wheel designed specifically for burr-free cutting of soft carbon steels, tool steels, super alloys for microscopic metal analysis
- Superior bond system generates pure cuts for sectioning off samples while minimizing wheel wear and odor
- Designed to work on Buehler®, LECO® and Struers® machinery

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PRODUCT #	APPLICATION	TIER: BEST PART #
Type 01/41 Straight Cut-off – Non-Reinforced					
9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	4,025	10	ML-109	Very Hard Steels (Rc 55 - 68)	662531 17874
	4,025	10	ML-309	Medium Steels (Rc 30 - 40)	662531 17877
	5,085	10	ML-409	Soft Steels (Rc 20 - 30)	662531 17828
10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	3,500	10	ML-110	Very Hard Steels (Rc 55 - 68)	662531 17879
	3,500	10	ML-210	Hard Steels (Rc 40 - 55)	662531 17880
	3,500	10	ML-310	Medium Steels (Rc 30 - 40)	662531 17881
12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	4,585	10	ML-410	Soft Steels (Rc 20 - 30)	662531 17830
	3,820	10	ML-112	Very Hard Steels (Rc 55 - 68)	662533 22151
	3,820	10	ML-212	Hard Steels (Rc 40 - 55)	662533 22152
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	2,770	10	ML-114	Very Hard Steels (Rc 55 - 68)	662533 22863
	2,770	10	ML-214	Hard Steels (Rc 40 - 55)	662533 22156

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #
Type 01/41 Straight Cut-off – Non-Reinforced				
10 x 1/16 x 1-1/4	4,585	5	88A901-HB82 Metlab	662531 49449
12 x 1/16 x 1-1/4	3,820	5	88A901-HB82 Metlab	662532 62172



The Norton RailCut line is designed for high-speed fixtured hydraulic or gas-powered rail saws.

- Applications:** Fixed rail track cutting
- Size range:** 14" and 16" diameter
- Thickness range:** 1/8"
- Grit range:** 14 – 16
- Abrasive grain:** Zirconia Alumina / Aluminum Oxide Blend, Zirconia Alumina, and Aluminum Oxide
- Shape:** Type 01/41 Straight
- Reinforcement:** Side reinforced with R (rough) sides
- Speed rating:** All wheels are rated for 20,000 SFPM applications
- Machines Used:**



FIXTURED HYDRAULIC OR
GAS-POWERED RAIL SAW

Cross Reference Guide and Machine-to-Product Recommendation Guide

	BEST	BETTER	GOOD	GOOD
NORTON	RailCut X	RailCut NorZon III	RailCut A30X	RailCut Metal
Bullard Abrasive	Trackmaster Pro ZA24 Q-BF (Blue)	Trackmaster Pro ZA24 Q-BF (Blue)	Trackmaster A30 R-BF (Red)	—
DiaTool	—	—	—	RailMaster Rail Cut 27
Flexovit USA	—	—	A30-PB	—
Giesmar	AM303-R	AM303-R	NR242-Q	NR242-Q
Klingspor	A 24 SX Special	A 24 SX Special	—	—
Portaco	A30 R-BF	A30 R-BF	—	—
Racine Kwik Kut	A24R	A24R	—	—

	BEST	BETTER	GOOD	GOOD	
NORTON	RailCut X	RailCut NorZon III	RailCut NorZon III FastCut	RailCut A30X	RailCut Metal
HYDRAULIC SAW	◆	—	—	◆	◆
GAS SAW	—	—	—	—	—
High-Horsepower / Newer Machine	◆	◆	—	◆	◆
Low-Horsepower / Older Machine	◆	◆	◆	◆	◆



Best choice for high-performance cutting of rails on applications where the hydraulic or gas saw is fixtured and has adequate power

RAILCUT X ZIRCONIA ALUMINA / A/O BLEND

- Highest-performance zirconia alumina and engineered aluminum oxide abrasive blend expertly cuts a broad range of rail material
- Rough sides enable fastest cutting and longest lasting wheels
- Achieve highest productivity with lowest total abrasive costs



Good choice for price-sensitive jobs with lowest initial price

RAILCUT METAL ALUMINUM OXIDE

- Quality aluminum oxide abrasive wheels designed for jobs where low initial price is a key purchasing criterion
- Side reinforced with rough sides; rated for 20,000 SFPM applications
- Designed for multi-purpose use; great versatility on a variety of rail materials



	BEST	BETTER	BETTER	GOOD	GOOD		
TRADENAME:	RAILCUT X	RAILCUT NORZON III	RAILCUT NORZON III FASTCUT	RAILCUT A30X	RAILCUT METAL		
ABRASIVE:	Zirconia Alumina/ Aluminum Oxide Blend	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide	Aluminum Oxide		
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #		
Type 01/41 Cut-Off							
14 x 1/8 x 1	5,400	10	662533 37716	662533 60493	662533 63694	662532 60462	
16 x 1/8 x 1	4,800	10	662533 35024	662534 64607	662534 64415	662532 59935	662434 82066



Foundry cut-off wheels are designed with abrasives, bonds and reinforcement types specific to foundry machine parameters and materials. Most of the specifications are non-stock. This stock listing is designed to provide popular size and starting specifications.

- Size Range:** Reinforced: 14" – 30" diameter; Non-reinforced: 12" – 20" diameter
- Grit Range:** 24 – 46 grit
- Abrasive Grain:** Ceramic Alumina (Norton Quantum; non-stock only), Zirconia Alumina, Aluminum Oxide
- Reinforcement:** Reinforced: Engineered with strengthening fabric or filaments, which make wheels resistant to cross-bending breakage. All portable cut-off, swingframe, locked-head push-through and foundry chop stroke operations require reinforced cut-off wheels.
- B:** One or more full diameter pieces of filament molded inside each wheel. This construction leaves the abrasive exposed on the side of the wheel, improving freeness of cut. Used for fixed work operations with low probability of side pressure.
- N:** Full diameter pieces of reinforcement on the side of the wheel. Offers greatest possible resistance to side pressure and bending.
- Non-Reinforced:** Designed for use on fixed-base types of machines where the work is securely clamped and guarded, and where the wheel operates on a controlled cutting plane.
- W:** Reinforcement around the center hole only. These wheels are not considered to be truly reinforced.
- Side Patterns:** Smooth sides: Used for precision cutting applications
 Rough (R) sides: Abrasive particles protrude from sides of wheel
 Used wet or dry on most metals

Material-to-Product Recommendation Guide

	BEST	BETTER	GOOD	GOOD
	Foundry X Quantum*	Foundry X BlueFire	Foundry X	Foundry Metal
INVESTMENT CAST ALLOYS				
Stainless Steel	◆	◆	◆	◆
Titanium	◆	◆	◆	◆
CAST IRON				
	◆	◆	◆	◆
CAST STEEL				
Carbon and Low Alloy	◆	◆	◆	◆
Stainless Steel and High Alloy	◆	◆	◆	◆
Aluminum Alloy	◆	◆	◆	◆
Copper Alloys, Brass, Bronze	◆	◆	◆	◆

*Foundry X Quantum wheels are non-stock, custom-made to your requirements

Cross Reference Guide

	TOTAL PERFORMANCE		INITIAL PRICE	
	BEST	BETTER	GOOD	GOOD
NORTON	Foundry X Quantum and B97 (Non-stock; custom-made to your exact requirements)	Foundry X BlueFire	Foundry X	Foundry Metal
Allison	TA362 R6 8045HA, YW462 MR B2HA	TA302-T6-B6HA, A46-T6-BX5T6A, HF 1247 K – CHALLENGER	—	Economiser
Avery	—	TA30-V680	A 3226 C7A, C11922 W071	92871H
Buckeye	—	Steel Shark	—	—
DiaTool	BV1734R 710	BV 1397-5284-C	—	—
Flexovit	—	ZAX30TB	A24PB, A30RB	—
Klingspor	20A24-QBF	—	—	—
NATAB	—	—	T 1584 HA	—
Rappold	—	6Z30U-B3F2	—	—



Better choice on stainless steel, aerospace alloys, cast iron, and steel

FOUNDRY X BLUEFIRE REINFORCED

- Next generation self-sharpening zirconia alumina abrasive provides fast cuts on foundry cut-off applications
- Improved durability and heat resistance result in longer abrasive life
- More aggressive; can withstand very demanding applications



Good choice on general purpose applications

FOUNDRY X ALUMINUM OXIDE

- Durable, versatile aluminum oxide abrasive engineered for consistent performance and economical price on foundry cut-off applications
- Advanced bond technology with improved thermal stability and mechanical strength
- Excellent value on stainless steel and exotic aerospace alloys



Good choice for price-sensitive jobs with lowest initial price

FOUNDRY METAL ALUMINUM OXIDE

- Great versatility from multi-purpose aluminum oxide abrasive formulated specifically for typical foundry applications
- Bond and reinforcement engineered to foundry market machine parameters and materials
- Good choice for small jobs and quick applications where performance is not measured

Reinforced



TIER:	BETTER	GOOD	GOOD
TRADENAME:	FOUNDRY X BLUEFIRE	FOUNDRY X	FOUNDRY METAL
ABRASIVE:	Zirconia Alumina / Aluminum Oxide	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type O1/41 Straight Cut-off – Foundry Reinforced								
14 x 1/8 x 1	4,365	10			U57A30-TB75N	662533 45779		
	4,365	10			U57A30-VB75N	662531 79191		
16 x 5/32 x 1	3,820	10	NV24-TB75N	662533 47676	U57A30-TB75N	662533 45781	Side Reinforced	662434 85919
	3,820	10	NV24-VB75N	662531 79147	U57A30-VB75N	662531 79148		
20 x 5/32 x 1	2,710	10	NV24-TB75N	662533 47683	U57A30-TB75N	662533 47546	Side Reinforced	662434 85920
	2,710	10	NV24-VB75N	662531 79363	U57A30-VB75N	662531 79364		
	2,710	10	NV24-YB97N	662533 47694	U57A30-YB97N	662533 47701		
20 x 3/16 x 1	2,710	10	NV24-TB75B	662533 47684	U57A30-TB75B	662533 47547	Centrally Reinforced	662434 85921
	2,710	10	NV24-VB75B	662531 79366				
	2,710	10	NV24-YB97B	662533 47699	U57A30-YB97B	662533 47702		
24 x 7/32 x 1-3/4	2,260	10	NV24-TB75B	662533 47685				
	2,260	10	NV24-VB75B	662531 79374	U57A30-VB75B	662531 79375		
	2,260	10	NV24-YB97B	662533 47697				
30 x 1/4 x 1-3/4	1,810	10	NV24-TB75B	662533 47722				
	1,810	10			U57A30-YB97B	662533 47721		

Specifications ending in "B" are centrally reinforced; specifications ending in "N" are side reinforced.

Non-Reinforced



TIER:	BETTER	GOOD
TRADENAME:	U57A	GEMINI
ABRASIVE:	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #	SPEC	PART #
Type O1/41 Straight Cut-off – Foundry Non-Reinforced R-Sides						
12 x 3/32 x 1	5,095	10	U57A461-PB25	662532 61887		
16 x 1/8 x 1	3,820	10			AP	662534 22942
20 x 1/8 x 1	2,710	10	U57A304-VB25W	690786 65497		

Ask your Norton representative about our custom, made-to-order Norton Foundry X Quantum ceramic alumina wheels for high alloys, stainless steel, and aerospace applications.

CUT-OFF WHEEL DESCRIPTION CODES

AP = All Purpose

Where a good blend of cut rate and life is needed



For consistent, quality performance in foundries, welding shops, fabrication facilities, steel mills and shipyards, Norton portable snagging wheels maximize your productivity. Used on horizontal/straight shaft grinders or right angle portable cup grinders.

- Applications:** Removing flaws, cracks, gates, risers and parting lines, smoothing weld seams, cleaning castings, and rough beveling
- Size Range:** Type 01 Straight Wheels: 2-1/2" – 8" diameter
Type 06 and 11 Cup Wheels: 4" – 6" diameter
Cones and Plugs: Type 16, 17, 17R, 18 and 18R
- Grit Range:** 14 – 24
- Abrasive Types:** Zirconia Alumina NZ and NV; Zirconia Alumina / Silicon Carbide Blend NVC; Aluminum Oxide 57A and Metal; Aluminum Oxide / Silicon Carbide Blend 57AC, Silicon Carbide 37C and Masonry

Machine Used:



Material-To-Product Recommendation Guide

	BEST NorZon Plus	BETTER BlueFire	GOOD Gemini	Metal
IRON				
Gray	◆ NZ14-R	◆ NV16-Q	◆ 57A16-Q	◆
Ductile/Malleable	◆ NZ14-R	◆ NV16-Q	◆ 57A16-Q	◆
Dirty/Scale-covered		◆ NVC16-Q	◆ 57AC16-Q	
STEEL				
Carbon and Low Alloy	◆ NZ14-Q	◆	◆ 57A16-Q	◆
Stainless and High Alloy	◆ NZ14-P	◆	◆ 57A16-Q	◆
ALUMINUM, COPPER, BRASS, & BRONZE ALLOYS		◆ NVC16-Q	◆ 57AC16-Q	

NOTE: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Cross Reference Guide for Type 01, 06 and 11 Wheels

NORTON	TOTAL PERFORMANCE ←			INITIAL PRICE →	
	BEST NorZon Plus	BETTER BlueFire NV	GOOD Gemini 57A/Metal	Gemini 57AC	Gemini 37C/Masonry
Bullard	—	ZA16PB	A16R	AC16	C16P
Camel	—	—	A	CA	C
Flexovit	ZA16PB	—	A16QB	AC16QB	C16PB
Gulf States	Zirconium	—	A16	—	C16
Pacific	Z, Z-GPC	—	A	CA	—
Pearl	—	—	A16Q	—	C16-Q
Pferd	ZA 16 Q SG	—	A 16 Q SG	—	C 16 Q SG
Sait	—	Z16	A16, 20	CA16	C16
Tyrolit	—	—	A16PB	—	C16PB
Walter	—	—	A	—	C

Best choice for heavy-duty stock removal on medium- and high-horsepower grinders



NORZON PLUS ZIRCONIA ALUMINA

- Tough, durable, premium zirconia alumina grain provides 10X life and 50% faster grinding versus aluminum oxide products
- Engineered to excel on the toughest foundry snagging applications
- Best performance on a wide variety of materials; 300 and 400 series stainless, soft and hard carbon steels, tool steels, titanium, super alloys, soft metals, and cast, ductile and gray iron

Better choice for stock removal on high- and medium-horsepower grinders



BLUEFIRE ZIRCONIA ALUMINA

- Friable zirconia alumina grain and durable resin bond technologies deliver sharper grain longer, for extended wheel life, higher metal removal rates, and faster, freer cutting action than standard zirconia alumina blends
- Ideal for foundry snagging, tool sharpening, portable grinding and stock removal applications on high- and medium-horsepower grinders
- Strong operator preference for these smooth-acting wheels that require less pressure and exertion, while improving productivity
- NVC – zirconia alumina / silicon carbide blend is highly effective on dirty, scale-covered castings
- Available with low odor bond to help reduce odors associated with portable grinding when used in confined spaces

Good choice for steel and ferrous metals as well as specialty applications in aluminum and foundries



GEMINI ALUMINUM OXIDE

- Tough, durable aluminum oxide abrasive for heavy-duty work including foundry snagging, tool sharpening, and stock removal
- Work well with a variety of machines, horsepower, and operations
- Good general-purpose choice for numerous small jobs
- Available with low odor bond to help reduce odors associated with portable grinding when used in confined spaces

Good choice for steel/ferrous metal applications with low initial price



METAL ALUMINUM OXIDE

- Tough, durable aluminum oxide abrasive for heavy-duty work including foundry snagging, tool sharpening, and stock removal
- Work well with a variety of machines, horsepower, and operations
- Good general-purpose choice for numerous small jobs on 300 and 400 series stainless, soft and hard carbon steels, tool steels, titanium, super alloys, soft metals, and cast, ductile and gray iron

Good choice for masonry applications with low initial price







MASONRY ALUMINUM OXIDE

- Sharp silicon carbide abrasive for small-volume snagging jobs
- Delivers rapid stock removal in small areas on a portable cup grinder
- Versatile; good starting specification where initial price is a primary purchasing consideration, especially nonferrous and masonry



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	NORZON PLUS	BLUEFIRE	GEMINI	METAL/MASONRY
SHAPE:	Type 01 and 11	Type 01, 06, and 11	Type 01 and 11	Type 11
ABRASIVE:	Premium Zirconia Alumina	Zirconia Alumina NV Zirconia Alumina/ Silicon Carbide NVC	Aluminum Oxide 57A, Silicon Carbide 37C, Aluminum Oxide/ Silicon Carbide 57AC	Metal – Aluminum Oxide Masonry – Silicon Carbide

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #	SPEC	PART #
Type 01 Straight 										
2-1/2 x 1/2 x 3/8	21,700	20					57A24-R	662435 22381		
3 x 1/4 x 3/8	20,370	25			NV20-T	662533 43872*	57A24-T	662435 28831		
3 x 3/8 x 3/8	18,080	10					57A24-R	662435 22415		
3 x 1/2 x 3/8	18,080	10					57A24-P	662435 22417		
4 x 1/4 x 3/8	15,280	10			NV20-T	662533 44098	57A24-R	662435 22221		
6 x 1 x 5/8	8,000	5			NV14-R	662531 98589	57A16-QS	662528 09563		
S Webs	8,000	5			NZ III 14-Q	662528 38075				
	8,000	5			NZ III 14-R	662528 37961				
8 x 3/4 x 5/8	6,000	10			NV14-S	662533 44347				
S Webs										
8 x 1 x 5/8	6,000	5	NZ IV 16-Q	662530 30778	NV16-Q	662531 98590				
S Webs	6,000	5	NZ IV 16-Q	662530 44532						
	6,000	10			NV14-R	662533 44355				
	6,000	10			NV14-T	662533 44365				
	6,000	10			NVC16-Q	662531 98592				
Type 06 Straight Cup 										
6 x 2 x 5/8-11	6,000	5			NZ III 16-R	662528 38577				
Rim 2" Back 3/4"										
Type 11 Flaring Cup 										
4/3 x 2 x 5/8-11	9,070	10	NZ IV 16-Q	662435 30761	NV16-Q	662531 98583	57A16-Q	662435 10512	Masonry C16-Q	076607 89431
Rim 3/4" Back 3/4"										
5/3-3/4 x 2 x 5/8-11	7,260	5			NV16-Q	662531 46918	57A16-Q	662528 09598	Metal 16-Q	076607 89430
Rim 1" Back 3/4"	7,260	5			4NZ16-Q RB	690786 40233	57AC16-Q RB	690786 40234		
6/4-3/4 x 2 x 5/8-11	6,000	5			NV16-Q	662531 46925	57A16-Q	662528 25201		
Rim 1" Back 3/4"	6,000	5			NZ III 16-Q	662528 38568				
6/4-3/4 x 2 x 5/8-11	6,000	5	NZ IV 16-P	662528 30765	NV14-R	662533 44371	37C16-P	662528 09609		
Rim 1-1/2" Back 3/4"	6,000	5			NV16-Q	662531 98584	57A16-Q	662528 09618		
	6,000	5			NVC16-Q	662531 46922	57AC16-Q	662528 09608		
	6,000	5			4NZ16-Q RB	690786 40484				
							57AC16-Q RB	690786 40485		
Type 11 Flaring Cup with Steel Back 										
4/3 x 2 x 5/8-11	9,070	10			NV16-Q	662531 46917				
Rim 3/4" Back 3/4"										
5/3-13/16 x 2 x 5/8-11	7,260	10			NV16-Q	662531 46920				
Rim 1" Back 3/4"										
6/4-13/16 x 2 x 5/8-11	6,000	5			NV14-R	662533 44373	57A16-Q	662528 09599		
Rim 1-1/2" Back 3/4"	6,000	5			NV16-Q	662531 98586	57AC16-Q	662528 09600		
	6,000	5			NVC16-Q	662531 46929	57AC16-Q RB	690786 40486		
	6,000	5			4NZ16-Q RB	690786 40487				

* Std. Pkg. = 50






RB = Low odor bond. Note: Ti formulation optimized for grinding Titanium

TECH TIP

Norton BlueFire and Gemini Type 11 cup wheels now available in new RB low odor bond to help reduce odors associated with portable grinding when used in confined spaces.



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	NORZON PLUS	BLUEFIRE	GEMINI	METAL
ABRASIVE:	Zirconia Alumina	Zirconia Alumina/Aluminum Oxide	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #	SPEC	PART #
Type 16 Cones 										
1 x 3 x 3/8-24 (ME 107019)	36,290	10			NV20-S	662533 44376	57A24-R	614636 22342	Metal 24	662533 49752
1-1/2 x 2-1/2 x 3/8-24 (ME 44436)	24,190	10					57A24-R	614636 22349	Metal 24	662533 49754
1-1/2 x 2-1/2 x 5/8-11 ME 171651	24,190	10							Metal 20	690786 40046
1-1/2 x 3 x 3/8-24 (ME 139029)	24,190	10			NV20-S	662533 44377				
1-1/2 x 3 x 3/8-24 (ME 171652)	24,190	10							Metal 20	690786 40215
1-1/2 x 3 x 5/8-11 (ME 70535)	24,190	10	NZ IV 20-R	614636 44231	NV20-S	662533 44379	57A24-R	614636 22190	Metal 24	662533 49757
1-3/4 x 3 x 3/8-24 (ME49226)	20,735	10					57A24-R	614636 14503	Metal 24	662533 49840
1-3/4 x 3 x 5/8-11 (ME 33432)	20,740	10					57A24-R	614636 22195	Metal 24	662533 49841
2 x 3 x 3/8-24 ME 157287	18,145	10							Metal 24	662534 76413
2 x 3 x 5/8-11 (ME 28229)	18,145	10	NZ IV 20-R	614636 44232	NV20-S	662533 44381	57A24-R	614636 22218	Metal 24	662533 49846
2-3/4 x 3-1/2 x 5/8-11 (ME 18265)	13,195	10			NV20-S	662533 44383	57A24-R	614636 22387	Metal 24	662533 49855
3 x 3 x 5/8-11 (ME70537)	12,100	10							Metal 24	662434 96885
Type 17 Cones, Square Tip 										
1-1/2 / 1/2 x 3 x 3/8-24	24,190	10					57A24-R	614636 22194	Metal 24	662533 49753
1-1/2 / 1/2 x 3 x 5/8-11	24,190	10							Metal 20	690786 40224
2 / 1/2 x 3 x 5/8-11	18,145	10					57A24-R	614636 15722	Metal 24	662533 49845
Type 17R Cones, Round Tip 										
2 / 3/4 x 3 x 5/8-11 (ME 151373)	18,145	10			NV20-S	662533 44384				
Type 18 Plugs, Square Tip 										
1-1/2 x 2-1/2 x 3/8-24	24,190	10					57A24-R	614636 22217	Metal 24	662533 49755
1-1/2 x 2-1/2 x 5/8-11	24,190	10	NZ IV 20-R	614636 44224	NV20-S	662533 44385	57A24-R	614636 22351	Metal 20	690786 40226
1-1/2 x 3 x 5/8-11	24,190	10			NV20-S	662533 44386	57A24-R	614636 22191	Metal 24	662533 49838
2 x 3 x 5/8-11	18,145	10	NZ IV 20-R	614636 44234	NV20-S	662533 44387	57A24-R	614636 22219	Metal 24	662533 49847
	18,145	10			NV24-S	662533 44391				
2 x 4 x 5/8-11	18,145	10					57A24-R	614636 22366	Metal 24	662533 49850
Type 18R Plugs, Round Tip 										
1-1/2 x 2-1/2 x 3/8-24	24,190	10					57A24-R	690786 40230	Metal 20	690786 40229
1-1/2 x 2-1/2 x 5/8-11	24,190	10							Metal 20	690786 40227
1-1/2 x 3 x 3/8-24	24,190	10					57A24-R	614636 22192	Metal 24	662533 49756
1-1/2 x 3 x 5/8-11	24,190	10							Metal 24	662434 95628
2 x 3 x 5/8-11	18,145	10			NV20-S	662533 44389	57A24-R	614636 22220	Metal 24	662533 49849
3 x 3 x 5/8-11	12,095	10							Metal 20	690786 40231

Core Files

These files consist of coarse grit silicon carbide abrasive in a hard grade, resin-bonded to a reinforcing rod. Half-round in shape, they are a frequent choice for easy cleaning of rough castings.



TIER:	GOOD
ABRASIVE:	Silicon Carbide

SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
Stock Resinoid Core Files – Silicon Carbide			
1/2 x 1 x 10	5	37C24-SB	614636 10314

Floorstand and Swingframe Snagging



Norton snagging wheels maximize your productivity in foundries, welding shops, fabrication facilities, steel mills, and ship yards.

- Applications:** Removing unwanted metal on castings, removing flaws and cracks, removing gates, risers and parting lines
- Size Range:** 24" and 30" diameters in stock; other diameters available as made-to-order
- Abrasive Grain:** Zirconia Alumina, Zirconia Alumina/Silicon Carbide blend, Aluminum Oxide
- Shape:** Type 01 Straight
- Reinforcement:** Strong fiberglass webbing and steel rings for maximum strength

Floorstand Snagging Wheel Material-to-Product Recommendation Guide

	BEST					BETTER		GOOD
	4ZF1434-R5B38S	4ZF1434-Q5B38S	4NZ1434-R5B38S	4NZ1434-Q5B38S	ZI/25-R	ZI/26-Q	Charger	Gemini All Purpose
IRON								
Gray	◆				◆	◆	◆ Long Life	◆
Ductile/Malleable		◆			◆	◆	◆ Long Life	◆
STEEL								
Carbon and Low Alloy			◆				◆ Free Cut	◆
Stainless and High Alloy				◆			◆ Free Cut	◆

Note: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Swingframe Snagging Wheel Material-to-Product Recommendation Guide

	BEST				GOOD	
	4ZF1234-R5B38S	4ZF1434-R5B38S	NZC142-R5B38S	ZI/25-R	ZI/26-Q	Gemini All Purpose
IRON						
Gray		◆			◆	◆
Ductile/Malleable		◆			◆	◆
STEEL						
Carbon and Low Alloy			◆			◆
Stainless and High Alloy						◆
ALUMINUM ALLOY				◆		
COPPER ALLOYS / BRASS / BRONZE				◆		

Note: Grade, Grit and Abrasive tuning may be necessary to obtain optimum performance

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Poor stock removal	Insufficient pressure applied	Increase pressure to use all available power
	Wheel too coarse or hard	Use finer grit and/or softer grade wheel
	Inadequate abrasive	Try NorZon, 4ZF, or ZI/25 specification
Grinding costs too high	Wheel acting too soft	Use harder and/or coarser wheel
	Low performance specification	Try NorZon or ZI products
Wheel loading or glazing	Grade too hard	Try softer grade
	Grit too coarse	Try finer grit
	Dirty, scale-covered parts	Try NZC wheels
Wheels "dusty"	Wheel too soft	Try harder grade
Wheel doesn't hold corner or wheel spalling	Wheel too coarse	Use finer grit and/or 2 grit combination
	Wheel too soft	Use harder grade
Burning the workpiece	Wheel too hard	Use softer grade
	Wheel glazed or loaded	Dress the wheel face
	Grinding pressure too low	Increase grinding force
	Grinding pressure too high	Reduce grinding force
Surface finish too rough	Wheel too coarse	Try finer grit or try ZI/26 specification
	Wheel speed too slow	Try higher speed machine (Do not exceed maximum operating speed of wheel)
	Worn machine bearings	Rebuild machine
Vibration	Wheel worn out of round	Try truing the wheel
	Faulty flanges	Check flanges for flatness and burrs (see ANSI B7.1)
	Bent machine spindle	Check spindle run-out
	Worn machine bearings	Rebuild machine
Wheel stalls or slows	Grinding force too high	Reduce pressure or contact area
	Wheel too hard	Use softer grade wheel
	Machine power too low	Replace machine with higher power grinder

Best choice for demanding applications

4ZF, 4NZ, ZI, AND NZC ZIRCONIA ALUMINA

- Zirconia alumina abrasive engineered for high-pressure, heavy duty, snagging operations including foundry snagging and stock removal
- These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- 4ZF – zirconia alumina grain for exceptional wheel life; engineered for high-pressure, heavy-duty, snagging operations, particularly on iron
- 4NZ – zirconia alumina grain for sharpness and an exceptionally high cut rate; developed for low- to medium-pressure operations, especially on steel and steel castings; the most operator-friendly wheels
- ZI – zirconia alumina grain stays sharper, longer, making it the choice for iron castings: ZI/25 for tough metal removal, ZI/26 for finer surface finish
- NZC – zirconia alumina and silicon carbide blend is ideal for dirty, scale-covered castings

Better choice for strong performance to price ratio

CHARGER ZIRCONIA ALUMINA

- Strong, free-cutting aluminum oxide abrasive for foundry snagging and stock removal
- These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- Good, general-purpose choice for heavy-duty stock removal on low- to medium-horsepower machines

Good choice for numerous small jobs

5ZF ZIRCONIA ALUMINA AND GEMINI ALUMINUM OXIDE

- These wheels have high-speed steel rings with fine centers and reinforcing webs for added safety
- Ideal for lower horsepower machines or low-pressure applications
- 5ZF - Versatile, good quality zirconia alumina abrasive for foundry snagging and stock removal
- Gemini – versatile aluminum oxide formulation works well with a variety of machines, horsepowers, and operations

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BEST		BETTER		GOOD	
			TRADENAMES: 4ZF, 4NZ, ZI, NZC		CHARGER		5ZF / GEMINI	
			SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type O1 Straight								
24 x 3 x 12	1,990	1	4ZF1234-R5B38S	690831 66310			5ZF14-QS	690831 66858
HS Steel Rings with Fine Centers, S Webs	1,990	1					Gemini All Purp.	690831 67173
30 x 2 x 12	1,595	1	4NZ1634-Q5B38S	692104 21412	Charger Free Cut	692104 21417	5ZF14-R	692104 67105
HS Steel Rings with Fine Centers, S Webs	1,595	1	4ZF1434-R5B38S	692104 66458	Charger Long Life	692104 21418	Gemini All Purp.	692104 17463
	1,595	1	ZI/25-R	662531 19636				
	1,595	1	ZI/26-Q	662531 19638				
	1,595	1	NZC142-R5B38S	692104 21414				

For your safety: all floorstand and swingframe wheels have strong fine centers, steel rings and high-strength fiberglass reinforcement construction.

TECH TIP

- Always ensure proper mounting of floorstand and swingframe wheels by mounting with arrow down as marked on wheel
- Always use safety guard
- Always run wheel for 1 minute before grinding
- For optimum performance, ensure adequate air pressure and air volume when using pneumatic machines
- Use constant surface foot per minute machines for highest efficiency
- Do not overdress the wheel face
- Avoid loading or glazing by changing the contact angle
- Use pressure assist whenever possible to obtain maximum cut rate



It is the user's responsibility to refer to and comply with ANSI B7.1

get wired
FOR SUCCESS

Our broad wire brush offering includes the shapes, wire configurations and filament materials you'll need for heavy- to light-duty brushing applications.





Our Norton wire brush broad offering includes all the basic shapes and configurations. Informative, attractive packaging clearly explains dimensions, structure, safety and machine usage. All brushes are individually clamshell packaged unless otherwise noted. When using wire brushes, be sure to comply with ANSI B165 "Power-Driven Brushing Tools: Safety Requirement for the Design, Care and Use." and safety documents on nortonabrasives.com website.

Applications:

Cleaning rust, scale and dirt; light deburring; edge blending; roughening for adhesion; finishing for appearance; finish preparation prior to plating or painting

Shapes:

Cup, saucer cup, wheel, joint/crack, end brush, hand brush

Wire Design:

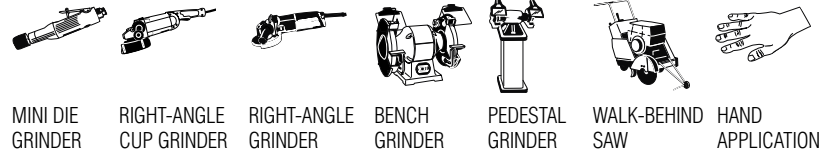
Twist knot, crimped, and stringer bead

Other:

Color-coded for easy identification:

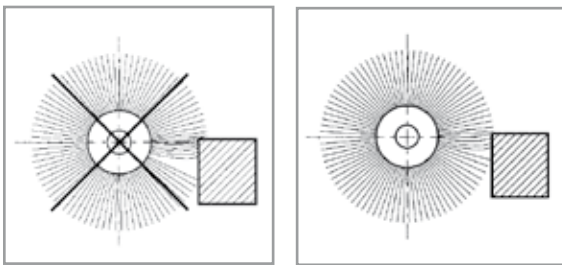


Machine Used:



Why Use Wire Brushes vs. Other Brushes, Coated Abrasive, and Surface-Cleaning Products

Norton Wire brushes remove rust and oxidations, paint, slag, weld spatter and other unwanted surface contaminants, without removing any base material. Other products can remove base material along with the surface contaminant. Our flexible wire brushes are able to clean hard-to-reach places and conform to irregular surfaces, which more rigid products cannot do.



Let the tip of the wire brush do the work – operate the brush with the lightest pressure. If heavy pressure is used, wires will be overstressed, resulting in a wiping action, which, if continued, creates wire fatigue and will shorten brush life. Reversing the rotation periodically sharpens the wire tips for faster cutting action and longer life. Use finest suitable wire size.



Crimped

Standard Twist Knot

Stringer Bead Twist Knot

TECH TIP

When to Use Crimped Wire vs. Standard Twist Knot vs. Stringer Bead Twist Knot Brushes

Crimped Wire Brushes

Crimped wire brushes' individual filaments are supported only by each other – creating extra flexibility.

Ideal for work on irregular surfaces, finer surface finishing, and light- to medium-duty contaminant removal applications.

Standard Twist Knot Wire Brushes

Ensuring longer life, making them the choice for more aggressive applications requiring higher-impact action, and a rougher surface finish.

Standard twist knot brushes are made with straight wire filaments that are twisted together to make more rigid rope- or cable-like pieces.

Stringer Bead Twist Knot Wire Brushes

Stringer bead twist knots (vs. standard twist knots) are more tightly twisted to the end of the knot, creating a narrower face and highest-impact action.

The choice for tough weld scale cleaning, removing the bead scale that occurs at the initial joining of two sections of pipe, root and hot weld pass cleaning, and the most aggressive brushing applications.

Workpiece Material To Wire Brush Recommendation Guide

Workpiece Material	Steel	Stainless Steel	Brass	Nylon
ALUMINUM		■	■	■
BRASS			■	■
COPPER			■	■
IRON	■			
PLASTIC			■	■
CARBON STEEL/METAL	■			
STAINLESS STEEL		■	■	■
WOOD	■	■	■	■

Wire Diameter

Choose the appropriate wire brush wire diameter for the job

- Very fine to fine wire for light-duty applications
- Medium to coarse wire for heavy-duty applications

Wire	Coarse		Medium to Coarse		Medium		Fine		Very Fine	
DIAMETER IN INCHES	.032	.020	.020	.015	.012	.0104	.010	.008	.006	.005
DIAMETER IN MM	.80	.50	.50	.37	.30	.26	.25	.20	.15	.13

TECH TIP

Trim Length

Choose the appropriate trim length for the job. "Trim Length" equals the amount of usable filament:

- Longer trim lengths are more flexible, making them the choice for irregular surfaces
- Shorter trim lengths are fast acting and more rigid, so better for more severe applications

TECH TIP

Filament Do's and Don'ts

Excessive pressure bends and could break brush filaments. Instead of increasing the pressure applied, consider:

- A more aggressive brush:
 - Increasing wire diameter
 - Shorter trim length
- Different brush type, e.g. twist knot versus crimped wire
- Increasing RPM without exceeding the MAX RPMs marked on the brush

Slick Packaging

A good looking product on and off the shelf. Norton BlueFire wire brushes come in a sturdy, clear clamshell package protecting the wire brush until it's ready for use.

Educational information is prominently displayed for ease of selection in three languages.

The new packaging will be a great addition to the merchandising POP display signage.



Instructional Videos



Wire Brushes
Playlist

nortonsga.us/wgazw

To learn which wire style is the best choice for your job and see what makes Norton Wire Brushes the ultimate power tool accessories.

Better choice for deburring, removing rust, paint, corrosion and weld spatter from metal surfaces

BLUEFIRE WIRE BRUSHES

- Perfect for removing rust, scale, paint, and dirt from metal and other surface
- Available in a variety of brush types and sizes for large flat areas to small, tight spaces
- Durable design provides a uniform finish while offering the longest life



Good choice for removing rust oxidation, paint, slag and weld spatter without removing base material

GEMINI WIRE BRUSHES

- Ideal low-impact solution for refining surfaces without removing any base material
- Flexible design for cleaning hard-to-reach places and conforming to irregular surfaces, which more rigid products cannot do
- Economically priced yet solid-performing to complement your projects perfectly while bringing real savings to the bottom line



Deburring; roughing; cleaning rust, scale, paint and oxidation; cleaning corners, recesses, and other hard-to-reach areas and removing concrete and large surfaces



WIRE CUP BRUSHES

- Used on right angle cup grinders
- Twist Knot style for heavy-duty applications
- Crimped cup for light- to medium-duty applications

Twist Knot Wire Saucer Cup Brushes

- Saucer cup brushes are ideal for reaching into and cleaning corners and hard-to-reach areas where a standard cup brush cannot.



TIER:	BETTER	BETTER
TRADENAME:	BLUEFIRE	BLUEFIRE
WIRE TYPE:	STEEL	STAINLESS

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #
Twist Knot Wire Saucer Cup Brushes - Single Row - with Threaded Nut					
4 x 0.020 x 5/8-11	7/8	15,000	5	662528 33483	
5 x 0.020 x 5/8-11	1-1/8	12,500	10	662528 35585	662528 35586



Twist Knot Wire Cup Brushes

- Their more rigid structure allows efficient, high-impact cutting and cleaning on more demanding applications.
- Single row construction limits flaring of the brush on corners and angles



TIER:	BETTER	BETTER	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	STEEL	STEEL	STEEL	STAINLESS

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
Twist Knot Wire Cup Brushes – Single Row – with Threaded Nut									
2-3/4 x 0.014 x 5/8-11	7/8	14,000	5						662528 38871
2-3/4 x 0.014 x 5/8-11	1	14,000	5					662528 39109	
2-3/4 x 0.020 x 5/8-11	3/4	15,000	5	699366 53336	699366 53340				
2-3/4 x 0.020 x 5/8-11	1	14,000	10					662528 39033	662528 38812
3 x 0.020 x 5/8-11	7/8	14,000	5					662528 38835	662528 39127
3 x 0.020 x M10	7/8	14,000	5					662528 39075	
3-1/2 x 0.020 x 5/8-11	7/8	13,000	5					662528 38813	
3-1/2 x 0.020 x 5/8-11	1-3/8	13,000	5					662528 38868	
4 x 0.020 x 5/8-11	1-1/8	9,000	10					662528 39103	
4 x 0.020 x 5/8-11 with bridle	1-1/16	10,200	5	699366 53345	662528 33947				
4 x 0.023 x 5/8-11	1-1/4	9,000	5					662528 39090	
6 x 0.020 x 5/8-11	1-3/8	6,000	5	699366 05965	662533 71115			662528 39104	
6 x 0.023 x 5/8-11	1-3/8	6,000	5					662528 39091	
6 x 0.035 x 5/8-11	1-3/8	6,000	5	699366 02003					
Twist Knot Wire Cup Brushes - Single Row - with Threaded Nut and Protective Guard									
2-3/4 x 0.020 x 5/8-11	3/4	15,000	5			662528 33492			
4 x 0.020 x 5/8-11	1-1/8	10,200	5			662528 33496			
5 x 0.020 x 5/8-11	1-1/8	6,500	5			662528 33497			
Twist Knot Wire Cup Brushes - Double Row - with Threaded Nut									
6 x 0.020 x 5/8-11	1-3/8	6,000	5			699366 53346			

Crimped Wire Cup Brushes

For light- to medium-duty brushing applications on flat or irregular surfaces, and bevel buffing where added flexibility is needed; fast-cutting and flexible, with heavy wire fill

- Machine for cups with threaded nuts: right angle cup grinder
- Machine for stem mounted cups: straight in-line grinder, pencil grinder



TIER: **BETTER**
TRADENAME: **BLUEFIRE**
WIRE TYPE: **STEEL**

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #
High Performance Cable Crimped Wire Cup Brushes - with Threaded Nut and Protective Guard				
3 x (12 x 0.009) x 5/8-11	7/8	15,000	5	662528 33493
4 x (12 x 0.009) x 5/8-11	1-3/16	9,000	5	662528 33494



TIER: **BETTER** **BETTER** **GOOD**
TRADENAME: **BLUEFIRE** **BLUEFIRE** **GEMINI**
WIRE TYPE: **STEEL** **STAINLESS** **STEEL**

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Crimped Wire Cup Brushes – with Threaded Nut						
2-3/4 x 0.014 x 5/8-11	1	14,000	5			662528 38856
2-3/4 x 0.020 x 3/8-24	1	14,000	5			662528 39080
3 x 0.014 x 5/8-11	13/16	14,000	5			662528 39076
3 x 0.014 x 5/8-11	7/8	15,000	5	699366 53341	662528 36362	
3 x 0.014 x 5/8-11	1	14,000	10			662528 39034
4 x 0.014 x 5/8-11	1-1/8	9,000	10			662528 39121
4 x 0.014 x 5/8-11	1-3/16	10,200	5	699366 53347		
4 x 0.020 x 5/8-11	1-3/16	10,200	1	699573 70103		
4 x 0.020 x 5/8-11	1-3/16	10,200	5		662528 43844	
5 x 0.014 x 5/8-11	1-3/8	8,000	5			662528 39105
6 x 0.014 x 5/8-11	1-1/8	6,600	5	699366 53348		
6 x 0.020 x 5/8-11	1-1/8	6,600	5	699366 53349		



TIER: **BETTER** **BETTER**
TRADENAME: **BLUEFIRE** **BLUEFIRE**
WIRE TYPE: **STEEL** **STEEL**

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #
Crimped Wire Saucer Cup Brush - with Threaded Nut					
4 x 0.014 x 5/8-11	7/8	15,000	10	662528 33485*	

* Brass-coated carbon steel filaments



TIER: **GOOD** **GOOD** **GOOD**
TRADENAME: **GEMINI** **GEMINI** **GEMINI**
WIRE TYPE: **STEEL** **STAINLESS** **BRASS**

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Crimped Wire Cup Brushes - with Stem						
5/8 x 0.005 x 1/8	1/4	37,000	100			662528 39087
1-3/4 x 0.012 x 1/4	3/4	13,000	12	662528 39028		
2 x 0.010 x 1/4	5/8	10,500	12		662528 38859	
2-1/4 x 0.014 x 1/4	5/8	4,500	10	662528 38860		

Applications range from the toughest, more aggressive surface cleaning applications, including removing weld scale, spatter, extra-heavy rust and corrosion, cleaning pipe joints, or surface roughening to light- to medium- duty surface cleaning and contaminant removal



EXPANDED OFFERING

WIRE WHEEL BRUSHES

- Available in Standard Twist Knot, Stringer Bead Twist Knot, and Crimped
- See specific machines for each wire wheel below



Standard Twist Knot Wire Wheel Brushes

Our twist knot wire design provides added rigidity for extra cutting and cleaning power, and a rougher surface finish.

- Wheel brushes with threaded nuts perform well on more aggressive applications requiring high-impact action: tough welding and metal fabrication applications, including removing weld scale, spatter, extra-heavy rust.
- These stem-mounted wheel brushes are used for small-to medium-duty jobs requiring some flexibility and lighter brushing action for corrosion, or surface roughing applications. These brushes are used on straight shaft, die, pencil grinders, drills and right angle grinders.



TIER:	BETTER	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	PIPELINE	STEEL	STAINLESS

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #
Standard Twist Knot Wire Wheel Brushes – with Threaded Nut									
4 x 0.014 x 5/8-11	1/2	3/4	20,000	6	699573 70137				
4 x 0.014 x 5/8-11	1/2	7/8	20,000	10				662528 39052	
4 x 0.020 x 5/8-11	1/2	3/4	20,000	5	662528 38300				
4 x 0.020 x 5/8-11	1/2	3/4	20,000	6		699573 70138			
4 x 0.020 x 5/8-11	1/2	7/8	20,000	5				662528 39078	662528 39020
4 x 0.020 x 5/8-11	1/2	7/8	20,000	10				662528 39035	
4 x 0.020 x 5/8-11	9/16	7/8	20,000	10				662528 39019	
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	5	699366 06275	699366 53333			
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	6	699366 53331				
4-1/2 x 0.020 x 5/8-11	1/2	1	20,000	6			662528 40466		
5 x 0.020 x 5/8-11	1/2	1	12,500	5	662528 33487	662528 33488			
6 x 0.020 x 5/8-11	1/2	1-3/8	12,500	5	699366 53352				
6 x 0.020 x 5/8-11	5/8	1-1/4	9,000	5				662528 39107	
Standard Twist Knot Wire Wheel Brushes – with Arbor Hole									
3 x 0.014 x 3/8	3/8	5/8	25,000	1				662528 39021	
4 x 0.014 x 5/8	5/16	7/8	20,000	5				662528 39011	
4 x 0.014 x 5/8	1/2	3/4	20,000	6	699573 70136				
6 x 0.014 x 5/8	1/2	1-1/2	9,000	5				662528 39014	



TIER:	GOOD
TRADENAME:	GEMINI
WIRE TYPE:	STEEL

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #
Standard Twist Knot Wire Wheel Brushes - with Stem					
3 x 0.014 x 1/4	1/4	5/8	25,000	12	662528 39015
3-1/4 x 0.014 x 1/4	3/8	5/8	25,000	10	662528 39031
4 x 0.014 x 1/4	1/2	7/8	25,000	8	662528 39032



Stringer Bead Twist Knot Wire Wheel Brushes

The choice for toughest weld scale cleaning; removing the bead scale that occurs at the initial joining of two sections of pipe; root, and hot weld pass cleaning, and the most aggressive brushing applications. Stringer Bead Twist Knot Wire Wheel Brushes are best used on right angle grinders for difficult jobs.



TIER:	BETTER	BETTER	BETTER	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STEEL	STEEL	STAINLESS	STAINLESS	STEEL	STAINLESS
OTHER:		Pipeline	Heavy-Duty		Pipeline		

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
Stringer Bead Knot Wire Wheel Brushes – with Threaded Nut										
4 x 0.020 x 5/8-11	3/16	7/8	20,000	5	699366 06277		699366 06278			
4 x 0.020 x 5/8-11	3/16	7/8	20,000	6		662528 40467*		662528 42233*		
4 x 0.020 x 5/8-11	3/16	7/8	20,000	10	662533 70022*				662528 39036	662528 39039
4 x 0.020 x 5/8-11	1/4	7/8	20,000	5					662528 38997	
4 x 0.020 x 5/8-11	1/4	7/8	20,000	10						
4 x 0.020 x 5/8-11	1/2	7/8	20,000	10					662528 39130	
4 x 0.020 x 5/8-11	1/2	1	20,000	10					662528 39106	
4 x 0.020 x M10	3/16	7/8	20,000	6			699573 70144			
4 x 0.020 x M10	3/16	7/8	20,000	10						
4-1/2 x 0.020 x 5/8-11	3/16	3/16	15,000	5					662528 39111	
4-1/2 x 0.020 x 5/8-11	3/16	1-1/8	12,500	6		662528 42299*	662528 44886			
5 x 0.020 x 5/8-11	3/16	7/8	12,500	10	662528 33490*		662528 33491*			
5 x 0.020 x 5/8-11	1/2	7/8	12,500	5					662528 39133	
6 x 0.020 x 5/8-11	3/16	1-3/8	12,500	10		662528 40469*	662528 44887	699366 53351		
6-7/8 x 0.020 x 5/8-11	3/16	1-1/8	9,000	10		662528 40468*	662528 43919*			
9 x 0.020 x 5/8-11	3/16	2-1/8	6,000	6	662528 37993					
Joint Crack Cleaning Brush for Walk Behind Machines										
12 x 0.035 x 1-DP	3/8	3-1/4	4,500	2	699366 06280					

*Bulk Packed Item



Radial Wheel

Nylon Radial Wheel Brushes are best used for deburring, surface and light cleaning, adding an edge radius on ferrous and non-ferrous parts. The long trim length is ideal when used on intricate or irregular parts.

- Machine: Bench and Pedestal, Automated CNC, Inline Grinders



TIER:	GOOD
TRADENAME:	GEMINI
WIRE TYPE:	NYLON

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #
Radial Wheel with Arbor Hole					
3 x 3/8 x 5/8	3/8	15/16	15,000	12	662528 38842

Crimped Wire Wheel Brushes

Stem-mounted wheel brushes are used on straight shaft, die, and pencil grinders, and drills. Wheel brushes with arbor holes are used on bench and pedestal grinders. Their extra flexibility and lower impact makes these brushes an excellent choice for cleaning irregular surfaces and finer surface finishing, and light to medium duty surface contaminant removal applications. May be used individually or stacked on a shaft.

- Narrow-faced brushes are ideal for general-purpose brushing of uneven or difficult-to-reach surfaces.
- Medium-faced brushes clean larger surface areas and have longer life.



Crimped Wire with Threaded Nut – Narrow Face – Steel



TIER:	BETTER	GOOD
TRADENAME:	BLUEFIRE	GEMINI
WIRE TYPE:	STEEL	STEEL

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #
Crimped Wire Wheels Brushes with Threaded Nut – Narrow Face						
4 x 0.014 x 5/8-11	7/16	7/8	15,000	10		662528 39001
Crimped Wire Wheels Brushes with Threaded Nut – Medium Face						
4-1/2 x 0.014 x 5/8-11		1	13,000	6		662533 70278



TIER:	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STEEL	STAINLESS



Crimped Wire with Arbor hole – Narrow Face – Steel

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #
Crimped Wire Wheels Brushes with Arbor Hole – Narrow Face							
2 x 0.014 x 1/2	3/8	1/2	20,000	12		662528	39023
3 x 0.005 x 1/2	1/4	1	20,000	20			662528 38960
3 x 0.014 x 1/2	5/8	1	20,000	10		662528	39024
6 x 0.014 x 1/2-2	3/4	1-1/8	6,500	5	699366	53306	
8 x 0.014 x 5/8	3/4	1-9/16	4,500	5		662528	39099
8 x 0.014 x 5/8	3/4	1-5/8	4,000	1	699573	70117	
8 x 0.014 x 5/8	3/4	2-1/16	6,000	5		662528	39089
8 x 0.014 x 1-1/4	5/8	1-1/2	4,000	5		662528	38978
Crimped Wire Wheels Brushes with Arbor Hole – Medium Face							
6 x 0.014 x 1/2-2	1	1-1/8	6,500	5	699366	53324	
8 x 0.014 x 1/2-2	1-1/16	1-5/8	4,500	5	699366	53326	
8 x 0.014 x 5/8	1	1-9/16	4,000	5		662528	39100
8 x 0.014 x 2	1	1-3/8	4,500	5		662528	39025
10 x 0.014 x 3/4	1-9/16	2-1/2	3,600	1		662528	39102
12 x 0.012 x 2	2	2	3,600	1	699573	70135	
12 x 0.012 x 2	2	3-1/4	3,600	1		662528	39006



TIER:	BETTER	BETTER	GOOD	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	STEEL	STAINLESS	BRASS



Crimped Wire with Stem

SIZE	FACE WIDTH	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Crimped Wire Wheels Brushes with Narrow Face - with Stem								
1 x 0.005 x 1/8	1/8	5/16	37,000	100				662528 39085
1-1/2 x 0.008 x 1/4	1/4	1/4	25,000	20		662528	38962	
1-1/2 x 0.014 x 1/4	1/4	1/4	25,000	20		662528	38963	
2 x 0.006 x 1/4	3/8	1/2	20,000	20		662528	39029	
2 x 0.008 x 1/4	3/8	7/16	25,000	20		662528	38964	
2 x 0.0118 x 1/4	3/8	1/2	20,000	20		662528	39030	
2 x 0.014 x 1/4	3/8	7/16	25,000	12	699573	70123		
2-1/2 x 0.008 x 1/4	7/16	11/16	25,000	10		662528	38967	
2-1/2 x 0.014 x 1/4	5/8	5/8	25,000	12	699573	70126		
3 x 0.008 x 1/4	7/16	3/4	25,000	10		662528	38969	
3 x 0.008 x 1/4	7/16	3/4	25,000	12		662528	38972	
3 x 0.0118 x 1/4	5/8	5/8	25,000	12	699573	70132		
3 x 0.014 x 1/4	7/16	3/4	25,000	12		662528	38973	
3 x 0.014 x 1/4	1/2	1	20,000	20		662528	39048	
3 x 0.014 x 1/4	5/8	5/8	25,000	12	699573	70130	699573	70131
3 x 0.020 x 1/4	3/8	1	20,000	12		662528	39096	
4 x 0.014 x 1/4	1/2	1	25,000	12		662528	38974	

Clean and deburr recessed areas or inside diameters of tubes and pipes to proper surface finish; rubber and plastic flash removal; paint and rust removal, and mold and tool polishing



END BRUSHES

- Used on CNC, Robotic, die grinders, and drill presses
- Twist knot wire end brushes for more aggressive cutting
- Crimped wire end brushes for lighter brushing action and contoured surfaces



Twist Knot Wire End Brush

Their added wire rigidity makes these brushes the choice for more aggressive cutting.



TIER:	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	STEEL	STAINLESS

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Twist Knot Wire End Brushes – with Stem							
1/2 x 0.006 x 1/4	1-1/8	22,000	20			662528 38876	
1/2 x 0.014 x 1/4	1-1/8	22,000	20			662528 38877	
3/4 x 0.014 x 1/8	7/8	22,000	20			662528 39056	
3/4 x 0.014 x 1/4	7/8	25,000	10		699573 70165		
3/4 x 0.014 x 1/4	7/8	22,000	20			662528 38879	
3/4 x 0.020 x 1/4	7/8	25,000	10	699366 53316*			
3/4 x 0.020 x 1/4	7/8	22,000	20			662528 39057	
3/4 x 0.020 x 1/4	1	22,000	20			662528 39116	662528 39118
3/4 x 0.020 x 1/4	1-1/8	22,000	20			662528 38878	
1 x 0.006 x 1/4	1-1/8	22,000	20				662528 38885
1 x 0.010 x 1/4	1-1/8	22,000	25				662528 38886
1 x 0.014 x 1/4	7/8	25,000	10	699366 06279*	699573 70167		
1 x 0.014 x 1/4	1	22,000	20			662528 38882	662528 38887
1 x 0.020 x 1/4	7/8	25,000	10	699366 53310*			
1 x 0.020 x 1/4	1	22,000	20				662528 39119
1 x 0.020 x 1/4	1	22,000	25			662528 39117	

* Bulk Packed Item



Insert Circular Flared Crimped Wire End Brush

The flared end configuration facilitates interior side cleaning and will not harm the bottom of the hole.



TIER:	BETTER	GOOD
TRADENAME:	BLUEFIRE	GEMINI
WIRE TYPE:	STEEL	STEEL

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #
Insert Circular Flared Crimped End Brushes – with Stem					
1-1/2 x 0.006 x 1/4	7/8	20,000	12		662528 39108
1-1/2 x 0.020 x 1/4	1	15,000	12		662528 38898
2 x 0.010 x 1/4	1-1/8	15,000	10		662528 38899
3 x 0.008 x 1/4	1	25,000	10	699573 70163	



Crimped Wire End Brushes

Designed to generate lighter brushing action and reach into contoured surfaces.



TIER:	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLUEFIRE	BLUEFIRE	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	STEEL	STAINLESS

SIZE	TRIM LENGTH	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Crimped Wire End Brushes – with Stem							
1/4 x 0.005 x 1/8	7/16	37,000	12				66252839086
1/2 x 0.005 x 1/4	1	25,000	20				66252838902
1/2 x 0.006 x 1/4	3/8	25,000	20			66252839040	
1/2 x 0.006 x 1/4	1	25,000	20			66252838889	66252839043
1/2 x 0.010 x 1/4	1	25,000	20			66252838890	
1/2 x 0.014 x 1/4	1	25,000	20				66252838888
1/2 x 0.020 x 1/4	1	25,000	20			66252838891	
3/4 x 0.006 x 1/4	1	25,000	10		69936606145*		
3/4 x 0.010 x 1/4	3/8	22,000	20			66252839053	
3/4 x 0.014 x 1/4	1	25,000	10	69936653317*			
3/4 x 0.020 x 1/4	7/8	22,000	20			66252839112	
3/4 x 0.020 x 1/4	1	25,000	10	69957370152			
3/4 x 0.020 x 1/4	1	22,000	20			66252838892	
1 x 0.005 x 1/4	1	22,000	20				66252838896
1 x 0.006 x 1/4	1	22,000	25			66252839045	66252838838
1 x 0.006 x 1/4	1-3/16	25,000	10	69957370154	69957370155		
1 x 0.010 x 1/4	1	22,000	20				66252838897
1 x 0.010 x 1/4	1	22,000	25				66252839055
1 x 0.0104 x 1/4	1-3/16	25,000	10		69957370157		
1 x 0.014 x 1/4	3/4	20,000	20			66252839094	
1 x 0.014 x 1/4	1	22,000	20			66252839046	
1 x 0.014 x 1/4	1-3/16	25,000	10	69957370158			
1 x 0.020 x 1/4	7/8	22,000	20			66252839095	
1 x 0.020 x 1/4	1-3/16	25,000	10	69936653309*			

* Bulk Packed Item



Cleaning, polishing, reaming, finishing and removing debris, burrs, rust, residues, and surface contaminants inside cylindrical items, including tubes, pipes, bottles, smooth-sided and threaded holes, and other industrial components



TUBE BRUSHES

- Use manually or fastened to portable or fixed machines (including drills, drill presses, and CNC machines)
- Available in single and double stem providing firm support when working internally
- A wide selection of shapes and filament variations to achieve the best results on many different applications



Single Stem, Single Spiral Tube Brush – with Eye Loop

These spiral brushes have a single layer of filament twisted around a stem wire to create additional strength and higher density fill brushes. This spiral configuration ensures consistent and constant abrasive contact with the tube. Formed eye loop at the end of the stem for convenient hand use.



Double Stem, Single Spiral Tube Brush – with Stem

These brushes have two stem wires. This results in a brush with high strength and one with consistent and constant abrasive contact with the tube.

TIER:	GOOD	GOOD	GOOD
TRADENAME:	GEMINI	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS	BRASS

SIZE	TRIM LENGTH	STD. PKG.	PART #	PART #	PART #
Single Stem, Single Spiral Tube Brush – with Eye Loop					
3/16 x 0.004 x 0.094	5/64	12	662528 38913		
3/16 x 0.003 x 0.094	1-1/2	12	662528 38822		
1/4 x 0.004 x 0.115	5/64	12	662528 38914		
3/8 x 0.004 x 0.125	2	12			662528 38826
3/8 x 0.004 x 0.132	1/8	12	662528 38916		
3/8 x 0.006 x 0.168	1-1/2	12		662528 38946	

TIER:	GOOD
TRADENAME:	GEMINI
WIRE TYPE:	NYLON

SIZE	TRIM LENGTH	STD. PKG.	PART #
Double Stem, Single Spiral Tube Brush – with Stem			
3/4 x 0.040 x 0.238	3/8	12	662528 38850



Power Burr, Single Spiral Tube Brush – with Stem

Power burr brushes are used to remove burrs resulting from previous operations. They are designed to remove burrs without creating secondary burrs or leaving sharp edges.



Double Stem, Double Spiral Tube Brush – with Stem

Brush filaments are twisted between two stem wires with two layers of filament bristles. Each layer is perpendicular to the other with a single stem wire in each of the brush's four sections. This configuration ensures consistent and constant abrasive contact with the tube.



Single Spiral Nylon Hand Tube Brush – with Eye Loop

These brushes are made with larger stem wires to give them the strength and rigidity needed for manual cleaning applications.



TIER:	GOOD	GOOD
TRADENAME:	GEMINI	GEMINI
WIRE TYPE:	STEEL	STAINLESS

SIZE	TRIM LENGTH	STD. PKG.	PART #	PART #
Power Burr Single Spiral Tube Brushes – with Stem				
1/4 x 0.004 x 0.125	1	12	662528 39061	662528 39081
3/8 x 0.004 x 0.125	1	12	662528 39062	662528 39050
3/8 x 0.005 x 0.125	9/64	12	662528 38910	
1/2 x 0.005 x 0.188	1	12	662528 39063	662528 39051
5/8 x 0.005 x 0.188	1	12	662528 39064	
3/4 x 0.006 x 0.219	1	12	662528 39065	
1 x 0.005 x 0.125	15/32	12	662528 38912	
1 x 0.005 x 0.250	1	12	662528 39066	662528 39083



TIER:	GOOD
TRADENAME:	GEMINI
WIRE TYPE:	BRASS

SIZE	BRUSH LENGTH	STD. PKG.	PART #
Double Stem, Double Spiral Tube Brush – with Stem			
3/4 x 0.006 x 0.250	2-1/2	12	662528 38832



TIER:	GOOD
TRADENAME:	GEMINI
WIRE TYPE:	NYLON

SIZE	TRIM LENGTH	STD. PKG.	PART #
Single Spiral Nylon Hand Tube Brush – with Eye Loop			
1/2 x 0.008 x 0.094	3	12	662528 38939
1/2 x 0.010 x 0.125	3	12	662528 38820
1 x 0.010 x 0.156	25/64	12	662528 38941
1 x 0.022 x 0.156	2-1/2	12	662528 38817
1-1/4 x 0.010 x 0.219	1/2	12	662528 38943
2 x 0.010 x 0.219	1/2	12	662528 38944



Flue Double Spiral Tube Brushes – with 1/4" x 2" NPT Pipe Nipple with Stem

These aggressive brushes are designed specifically for efficient pipe and boiler cleaning.

TIER: **GOOD**

TRADENAME: **GEMINI**

WIRE TYPE: **STEEL**

SIZE	TRIM LENGTH	STD. PKG.	PART #
Flue Double Spiral Tube Brushes – with 1/4" x 2" NPT Pipe Nipple – with Stem			
1 x 0.010 x 0.313	25/64	12	662528 38932
1-3/4 x 0.012 x 0.313	1/2	12	662528 38934



Side-Action Tube Crimped Wire Tube Brushes – with Stem

Their dense side filament configuration creates increased bristle rigidity with minimal flexing, to aggressively clean the tube without changing its geometry or surface finish.

TIER: **GOOD**

TRADENAME: **GEMINI**

WIRE TYPE: **STEEL**

SIZE	TRIM LENGTH	STD. PKG.	PART #
Side-Action (Burrite) Crimped Wire Tube Brush – with Stem			
1/4 x 0.003 x 0.094	5/64	12	662528 38908



Hand Brushes

Hand brushes come in a variety of handle and filament shapes and styles for most hand scratching applications. They are favored by many in removing scale, surface coatings, or removing weld debris.

For steel/stainless



HAND BRUSHES

- Long handle and shoe handle brushes are made with a high-carbon, brass-coated steel; stainless steel is made with a 302 stainless.
- Plastic ergonomic handle scratch brush with curved face to access hard-to-reach places. Crimped wire for longer life. Wires are wrapped up and around the metal post so they never come out.
- Narrow brush allows access into tight areas and slots.



TIER: **BETTER**

TRADENAME: **BLUEFIRE**

WIRE TYPE: **STAINLESS**

TIER: **BETTER**

TRADENAME: **BLUEFIRE**

WIRE TYPE: **STEEL**

TIER: **BETTER**

TRADENAME: **BLUEFIRE**

WIRE TYPE: **STAINLESS**

TIER: **BETTER**

TRADENAME: **BLUEFIRE**

WIRE TYPE: **STEEL**

TIER: **BETTER**

TRADENAME: **BLUEFIRE**

WIRE TYPE: **STAINLESS**

SIZE	HANDLE TYPE	TRIM LENGTH	STD. PKG.	PART #	PART #	PART #	PART #	PART #
Hand Scratch Brushes – With Handle								
3 x 19	Long Handle	1-3/16	12	662528 33950				
4 x 16	Shoe Handle	1-3/16	12		662528 33949	662528 33951		
5 x 10	Plastic Handle	1-1/8	24				662528 33954	
3 x 7	Inspection Brush	1/2	36					662528 33952



When maximum conformability is needed, tough, Norton nylon brushes' flexible nylon filaments embedded with abrasive grain provide exceptional finishing and polishing and eliminate the need for costly and inconsistent hand deburring applications.

Norton nylon brushes are precision-engineered with the highest quality abrasive grains for those markets with the strictest requirements – for easy integration into today's automated machinery, CNC machining centers, transfer lines, robotic cells, and other highly-specialized machinery, as well as hand tools.

- Applications:** Deburring, cleaning, finishing, and polishing
- Brush Configurations:** Radial wheel brushes, narrow face wheel brushes, disc brushes, end brushes, and twisted brushes
- Markets:** Aerospace/aircraft, automotive, construction/utility products, medical, metal finishing, woodworking
- Abrasive Grain:** Ceramic Alumina, Silicon Carbide

Why Choose Nylon Abrasive Brushes?

- Abrasive grain cutting points are increased as the grain is exposed and cut equally when pressure is applied to the side or tip of the filament
- Uniform distribution of grain throughout the filaments allows cutting and finishing performance levels to remain consistent throughout the life of the brush – making Norton abrasive brushes ideal for automated applications
- Heat- and stress-resistant filaments prolong brush life and allow for superior conformability to irregular surface shapes
- The grain impregnated filaments act as a flexible file to deburr and radius edge profiles with precision, without gouging or affecting the overall geometry of a part
- The filaments bend at various angles to fit contours, creating a less prominent, more uniform surface finish in comparison to wire wheels or coated abrasive products
- Brush conformability allows usage on variety of complex part shapes without the need for ultra-precise programming and fixturing that is required with other deburring and finishing tools

Currently, all Norton Blaze ceramic alumina nylon abrasive brushes are custom-made to your exact requirements. Your Norton representative would be pleased to review availability, quotations, and lead-times with you.



the brightest product
solutions from
**A TOTAL SPECTRUM
OF INNOVATION**

For everything from heavy-to-medium stock removal, to fine finishing, to light blending and polishing, abrasive products are available in many shapes, abrasive grains, specialty coatings and backing configurations to meet many application needs.

Coated Abrasives

A coated abrasive product is made up of three basic raw materials: an abrasive grain, the backing onto which the abrasive is applied, and an adhesive bond.

Abrasive Types

Emery (6)

Emery is a dark gray, round-shaped grain which tends to polish rather than abrade a work surface.

- For polishing and cleaning metal only



Garnet (5)

Garnet is reddish brown in color. This natural abrasive is medium hard and relatively sharp, but not as durable as synthetic abrasives.

- For use on wood only
- Particularly good for soft woods such as pine
- Produces an excellent finish



Silicon Carbide (4)

Silicon carbide is the hardest and sharpest of the manufactured abrasives. Because of its extreme sharpness, this bluish-black abrasive grain permits fast stock removal and cool cut.

- Cast iron
- Non-ferrous metals, i.e. brass, aluminum and bronze
- Non-metallics, i.e. glass, rubber, plastic and stone
- Final finish on wood and stainless steel
- Abrasive planing particleboard



Light Brown Aluminum Oxide (2)

Light brown aluminum oxide is a tough, yet sharp synthetic abrasive characterized by cool cut, long life and the ability to break down under pressure, producing new cutting edges.

- Production wood sanding
- Non-ferrous metal finishing



Brown Aluminum Oxide (2, 7)

Brown aluminum oxide is a tough, durable, synthetic abrasive characterized by the long life and wear resistance of its cutting edges. It offers enormous penetrating strength, even at high speeds.

- Ferrous metals
- Aluminum
- Hardwood



Heat-treated Aluminum Oxide (2)

Heat-treated aluminum oxide is a tough but cool cutting abrasive which gives both long life and freeness of cut on a wide range of materials.

- Ferrous metals
- Wood sanding



Zirconia Alumina (8)

Zirconia alumina is an ultra-tough, synthetic abrasive which provides a free, cool cut for high stock removal applications. It is tougher and sharper than aluminum oxide. It has a micro-crystalline structure which allows for controlled breakdown and self-sharpening.

- Heavy-duty snagging and grinding of all ferrous and non-ferrous metals
- Abrasive planing of wood, plywood and particleboard
- Grinding fiberglass, rubber and plastics



Ceramic Alumina (9)

The sub-micron structure of ceramic alumina allows each grain to continually expose sharp cutting points, resulting in a cooler cutting action and an extended life.

- All ferrous/non-ferrous metals, carbon steel and exotic alloys



Backing Types

Backings are the base for the abrasive minerals and, combined with the adhesive bond, support and anchor the abrasive mineral. The backings used in the manufacture of coated abrasives are:

Paper

Due to the fine surface of paper, a consistent finish is produced. Paper weights include *A, B, C, D, E* and *F* weights with *A* being the lightest and most flexible and *F* being the heaviest and least flexible. *A, B, C* and *D* weight papers are used for hand sanding and light mechanical operations in the form of sheets, PSA (pressure sensitive adhesive) and hook and loop discs and sheet rolls. *E* and *F* weight papers are primarily used for more aggressive mechanical operations in the form of belts and discs.

Cloth

Cloth backings used for coated abrasives are identified by weight. Cloth backings are filled or "finished" with a variety of materials (glues or resins) to create various backing characteristics, most notably flexibility. Several cloth types are used: cotton, polyester, polyester/nylon and polyester/cotton blends, and rayon.

There are three basic weights of cloth: J-weight or "jeans" is the lightest and most flexible. X-weight or "drills" is a heavier cloth that ranges in flexibility, strength and durability and is used on the broadest range of applications. Y-weight is a heavyweight drills cloth used on heavy-duty, high stock removal operations.

Fiber

Vulcanized fiber (cotton fibers which are chemically treated and then pressed under temperature and pressure to form a very durable backing) is used exclusively as the backing for resin fiber discs.

Film

Polyester film backing comes in 3 mil. and 5 mil. thicknesses, which have high strength and surface smoothness. They are used primarily in disc and roll applications requiring consistent surface finish, including powertrain applications.

Foam

Primarily used as backing for sponges, finer grit finishing discs, and buffing and polishing pads for cleaning and moist finishing applications.

Mesh

Mesh matrix backing comprised of thousands of tiny holes allowing for maximum dust extraction.

Bond Types

An adhesive bond system is required to secure the abrasive mineral to the backing. All coated abrasive products are made with a two stage bonding process, the *make coat* and the *size coat*.

The *make coat* is the first layer of bond applied to the backing. The make coat provides the adhesive base between the abrasive mineral and the backing.

The *size coat* is the second coat, which is applied over the abrasive mineral and make coat to anchor the abrasive mineral and provide the desired physical strength of the finished product.

Glue, urea resin, and phenolic resin are the three basic bonding agents most commonly used. There are many size coat and make coat combinations, such as *glue over glue, urea over glue, and resin over resin*. *Glue over glue* is the most flexible bond while *resin over resin* bond is moisture-resistant, harder, less flexible, heat-resistant and has superior grain retention.

Coating Types

There are two types of abrasive coatings used in the manufacturing of coated abrasives: *open coat* and *closed coat*.

Open Coat

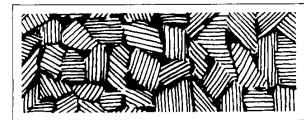
With an open coat, 50% to 75% of the surface is covered by abrasive grain. There are evenly spaced voids between the particles of grain, helping reduce the effect of loading caused by wood dust or metal particles.



OPEN COAT
(1/3 LESS GRAIN THAN CLOSED)

Closed Coat

With a closed coat, the entire surface is covered with abrasive grain, with no voids between the particles. This is the most typical coating, permitting the greatest degree of stock removal and longest product life.



CLOSED COAT

Super Size Coating

The Super Size coat is an optional final coat and grinding aid applied over the size coat to help maintain low grinding temperatures and prevent loading.

How to Read a Coated Abrasive Specification

The Norton coated abrasive marking system includes both a generic and a technical marking, which identifies the actual components which make up the product. The markings identify the tradename, abrasive type, bond, backing, and any special features. An example would be: Norton Blaze R980P.

R 9 8 0 P				
Backing / Bond	Principal Abrasive	Coating	Random	Modifier
A = Lightweight Paper (A-D wts.) excluding Waterproof	1 = Aluminum Oxide	Odd = Open Coat	Designates different products within the same product group.	Additional description, often indicative of a product upgrade, i.e. "P" = Plus
F = Fiber	2 = Aluminum Oxide	Even = Close Coat		
H = Heavy Paper / Resin Bond (E and F wts.)	3 = Layered Aluminum Oxide			
K = Cloth / Glue Bond (J and X wts.)	4 = Silicon Carbide			
M = Mesh	5 = Garnet			
PB = B-wt. Paper with Resin Bond and Latex	6 = Crocus & Emery			
Q = Various (e.g. Screen-Bak, Film, and Foam)	7 = Aluminum Oxide			
R = Cloth / Resin Bond (H, J, X and Y wts.)	8 = Zirconia Alumina			
T = Waterproof Paper (A, C wts.)	9 = Norton SG Ceramic Alumina			
U = Lightweight Waterproof Paper/ NORaX Engineered Abrasive Resin Bond				

Coated Abrasive Grit Comparison Chart

AVERAGE PARTICLE SIZE IN MICRONS	GRADING SYSTEMS (OTHER THAN EMERY)			EMERY PRODUCTS
	ANSI	FEPA	JIS	
5.0	-	-	-	-
6.0	-	-	3000	-
6.5	1200	-	2500	4/0
8.4	-	P2500	-	-
8.5	-	-	2000	-
9.2	1000	-	-	3/0
10.3	-	P2000	-	-
10.5	-	-	1500	-
12.2	800	-	1200	-
12.6	-	P1500	-	-
15.0	-	-	-	-
15.3	-	P1200	1000	-
16.0	600	-	-	2/0
18.3	-	P1000	800	-
19.7	500	-	-	0
20.0	-	-	-	-
21.8	-	P800	-	-
23.6	400	-	600	-
25.0	-	-	-	-
25.75	-	P600	-	-
28.8	360	-	500	-
30.0	-	P500	-	-
35.0	-	P400	400	-
36.0	320	-	-	-
40.0	-	-	360	-
40.5	-	P360	-	-
44.0	280	-	-	1
45.0	-	-	-	-
46.2	-	P320	320	-
50.0	-	-	-	-
52.5	-	P280	280	-
53.5	240	-	-	-
55.0	-	-	-	-
58.5	-	P240	-	-
60.0	-	-	240	-
64.0	-	-	-	2
65.0	-	P220	220	-
66.0	220	-	-	-
78.0	180	P180	180	-
79.0	-	-	-	3
93.0	150	-	150	-
95.0	-	-	-	FINE
97.0	-	P150	-	-
116.0	120	-	120	-
127.0	-	P120	100	-
136.0	-	-	-	MEDIUM
141.0	100	-	-	-
156.0	-	P100	-	-
189.0	-	-	-	COARSE
192.0	80	-	80	-
197.0	-	P80	-	-
260.0	-	P60	-	-
268.0	60	-	60	-
326.0	-	P50	50	-
341.0	-	-	-	EX. COARSE
351.0	50	-	-	-
412.0	-	P40	40	-
428.0	40	-	-	-
524.0	-	P36	-	-
535.0	36	-	36	-
622.0	-	P30	-	-
638.0	30	-	30	-
715.0	24	-	-	-
740.0	-	P24	24	-
905.0	20	-	-	-
984.0	-	P20	20	-
1320.0	16	-	16	-
1324.0	-	P16	-	-
1764.0	-	P12	-	-
1842.0	12	-	-	-

Coated Abrasive Storage

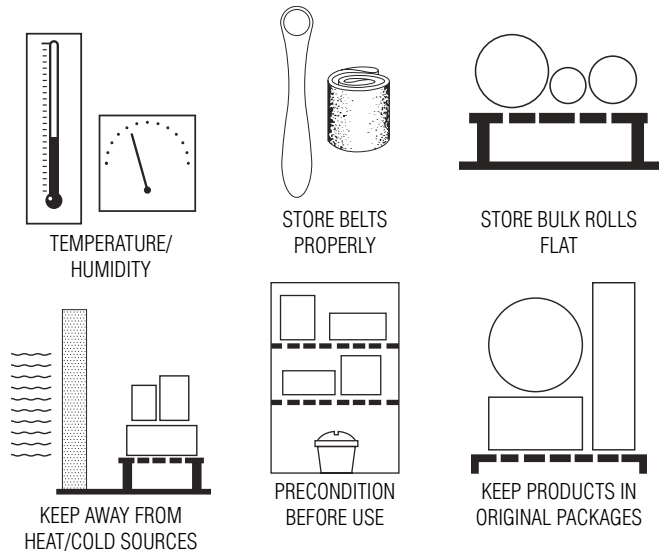
Stored under proper conditions, coated abrasives will retain their efficiency and usefulness over long periods. Improper or inadequate storage can introduce problems of weakened bond, curl, brittleness, and breakage.

Temperature and humidity are the two most important climatic factors influencing coated abrasive performance. Backings and adhesives are sensitive to climatic changes and will gain or lose moisture according to the relative humidity of their surroundings.

Excessive humidity may cause a softening of some types of adhesive bonds so that the product quickly fills and clogs, or loses its grain during use. Excessive dryness may cause brittleness, reduced flexibility, and distortion of product shapes.

As moisture in the coated abrasive product increases or decreases, dimensional changes can occur. When the backing changes more than the adhesive bond, it causes cupping. High and low humidity can cause concave and convex cupping respectively.

The newer synthetic-backed belts are not affected by moisture. Broad temperature swings will not permanently harm these products either, but cold temperatures will cause a "cold set" condition. Consequently, these products should be allowed to come to room temperature before use.



Storage Facilities

The ideal storage (stock) room for coated abrasives would be one in which all the walls are inside partitions, rather than the outside walls of the building.

- Constant levels of humidity and temperature should be maintained. Stockroom temperature should be 60-degrees to 80-degrees F and relative humidity between 35 and 50%.
- Cartons should be kept away from damp or cold walls and floors, where they might absorb moisture.
- Store coated abrasives away from heat sources – steam heated radiators, steam pipes, hot air inlets, heat ducts, or rooms near furnaces or ovens.
- Keep products in original packages. These packages facilitate handling and can be stacked in the most practical and convenient manner.
- Bulk rolls should not be allowed to stand on edge after they have been unpacked. Store flat on shelves or pallets.
- Narrow belts which have been removed from the carton should be rolled up and stored on edge on a clean shelf. Belts may be draped over a large cylinder, such as a gallon can, brake drum, or flanged hanger of the type used for a garden hose. Never hang a belt from a nail – the backing will crease and the abrasive belt might crack. Wide belts should be hung over a tube of at least 4" diameter. Center the belt joint over the tube and add a light weight (such as old packaging tubes) to the bottom loop of the belt to aid in removing set. Condition for 24 hours prior to use.
- For maximum product efficiency, precondition coated abrasive products in a chamber of controlled temperature and humidity before use.

Introduction

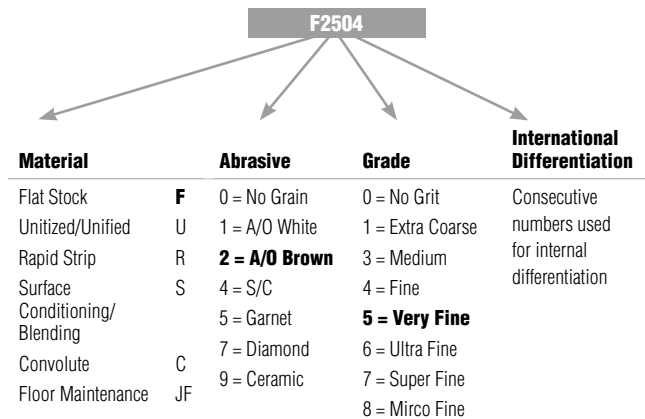
Most Norton Bear-Text products consist of a non-woven web of nylon fibers impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting. The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Norton Bear-Text products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic and non-rusting. Non-woven wheels are easily pre-formed to conform to special-shaped work pieces.

Since non-woven products are designed for use where stock removal is not required, they begin where other abrasives leave off. The relatively non-aggressive nature of nylon and grit inherent in the material makes it ideal as a finishing tool. While 60 to 80 grits are considered intermediate sizes in other products, they are considered coarse for non-woven items.

Used wet or dry, Norton Bear-Text non-woven products offer the following advantages: controlled cut (with little or no stock removal) allows for increased productivity, consistent, uniform finish, ability to automate operations, minimized smearing and reduced operator training. These advantages make our non-woven products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds and steel wool.

Product Identification System



Abrasives

Ceramic alumina, silicon carbide and aluminum oxide abrasives are offered. Ceramic alumina cuts the fastest and is the most cost effective on large-volume applications. Silicon carbide is sharper, cuts faster than aluminum oxide, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer. It causes less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Norton Bear-Text hand pads are also available in a non-abrasive material.

Grits

Grit refers to the size of the abrasive grain impregnated into the nylon web. The coarser the grit, the more aggressive the cut, the rougher the finish. The finer the grit, the less aggressive the cut and the resulting surface finish will be finer, if all other conditions are equal.

GRIT DESIGNATIONS	GRIT SIZE
Extra Coarse (XC)	50
Coarse (C)	60 – 80
Medium (M)	100 – 150
Fine (F)	180 – 220
Very Fine (VF)	240 – 360
Super Fine (SF)	400
Ultra Fine (UF)	600
Micro Fine (MF)	800 – 1200

Densities

The product "density" refers to the number of fibers which have been compressed into the nylon web material. Under identical conditions, harder density wheels cut faster, last longer and produce finer finishes than softer density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the work piece.

Fiber Sizing

Several nylon fiber sizes are used in the manufacture of Norton Bear-Text and Merit web material because the fiber size is a significant factor in the coating process, as each produces distinct cutting characteristics.

Bonding Agents

Waterproof resins are used in the manufacture of Norton Bear-Text and Merit web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web.



Getting the Most Out of Norton Bear-Tex Wheels

Maximum wheel life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

1) Wheel Direction

Convolute, interleaf flap wheels, and conventional flap wheels must always run in the direction indicated by the arrow printed on the side of each wheel. Unified wheels can be run in either direction.

2) Wheel Speed

Wheel speed is an important factor in that it affects product finish, rate of cut, and wheel life. In general, fast wheel speeds give harder action and a finer finish; whereas, slower speeds give a softer action and a coarser finish for the same wheel density.

The following are recommended operating speeds for the most common applications.

APPLICATION	RECOMMENDED SPEED
Cleaning and upgrading of surface conditions	2200 to 6000 SFPM
Cut-buffing on metal surfaces	6500 to 8000 SFPM
Deburring	5500 to 8000 SFPM
Decorative finishing	500 to 3000 SFPM
Imparting decorative finishes	900 to 3000 SFPM
Oxide removal	3500 to 6500 SFPM

Testing might show that a slower or faster speed is desirable for specific operations. Never exceed the maximum RPM rating of the wheel.

3) Pressure

Light to medium pressure is recommended for most operations. Flap wheels require much lighter pressure to perform properly than other non-woven wheels; unified wheels can withstand much higher pressures in order to perform deburring jobs. In all cases, avoid excessive pressure which might result in wheel deformation and damage to the work surface.

4) Feed Speed

Low feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.

5) Oscillation

Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut might be experienced.

A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

6) Lubricants

Lubricants, such as water, water soluble oil, and straight oil, will decrease the heat generated while running, improve the luster, and reduce the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

Factors in Wheel Choice

This chart provides a relative comparison of other Norton Bear-Tex wheel variables. It can serve as a useful guide in choosing the most suitable product for a given application. However, as many other factors affect wheel performance, this chart can only be general in nature. The most cost-effective results can always be obtained by wheel testing on the application.

Factor	Direction	Product/Action
1 Wheel Conformability	← MOST CONFORMABLE (SOFT)	Flap Wheels, Clean & Finish, Metal Finishing
	→ LEAST CONFORMABLE (HARD)	Rapid Finish GP 7 Density, Rapid Finish GP 8 & 9 Density, Series 4000
2 Wheel Openness	← OPEN MESH	Clean & Finish, Metal Finishing
	→ CLOSED MESH	Rapid Finish GP 7 Density, Rapid Finish GP 8 & 9 Density, Series 4000
3 Wheel Aggressiveness	← MOST AGGRESSIVE	Metal Finishing
	→ LEAST AGGRESSIVE	Clean & Finish, Rapid Finish GP, Flap Wheels
4 Finishing Action	← COARSER	Metal Finishing, Clean & Finish
	→ FINER	Series 4000, Rapid Finish GP Series 4000, Flap Wheels
5 Pressure for Best Results	← LIGHTER	Flap Wheels, Clean & Finish
	→ HIGHER	Metal Finishing Rapid Finish GP 7 Density, Rapid Finish GP 8 & 9 Density, Series 4000

* On steel surfaces, silicon carbide wheels will produce a brighter finish than aluminum oxide wheels.

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the work piece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1 Grit Size	Coarse ←	→ Very Fine
2 Wheel Grade	Soft ←	→ Hard
3 Wheel Speed	Slow ←	→ Fast
4 Feed Speed	Faster (Long Scratch) ←	→ Slower (Short Scratch)
5 Oscillation	No Oscillation ←	→ Oscillation
6 Lubricants and Compounds	Dry ←	→ Straight Oil
	← Water	→ Soluble Oil
	← Compounds	→

Conventional Finishing Methods Versus Norton Bear-Tex Non-Woven Products

The following chart outlines the advantages achievable when using our products as alternatives to other cleaning, blending, deburring and finishing methods. These products are listed in the sequence of normal preference for the application stated. However, because of the numerous variables, only testing can ensure selection of the most cost-effective product.

CONVENTIONAL FINISHING METHOD	KEY APPLICATION	NORTON PRODUCT ALTERNATIVES	ADVANTAGES OF NORTON/MERIT PRODUCT VERSUS ALTERNATE FINISHING METHODS
Bristle Brushes	Cleaning	Rapid Strip Convolute Wheels Rapid Prep Discs Rapid Prep Flap Discs	Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminate compound dust
Greaseless Compounds	Finishing	Flap Wheels Convolute Wheels Unified Wheels Rapid Prep Discs Rapid Prep Flap Discs	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate
Set-up Wheels	Blending/ Deburring	Convolute Wheels Unified Wheels XHD Discs Rapid Prep Discs Rapid Prep Flap Discs	No break-in time required More consistent cut More uniform finish Maintain geometry Safer, no flying wheel pieces
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters

Conventional Finishing Method



Norton Bear-Tex Non-Woven Finishing Method

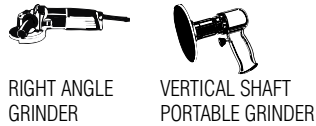




The strongest of coated abrasive discs with resin-over-resin construction on heavy-duty fiber backing. Designed for applications ranging from heavy stock removal to surface blending. Used with back-up pads on portable angle grinders.

- Applications:** Stock removal, edge chamfering, weld blending, deburring/deflashing, rust removal, cleaning and finishing
- Size Range:** 4" x 5/8" hole, 4-1/2" – 9-1/8" x 7/8" and 5/8"-11 hole
- Grit Range:** 16 – 120
- Abrasive Grain:** Ceramic Alumina, Zirconia Alumina Blend, and Aluminum Oxide
- Product Options:** Conventional, Speed-Change hubs (5/8"-11), and AVOS technology
- Accessories:** Air-cooled, smooth-faced, and AVOS back-up pads

Machines Used:



RIGHT ANGLE GRINDER

VERTICAL SHAFT PORTABLE GRINDER



How To Select The Correct Abrasive To Blend a Weld

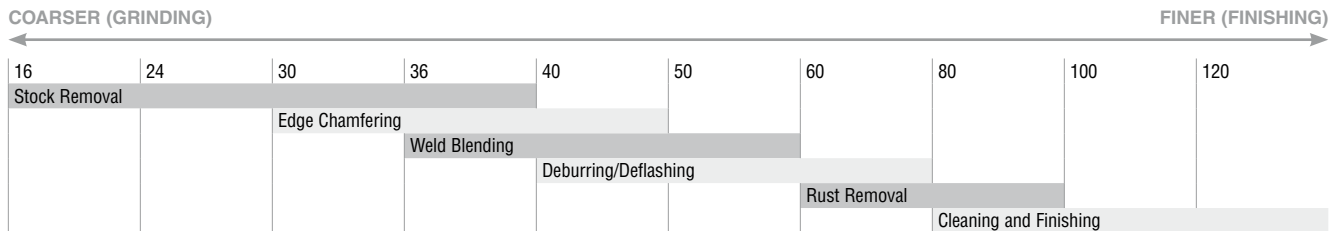
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Material-to-Product Recommendation Guide

	BEST			BETTER	GOOD
	BlazeX F970	BlazeX F980	Blaze F980	BlueFire F826P	Metal F240
Stainless Steel / Titanium / Super Alloys*		◆	◆	◆	◆
Mild Carbon Steel / Welds	◆			◆	◆
Ferrous Metals / Cast Iron	◆			◆	◆
Brass / Bronze / Aluminum					◆

*Nickel/Cobalt Based – Hastelloy, Inconel, Waspalloy

Application/Grit Recommendation Guide



Cross Reference Guide

	TOTAL PERFORMANCE			INITIAL PRICE
	←			→
	BEST		BETTER	GOOD
NORTON	BlazeX F970	BlazeX F980, Blaze F980	BlueFire F826P	Metal F240
3M	782C, 982C, 988C	785C, 787C, 985C, 987C	501C	—
Camel	—	Ceramic	Zirconia	—
Flexovit	CG	CG+	ZA	—
GemTex	PMD, Gem Supreme	PMD Supreme, PMD Supreme Plus	Zee-Type, Zee Supreme, Gem Supreme	A-Type
Hermes	—	CR456	RB414X, RB414X Procut	RB314
Klingspor	FS964 ACT	FS966	CS565, CS570	CS561
Metabo	CER	CER	ZA	A/O
Mirka	—	—	Blue, Gold	Red
Pearl	Red Line	—	FZ	Silver Line
Pferd	CO-PMD	CO Cool	Z, Z Cool	A
United Abrasives/Sait	7S, 7A-S, 7-11	9S, 9-11	3Z, Z, AZX	A/O, 2A
SIA	4515, 4580	4515, 4560,	4815, 4819	4919, 4961
Standard	Ceramic	Ceramic Pro	Zirconia	A/O
VSM	XF760	AF890, AF799, XF885, XF870, XF850	ZF713, ZF714, ZF844	KF708
Walter	Walter Coolcut XX	Walter Coolcut XX	Walter Topcut	—
Weiler	—	Tiger Ceramic	Tiger Zirc, Wolverine Zirc	Wolverine A/O



Best choice for carbon steel and other soft-to-grind materials

BLAZEX F970 CERAMIC ALUMINA

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Heavier fiber backing for additional strength and tear resistance
- Non-supersized design for cool cutting and long life on carbon steel and other soft-to-grind materials



Best choice for coarse grit beveling, blending, deburring, and stock removal

BLAZEX F980 CERAMIC ALUMINA

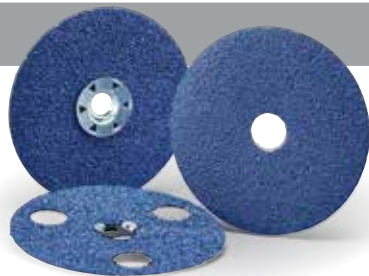
- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Strong fiber backing for strength and tear resistance
- Supersized design for stainless steel and hard-to-grind materials



Best choice for stainless steel, titanium, and super alloys

BLAZE F980 CERAMIC ALUMINA

- 100% ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Self-lubricating grinding aid treatment delivers the coolest cut on stainless steel, high alloy steels, super alloys, titanium, and other difficult-to-grind materials
- Heavier fiber backing for additional strength and tear resistance



Better choice for stainless, super alloys, steel, cast iron and high-pressure applications

BLUEFIRE F826P ZIRCONIA ALUMINA

- High-performance zirconia alumina abrasive blend provides 15% faster cut and longer life with less power draw than conventional zirconia discs
- Advanced resin bond technology with enhanced grain adhesion for extended life
- Heavier fiber backing for additional strength and tear resistance



Good choice for small jobs, applications where performance is not measured, and price-sensitive operations

METAL F240 ALUMINUM OXIDE

- Versatile, multi-purpose aluminum oxide abrasive provides consistent performance on numerous materials and small jobs
- Full resin bond for strength and durability
- Heavier fiber backing for additional strength and tear resistance; low initial price



		BEST		BEST		BEST		BETTER		GOOD		
		BLAZEX F970		BLAZEX F980		BLAZE F980		BLUEFIRE F826P		METAL F240		
		Ceramic Alumina		Ceramic Alumina		Ceramic Alumina		Zirconia Alumina Blend		Aluminum Oxide		
		OTHER:		Supersize		Supersize						
SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	
4-1/2 x 7/8	24	25			69957398000		66261138457		66623353309			
	36	25	69957370193	78072743400			66261138456		66623353306			
	36	50 V					66623377276					
	50	25	69957370194		69957398002		66261138454		66623353310			
	60	25	69957370195		69957398003		66261138453		66623353311			
	80	25	69957370196		69957398004		66261138452		66623353312			
	100	25							66623353313			
5 x 7/8	120	25			66254425332				66623353314			
	16	25						05539510684				
	24	25			69957398005		66261138563		66623357276			
	36	25	69957370197	78072743401			66261138562		66623357277			
	36	50 V					66623377283					
	50	25	69957370198		69957398007		66261138561		66623357278			
	60	25	69957370199		69957398008		66261138601		66623357279			
6 x 7/8	80	25	69957370200		69957398009		66261138600		66623357280			
	100	25						66623357281				
	120	25			66254409084			66623357282				
	7 x 7/8	24	25			66261160033						
		16	25						05539510693			
		24	25			69957398010		66261138594		66623357283		
		36	25	69957370201	78072743402			66261138593		66623357284		
50		25	69957370202		69957398012		66261138592		66623357285			
60		25	69957370203		69957398013		66261138591		66623357286			
80		25	69957370204		69957398014		66261138590		66623357287			
9-1/8 x 7/8	100	25						66623357288				
	120	25			66254411528			66623357289				
	24	25			69957398015		66261138584		05539510702			
	36	25		69957398016			66261138583		05539510701			
	50	25			69957398017		66261138582					
	60	25						05539510699				

Note: Fiber discs must be used with back-up pads shown on the last page of this section.

V = Vendible Package. Ideal for vending machines and small jobs. 10 discs/package, 5 packages per standard carton. Order in multiples of 50.

B = Bulk & Baled. Baling Units also available on Page 68.

AVOS Fiber Discs

- Patented, see-through design allows interrupted cut which reduces heat up to 30% over standard discs
- The scooped holes create air flow to pull swarf away from grinding zone; cool cutting and extended product life
- 15° back-up pad for full utilization of discs – no gouging
- Quick, tool-free, twist-on and -off Speed-Lok fasteners



		BEST		BEST		BETTER	
		BLAZEX F980		BLAZE F980		BLUEFIRE F826P	
		Ceramic Alumina		Ceramic Alumina		Zirconia Alumina Blend	
SIZE	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
4-1/2 Speed-Lok (3 hole)	24	10		66254468389		66261129718	
	36	10	66254468390			66261129719	
	50	10			66254468391		66261129720
	60	10			66254468392		66261129721
	80	10			66254468393		66261129722
5 Speed-Lok (3 hole)	24	10			66254468385		66261126556
	36	10	66254468386				66261126557
	50	10			66254468387		66261126558
	60	10			66254468388		66261126559
	80	10					66261126560
7 Speed-Lok (6 hole)	24	10			66254468381		66261137454
	36	10	66254468382				66261137455
	50	10			66254468383		66261137456
	60	10			66254468384		
	80	10					66261137458

Note: AVOS fiber discs must be used with AVOS Speed-Lok back-up pads, see accessories page for details.

Speed-Change Fiber Discs

These fiber discs feature Norton quick, tool-free, twist-on and -off Speed-Change fasteners. Discs lock to standard back-up pads with a unique nut design and are easily removed, increasing your productivity with more time to grind.



		BEST		BEST		BEST		BETTER	
		BLAZEX F970		BLAZEX F980		BLAZE F980		BLUEFIRE F826P	
		Ceramic Alumina		Ceramic Alumina		Ceramic Alumina		Zirconia Alumina Blend	
		OTHER:		Supersize		Supersize			
SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #
4-1/2 x 5/8-11	24	25				662610 23269			
	36	25	699573 70205		780727 43403				
	50	25	699573 70206						
	60	25	699573 70207			662610 42247			
	80	25	699573 70208			666233 28529			
5 x 5/8-11	24	25				662544 25336		662611 38797	
	36	25	699573 70209		780727 43404			662611 38796	
	50	25	699573 70210						
	60	25	699573 70211			662611 85803			
	80	25	699573 70212			666233 16697			
7 x 5/8-11	24	25				699573 49782		662611 38819	
	36	25	699573 70213		780727 43405			662611 38818	
	50	25	699573 70214					662611 38817	
	60	25	699573 70215			662610 42249		662611 38816	
	80	25	699573 70216			662544 74373			

Note: Speed Change fiber discs must always be used with smooth face back-up pads, see next page for details.



Better Choice for grinding concrete, marble, granite and other natural stone with ease

FASTCUT SILICON CARBIDE

- Sharp, fast-cutting silicon carbide abrasive quickly penetrates and removes any coatings
- Engineered specifically with cooling ridges to remain free-cutting, minimize loading, and maximize life
- Rigid fiber backing helps to aggressively grind concrete, marble, granite and other stone works
- Ideal for demanding right angle grinding at comfortable lower angles



		BETTER		BETTER	
		FASTCUT		FASTCUT	
		Silicone Carbide		Silicone Carbide	
		TYPE: 27		29	
SIZE	GRIT	STD. PKG.	PART #	PART #	PART #
4-1/2 x 7/8	16	25	662611 99054		
7 x 7/8	16	25	662544 37691	662611 99052	

Note: Use with Norton Air-Cooled back-up pad for best performance.

Efficiently Grind Softer Materials Where Loading is a Problem

Extra coarse, sharp, silicon carbide abrasive and cooling ridges make fast work of all your masonry, concrete, marble, and granite surface preparation and stock removal jobs – without loading. Quickly penetrates and removes any coating, such as adhesive, paint, acrylic, mastic, etc.

Fiber Disc Accessories



- Fiber Disc Baling Unit**
- Places 100 discs on a spindle between two plates
 - Locks down with a pinch screw
 - Maintains the shape of the discs by maintaining pressure to minimize curl
 - User-friendly and reusable



- Air-Cooled Standard Back-up Pad**
- Slotted hub design and curved ribs draw heat away from the grinding zone, reducing disc loading and increasing life. All pads have a 5/8"-11 threaded female hub for mounting. We also offer a no-nose pad for shorter-shafted right angle grinders.



- Smooth Face Speed-Change Back-up Pad**
- Molded rubber back-up pads with a smooth face.
- Hard density pads are for aggressive cutting action
 - Medium density pads are for all-purpose applications




- AVOS Fiber Disc Back-up Pad**
- Patented, see-through design allows interrupted cut which reduces heat up to 30% over standard discs
 - The scooped holes create air flow to pull swarf away from grinding zone
 - 15° back-up pad for full utilization of discs – no gouging
 - Quick, tool-free, twist-on and -off Speed-Lok fasteners

DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Fiber Disc Baling Unit			
7" or below	—	1	776960 01066
Rubber Back-up Pads			
Air-Cooled Standard for 7/8 Hole Fiber and Non-Woven Discs			
4" Medium	12,000	5	636425 04918
4-1/2" Medium	11,000	5	636425 02122
5" Medium	10,000	5	636425 43421
7" Hard	8,600	5	636425 43425
7" Medium	8,600	5	636425 43422
9" Hard	6,600	5	636425 43426
9" Medium	6,600	5	636425 43423
<i>Note: Retainer nuts are not included with back-up pads. These must be ordered separately.</i>			
Air-Cooled No-Nose			
4-1/2" Medium	11,000	5	636425 04872
5" Medium	10,000	5	636425 03000
Smooth Face for Fiber and Non-Woven Speed-Change Discs			
4-1/2" Medium	20,000	5	662544 92277
5" Medium	12,000	5	636425 43235
7" Hard	8,600	5	636425 43240
7" Medium	8,600	5	636425 43245
7" Soft	8,600	5	636425 43250
9" Medium	7,000	5	636425 43270
AVOS Speed-Lok Back-up Pads			
AVOS Triangular Speed-Lok Back-up Pads			
4-1/2" x 5/8-11	13,000	5	636425 02985
5" x 3/8-24 Pistol Grip*	20,000	5	636425 03029
5" x 5/8-11	13,000	5	636425 02517
5" x 5/8-11 Thicker	13,000	5	636425 03663
5" x 7/16-20 Pistol Grip*	20,000	5	636425 03030
<i>*Use on air pneumatic and high-speed pistol grip Sanders</i>			
AVOS Round Speed-Lok Back-up Pads			
7" x 5/8-11 Hard	8,600	5	636425 04873
Tools			
#103 Retainer Nut	—	10	636425 43463
Spanner Wrench	—	5	636425 43005
66NS Short Retainer Nut	—	10	636425 43461

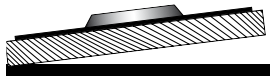
All fiber disc back-up pads are packed in individual boxes within the shipping carton. Each box can be used in a vending machine.



Flap discs are versatile grinding and finishing tools having four main components: abrasive flaps, flap density (how the flaps are stacked), backing plate shape (flat or conical), backing plate material (fiberglass or plastic). All flap discs have flaps that are overlapped and glued to the backing plate. The flaps wear during use, exposing new abrasive grain. The different variations of the components above provide a variety of application choices ranging from heavy stock removal to blending to finishing. Flap discs are designed for portable grinder applications and can be the preferred choice over depressed center wheels or fiber discs.

Applications:	Grinding, stock removal, edge chamfering/beveling, weld blending, deburring/deflashing, rust removal, blending, cleaning and finishing
Size Range:	4" : 5/8" hole 4-1/2" - 7" : 5/8"-11 discard mount, 7/8" hole, and 2" - 3" quick-change
Grit Range:	24 - 120
Abrasive Grain:	Ceramic Alumina, Zirconia Alumina
Abrasive Flaps:	Polyester, Cotton/Poly Blend
Flap Disc Shape:	Type 27 Flat and Type 29 Conical
Abrasive Flap Density:	Standard or high
Backing Plate Material:	Fiberglass and plastic
Machine Used:	 RIGHT ANGLE GRINDER

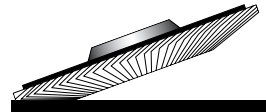
Flap Disc Shapes



GRIND AT FLATTER ANGLES:
0° - 15°

Type 27 Flat – The Best Choice for Finishing

- Used primarily on flat surfaces
- The best choice for blending and smooth finishing



GRIND AT STEEPER ANGLES:
15° - 25°

Type 29 Conical – The Best Choice for Aggressive Stock Removal

- Conical flap discs have angled flaps and may be used on both contoured and edge work
- The angle provides greater surface contact for stock removal on flat surfaces
- The best choice when speed and stock removal are primary considerations

Abrasive Flap Densities



Standard Density

- Excellent for heavy-duty applications and rapid stock removal

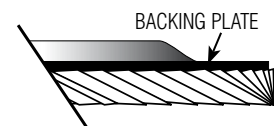


High Density

- Ideal when working on uneven or curved surfaces, as well as finer grit blending

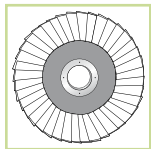
Backing Plate Materials

All flap discs are a combination of abrasive flaps adhered to a rigid backing plate. It is the backing plate that provides stability during operation. There are two main materials used: fiberglass and plastic. The fiberglass backing plate, along with the flap shape, helps to absorb vibration and is consumed during use with no smearing. Fiberglass is the most popular material because of its high strength and light weight. The plastic backing plate offers some additional conformability and is trimmable.



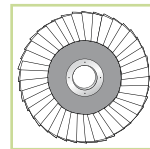
Why Choose Flap Discs?

Flap discs replace both grinding wheels and fiber discs. The same flap disc can be used for applications ranging from stock removal to blending.



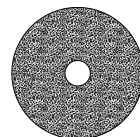
Flap Discs vs. Grinding Wheels

- Faster stock removal
- Smoother finish, no gouging
- Cooler cutting, less glazing
- Lightweight, easier to control
- Less vibration, less operator fatigue
- Reduced noise



Flap Discs vs. Fiber Discs

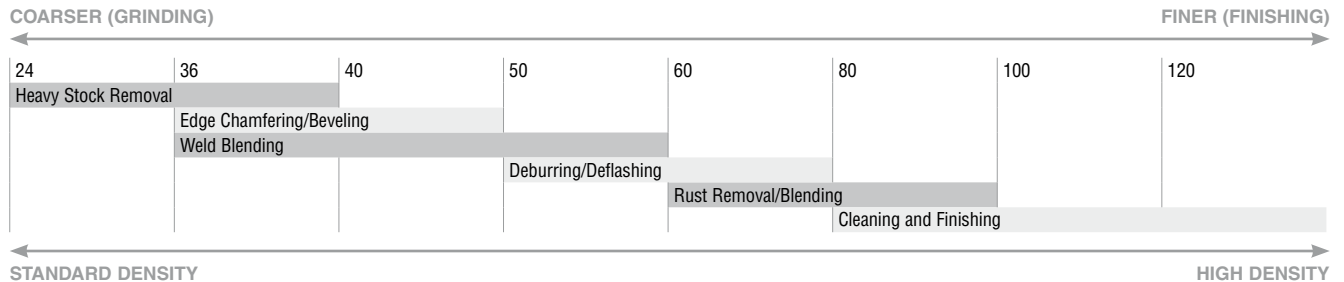
- 20X longer life, reduced abrasive cost
- Fewer disc changes, reduced labor cost
- More consistent finish
- No back-up pad required
- Easier storage, no curling
- Reduced loading
- Use flap discs one grit size coarser than fiber discs, except in 36 grit



Material-to-Product Recommendation Guide

	BEST Blaze R980P	BETTER BlueFire R860	GOOD Metal R828	Gemini R766
TYPE 29 FOR STOCK REMOVAL				
Stainless Steel / Titanium / Super Alloys	◆	◆	◆	◆
Mild Carbon Steel / Welds		◆	◆	◆
Ferrous Metals / Cast Iron		◆	◆	◆
Brass / Bronze / Aluminum		◆		
TYPE 27 FOR BLENDING AND FINISHING				
Stainless Steel / Titanium / Super Alloys	◆	◆	◆	◆
Mild Carbon Steel / Welds		◆	◆	◆
Ferrous Metals / Cast Iron		◆	◆	◆
Brass / Bronze / Aluminum		◆	◆	◆

Application/Grit Recommendation Guide



Cross Reference Guide

	TOTAL PERFORMANCE		INITIAL PRICE	
	BEST Blaze R980P	BETTER BlueFire R860	GOOD Metal R828	Gemini R766
NORTON				
3M	747D, 947D, 967A, 969F	546D, 566A, 577F	—	—
Camel	Ceramic Pro	ZA Pro	ZA	A Pro
CGW/Pasco	Ceramic	Zirconia	—	A/O
DeWalt	XP Ceramic	HP Zirconia	FlexVolt	Zirconia
Flexovit	Zircotex Ceramic	Zircotex, Zircocomax, Tornado	—	—
Garryson	CeramiQ	Zirc+	A/O	Zirconium
GemTex	Ceramic Flaptec	Zirconia Flaptec	—	A/O Flaptec
Hermes	—	FL390	Webrax-AN 701	RB48024YX, RB48624YX
Klingspor	SMT656	SMT624, SMT626, SMT627, SMT630	—	SMT627
Metabo	Flexiamant Super Ceramic	Flexianmant Zirconia, Novoflex	—	—
Mirka	—	—	—	Blue
Pearl	Redline Maxidics, Stainlessmax Maxidics	Zirconia Maxidisc, Silver Line Zirconia	Silver Line A/O	A/O Maxidisc
Pferd	Polifan Z-SG, Polifan SG-CO	Polifan SG Zirkon, Polifan SG ZA, SGP, PSF Zirc	Polifan PSF A/O	Polifan SG A, A-Cool
United Abrasives/Sait	Encore Ceramic, Ovation Ceramic	Ovation, Saitlam U	Encore	Ovation Attacker
SIA	—	—	—	2824 SIAFlap
Standard	Ceramic Pro, Ceramic	Zirconia HP, Zirconia AP	—	Zirconia GP
Tyrolit	Cerabond Ceramic, Premium Ceramic	Fastcut, Premium Longlife	Basic, Standard	Premium A/O
VSM (Lehigh Valley)	Ceramic	Zirconia	—	A/O
Walter	Enduro-Flex Turbo	Enduro-Flex, Enduro-Flex Stainless	Flexsteel	Enduro-Flex Alu.
Weiler	Tiger Ceramic, Tiger X, Tiger Saber Tooth	Tiger Paw, Wolverine	Tiger	Tiger Premium



Best/highest productivity for stainless steel, titanium, and super alloys

BLAZE R980P CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain lasts 50% – 200% longer than many flap discs on stainless steel, cobalt, chrome, inconel, titanium and other hard-to-grind materials
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably fast cut rate
- High-strength fiberglass back on Type 29 and Type 27 High Density is durable, lightweight, and absorbs vibration; flexible plastic backing plate on Type 27 Quick Trim allows for trimmability of the plate



Better choice for mild carbon steel, and welds

BLUEFIRE R860 ZIRCONIA ALUMINA

- High performance zirconia alumina abrasive for aggressive cut and long life, with up to 30% longer life than competitive zirconia alumina products
- Polyester/cotton flaps with semi-open coat provide improved durability and reduces loading on aluminum
- High-strength fiberglass back on Type 29 and Type 27 High Density is durable, lightweight, and absorbs vibration; flexible plastic backing plate on Type 27 Quick Trim allows for trimmability of the plate
- Vendible 2-disc package is ideal for vending machines, small jobs, or carrying to a job site



Good consistent performance with low initial price

METAL R828 ZIRCONIA ALUMINA

- Durable zirconia grain provides good cut rate and life with consistent finish
- Fiberglass/resin backing plates with high strength, light weight, ability to absorb vibration, and operator comfort
- Good choice for coarse grit blending, deburring, and stock removal



Good choice for carbon steel and aluminum applications

GEMINI R766 ALUMINUM OXIDE

- Alternating zirconia alumina and aluminum oxide flaps provide higher performance than aluminum oxide while retaining an economical price
- Polyester/cotton flaps are the best choice when speed of job completion and stock removal are primary considerations
- Type 27 Flat with quick trim, flexible plastic backing plate or high-density fiberglass back


BlueFire R860

Proprietary new grain shape and chemistry for faster cutting and longer life on a wide range of materials.

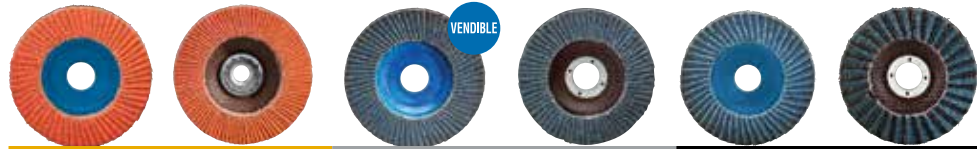




TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	BLUEFIRE R860	METAL R828	METAL R828
SHAPE:	Type 29 Conical	Type 29 Conical	Type 29 Conical	Type 29 Conical
FLAP DENSITY:	Standard	Standard	Standard	High
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING PLATE:	Fiberglass	Fiberglass	Fiberglass	Fiberglass
OTHER:	Supersize			

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Type 29 Conical							
4 x 5/8	36	15,300	10		666233 99049		
	40	15,300	10		666233 99050		
	60	15,300	10		666233 99051		
	80	15,300	10		666233 99052		
4-1/2 x 5/8-11	36	13,300	10	662611 83490	662544 61165	662544 19991	
	36	13,300	10 V		666233 41104 2-Pack		
	40	13,300	10	662611 83491	662544 61167	662544 19994	662611 132535
	60	13,300	10	662611 83492	662544 61170	662544 19996	662611 132536
	60	13,300	10 V		666233 41105 2-Pack		
	80	13,300	10	662611 83493	662544 61173	662544 19997	662611 132537
	80	13,300	10 V		666233 41106 2-Pack		
	120	13,300	10			666233 99174	
4-1/2 x 7/8	24	13,300	10		666233 99204		
	36	13,300	10	662611 83486	662544 61155	662544 19963	
	36	13,300	10 V		666233 41107 2-Pack		
	40	13,300	10	662611 83487	662544 61161	662544 19978	662611 132538
	60	13,300	10	662611 83488	662544 61163	662544 19984	662611 132539
	60	13,300	10 V		666233 41108 2-Pack		
	80	13,300	10	662611 83489	662544 61164	662544 19987	662611 132540
	80	13,300	10 V		666233 41109 2-Pack		
5 x 5/8-11	120	13,300	10			666233 99175	
	36	12,000	10		666233 99189		
	40	12,000	10		666233 99190		
	60	12,000	10		666233 99191		
	80	12,000	10		666233 99192		
5 x 7/8	120	12,000	10				
	24	12,000	10		666233 99206		
	36	12,000	10	662611 90001	662544 61174	662544 19998	
	40	12,000	10	662611 90002	662544 61176	662544 20001	
	60	12,000	10	662611 90003	662544 61177	662544 20002	
	80	12,000	10		662544 61178	662544 20003	
6 x 5/8-11	120	12,000	10				
	40	10,200	10			662544 91779	
	60	10,200	10			662544 91780	
	80	10,200	10			662544 91781	
6 x 7/8	24	10,200	10		666233 99066		
	36	10,200	10		666233 99298		
	40	10,200	10		666233 99193	662544 91776	
	60	10,200	10		666233 99194	662544 91777	
	60	10,200	10		666233 99195	662544 91778	
	80	10,200	10				
7 x 5/8-11	36	8,600	10	662611 83498	662544 61188	662544 20009	
	40	8,600	10	662611 83499	662544 61190	662544 20010	
	60	8,600	10	662611 83500	662544 61192	662544 20012	
	80	8,600	10	662611 83501	662544 61193	662544 20013	
	120	8,600	10				
	80	8,600	10				
7 x 7/8	24	8,600	10		666233 99196		
	36	8,600	10	662611 83494	662544 61180		
	40	8,600	10	662611 83495	662544 61183	662544 20006	
	60	8,600	10	662611 83496	662544 61185		
	80	8,600	10	662611 83497	662544 61186		

V = Vendible package. 2 discs/pack; 5 packs/carton. Order in multiples of 10.



TIER:	BEST	BEST	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	BLAZE R980P	BLUEFIRE R860	BLUEFIRE R860	GEMINI R766	GEMINI R766
SHAPE:	Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat	Type 27 Flat
FLAP DENSITY:	Standard	High	Standard	High	Standard	High
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING PLATE:	Quick Trim Plastic	Fiberglass	Quick Trim Plastic	Fiberglass	Quick Trim Plastic	Fiberglass
OTHER:	Supersize	Supersize				

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
Type 27 Flat									
4-1/2 x 5/8-11	36	13,300	10		662544 99894	666233 99136		666233 99125	
	36	13,300	10 V			666233 41086 2-Pk			
	40	13,300	10	662544 00257	662610 98290	666233 99137	776960 90086	666233 99000	
	60	13,300	10	662544 00258	662610 96435	666233 99138	776960 90087	666233 99001	666233 99060
	60	13,300	10 V			666233 41087 2-Pk			
	80	13,300	10	662544 00259	662610 96436	666233 99139	776960 90088	666233 99002	
4-1/2 x 7/8	120	13,300	10	662544 00261				666233 99003	
	36	13,300	10	636425 01865	662610 97678	666233 99140	776960 90081		
	40	13,300	10	662544 00253	662610 20628	666233 99141	776960 90082		
	60	13,300	10	662544 00254	662610 20633	666233 99142	776960 90083		
	80	13,300	10	662544 00255	662610 20634	666233 99143	776960 90084		
	120	13,300	10	662544 00256			776960 90085		
5 x 5/8-11	36	12,000	10			666233 99144		666233 99127	
	40	12,000	10	776960 90141		666233 99145		666233 99128	
	60	12,000	10	776960 90142		666233 99146		666233 99130	
	80	12,000	10	776960 90143		666233 99147		666233 99131	
	120	12,000	10					666233 99132	
5 x 7/8	36	12,000	10			666233 99148			
	40	12,000	10	662544 00262		666233 99149		666233 99212	
	60	12,000	10	662544 00264		666233 99150		666233 99213	
	80	12,000	10	662544 00265		666233 99151			
	120	12,000	10	662544 00519					
6 x 5/8-11	40	10,200	10	662611 32128	662611 32145			666233 99219	
	60	10,200	10	662611 32129	662611 32146			666233 99220	
	80	10,200	10	662611 32130	662611 32147			666233 99221	
	120	10,200	10						
6 x 7/8	40	10,200	10	662611 32123		666233 99152		666233 99216	
	60	10,200	10	662611 32124	662611 32136	666233 99153		666233 99217	
	80	10,200	10	662611 32125		666233 99154			
	120	10,200	10						
7 x 5/8-11	36	8,600	10			666233 99155			
	40	8,600	10	662544 61066	662611 32148	666233 99156	776960 90092		
	60	8,600	10	662544 61067	662611 32168	666233 99157	776960 90093	666233 99017	
	80	8,600	10	662544 61068		666233 99158	776960 90094	666233 99018	
	120	8,600	10	662544 61069				666233 99019	
7 x 7/8	36	8,600	10	636425 01866		666233 99159			
	40	8,600	10	662544 61059		666233 99160	776960 90089		
	60	8,600	10	662544 61060		666233 99161	776960 90090		
	80	8,600	10	662544 61061		666233 99162			

V = Vendible package. Ideal for vending machines & small jobs. 2 Flap Discs/pack, 5 packs/carton. Order in multiples of 10.

Packaged for retail / walk-in selling / small jobs



BLUEFIRE R860 ZIRCONIA ALUMINA

- Zirconia alumina abrasive for aggressive cut and long life
- Individual hang cards provides product selling points; ships in merchandise display case of small quantities
- Available wire rack (with header card) allows merchandising of 4-1/2" product three ways: hung on pegboard, mounted on an upright, or placed on a shelf/counter



WIRE RACK (WITH HEADER CARD)
ALLOWS MERCHANDISING OF 4-1/2"
PRODUCT THREE WAYS: HUNG ON
PEGBOARD, MOUNTED ON AN UPRIGHT,
OR PLACED ON A SHELF/COUNTER

TIER:	BETTER
TRADENAME:	BLUEFIRE R860
SHAPE:	Type 29
FLAP DENSITY:	Standard
ABRASIVE:	Zirconia Alumina
BACKING PLATE:	Fiberglass

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #
4-1/2 x 5/8-11	40	13,300	5	076607 03211
	60	13,300	5	076607 03212
	80	13,300	5	076607 03213
7 x 5/8-11	60	8,600	5	076607 03206
Wire Rack			1	076607 04157



See Portable Tools and Specialties section for mini flap discs.



Non-woven discs have three components: strong synthetic fiber mesh and quality abrasives, bonded together by a smear-resistant adhesive. Rapid Strip discs have an open web construction that enables aggressive cutting action while maintaining a cool, non-loading surface. Rapid Blend discs have a unitized construction with varying weave – from open to tighter – for deburring and finishing. Rapid Prep discs have a more open weave that excels in surface preparation and cleaning. Each product provides excellent cutting action while improving surface finish.

Applications:

Medium-to-light material removal, deburring, blending, cleaning, finishing, and polishing

Size Range:

4" - 7"

Grit Range:

Extra Coarse, Coarse, Medium, Fine, Very Fine

Abrasive Grain:

Ceramic Alumina, Silicon Carbide, Engineered Aluminum Oxide, Aluminum Oxide

Machine Used:



RIGHT ANGLE GRINDER

VERTICAL SHAFT PORTABLE GRINDER

DIE GRINDER

Material/Application-To-Product Recommendation Guide

Stripping Discs

	BEST	BETTER
	Blaze Rapid Strip Ceramic	Rapid Strip Silicon Carbide
Removing scale and coarse welding marks	◆ XC	◆ XC
Removing coatings, epoxy/glue, paint and other clogging material	◆ XC	◆ XC
Removing rust, oxidation, corrosion and residue	◆ XC	◆ XC
Removing parting lines and seams on fiberglass parts	◆ XC	◆ XC
Removing paint/graffiti from concrete/stone	◆ XC	◆ XC

Deburring, Blending, Finishing Discs

	BEST	BETTER
	Vortex Rapid Blend	Rapid Blend
Removing weld marks and weld spatter	◆ C	◆ C
Stainless steel deburring and cleaning	◆ C	◆ C
Removing small flashings and parting lines	◆ C	◆ C
Surface preparation before coatings/plating		◆ C
Light cleaning		◆ F
Cleaning and prepping welds		◆ M
Removing blemishes after welding stainless		◆ M
Blending and finishing all metal parts		◆ VF
Creating decorative finishes on stainless steel	◆ VF	◆ VF
Final finishing and polishing	◆ VF	◆ VF
Final finishing/polishing where high conformability is needed		◆ VF

XC - Extra Coarse, C - Coarse, M - Medium, F - Fine, VF - Very Fine

Application/Product Recommendation Guide

← MOST AGGRESSIVE / LEAST CONFORMABLE

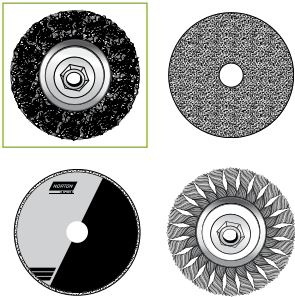
LEAST AGGRESSIVE / MOST CONFORMABLE →

	Blaze Rapid Strip	Vortex Rapid Blend A/O Med. Rapid Blend A/O Coarse	Rapid Blend A/O Medium	Rapid Blend S/C Fine	
Depressed Center Discs					
Discs With Back-Up Pad		Vortex Rapid Prep Rapid Prep A/O Coarse	Rapid Prep A/O Medium	Rapid Prep A/O Fine	Rapid Prep Very Fine
Scale Removal	First Choice	Second Choice			
Stock Removal	First Choice	First Choice			
Heavy Deburring	Second Choice	First Choice	Second Choice		
Light Deburring		First Choice	First Choice		
Light Finishing		Second Choice	Second Choice		
Blending			First Choice	Second Choice	
Finishing			Second Choice	First Choice	
Polishing				First Choice	Second Choice

Cross Reference Guide – For All Discs Used on Right Angle Grinders

	STRIPPING (EXTRA COARSE)		SURFACE FINISHING (COARSE – MEDIUM – FINE)			SURFACE PREP (VERY FINE)	
	BEST	BETTER	BEST	BETTER	BEST	BETTER	
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend	Vortex Rapid Prep	Rapid Prep	
3M	Clean & Strip XT PRO, Clean & Strip XT PRO Extra Cut	Clean & Strip X	Debur and Finish PRO, Cut and Polish	EXL	SE, Duraflex	SC, PD, AI, LS	
Bibielle	—	SDR Strip-It/Red	—	BUR Unitized	SCHD	SCLS, SCD, SCSB	
Camel	—	EZ Strip Black/Red	—	—	—	—	
Flexovit	—	Clean & Strip	—	—	—	—	
Hermes	Strip Discs	Webrax	—	—	—	—	
Pearl	—	S/C Stripping	—	—	—	Surface Preparation	
Pferd	—	Policlean	—	Poliflex PUR	—	—	
Sait	—	Sait-Strip	—	Unitized	7S, 8S	3Z	
SIA	SiaStrip	—	—	—	6260	6250	
Standard	—	Cleaning	700/800/900 Series	700/800/900 Series	FE, GP	FE, GP, RC	
Superior	—	Stripping	—	XL Unitized	—	FD, GD, CC	
Walter	—	FX Cleaning	—	—	—	Blendex Surface Conditioning	

Why Choose Non-Woven Depressed Center Discs?



Non-Woven Right Angle Discs vs. Fiber Discs, Wire Wheels, and Depressed Center Wheels

- Deburring, blending and finishing done with one product to reduce the number of steps
- To provide a controlled, sustained finish
- To prevent undercutting and gouging
- To provide a cooler grinding action to lessen the chance of warping or discoloration
- When loading is an issue with fiberglass, adhesives and soft metals
- For stripping coatings and paint off of hard materials like concrete, cement and stone
- Less vibration and quieter for high operator acceptance
- To provide an alternative to wire brushes



**RAPID, DURABLE
BLENDING AND FINISHING**

Reduce Steps and Increase Productivity
Choose a Vortex Rapid Prep Flap Disc

Norton Vortex Rapid Prep flap discs, featuring layers of non-woven surface conditioning material, offer a longer life over traditional single layer products. Featuring high performance Vortex grain technology that cuts coarser and finishes finer with a smear free resin system.

The Type 27 shape provides forgiveness when going over uneven surfaces and reduces vibration to improve the ergonomics of any operation.

- Product finer finish faster, reduce steps
- Improve life and reduce disc changes, reduce vibration
- Faster cut rate, longer life and less disc changes

Recommended Starting Grits for Applications

GRIT	AVERAGE RA (µIN)	BLENDING	DEBURRING	EDGE BREAK	FINISHING	PAINT REMOVAL	PARTING LINE REMOVAL	POLISHING	RUST REMOVAL	SANDING	SMOOTHING	STRIPPING	SURFACE PREP
COARSE	40	◆	◆	◆		◆	◆		◆	◆	◆	◆	◆
MEDIUM	20	◆	◆	◆	◆	◆	◆	◆		◆	◆	◆	◆
FINE	10	◆			◆			◆			◆		◆
VERY FINE	5	◆			◆			◆		◆			◆

Rapid Strip

Best choice for quick and easy rough cleaning and stripping of all materials



BLAZE RAPID STRIP CERAMIC ALUMINA

- Blaze ceramic grain provides 2X plus faster, consistent rate and life than silicon carbide discs, leaves a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as painting and soldering
- Open web construction for minimal loading; does not shed or snag on rusty pieces; prevents gouging and rework
- Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish

Better choice for use on a variety of materials, including metal, fiberglass and stone



RAPID STRIP SILICON CARBIDE

- Sharp silicon carbide abrasive provides fast aggressive cutting action
- Advanced resin bond prevents shedding, snagging, gouging, and rework
- Open web construction for minimal loading; great alternative to wire brushes



		TIER: BEST		TIER: BETTER		
		BLAZE RAPID STRIP		RAPID STRIP		
<i>TRADENAME:</i>		Ceramic Alumina		Silicon Carbide		
<i>ABRASIVE:</i>		36-50		36-50		
<i>GRIT SIZE:</i>		X-Coarse		X-Coarse		
<i>GRADE:</i>		Type 27/Fiberglass		Type 27/Fiberglass		
<i>TYPE/BACKING:</i>		SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #
		4-1/2 x 5/8-11	12,000	10	662544 98101	662610 09585
		4-1/2 x 7/8	12,000	10	666233 03783	662610 09649
		5 x 5/8-11	11,000	10	666233 03915	
		5 x 7/8	11,000	10	666233 03916	
		7 x 5/8-11	8,000	10	666233 03919	662610 09650
		7 x 7/8	8,000	10	666233 03920	662610 09586

Rapid Blend / High Strength



Best choice with revolutionary technology for heavy deburring and finishing

VORTEX RAPID BLEND ALUMINUM OXIDE

- Proprietary engineered Vortex aluminum oxide agglomerated grain performs the medium to fine grit steps of traditional aluminum oxide discs
- Thick nylon web for 2X longer life and faster finishing vs. traditional aluminum oxide discs, with minimal shedding
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing



Best Choice for tough and conformable, resists tearing on burrs and sharp edges

HIGH-STRENGTH ALUMINUM OXIDE

- Premium aluminum oxide grain; engineered for more demanding applications
- Uniform construction maintains part tolerance; prevents cutting and gouging
- Smear-free bond excels at producing light satin finishes



Better choice for surface prep, deburring, blending and removing parting lines, rust, and coatings

RAPID BLEND NEX A/O / S/C

- Premium aluminum oxide or silicon carbide grain for consistent performance
- Uniform construction extends life and maintains part tolerance; prevents cutting and gouging
- Resin formula produces consistent, smear-free finishes

MOST AGGRESSIVE / LEAST CONFORMABLE

LEAST AGGRESSIVE / MOST CONFORMABLE



	BEST			BETTER		BETTER		BEST		
TIER:	BEST			BETTER		BETTER		BEST		
TRADENAME:	VORTEX RAPID BLEND			RAPID BLEND NEX		RAPID BLEND NEX		HIGH-STRENGTH		
ABRASIVE:	Engineered A/O			Aluminum Oxide		Aluminum Oxide		Silicon Carbide		
GRIT SIZE:	Coarse			Medium		Fine		Medium		
SPECIFICATION:	Vortex 5AC			High Strength		NEX-2AF		High Strength		
TYPE/BACKING:	Type 27/ Fiberglass			Type 27/ Fiberglass		Type 27/ Fiberglass		Type 27/ Fiberglass		
SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #		
4-1/2 x 5/8-11	12,000	10	662611 32881	662611 32929	662544 29243	776960 00144	662610 23947	662610 23946	662610 23943	662610 23949
4-1/2 x 7/8	12,000	10	662611 32880	662611 32928	662544 29268	776960 00145	662610 20548	662610 20547	662610 20546	662610 20549

Vortex Rapid Prep Flap Discs

Best choice for cleaning, light deburring and processing TIG welded seams on stainless steel



VORTEX RAPID PREP FLAP DISCS

- High-performing, patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit with the finish of a finer grit
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals
- Multiple layers of surface conditioning material provide added life, fewer disc changes, and reduced vibration



	BEST	BEST	BEST	BEST
TIER:	BEST	BEST	BEST	BEST
TRADENAME:	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP
ABRASIVE:	Engineered A/O	Engineered A/O	Engineered A/O	Engineered A/O
GRADE:	Coarse	Medium	Fine	Very Fine
TYPE/BACKING:	Type 27 Fiberglass	Type 27 Fiberglass	Type 27 Fiberglass	Type 27 Fiberglass
	PART #	PART #	PART #	PART #
	776960 97544	776960 97545	776960 97546	776960 97547
	776960 97539	776960 97540	776960 97541	776960 97542

SIZE (D x H)	MAX. RPM	STD. PKG.
4-1/2 x 5/8-11	13,300	10
4-1/2 x 7/8	13,300	10



Reduce Grits & Steps with Norton Vortex Rapid Prep Flaps Discs!
[youtube.com/watch?v=DOFf9cHWQc](https://www.youtube.com/watch?v=DOFf9cHWQc)



Rapid Polish

Better choice for finishing to a mirror like shine



RAPID POLISH

- Type 27 disc with premium quality pressed hardened felt for polishing to a mirror like finish
- Use with our without polishing compound
- Soft padding is Ideal for final finishing with no vibration



TIER:	BETTER	BETTER
TRADENAME:	RAPID POLISH	RAPID POLISH
ABRASIVE:	Non-Woven	Non-Abrasive
SPECIFICATION:	Felt	Compound
TYPE/BACKING:	Type 27/Plastic	Stick

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #
4-1/2 x 5/8-11	12,000	10	780727 47430	
4-1/2 x 7/8	12,000	10	780727 47429	
4" x 1-1/8" x 1-1/8"		2		780727 47942



How to Get a Mirror Finish with Norton Rapid Polish Discs

[youtube.com/watch?v=h7bdY8fWJEG](https://www.youtube.com/watch?v=h7bdY8fWJEG)



Rapid Strip Arbor Hole Discs

Best choice for removing rust, scale and paint/coatings on a variety of substrates, such as wood, metal and plastics



BLAZE RAPID STRIP CERAMIC ALUMINA

- Norton Blaze ceramic alumina grain provides 2X cut rate, 2X life over silicon carbide products
- Advanced resin bond does not shed on rust-encrusted pieces, and prevents gouging and rework; does not snag when used for deburring
- Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering

Better choice for removing coatings on a variety of substrates such as wood metal and plastics



RAPID STRIP SILICON CARBIDE

- Faster cutting, sharp, extra coarse silicon carbide abrasive provides a unique combination of aggressive performance, long life, and improved finish
- Advanced resin bond prevents shedding on rust-encrusted pieces and gouging and rework; does not snag when used for deburring
- Leaves a thoroughly clean surface that ensures excellent adhesion in subsequent processes such as coating, painting and soldering



TIER:	BEST	BETTER
TRADENAME:	BLAZE RAPID STRIP	RAPID STRIP
ABRASIVE:	Ceramic Alumina	Silicon Carbide
GRIT:	Extra Coarse	Extra Coarse

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
Arbor Hole			
4 x 1/4	8,000	25	662610 09324
4 x 1/2	8,000	25	666233 04856
6 x 1/4	4,000	15	666233 40171
6 x 1/2	4,000	15	662610 99378
			662610 08051

NS Non-Stock, contact your Norton representative for current order quantities and lead times.
*



FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	PART #
Mandrel Assemblies							
1/4"	1/2" (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	662610 09502

High-Strength Arbor Hole Discs

Applications include rust/oxide or coating removal, pipe ID and OD polishing, casting cleaning, highlighting (antiquing), contaminant removal, removal of handling marks, gasket removal, cleaning and blending of surface imperfections, prepping prior to soldering, removal of filling materials, cleaning angles and odd shapes. Will not stretch or shed. Ganging increases versatility. For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.

Best choice for removing rust, scale and paint/coatings on a variety of substrates, such as wood, metal and plastics



HIGH-STRENGTH ALUMINUM OXIDE DISCS

- Strongest non-woven buffing and polishing disc
- Premium aluminium oxide grain; engineered for more demanding applications
- Tough but flexible web resists tearing on burrs and sharp edges; and conforms to intricate shapes and contours without changing the workpiece dimension; can be ganged together and used as a wheel
- Smear-free bond excels at producing light satin finishes



TIER: **BEST**
 TRADENAME: **HIGH STRENGTH**
 ABRASIVE: Aluminum Oxide

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #
6 x 1/4	VF	4,000	70	662610 07628
6 x 1/2	C	4,000	70	776960 00146
	M	4,000	70	662610 05073
	VF	4,000	70	662610 04980
8 x 1/2	C	3,000	50	776960 00147
	M	3,000	50	662610 05491
	VF	3,000	50	662610 04506
12 x 1-1/4	C	1,900	25	776960 00148
	VF	1,900	25	662610 08723

See page 169 for High Strength quick-change discs.



FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	PART #
Mandrel Assemblies For Using Discs On Edge							
1/4"	1/2" (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	662610 09502
1/2"	1/2" (Standard)	Up to 8"	1/4"	3-1/8"	2-1/4"	1	662610 59420

Rapid Prep
7/8" Center Hole

Best choice for aggressive stock removal and blending in one step



RAPID PREP XHD

- Coarse and Medium discs solve your most aggressive stock removal and blending challenges; remove weld lines, weld spatter, weld discoloration and blend surfaces in a single step
- Improve cut control and surface blending over traditional coated flap discs and fiber discs from our unique combination of a conformable fiber matrix and premium ceramic grain
- XHD Coarse discs for aggressive weld removal and surface blending on steels and Medium discs on softer metals/alloys



TIER: **BEST**
 TRADENAME: **RAPID PREP XHD**
 ABRASIVE: Ceramic Alumina

SIZE (D x H)	STD. PKG.	PART #
Coarse		
4-1/2 x 7/8	40	662611 70275
5 x 7/8	40	662611 70279
7 x 7/8	25	662611 70280
Medium		
4-1/2 x 7/8	40	662611 70282
5 x 7/8	40	662611 70283
7 x 7/8	25	662611 70284

Note: Max RPM is determined by corresponding back up pad.



Norton Rapid Prep Surface Conditioning Products

The Perfect Abrasive, Coating, and Bond Built into Every Disc and Belt

- Available in premium Vortex aluminum oxide aggregate grain and Norton aluminum oxide grain; ideal for many aerospace, metal and stainless steel fabrication, and MRO applications
- Our proprietary coating method extends life and delivers consistent finishes by creating a thick layer of grain throughout the product; grain does not sit on top of fibers as other competitive products can
- Our new Clean Bond resin system guarantees smear-free finishes, even on high nickel content alloys; will not load on aluminum and soft metals, as competitive products can



Rapid Prep
7/8" Center Hole

Best choice for finishing and blending applications



VORTEX RAPID PREP ALUMINUM OXIDE DISCS

- High-performing, patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit with the finish of finer grits
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life and provides added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

Better choice for high nickel content alloys, aluminum and other soft metals



RAPID PREP ALUMINUM OXIDE

- Quality aluminum oxide abrasive grain coating provides up to 20% higher cut rate and 50% better performance than competitive products
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life, added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals



	TIER: BEST		BETTER	
	TRADENAME: VORTEX RAPID PREP		RAPID PREP	
	ABRASIVE: Engineered Aluminum Oxide		Aluminum Oxide	
SIZE (D x H)	STD. PKG.	PART #		PART #
Extra Coarse				
4-1/2 x 7/8	25			666233 26070
5 x 7/8	25	666233 34975		
7 x 7/8	25	666233 41360		
Coarse				
4-1/2 x 7/8	25	666233 34944		662544 73868
5 x 7/8	25	666233 34946		662610 08293
7 x 7/8	25	666233 41362		666233 25138
Medium				
4-1/2 x 7/8	25	666233 33612		666233 25915
5 x 7/8	25	666233 34963		662610 17124
7 x 7/8	25	666233 41364		666233 25919
Fine				
4-1/2 x 7/8	25	666233 33608		666233 25153
5 x 7/8	25	666233 34954 NS		662544 69132
7 x 7/8	25	666233 41366 NS		
Very Fine				
4-1/2 x 7/8	25	666233 33616		
5 x 7/8	25			666233 25943
7 x 7/8	25	666233 41368 NS		666233 25959

Additional sizes are available made-to-order, contact your Norton representative for current order quantities and lead times.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Note: Max RPM is determined by corresponding back-up pad.

See page 68 for 7/8" Hole Air Cooled Back-up Pads

Rapid Prep

Speed Change 5/8"-11

- These discs feature Norton quick, tool-free, twist-on and -off Speed-Change fasteners. Discs lock to standard back-up pads with a unique nut design and are easily removed, increasing your productivity with more time to grind.
- Rapid Prep XHD are the best choice for aggressive stock removal and blending in one step.



TIER: **BEST**
 TRADENAME: **RAPID PREP XHD**
 ABRASIVE: Ceramic Alumina

SIZE (D x H)	STD. PKG.	PART #
Coarse		
4-1/2 x 5/8-11	25	662611 70060
5 x 5/8-11	25	662611 70061
7 x 5/8-11	25	662611 70288
Medium		
4-1/2 x 5/8-11	25	662611 70062
5 x 5/8-11	25	662611 70063
7 x 5/8-11	25	662611 70289

Max RPM is determined by corresponding back up pad.



TIER: **BEST** | **BETTER**
 TRADENAME: **VORTEX RAPID PREP** | **RAPID PREP**
 ABRASIVE: Engineered Aluminum Oxide | Aluminum Oxide

SIZE (D x H)	STD. PKG.	PART #	PART #
Extra Coarse			
4-1/2 x 5/8-11	25	666233 73667 NS	666233 73690 NS
5 x 5/8-11	25	666233 73669 NS	
7 x 5/8-11	25	666233 73670	
Coarse			
4-1/2 x 5/8-11	25	666233 73671	666233 73693 NS
5 x 5/8-11	25	666233 73674 NS	662544 98516
7 x 5/8-11	25	666233 73675 NS	662611 92908
Medium			
4-1/2 x 5/8-11	25	666233 73678	666233 08157
5 x 5/8-11	25	666233 73679 NS	666233 73694 NS
7 x 5/8-11	25	666233 73680 NS	662611 92913 NS
Fine			
4-1/2 x 5/8-11	25	666233 73681	
5 x 5/8-11	25	666233 73682 NS	666233 73695 NS
7 x 5/8-11	25	666233 73684 NS	
Very Fine			
5 x 5/8-11	25	666233 73686 NS	666233 73699 NS
7 x 5/8-11	25	666233 73687	666233 73700 NS

Note: Speed Change discs must always be used with smooth face back-up pads.

Max RPM is determined by corresponding back-up pad.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

AVOS Non-Woven Speed-Lok

- Patented hole design allows for interrupted cut, reducing heat up to 30% over standard surface preparation discs for cooler cutting and longer life
- With complete vision into the grinding zone, operators can grind more accurately with less re-work; scooped holes create air glow to pull loose abrasive and swarf away from work surface grinding zone – resulting in extended disc life
- The 15° angle back-up pad lets you grind at 5° - 15° angle allowing for greater utilization of disc surface and eliminates gouging of workpiece

See page 68 for Speed Change and AVOS Back-up Pads



TIER: **BETTER**
 TRADENAME: **RAPID PREP AVOS**
 ABRASIVE: Aluminum Oxide

SIZE (DIAMETER)	STD. PKG.	PART #
Coarse		
4-1/2	10	662610 10447
5	10	666233 74818
Medium		
4-1/2	10	662610 10448
5	10	666233 74819
Very Fine		
4-1/2	10	666233 74823
5	10	666233 74824

Note: AVOS discs must be used with AVOS Speed-Lok back-up pads.

Max RPM is determined by corresponding back up pad.

Rapid Prep

Non-Woven Hook and Loop Discs

- Rapid Prep XHD are the best choice for aggressive stock removal and blending in one step.



TIER: **BEST**
 TRADENAME: **RAPID PREP XHD**
 ABRASIVE: Ceramic Alumina

SIZE (DIAMETER)	STD. PKG.	PART #
Coarse		
4-1/2	40	662611 70179
5	40	662611 70181
7	25	662611 70182
Medium		
4-1/2	40	662611 70183
5	40	662611 70185
7	25	662611 70186

Max RPM is determined by corresponding back-up pad.

* Standard Package = 80

Back-up Pads

Hook & Loop Back-up Pads



PAD DIAMETER	SPINDLE OR HOLE SIZE	MAX. RPM	3M EQUIVALENT	STD. PKG.	PART #
Back-up Pads for Non-Woven Hook and Loop Discs					
2	1/4 Steel Shank	23,000	922	5	662610 59352
3	1/4 Steel Shank	20,000	923	5	662610 59354
4	1/4 Steel Shank	18,000	924	5	662610 59356
	5/8-11	13,000	914	5	662610 59304
4-1/2	5/8-11	10,000	9145	5	662610 06948
5	5/16-24 Male	10,000	905	5	662610 59360
	5/8-11	10,000	915	5	662610 59310
6	5/8-11	8,000	916	5	662610 59312
7	5/8-11	6,000	917	5	662610 59368
8	5/8-11	4,500	918	5	662610 59372



TIER: **BEST** **BETTER**
 TRADENAME: **VORTEX RAPID PREP** **RAPID PREP**
 ABRASIVE: Engineered Aluminum Oxide Aluminum Oxide

SIZE (DIAMETER)	STD. PKG.	PART #	PART #
Extra Coarse			
2	50		662610 17900 NS
4-1/2	25	666233 34972	662610 17906
5	25	666233 34974	662610 17215
7	25	666233 34976	662611 92846
Coarse			
2	50	666233 34882	662610 04431*
3	25	666233 34883	662610 55015
4-1/2	25	666233 34943	662610 17806
5	25	666233 34945	662610 04435
7	25	666233 34951	662610 55027
Medium			
2	50	666233 34958	662610 04441
3	25	666233 34956	662610 04442
4-1/2	25	666233 34961	662610 04444
5	25	666233 34962	662610 55022
7	25	666233 34965	662610 17813
Fine			
2	50		666233 25141
3	25	666233 33605	666233 25143 NS
4-1/2	25	666233 33607	666233 25147
5	25	666233 33609	666233 25154
7	25	666233 34955	662611 99465
Very Fine			
2	50		666233 25926
3	25	666233 33614	666233 25934
4-1/2	25	666233 33615	666233 25936
5	25	666233 33617	666233 25941
7	25	666233 34969	662610 19990

Max RPM is determined by corresponding back-up pad.

* Standard Package = 80

NS Non-Stock, contact your Norton representative for current order quantities and lead times.





Norton PSA (pressure sensitive adhesive) individual cloth discs are used on four different types of machines and the application changes depending on which machine they are used on.

Applications:

Pneumatic and Electric Dual-Action (DA) and Electric Random Orbital Sanders – for use on contours or flat surfaces for light- to medium-pressure grinding, blending, leveling, and finishing applications.

Stationary Disc Sanders – used in woodworking and metalworking for stock removal, sanding/grinding flat surfaces, dimensioning and finishing.

Size Range:

5" – 24" diameter

Grit Range:

24 – 180

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

Back-up Pads:

Rubber, with hardness variations for different applications, for portable machines. Steel for stationary disc sanders.

Machine Used:



ORBITAL SANDER



STATIONARY DISC SANDERS



Best choice for all hard-to-grind high alloy steels



BLAZE R980P CERAMIC ALUMINA

- 100% ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to provide fastest cut rate and longest life over competitive blended/low-ratio ceramic alumina discs
- Strong resin bond and heavy-duty Y-weight polyester backing for consistent cut, better grain adhesion, edge-tear resistance, and durability
- Self-lubricating grinding aid treatment delivers the coolest cut on stainless steel, high alloy steels, super alloys, titanium, and other difficult to grind materials

Better choice for grinding and deburring stainless steel



BLUEFIRE R821P ZIRCONIA ALUMINA

- Latest generation of self-sharpening, zirconia alumina abrasive for cooler cut and extended life over aluminum oxide discs
- Heavy-duty Y-weight cotton backing for edge-tear resistance and durability
- Pressure sensitive adhesive makes for easy application and removal

Good choice for general-purpose metalworking



GEMINI R228 ALUMINUM OXIDE

- Premium aluminum oxide abrasive gives an excellent initial cut rate
- Durable X-weight cotton backing makes these discs a good blend of flexibility and life
- The cotton backing provides good resistance to heat

Good option for light- to medium-pressure grinding, blending, leveling and finishing applications



METAL R243 ALUMINUM OXIDE

- Aluminum Oxide grain provides consistent cut for general purpose use
- Improved resin bond system provides longer life
- Flexible J-weight cotton backing for added conformability, tabs allow for easy liner removal

Cloth PSA Discs for Dual-Action and Random Orbital Sanders



		TIER: BEST		TIER: BETTER		TIER: GOOD	
		TRADENAME: BLAZE R980P		TRADENAME: BLUEFIRE R821P		TRADENAME: GEMINI R228	
		ABRASIVE: Ceramic Alumina		ABRASIVE: Zirconia Alumina		ABRASIVE: Aluminum Oxide	
		ATTACHMENT: PSA Discs		ATTACHMENT: PSA Discs		ATTACHMENT: PSA Discs	
		OTHER: Supersize		OTHER: Tabbbed		OTHER: Tabbbed	
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #
5	36	50/250	662544 61506*	662611 32579	662611 36589		
	40	50/250	662544 61507		662611 36588		
	50	50/250	662544 61508	699573 49352	662611 36587		
	60	50/250	662544 61509	699573 49353	662611 36586		
	80	50/250	662544 61510	662611 35091	662611 36585	699573 39967	
	100	50/250			662611 36584		
	120	50/250	662544 61512		662611 36583	699573 39969	
	150	50/250			662611 36582		
	180	50/250			662611 36581		
6	60	50/250			662611 36596		
	80	50/250			662611 36595	699573 39973	
	100	50/250			662611 36594		
	120	50/250			662611 36593	699573 39978	
	150	50/250					
8	180	50/250			662611 36592		
	36	50/250			662611 36350		
	40	50/250			662611 36351		
	50	50/250			662611 36352		
	60	50/250			662611 36352		
	80	50/250			662611 36354		
	120	50/250			662611 36355		

*Pkg./Case: Blaze R980P 5" 36 grit discs = 50/200



Back-up Pads for Cloth PSA Discs

DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Back-up Pads for Cloth PSA Discs			
5" Diameter – Low Profile – Soft	12,000	5	636425 06126
5" Diameter – Low Profile – Medium	12,000	5	636425 06131
5" Diameter – Tapered – Medium	12,000	5	636425 06139
6" Diameter – Low Profile – Soft	10,000	5	636425 06127
6" Diameter – Low Profile – Med	10,000	5	636425 06133
6" Diameter – Tapered – Medium	10,000	5	636425 06141
8" Diameter – Tapered – Medium	6,000	5	636425 43112

Large Diameter Cloth PSA Discs

Used on stationary disc machines for dimensioning and finishing metal workpieces and woodworking. Pressure sensitive adhesive offers fast, convenient mounting. Made without center holes for full-face usage.



TIER:	BEST	BETTER	GOOD
TRADENAME:	BLAZE R980P	BLUEFIRE R821P	GEMINI R228
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide
ATTACHMENT:	PSA	PSA	PSA
OTHER:	Supersize		

SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #
10	36	25/50			662611 36606
	40	25/50		662611 38314	662611 36604
	50	25/50			662611 36607
	60	25/50		662611 38316	662611 36602
	80	25/50		662611 38317	662611 36601
	100	25/50			662611 36600
12	24	25/50		662611 38318	
	36	25/50	662544 16171	662611 38319	662611 36635
	40	25/50	662544 16172	662611 38320	662611 36630
	50	25/50	662544 16173	662611 38321	662611 36625
	60	25/50	662544 16174	662611 38322	662611 36620
	80	25/50	662544 16175	662611 38323	662611 36615
	100	25/50			662611 36614
	120	25/50	662544 16176		662611 36613
15	36	25/50			662611 36666
	60	25/50			662611 36663
	80	25/50			662611 36662
16	36	25/50			662611 36700
	40	25/50			662611 36685
	50	25/50			662611 36684
	60	25/50		662611 38334	662611 36683
	80	25/50			662611 36701
18	36	25/50			662611 36720
	60	25/50			662611 36696
	80	25/50			662611 36723
20	36	25/50	662544 16165	662611 38343	662611 36710
	40	25/50		662611 38344	662611 36709
	50	25/50	662544 16167		662611 36711
	60	25/50	662544 16168	662611 38346	662611 36712
	80	25/50	662544 16169		662611 36706
	120	25/50	662544 16170		
24	36	10/10			662611 36718
	40	10/10			662611 36717
	50	10/10			662611 36725
	60	10/10			662611 36726
	80	10/10			662611 36727



For use on dual action and random orbital sanders. The industry's highest performing and broadest selection of paper discs in PSA (pressure sensitive adhesive) disc rolls and individual discs, and hook and loop discs.

- Applications:** Stripping and preparing primed and painted surfaces for finishing, sanding of plastics, fiberglass and composites, bare wood sanding, light weld blending, preparing and finishing metal, and sanding of all gel coat and body filler compounds.
- Size Range:** 3" – 8"
- Grit Range:** 36 – 1500
- Abrasive Grain:** Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide
- Attachment Systems:** PSA (pressure-sensitive adhesive), hook and loop
- Paper Weights:** Heavyweight – E and F; Lightweight – B, C, and D
- Vacuum Holes:** See product availability charts
- Machine Used:**



ORBITAL SANDER



VERTICAL SHAFT PORTABLE GRINDER

Material/Application-to-Product Recommendation Guide

	BEST			BETTER		GOOD	
	Heavy-Medium Stock Removal	Light Stock Removal Finishing	Light Stock Removal Finishing	Heavy-Medium Stock Removal	Light Stock Removal Finishing	Light Stock Removal Finishing	Light Stock Removal Finishing
	SG H920	Blaze A995	Dry Ice A975	BlueFire H875P	BlueFire H822	A2750P	Gold Reserve A296
Primed, Painted Surfaces		◆	◆	◆		◆	◆
Fiberglass / Composites / Gel Coats		◆	◆	◆		◆	◆
Wood		◆	◆	◆		◆	◆
Metal	◆	◆	◆		◆	◆	◆
Body Fillers / Compounds / Plastics		◆	◆	◆		◆	◆

Application/Grit Recommendation Guide

COARSER (GRINDING)										FINER (FINISHING)														
36	40	60	80	100	120	150	180	220	240	280	320	360	400	500	600	800	1000	1200	1500					
Roughing to Intermediate					Intermediate to Finishing										Fine Finishing					Ultra Fine Finishing				

Cross Reference Guide

	TOTAL PERFORMANCE							INITIAL PRICE
	BEST			BETTER				GOOD
NORTON	F-Weight	D-Weight	B- & C-Weight	F-Weight	E-Weight	B-Weight	B-Weight	C-Weight
	SG H920	Blaze A995	Dry Ice A975	BlueFire H822	BlueFire H875P	A275 OP	Durite A475	Gold Reserve A296
3M	763U	732U, 737U, 755L 775L	334U, 734U, 735U	—	740I, 745I, 750U, 751U, 751I	216U, 255L, 236U, 260L, 334U	405N, 414N, 415U, 426U, 435U	236U, 316U, NX, 216U, 236U
Hermes	BW114, CR116	CR116	—	BW115, BW184	BW110, VC153	VC154-LL	SF168	VC151-LL, VC152, WA flex 28
Indasa	—	HT Line	HT Line, RedLine	—	HeavyLine	PlusLine	—	WhiteLine, YellowLine
Klingspor	PS61	—	PS36	PS21	PS36	PS33, PS73W	PL35, PS14	PS33, PL36
Mirka	—	—	—	—	Royal CRS. Cut	Q-Silver, Royal Micro	CaratFlex, PolarStar	Bulldog Gold, Basecut
SIA	—	—	Siaprime 5550, 1958	1820	1820, 1919, 1948	1940, 1944, 1950	1748	1947, 1960
VSM	—	—	—	—	KP510E, KP709	—	CP131A	KP911

Heavyweight Paper Discs



Best choice for most demanding stock removal applications

SG H920 CERAMIC ALUMINA

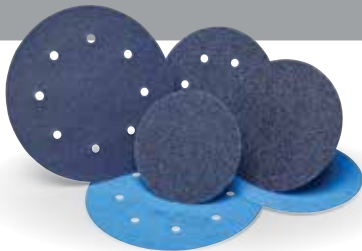
- Durable and friable Norton seeded gel ceramic alumina abrasive ensures fast, aggressive, yet cool cutting action and maximum life
- Strong F-weight paper, synthetically-coated, provides maximum durability and resistance to edge chipping and shedding
- Closed coat and sharp grain make this a premiere product for metal fabricating and blending; ideal for soldered and welded areas



Better choice for aggressive metalworking applications

BLUEFIRE H822 ZIRCONIA ALUMINA

- Patented zirconia alumina abrasive provides 2X-3X life over aluminum oxide products
- Strong F-weight paper, synthetically-coated for excellent durability and chip resistance; pressure sensitive adhesive and linked disc roll format allow easy application, removal, and dispensing
- Non-stearated (no anti-loading agents) for non-contaminating; often required for prime auto and aerospace paint applications



Better choice for soft material and wood applications

BLUEFIRE H875P ZIRCONIA ALUMINA

- Next-generation, self-sharpening zirconia alumina abrasive provides 2-3 times the life of aluminum oxide discs, longer life versus original zirconia alumina discs, improved cut rate, and minimal heat
- Strong E-weight latex/paper backing resists tearing while staying conformable and flexible
- Open coat contributes to minimized loading

Stick & Sand (PSA)
Heavyweight Disc Rolls
Non-Vacuum



		TIER: BEST		TIER: BETTER		TIER: BETTER	
		TRADENAME: SG H920		TRADENAME: BLUEFIRE H822		TRADENAME: BLUEFIRE H875P	
		ABRASIVE: Ceramic Alumina		ABRASIVE: Zirconia Alumina		ABRASIVE: Zirconia Alumina	
		PAPER BACKING WEIGHT: F-Weight		PAPER BACKING WEIGHT: F-Weight		PAPER BACKING WEIGHT: E-Weight	
		FASTENING: PSA		FASTENING: PSA		FASTENING: PSA	
SIZE (D)	GRIT	ROLLS/STD. PKG.	DISCS/ ROLL	PART #	PART #	PART #	PART #
5	60	4	100	662611 49873	662611 37310		
	80	4	100	662611 49872	662611 37309	662611 24977	
	100	4	100		662611 37308		
	120	4	100	662611 49870			
6	60	4	100		662611 37323		
	80	4	100	662611 49876	662611 37322	662611 25573	
	120	4	100	662611 49874			

Refer to the Sanding Accessories section for back-up pads and accessories.

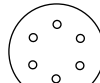
Heavyweight Paper Discs

Stick & Sand (PSA)
Individual Discs
Non-Vacuum and Vacuum



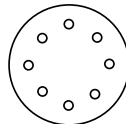
TIER:	BETTER	BETTER
TRADENAME:	BLUEFIRE H875P	BLUEFIRE H875P
ABRASIVE:	Zirconia Alumina	Zirconia Alumina
PAPER BACKING WEIGHT:	E-Weight	E-Weight
FASTENING:	PSA	PSA Vacuum

SIZE (D)	GRIT	PKG./CASE	PART #	PART #
5	36	50/200	662611 25436	
	40	50/200	662611 25307	
	80	50/200	662611 25244	



6" x 6 Hole
Die #3371

6	36	50/200	662611 23575	
	40	50/200	662611 23574	662611 23580
	80	50/200	662611 23573	



8" x 8 Hole
Die #3370

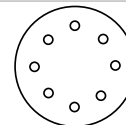
8	36	25/100	662611 23578	662611 23584
	40	25/100	662611 23577	
	80	25/100	662611 23576	662611 23582

Hook & Loop
Individual Discs
Non-Vacuum and Vacuum



TIER:	BEST	BETTER	BETTER
TRADENAME:	SG H920	BLUEFIRE H875P	BLUEFIRE H875P
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina
PAPER BACKING WEIGHT:	F-Weight	E-Weight	E-Weight
FASTENING:	Hook & Loop	Hook & Loop	Hook & Loop
OTHER:			Vacuum

SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #
5	40	25/100		662611 25684	
	60	50/250	662611 49864		
	80	50/250	662611 49865	662611 25444*	
6	36	25/100		662611 23590	
	40	25/100		662611 23589	
	80	25/100		662611 23588	



8" x 8 Hole
Die #3370

8	36	25/100		662611 23593	662611 23598
	40	25/100		662611 23592	
	80	25/100		662611 23591	662611 23596

Packaging Standards: Min. / Std. Pkg. * H875P = 25/100

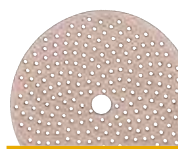
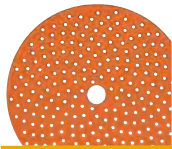
Lightweight Paper Discs

Less dust; more productivity



MULTI-AIR CYCLONIC HOOK & LOOP VACUUM

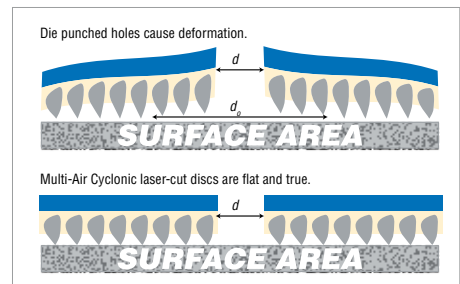
- Multi-Air Cyclonic precision laser-cut, spiral vacuum hole design maximizes dust extraction for cleanest work environment and less potential for contamination, while delivering coolest, fastest, most consistent cut rate, and longest life of any paper disc
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work
- Exceptional choice for the most demanding paper disc sanding applications; hook and loop back for easy disc mounting and changing



TIER:	BEST	BEST	BEST
TRADENAME:	BLAZE A995 NO-FIL	DRY ICE A975 NO-FIL	A2750P NO-FIL
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide
PAPER BACKING WEIGHT:	B-Weight	B- & C-Weight	B-Weight
FASTENING:	Hook & Loop	Hook & Loop	Hook & Loop
OTHER:	P-Graded	P-Graded	P-Graded



SIZE (D)	GRIT	PKG/ CASE	PART #	PART #	PKG/ CASE	PART #
3 x 0	80	50/200		776960 95005		
	120	50/200		776960 95006		
	150	50/200		776960 95007		
	180	50/200		776960 95008		
	220	50/200		776960 95009		
	240	50/200		776960 95010		
	320	50/200		776960 95011		
	400	50/200		776960 95012		
	500	50/200		776960 95013		
	600	50/200		776960 95014		
5 x 11/16 (125mm x 18mm)	80	50/200	636425 97500	776960 07745	100	666233 90524
	100				100	666233 90525
	120	50/200	636425 97501	776960 07753	100	666233 90526
	150	50/200	636425 97502	776960 07755	100	666233 90527
	180	50/200	636425 97503	776960 07756	100	666233 90528
	220	50/200	636425 97504	776960 07757	100	666233 90529
	240	50/200		776960 07760	100	666233 90530 NS
	280	50/200		776960 07762		
	320	50/200		776960 07763	100	666233 90531
	400	50/200		776960 07765	100	666233 90532
6 x 11/16 (150mm x 18mm)	40	25/200	636425 97515			
	60	50/200	636425 97519			
	80	50/200	636425 97505	776960 07770	100	666233 90503
	120	50/200	636425 97506	776960 07773	100	666233 90504
	150	50/200	636425 97507	776960 07774	100	666233 90505
	180	50/200	636425 97508	776960 07775	100	666233 90506
	220	50/200	636425 97509	776960 07776	100	666233 90507
	240	50/200		776960 07777	100	666233 90508
	280	50/200		776960 07778		
	320	50/200	636425 97516	776960 07781	100	666233 90509
400	50/200	636425 97517	776960 07784	100	666233 90510	
500	50/200		776960 07785	100	666233 90511	
600	50/200		776960 07786	100	666233 90512	
800	50/200		776960 07787	100	666233 90513	
1000	50/200		776960 07788	100	666233 90514	



Improved Dust

Extraction / Increased Productivity

The upgrade to precise, flat, laser-cut holes instead of die-punched holes, dramatically increases surface area contact allowing Norton Multi-Air Cyclonic discs to improve productivity by 32% versus conventional multi-hole sanding and by 60% versus non-vacuum sanding.

The end result is more holes for dust extraction, more abrasive coverage for a better cut and no deformation – for full surface contact utilizing all the cutting power of the premium ceramic grain.

Refer to the Sanding Accessories section for back-up pads and accessories.

Lightweight Paper Discs



Best choice for the most demanding coarse grit stripping, blending, and sanding applications

BLAZE A995 NO-FIL CERAMIC ALUMINA

- P-graded, next-generation sharper-edged ceramic aluminum oxide abrasive ensures fastest cut rate and longest life of any paper disc
- Unique polyester-reinforced, D-weight latex saturated backing provides maximum tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work



Best choice for the most demanding sanding applications

DRYICE A975 NO-FIL CERAMIC ALUMINA

- P-graded seeded-gel ceramic alumina abrasive for fastest cut rate and longest life of any paper disc
- Unique fiber reinforced, flexible B or C-weight latex saturated backing delivers 50% - 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work



Better choice for high-performance dry finishing on all materials

A2750P NO-FIL ALUMINUM OXIDE

- Premium P-graded, heat treated, toughened aluminum oxide abrasive delivers superior life, fast cut rate, consistent finish
- Unique fiber reinforced, flexible B-weight latex saturated backing provides 50% - 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work
- 5" and 6" individual PSA discs in fine grits have a tabbed, white translucent liner to protect the PSA adhesive from airborne contaminants; the tab allows easier removal of the paper liner



Better choice for hard-to-sand surfaces and wood applications

DURITE A475 NO-FIL SILICON CARBIDE

- Sharp and hard, P-graded, silicon carbide abrasive easily penetrates the hardest material and veneers to create finer finishes where finish is critical
- Flexible, B-weight fiber reinforced, latex paper backing provides flexibility and resistance to tearing
- Water-based, non-pigmented stearate No-Fil coating and open coat provide maximum load resistance and no color transfer to work



Good choice for sanding a broad range of substrates including primed or painted surfaces, wood, composites, aluminum, and ferrous metals

GOLD RESERVE A296 NO-FIL ALUMINUM OXIDE

- P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent surface finish
- Strong C-weight high latex/paper backing resists tearing while staying conformable and flexible
- Water-based, non-loading (No-Fil) stearate coating minimizes clogging and increases disc life

Lightweight Paper Discs

Stick & Sand (PSA)
Lightweight Disc Rolls
Non-Vacuum



TIER:	BEST	BETTER	BETTER	GOOD
TRADENAME:	DRYICE A975 NO-FIL	A2750P NO-FIL	DURITE A475 NO-FIL	GOLD RESERVE A296 NO-FIL
ABRASIVE:	Ceramic Alumina	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
PAPER BACKING WEIGHT:	B- & C-Weight	B-Weight	B-Weight	C-Weight
FASTENING:	PSA	PSA	PSA	PSA
OTHER:	P-Graded	P-Graded	P-Graded	P-Graded

SIZE (D)	GRIT	ROLLS/ STD. PKG.	DISCS/ ROLL	PART #	PART #	PART #	PART #
3-1/2	80	4	100		662611 36376		
	120	4	100		662611 36375		
	180	4	100		662611 36373		
	220	4	100		662611 36372		
	280	4	100		662611 36370		
	320	4	100		662611 36369		
	400	4	100		662611 36368		
5	60	4	100				780727 48552
	80	4	100	662611 40502	662611 131464*	662544 87415	662611 183806
	100	4	100	662611 40501	662611 131463*	662544 87417	662611 183807
	120	4	100	662611 40500	662611 131462*	662544 87418	662611 183808
	150	4	100	662611 40499	662611 131461*	662544 87440	662611 183809
	180	4	100	662611 40498	662611 131460*	662544 87441	662611 183810
	220	4	100	662611 42474	662611 131459*	662544 87442	662611 183811
	240	4	100	662611 55380	662611 131458*	662544 87443	780727 48551
	280	4	100		662611 131457*		
	320	4	100	662611 55378	662611 131456*	662544 87444	662611 183813
	400	4	100	662611 55377	662611 131454*	662610 65293	662611 183814
	500	4	100		662611 131453*		
	600	4	100	666233 05608	662611 131452*	662544 21217	662544 92263
	800	4	100	662544 80230	662611 131451*		776960 69730
6	60	4	100				780727 48553
	80	4	100	662611 40512	662611 131481*	662544 87446	662611 183815
	100	4	100	662611 40511	662611 131480*		662611 183816
	120	4	100	662611 40510	662611 131479*	662544 87447	662611 183817
	150	4	100	662611 40509	662611 131478*		662611 183818
	180	4	100	662611 40508	662611 131477*	662544 87448	662611 183819
	220	4	100	662611 48340	662611 131476*	662544 87449	662611 183820
	240	4	100	662611 55376	662611 131475*		662611 183821
	280	4	100		662611 131474*		
	320	4	100	662611 55374	662611 131473*	662544 87450	662611 183822
	400	4	100	662611 55373	662611 131471*		662611 183823
	500	4	100	636425 06198	662611 131470*		636425 06165
	600	4	100	636425 06199	662611 131469*		662610 40261
	800	4	100	636425 06200	662611 131468*		636425 06164
8	80	4	100		662611 131617		
	120	4	100		662611 131615		
	150	4	100		662611 131614		
	180	4	100		662611 131613		
	220	4	100		662611 131612		
320	4	100		662611 131609			

* Packaging Standards A275 = 6/100

Refer to the Sanding Accessories section for back-up pads and accessories.

Lightweight Paper Discs

Stick & Sand (PSA)
Lightweight Disc Rolls
Vacuum



TIER: **BETTER**

TRADENAME: **A2750P NO-FIL**

ABRASIVE: Aluminum Oxide

PAPER BACKING WEIGHT: B-Weight

FASTENING: PSA

OTHER: P-Graded

TIER: **GOOD**



TRADENAME: **GOLD RESERVE A296 NO-FIL**

ABRASIVE: Aluminum Oxide

PAPER BACKING WEIGHT: C-Weight

FASTENING: PSA

OTHER: P-Graded

SIZE (D)	GRIT	ROLLS/ STD. PKG.	DISCS/ ROLL	PART #	ROLLS/ STD. PKG.	PART #
						
				5" x 5 Hole Die #3329		
5	60				4	780727 48543
	80	6	100	662611 31498	4	662544 77327
	100	6	100	662611 31497	4	662611 30264
	120	6	100	662611 31496	4	666233 07048
	150	6	100	662611 31495	4	666233 05824
	180	6	100	662611 31494	4	662610 21898
	220	6	100	662611 31493	4	662544 77328
	240	6	100	662611 31492		
	320	6	100	662611 31490	4	662610 23787
	400	6	100	662611 31488	4	662611 30257
						
				6" x 6 Hole Die #3333		
6	80	6	100	662611 31515	4	780727 48550
	100	6	100	662611 31514	4	780727 48549
	120	6	100	662611 31513	4	780727 48547
	150	6	100	662611 31512	4	780727 48546
	180	6	100	662611 31511	4	780727 48545
	220	6	100	662611 31510	4	780727 02746
	240	6	100	662611 31509		
	280	6	100	662611 31508		
	320	6	100	662611 31507	4	780727 48787
	400	6	100	662611 31505		
	600	6	100	662611 31503		

Stick & Sand (PSA)
Individual Discs
Non-Vacuum



TIER: **BETTER**

TRADENAME: **A2750P NO-FIL**

ABRASIVE: Aluminum Oxide

PAPER BACKING WEIGHT: B-Weight

FASTENING: PSA Tabbed

OTHER: P-Graded

TIER: **BETTER**

TRADENAME: **GOLD RESERVE A296 NO-FIL**

ABRASIVE: Aluminum Oxide

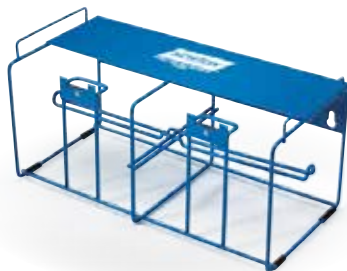
PAPER BACKING WEIGHT: C-Weight

FASTENING: PSA Tabbed

OTHER: P-Graded

SIZE (D)	GRIT	MIN./ STD PKG.	PART #
5	60	100/400	780727 45905 NS
	80	100/400	662610 38758
	100	100/400	780727 42907
	120	100/400	662610 38759
	150	100/400	662610 38760
	180	100/400	780727 42909
	220	100/400	780727 42910
	240	100/400	780727 42911
	320	100/400	780727 42912
	400	100/400	780727 42913
	600	100/400	780727 53545
	800	100/400	780727 53468
	1000	100/400	662611 131450
	1200	100/400	662611 131449
6	60	100/400	780727 53831 NS
	80	100/400	662611 83824
	100	100/400	662611 83825
	120	100/400	662611 83826
	150	100/400	662611 83827
	180	100/400	662611 83828
	220	100/400	662611 83829
	240	100/400	662611 83830
	320	100/400	662611 83831
	400	100/400	662611 83832
	600	100/400	780727 53546
	800	100/400	780727 53469
	1000	100/400	662611 131467
	1200	100/400	662611 131466
	1500	100/400	662611 131465

Refer to the Sanding Accessories section for back-up pads and accessories.



PSA Disc Roll Dispenser

- Norton disc roll dispensers feature heavy-duty construction and a rubberized finish to protect your product, as well as the finish on your workpiece
- These versatile dispensers are designed to accommodate any 5" or 6" disc roll or sheet roll
- They can be attached to a wall or stacked for multi-grit or multi-diameter operations
- Discs are individually dispensed and removed from the roll by a cutter bar

DESCRIPTION	STD. PKG.	PART #
PSA Disc Roll Dispenser		
Single Disc Roll Dispenser	1	636425 42772
Double Disc Roll Dispenser (shown)	1	636425 02981

Lightweight Paper Discs

Hook & Loop
Individual Discs
Non-Vacuum



TIER:	BEST	BEST	BETTER	BETTER	GOOD
CAP CODE:	BLAZE A995 NO-FIL	DRY ICE A975 NO-FIL	A2750P NO-FIL	DURITE A475 NO-FIL	GOLD RESERVE A296 NO-FIL
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide	Silicon Carbide	Aluminum Oxide
PAPER BACKING WEIGHT:	D-Weight	B- & C-Weight	B-Weight	B-Weight	C-Weight
FASTENING:	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop
OTHER:	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded

SIZE (D)	GRIT	PKG/CASE	PART #	PART #	PKG/CASE	PART #	PART #	PART #
3	80				50/200	662611 31532		
	100				50/200	662611 44926		
	120				50/200	662611 28688		
	150				50/200	662611 40385		
	180				50/200	662611 31528		
	220				50/200	662611 31527		
	240				50/200	662611 31526		
	320				50/200	662611 31524		
	400				50/200	662611 36995		
	500				50/200	662611 31521		
	600				50/200	662611 36996		
	800				50/200	662611 31519		
	1000				50/200	662611 35900		
	1500				50/200	662611 47434		
5	60				100/400			780727 48477
	80	50/200		662611 40522	100/400	662611 31549		666233 77539
	100	50/200		662611 40521	100/400	662611 31548		666233 77540
	120	50/200		662611 40520	100/400	662611 31547		666233 77541
	150	50/200		662611 40519	100/400	662611 31546		666233 77542
	180	50/200		662611 40518	100/400	662611 31545		666233 77543
	220	50/200		662611 49541	100/400	662611 31544		666233 05637
	240	50/200		662611 49540	100/400	662611 31543		662544 57751
	280				100/400	662611 31542		
	320	50/200		662611 49538	100/400	662611 31541		666233 05638
	400	50/200		662611 49537	100/400	662611 31539	662610 52270	666233 05639
	500	50/200		662544 80233	100/400	662611 31538		
	600				100/400	662611 31537		662611 05390
	800	50/200		662544 80232	100/400	662611 31536	662610 52267	666233 77544
	1000				100/400	662611 31535	662610 52254	699573 50989
	1200				100/400	662611 31534		
1500				100/400	662611 31533			
6	80	50/200	636425 97510	662611 40532	100/400	662611 31566		636425 06236*
	100	50/200		662611 40531	100/400	662611 31565		636425 06235*
	120	50/200	636425 97511	662611 40530	100/400	662611 31564		636425 06234*
	150	50/200	636425 97512	662611 40529	100/400	662611 31563		636425 06233*
	180	50/200	636425 97513	662611 40528	100/400	662611 31562		636425 06232*
	220	50/200	636425 97514	662611 49546	100/400	662611 31561		636425 06231*
	240				100/400	662611 31560		636425 06225*
	280				100/400	662611 31559		
	320	50/200		662611 49543	100/400	662611 31558		636425 06230*
	400	50/200		662611 49542	100/400	662611 31556		636425 06229*
	500	50/200		636425 06202	100/400	662611 31555		636425 06228*
	600	50/200		636425 06203	100/400	662611 31554		636425 06227*
	800	50/200		636425 06204	100/400	662611 31553		636425 06226*
	1000	50/200		636425 06375	100/400	662611 31552	662610 52255	699573 50990*
	1200	50/200			100/400	662611 31551		
	1500	50/200		636425 06377	100/400	662611 31550		
8	120				100/400	662611 31662		
	180				100/400	662611 31661		

Packaging Standards: PKG/CASE A296 = 50/250

Refer to the Sanding Accessories section for back-up pads and accessories.

Lightweight Paper Discs

Hook & Loop
Individual Discs
Vacuum



		TIER: BETTER		GOOD		GOOD	
		A2750P NO-FIL		GOLD RESERVE A296 NO-FIL		GOLD RESERVE A296 NO-FIL	
		Aluminum Oxide		Aluminum Oxide		Aluminum Oxide	
		B-Weight		C-Weight		C-Weight	
		Hook & Loop		Hook & Loop		Hook & Loop	
		P-Graded		P-Graded		P-Graded	
SIZE (D)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #
		 5" x 5 Hole Die #3328		 5" x 5 Hole Die #3328		 5" x 8 Hole Die #3392	
5	60	100/400		780727 48541*	780727 48542*		
	80	100/400	662611 31583	666233 07110*	662611 83916*		
	100	100/400	662611 31582	666233 12914*	662611 83917*		
	120	100/400	662611 31581	666233 07111*	662611 83918*		
	150	100/400	662611 31580	666233 12917*	662611 83920*		
	180	100/400	662611 31579	666233 07112*	662611 83921*		
	220	100/400	662611 31578	666233 07113*	662611 83934*		
	320	100/400	662611 31575	666233 07114*	662611 83977*		
	400	100/400	662611 31573	666233 07115*			
600	100/400	662611 31571					
		 6" x 6 Hole Die #3371		 6" x 6 Hole Die #3371			
6	80	100/400	662611 31600	666233 34786*			
	100	100/400	662611 31599	666233 34787*			
	120	100/400	662611 31598	666233 34788*			
	150	100/400	662611 31597	666233 34789* NS			
	180	100/400	662611 31596	666233 34790*			
	220	100/400	662611 31595	666233 34791*			
	240	100/400	662611 31594				
	320	100/400	662611 31592	666233 34793*			
	400	100/400	662611 31590	666233 34794*			
	500	100/400	662611 31589				
	600	100/400	662611 31588	666233 34796*			
	800	100/400	662611 31587	666233 34797*			
	1000	100/400	662611 31586				
1200	100/400	662611 31585					
1500	100/400	662611 31584					

Packaging Standards: * A975 Vacuum, A296 Vacuum = 50/200

Refer to the Sanding Accessories section for back-up pads and accessories.



An alternative to traditional perforated paper discs, mesh discs are a multi-functional abrasive, designed with thousands of holes, created by the unique mesh matrix structure. For use with random orbital and rotary sanders, superior performing mesh discs are engineered for maximum dust extraction on composite, automotive, and other fine finishing applications. Norton mesh discs produce superior finishes with virtually dust free sanding.

Applications:
Size Range:
Grit Range:
Machine Used:

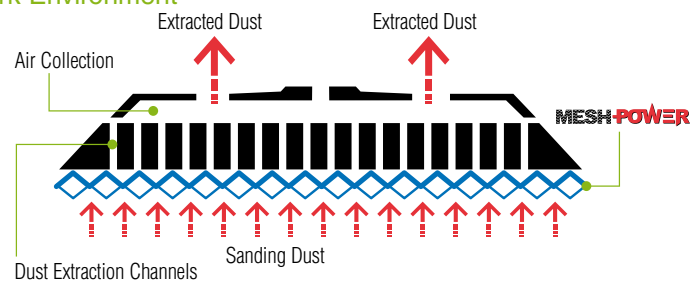
Surface preparation, Sanding, Finishing
5", 6"
60-400



ORBITAL SANDER

Powerful Dust Extraction Means A Cleaner, Safer Work Environment

We've answered the demands for a cleaner and safer working environment with Norton MeshPower discs. The open construction of the mesh backing allows dust particles to flow freely through the thousands of tiny holes, creating a virtually dust free sanding environment. Better for your health, better for your application and better for your business!



Best choice for sharp cutting along with powerful dust extraction



MESHPower CERAMIC

- Mesh matrix backing with thousands of tiny holes offers powerful dust extraction for a cleaner, healthier working environment
- Full ceramic grain for excellent cut rates and superior scratch pattern
- Norton No-Fil technology prevents clogging and creates a consistent cut throughout the product life
- Self-grip backing with no designated hole pattern is quick and easy to align to any backing pad – just apply and go!

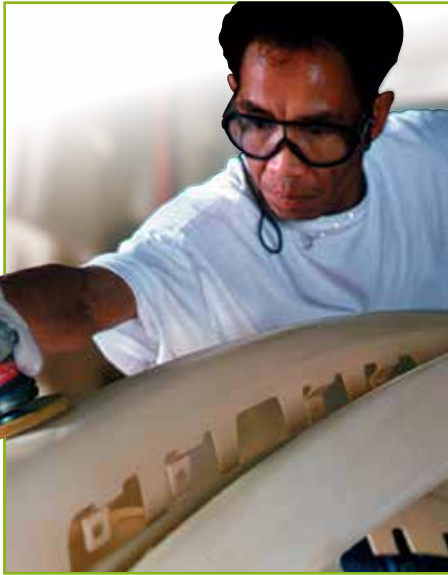
SIZE (D)	GRIT	PKG./CASE	PART #
5	60	50/200	776960 99015
	80	50/200	662611 50061
	120	50/200	662611 50062
	180	50/200	662611 50063
	220	50/200	662611 50064
	240	50/200	662611 50065
	320	50/200	662611 50066
	400	50/200	662611 50067
6	60	50/200	776960 99017
	80	50/200	662611 70645
	100	50/200	662611 70644
	120	50/200	662611 70643
	150	50/200	662611 70642
	180	50/200	662611 70641
	220	50/200	662611 70640
	240	50/200	662611 50054
	320	50/200	662611 50055
	400	50/200	662611 50057

TIER: **BEST**
 TRADENAME: **MESHPower**
 ABRASIVE: Ceramic

TECH TIP

Increase performance even further by using the Norton MeshPower discs with the Norton Multi-Air back-up pads - it's the ultimate dust extraction experience!

Contact your Norton representative for more information on additional grit sizes.



For use on random orbital and rotary sanders. The industry's highest performing film and foam finishing discs are engineered for composite, automotive, and other fine finishing applications. Norton microfinishing film discs produce superior finishes dry without sacrificing cut rate while Norton foam finishing discs are used moist to produce a semi-polished surface to reduce buffing time.

Applications:

Film discs: final dry finishing of primed and painted surfaces, varnishes, composites, and gel coats before buffing

Foam finishing discs: final moist finishing of clear coat, varnishes, composites, and gel coats before buffing

Compounds and buffing pads: removes swirl marks and sand scratches

Size Range:

3", 5" and 6"

Grit Range:

Film Discs: P80-P3000

Foam Discs: P1500, P2000, P3000

Machine Used:



ORBITAL SANDER



VERTICAL SHAFT PORTABLE GRINDER



MINI ANGLE SANDER

Finishing Film

Best choice for final dry finishing of primed and painted surfaces, varnishes, composites, and gel coats



PURE ICE Q175 A/O FINISHING FILM

- White aluminum oxide grain and patented resin system for better life, cut rate, and finish
- 3 mil polyester film backing for better flexibility and flatness of discs; hook and loop attachment for easy mounting and removal
- Color-coded backprint by grit size

Best choice for moist finishing of clear coats, varnishes, composites, and gel coats



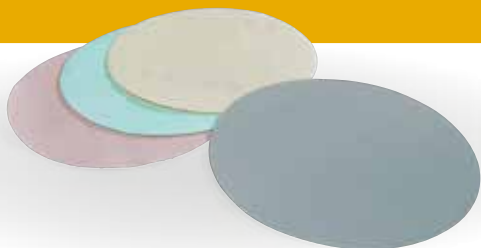
ICE Q255 A/O FINISHING FOAM

- Premium, P-graded fine grit aluminum oxide grain
- Conformable, integrated foam backing eliminates pigtailed and costly rework; produces a semi-polished finish that can be quickly buffed out; hook and loop attachment
- Open mesh design distributes pressure evenly for quicker sanding and uniform scratch patterns
- Color coded abrasive face by grit size for easy grit identification

Best choice for easy sanding of hard-to-reach areas

NORTON SUPERFLEXIBLE FILM

- Durable yet flexible film backing conforms better to surfaces and contours, preventing "over sanding" or "burn through"
- Anti-loading stearate for optimum performance and long life
- Consistent scratch pattern and even finish





TIER: **BEST**

TRADENAME: **PURE ICE Q175**
ABRASIVE: Aluminum Oxide
BACKING WEIGHT: 3 mil Polyester Film
ATTACHMENT: Hook and Loop
OTHER: P-Graded



BEST

SUPERFLEXIBLE
Aluminum Oxide
3 mil Polyester Film
Hook and Loop
P-Graded



BEST

ICE Q255
Aluminum Oxide
Foam
Hook and Loop
P-Graded

SIZE (D)	GRIT	PKG./CASE	COLOR	PART #	PKG./CASE	COLOR	PART #	PKG./CASE	COLOR	PART #
3	P800	50/200	Black	776960 88701						
	P1000	50/200	Red	776960 88702						
	P1200	50/200	Green	776960 88703						
	P1500	50/200	Blue	776960 88704	25/100	Rose	666233 90561	6/24	Blue	636425 06022
	P2000				25/100	Jade	666233 90562	6/24	Magenta	636425 06021
	P2500				25/100	Aquamarine	666233 90563			
	P3000				25/100	Meteorite	666233 90564	6/24	Green	636425 06020
6	P800	50/200	Black	776960 88713						
	P1000	50/200	Red	776960 88714						
	P1200	50/200	Green	776960 88715						
	P1500	50/200	Blue	776960 88716	25/100	Rose	666233 90556	15/60	Blue	636425 06015
	P2000				25/100	Jade	666233 90557	15/60	Magenta	636425 06014
	P2500				25/100	Aquamarine	666233 90558			
	P3000				25/100	Meteorite	666233 90559	15/60	Green	636425 06013

Refer to the Sanding Accessories section for back-up pads and accessories.





Norton flexible diamond coated discs combine the durability and aggressiveness of diamond, on a flexible backing.

Applications:

Grinding ceramic, glass, composites, carbide and ceramic coatings, fiberglass, and reinforced plastics; removing rust and scale on other materials; producing metallurgical stamps and coupons

Size Range:

PSA (Pressure Sensitive Adhesive) Discs: 2" – 6"

Quick-Change TR (Type III) Discs: 2" and 3"

Grit Range:

60 – 1500

Abrasive Types:

Diamond

Backing Color:

Color-coded backings for easily distinguished grit size selection

Machine Used:



ORBITAL
SANDER



VERTICAL SHAFT
PORTABLE GRINDER

Better choice for grinding glass, ceramics and composites, removing rust and scale, and producing metallurgical stamps and coupons



D71S PSA DISCS

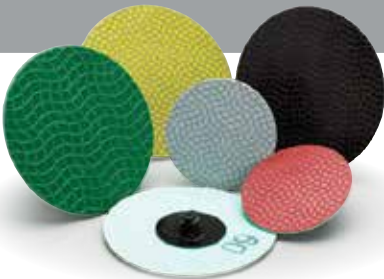
- Combines the durability and aggressiveness of a unique diamond abrasive face pattern with a flexible backing, to significantly increase life and lower costs versus standard coated and diamond discs
- Cloth backing provides strength, tear resistance, and flexibility
- Color-coded, PSA backing for quick, easy mounting and removal and identification of coarse grit sizes/applications

SIZE (D)	COLOR	MESH	STD. PKG.	TIER: BETTER	
				PART #	
Flexible Diamond Coated PSA Discs					
2	Green	60	1	662603	08159
	Black	120	1	662603	07722
	Red	200	1	662603	07723
	Yellow	400	1	662603	08160
	White	800	1	662603	07012
5	Green	60	1	662603	07839
	Black	120	1	662603	07838
	Red	200	1	662603	07019
	Yellow	400	1	662603	07960

SIZE (D)	COLOR	MESH	STD. PKG.	TIER: BETTER	
				PART #	
Flexible Diamond Coated PSA Discs					
6	Green	60	1	662603	06381
	Black	120	1	662603	06382

See Page 88 – Coated Abrasive Cloth PSA Disc section for back-up pads.

Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings



D7210 QUICK-CHANGE TR (TYPE III) DISCS

- Unique, durable diamond abrasive pattern increases life and lowers costs versus standard coated and diamond discs; color-coded backing for easy grit/application identification
- Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings
- Removes rust and scale on other material; producing metallurgical stamps and coupons

SIZE (D)	COLOR	MESH	STD. PKG.	TIER: BETTER	
				PART #	
Flexible Diamond Coated Quick-Change TR (Type III) Discs					
2	Green	60	12	662603	11778
	Black	120	12	662603	11779
	Red	200	12	662603	11780
	Yellow	400	12	662603	11781
	White	800	12	662603	11782

SIZE (D)	COLOR	MESH	STD. PKG.	TIER: BETTER	
				PART #	
Flexible Diamond Coated Quick-Change TR (Type III) Discs					
3	Green	60	12	662603	11783
	Black	120	12	662603	11784
	Yellow	400	12	662603	11786

See Page 170 – Quick-Change Disc Accessories section for back-up pads.

Multi-Air Foam Interface Pads

- Designed for use with fine grit Multi-Air Cyclonic hook and loop sanding discs to improve both surface finish and cut rate
- Use with Multi-Air hook and loop disc back-up pads
- Align the interface pad with the Multi-Air back up pad then simply attach the disc to the interface pad because the holes do not have to be lined up
- Ideal for use with new Mesh discs



SIZE (D x T)	DESCRIPTION	STD. PKG.	PART #
Multi-Air Foam Interface Pads with Vacuum Holes			
5 x 1/2	Multi-Air Hook & Loop Interface Pad	8	636425 85864
6 x 1/2	Multi-Air Hook & Loop Interface Pad	12	076607 19359

Multi-Air Hook & Loop Back-up Pads with Vacuum Holes

- Innovative design optimized for maximum air flow and powerful dust extraction
- Pads are engineered with a durable urethane foam, heat-resistant plastic, a molded-in 5/16"-24 spindle, and hooked face
- Holes in the disc do not have to be matched up with the holes in the pad, so changeover is fast and easy
- Ideal for use with new Mesh discs



SIZE (D)	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Multi-Air Hook & Loop Back-up Pads with Vacuum Holes				
5" (125mm) with 5/16"-24 Shank	Medium-Density Urethane Pad	15,000	5	666233 76000
6" (150mm) with 5/16"-24 Shank	Medium-Density Urethane Pad	15,000	5	636425 06160

Low-Profile Pads for Dual Action / Random Orbital Sanders

- Soft density low-profile pads utilize 1/2" thick foam for fine finish sanding and offer moderate conformability
- Medium low-profile pads have 1/2" thick urethane foam for intermediate and finish sanding
- Available with PSA (pressure sensitive adhesive) or hook and loop faces; both designs are shock resistant and have a fiberglass backing plate with a riveted 5/16"-24 threaded shank for added strength and increased heat resistance
- Available with standard hole patterns for vacuum-assist sanding



SIZE (D)	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Low Profile Pads for DA/Random Orbital Sanders				
3	Hook & Loop Soft Low-Profile	12,000	10	636425 06128
3-1/4	Hook & Loop Buffing Pad		5	662610 85302
5	PSA Soft Low-Profile	12,000	5	636425 06126
5	PSA Medium Low-Profile	15,000	5	636425 06131
5 x 5 holes	PSA Medium Low-Profile	15,000	5	636425 06132
5	Hook & Loop Soft Low-Profile	12,000	5	636425 06129
5	Hook & Loop Medium Low-Profile	15,000	5	636425 06135
5 x 5 holes	Hook & Loop Medium Low-Profile	15,000	5	636425 06136
6	PSA Soft Low-Profile	12,000	5	636425 06127
6	PSA Medium Low-Profile	15,000	5	636425 06133
6	Hook & Loop Soft Low-Profile	12,000	5	636425 06130
6	Hook & Loop Medium Low-Profile	15,000	5	636425 06137
6 x 6 holes	Hook & Loop Medium Low-Profile	15,000	5	636425 06138
8 x 8 holes, 5 screws	Hook & Loop Medium Low-Profile	1,500	5	636425 43712
8 x 8 holes, 6 screws	Hook & Loop Medium Low-Profile	1,500	5	636425 43714

Packed in individual clamshell

Tapered Pads for Dual Action / Random Orbital Sanders

- Designed with medium density polyurethane foam and a tapered edge for conformability, these pads are firm enough for flat surfaces, yet soft enough for severe curves and contours
- Available with either PSA (vinyl, pressure sensitive adhesive) or hook and loop faces in vacuum or non-vacuum
- The 5" and 6" pads are shock resistant and have a fiberglass backing plate with a riveted 5/16"-24 threaded shank for use on random orbital or dual action sanders
- The 8" pads have a 5/8"-11 threaded female hub



SIZE (D)	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Tapered Pads for DA/Random Orbital Sanders				
5	PSA Medium Tapered	15,000	5	636425 06139
5 x 5 holes	PSA Medium Tapered	15,000	5	636425 06140
5	Hook & Loop Medium Tapered	15,000	5	636425 06143
5 x 5 holes	Hook & Loop Medium Tapered	15,000	5	636425 06144
6	PSA Medium Tapered	15,000	5	636425 06141
6 x 6 holes	PSA Medium Tapered	15,000	5	636425 06142
6	Hook & Loop Medium Tapered	15,000	5	636425 06145
6 x 6 holes	Hook & Loop Medium Tapered	15,000	5	636425 06146
8	PSA Medium Tapered	6,000	5	636425 43112
8	Hook & Loop Medium Tapered	3,200	5	636425 43704

Packed in individual clamshell

Hook & Loop Foam Interface Pads

- Designed for use with our fine grit hook and loop sanding discs
- Improve both surface finish and cut rate
- Use with hook and loop back-up pads



SIZE (D x T)	DESCRIPTION	STD. PKG.	PART #
Foam Hook & Loop Interface Pads			
3 x 1/2	Interface Pad	10	636425 05457
6 x 1/2	Interface Pad	5	636425 42089
5 x 3/4	Interface Pad	2	636425 02161
6 x 3/4	Interface Pad	2	636425 02162

Half Moon Hand Pad

- The unique half moon pad takes a standard 5" hook and loop disc folded in half, which adheres to the hooks on the pad face
- The straight edge of the pad allows the operator to sand corners, contours, narrow crevices and minute imperfections without over-sanding



SIZE (D)	DESCRIPTION	STD. PKG.	PART #
Half Moon Hand Pad			
5	Hook & Loop	10	636425 02768

Polishing Adapter Pad

- Converts your standard hook and loop pad into a soft polishing pad
- The foam adapter is 3/8" thick and is excellent for fine grits where minimal removal is required
- It is ideal for either flat or contour surfaces



SIZE	DESCRIPTION	MAX. RPM	STD. PKG.	PART #
Polishing Adapter Pad				
5	Hook & Loop Adapter Pad	3,786	10	636425 03121

Ergonomic Hand Sanders

- The ergonomic palm sander is uniquely designed to be user-friendly, with finger indentations for the operator
- It quickly converts standard 5" and 6" hook and loop discs into hand sanders for finishing flat surfaces



SIZE (D)	DESCRIPTION	STD. PKG.	PART #
Ergonomic Hand Sander			
5	Hook & Loop	5	636425 03147
6	Hook & Loop	5	636425 03726

Disc Hand Pads

- Hand pads eliminate finger sanding
- The ultra-thin 3/16" thick pad is composed of a single layer of neoprene foam and is designed for maximum flexibility – producing excellent finishes
- The 1" thick pad is composed of two layers, neoprene and polyester foam, for excellent conformability and softness, resulting in fine finishes
- Each pad has an elastic hand strap to hold it firmly in place
- Available with either PSA (vinyl, pressure sensitive adhesive) faces or hook and loop face



SIZE (D x T)	DESCRIPTION	STD. PKG.	PART #
Disc Hand Pads			
5 x 3/16	Soft Foam PSA	10	636425 03111
5 x 1	Soft Foam PSA	10	636425 02842
5 x 1	Soft Foam Hook & Loop	10	636425 03117

Panel and Adhesive Cleaner

- Removes adhesives, tar, grease, wax, body sealers, undercoating sprays, and silicone from most surfaces
- Aggressive cleaner is safe to use on most paint applications
- Packaged with squirt dispenser
- Use as directed



SIZE/DESCRIPTION	STD. PKG.	PART #
Panel and Adhesive Cleaner		
Quart Can	12	076607 82780

Liquid Ice Extra-Cut Compound

- Water soluble; easy to use and easy to clean up
- Engineered to be used with a selection of 3 pads, depending on the finish required



SIZE	DESCRIPTION	STD. PKG.	STD. CASE	PART #
Quart	Liquid Ice Extra-Cut Compound	1	4	636425 97116

Liquid Ice Clean-up / Detailer Spray

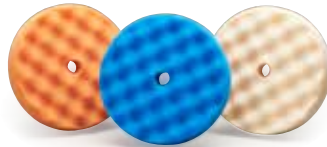
- The spray detailer easily cleans up excess buffing residue and produces paint protection
- Spray it on and wipe off with a Norton Microfiber cloth ("Masking Products" section)



SIZE	DESCRIPTION	STD. PKG.	STD. CASE	PART #
32 oz.	Spray Bottle Clean-up Detailer	1	4	636425 42082

8" Hook & Loop Buffing/Polishing Waffle Pads

- These pads can be used with Norton Liquid Ice Extra-Cut Compound



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
8	Orange Waffle Foam pad - Step 1	1	6	636425 06379
8	Blue Waffle Foam Pad - Step 2	1	6	636425 06380
8	White Waffle Foam Pad - Step 3	1	6	636425 06381

8" and 9" Hook & Loop Buffing/Polishing Pads

- These pads can be used with Norton Liquid Ice Extra-Cut Compound following the step numbers



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
8	Super Cut Wool Pad - Step 1	1	6	636425 42077
9	Blue Cutting Foam Pad - Step 2	1	6	636425 42078
9	White Finishing Foam Pad - Step 3	1	6	636425 42079

3" Hook & Loop Buffing/Polishing Pads

- For small spot repair



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
3	Super Cut Wool Pad - Step 1	10	40	636425 43832
3	Blue Cutting Foam Pad - Step 2	10	40	636425 05459
3	White Finishing Foam Pad - Step 3	10	40	636425 05460

Hook & Loop Back-up Pads for 8" and 9" Buffing Pads

- Black plastic back-up plate with hook and loop face. Molded-in 5/8"-11 threaded female hub



SIZE (D)	DESCRIPTION	STD. PKG.	STD. CASE	PART #
8 and 9	Hook & Loop Back-up Pad	1	3	636425 42080

Black Lambswool Hook & Loop Polishing Pads

- Distributing and applying material evenly and consistently, these dense, durable, lambswool pads are designed to repair clearcoat finishes



SIZE	DESCRIPTION	STD. CASE	PART #
3	Pad with Loop – 3/4" nap	40	636425 03670
4	Pad with Loop – 3/4" nap	250	636425 03671

Please pages 350 - 356 for additional finishing products



Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

Non-Woven Convolute wheels are formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core.

Applications:

- Burr and flashing removal
- Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

Abrasive Grain:

Aluminum Oxide, Silicon Carbide

Grit Range:

Medium (M), Fine (F), Very Fine (VF)

Machine Used:



BENCH GRINDER



PEDESTAL GRINDER

Application/Grit Recommendation Guide

NORTON	Rapid Finish GP Convolute Wheels	Metal Finishing Convolute Wheels	Clean & Finish Convolute Wheels	Light Finishing Convolute Wheels
Scale Removal				
Stock Removal	Second Choice			
Heavy Deburring	Second Choice			
Decorative Finishing		First Choice	Second Choice	
Blending	First Choice	Second Choice		
Cleaning		Second Choice	First Choice	
Light Deburring	Second Choice			First Choice
Light Finishing	Second Choice			First Choice
Polishing				First Choice
Buffing				

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1. Wheel Speed	Slow ←	Fast →
2. Feed Speed	Faster (Long Scratch) ←	Slower (Short Scratch) →
3. Oscillation	No Oscillation ←	Oscillation →
4. Lubricants	Dry ←	Soluble Oil →
	Water ←	Straight Oil →
		Compounds →

Non-Woven Marking System

ABRASIVE	SILICON CARBIDE	ALUMINUM OXIDE		
	←	→		
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN			
	MORE DURABLE, LONGER LASTING, POLISHED FINISH			
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)
	←			→
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH		REDUCED CUT RATE, FINER FINISH	
DENSITY	2			9
	←			→
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING		HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH	

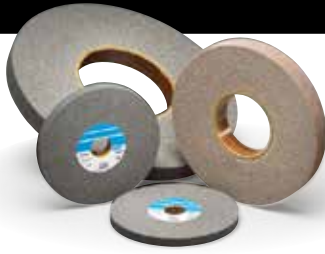
Cross Reference Guide

NORTON	BEST	BETTER	GOOD	GOOD	GOOD
3M	Rapid Finish 3M EXL, General Purpose	Metal Finishing Metal Finishing	Series 4000 EX2 & EX3	Light Finishing Light Deburring	Clean & Finish Multi Finishing
Standard	General Purpose Plus, Light Deburring	Metal Finishing	GP Plus	LDW	Multi Finishing



Convolute Wheels For
Cylindrical & Centerless Grinding!
youtu.be/fLqwBlq6xO8

Aggressive Deburring



Good choice for heavy deburring applications

SERIES 4000 ALUMINUM OXIDE & SILICON CARBIDE

- High-quality synthetic web provides long life for heavy deburring, edge-breaking, and parting line removal on exotic metals
- Advanced resin bond system ensures free cutting action
- Use both wet and dry

TIER: **GOOD**
TRADENAME: **SERIES 4000**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	4		6626100 4021
6 x 1 x 1	A/O	M	6,000	3	6626100 4208	
	S/C	F	6,000	3	6626100 4142	6626100 4141
8 x 1 x 3	A/O	M	4,500	3	6626100 4165	
	S/C	F	4,500	3	6626100 4123	6626100 4135
12 x 1 x 5	S/C	F	3,000	2	6626100 4284	6626100 4148
12 x 2 x 5	S/C	F	3,000	1		6626100 4011

General Duty



Best choice for broad range of applications: general deburring, blending, and finishing on all materials including metals, wood, glass

RAPID FINISH GENERAL PURPOSE A/O & S/C

- Eliminate smearing and loading on a wide range of workpieces (from high-nickel-content alloys to aluminum and other soft metals with patent-pending Norton Clean Bond resin technology)
- Increase throughput with a 30% faster finish through new Norton grain/bond configuration, decrease wheel changes with a 10-30% longer life, provided by a new fiber and the high-temperature resin bond
- Ease wheel selection with color-coding wheel to match the primary use (maroon for General Purpose), and fiberglass core to match the abrasive (black for silicon carbide and white for aluminum oxide)

TIER: **BEST**
TRADENAME: **RAPID FINISH GENERAL PURPOSE**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	PRODUCT CODE	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #	9 DENSITY PART #
6 x 1/2 x 1	A/O	M	6,000	4	C2315		662611 34177	662611 34178	662611 34179
	S/C	M	6,000	4	C4315				662611 08076
	S/C	F	6,000	4	C4415		662611 33213	662611 06732	662611 12985
6 x 1 x 1	A/O	M	6,000	3	C2315	662611 34180	662611 34181	662611 34182	662611 34183
	A/O	F	6,000	3	C2408	662611 32100		662611 32324	
	S/C	M	6,000	3	C4315		662611 08074	662611 33215	662611 08075
	S/C	F	6,000	3	C4415	662611 14475	662611 19988	636425 77269	636425 81587
	S/C	VF	6,000	3	C4515	662611 31970			
	S/C	M	6,000	2	C2315		662611 34184		
6 x 2 x 1	S/C	M	6,000	2	C4315		662611 14471		
	S/C	F	6,000	2	C4415		662611 32325		
	S/C	M	4,500	3	C4315		662611 08066	662611 08069	
8 x 1 x 3	S/C	F	4,500	3	C4415	662611 08064	662611 08065	636425 53754	636425 76004
	S/C	VF	4,500	3	C4515				662611 33209
	S/C	M	4,500	2	C4315		662611 14473		
8 x 2 x 3	S/C	F	4,500	2	C4415		662611 14480	662611 14483	662611 14486
	S/C	VF	4,500	2	C4515				662611 33210
	S/C	M	3,600	3	C2315		662611 34185		
10 x 1 x 5	S/C	F	3,600	3	C4415			662611 06554	662611 14488
	S/C	F	3,600	1	C4415			636425 81044	
12 x 1 x 5	A/O	M	3,000	2	C2315				662611 34186
	S/C	F	3,000	2	C4415	662611 08053	662611 14481	662611 14484	662611 14074
	S/C	VF	3,000	2	C4515				
12 x 2 x 5	S/C	F	3,000	1	C4415		662611 14482	662611 12766	662611 14490

Aesthetic Finishing

Better choice for decorative finishing, blending, and final finishing



METAL FINISHING ALUMINUM OXIDE

- Premium, medium grit aluminum oxide grain generates uniform distinct satin and antique finishes
- Dense, very durable web allows these wheels to be used for blending applications; strong resin binder provides resiliency and long life
- Uniform grain dispersion and coating clean and condition without gouging or changing dimensions of workpiece

TIER: **BETTER**

TRADENAME: **METAL FINISHING**

SIZE (D x T x H)	ABRASIVE	GRIT	DEN-SITY	MAX. RPM	STD. PKG.	PART #
6 x 1 x 1	A/O	M	5	6,000	3	662610 07936
	A/O	M	6	6,000	3	662610 10148
6 x 2 x 1	A/O	M	5	6,000	2	662610 07957
	A/O	M	6	6,000	2	662610 09635
8 x 1 x 3	A/O	M	5	4,500	3	662610 07831
8 x 2 x 3	A/O	M	5	4,500	2	662610 07904
	A/O	M	6	4,500	2	662610 12971

TIER: **BETTER**

TRADENAME: **METAL FINISHING**

SIZE (D x T x H)	ABRASIVE	GRIT	DEN-SITY	MAX. RPM	STD. PKG.	PART #
12 x 1 x 5	A/O	M	5	3,000	2	662610 07434
	A/O	M	6	3,000	2	662610 09481
12 x 2 x 5	A/O	M	5	3,000	1	662610 07212
14 x 2 x 8	A/O	M	5	2,550	1	662610 07817

Good choice for light deburring, polishing, and fine finishing applications



LIGHT FINISHING SILICON CARBIDE

- Advanced manufacturing process produces a consistent web and grain distribution for a consistent finish on intricate polishing applications
- Superior form holding for consistent, reliable edge breaking and finishing with minimal wheel dressing and reshaping; less dust and shedding with more uniform wear
- Controlled cut rate prevents “over benching”, deburrs and polishes without altering geometry

TIER: **GOOD**

TRADENAME: **LIGHT FINISHING**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #
6 x 1/2 x 1	S/C	F	6,000	662610 092322	662610 92324	662544 21572
6 x 1 x 1	S/C	F	6,000	662544 03708	662544 03709	662544 21573
8 x 1/2 x 3	S/C	F	4,500	662544 03707	662544 09698	662544 21575
8 x 1 x 3	S/C	F	4,500	662610 095702	662544 09924	662544 21577

All Light Finishing convolute wheels are non-stock. Ask your Norton representative for current lead-times and order quantities.

Good choice for fine finishing with light pressure



CLEAN & FINISH SILICON CARBIDE

- Sharp, more aggressive silicon carbide abrasive leaves a fine/brighter scratch pattern
- Conformable to intricate shapes and contours without changing the workpiece dimension
- Open web construction makes these ideal for low-to moderate-pressure, low speed applications

TIER: **GOOD**

TRADENAME: **CLEAN & FINISH**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
4 x 1 x 1	S/C	M	4	4,000	10	662610 58502
		F	4	4,000	10	662610 58501
6 x 1 x 1	S/C	M	4	3,000	4	662610 58507
		F	4	3,000	4	662610 58506
6 x 2 x 1	S/C	M	4	3,000	2	662610 58510
		F	4	3,000	2	662610 58509
6 x 3 x 1	S/C	M	4	3,000	1	662610 58512
6 x 4 x 1	S/C	M	4	3,000	1	662610 58514

TIER: **GOOD**

TRADENAME: **CLEAN & FINISH**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
8 x 1 x 3	S/C	M	4	2,500	3	662610 58518
8 x 2 x 3	S/C	M	4	2,500	2	662610 58521
8 x 3 x 3	S/C	M	4	2,500	1	662610 58524
8 x 4 x 3	S/C	M	4	2,500	1	662610 58526

Aluminum Reducing Bushings for Flap and Convolute Wheels



- Durable, aluminum one-piece-design flanges with integrated contact washer
- Snug fit; extended usable life
- Available in stock and non-stock sizes in many combinations of ID hole reduction

WHEEL CENTER HOLE	BUSHING REDUCES HOLE SIZE TO	FOR WHEEL DIAMETER	STD. PKG.	PART #
1	3/8	4 - 6	1 Pair	662610 80522 NS
	1/2	4 - 6	1 Pair	662610 80523
	5/8	4 - 6	1 Pair	662610 80524
	3/4	4 - 6	1 Pair	662610 80525 NS
2	7/8	4 - 6	1 Pair	662610 80526 NS
	1	6	1 Pair	662610 80527 NS
3	5/8	6	1 Pair	662610 80528 NS
	1	6	1 Pair	662610 80529 NS
5	1	8	1 Pair	662610 80531
	1-1/4	8	1 Pair	662610 80532
8	1	10 and 12	1 Pair	662610 80533
	1-1/4	10 and 12	1 Pair	662610 80534
	3	10 and 12	1 Pair	662610 80535 NS
8	1-1/4	14	1 Pair	662610 80536 NS

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

TECH TIP

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.
- Light to medium pressure is recommended. Excessive pressure may result in part damage.
- Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.



It is the user's responsibility to refer to and comply with ANSI B7.1



Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. The industry's broadest offering is available for light stock removal, deburring, blending, finishing and polishing. Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

Applications:

Cleaning and removing imperfections on metal surfaces, cleaning built-up residue, deburring or finishing a variety of surfaces, blending weld seams or creating decorative finishes. Non-woven surface finishing products have excellent versatility.

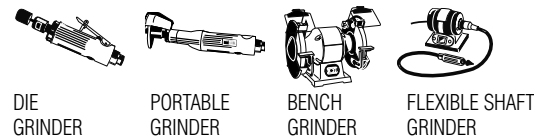
Abrasive Grain:

Engineered Aluminum Oxide, Aluminum Oxide, Silicon Carbide

Grit Range:

Extra Coarse (XC), Coarse (C), Medium (M), Fine (F)

Machine Used:



Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

Variable Factor	Rough Finish High RMS Reading	Smooth Surface Lower RMS Reading
1. Wheel Speed	Slow ←	→ Fast
2. Feed Speed	Faster (Long Scratch) ←	→ Slower (Short Scratch)
3. Oscillation	No Oscillation ←	→ Oscillation
4. Lubricants	Dry ←	→ Straight Oil
	← Water	→ Soluble Oil
		← Compounds →

Non-Woven Marking System

ABRASIVE	SILICON CARBIDE	ALUMINUM OXIDE		
	←	→		
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN	MORE DURABLE, LONGER LASTING, POLISHED FINISH		
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)
	←	→		
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH	REDUCED CUT RATE, FINER FINISH		
DENSITY	2	9		
	←	→		
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING	HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH		

Cross Reference Guide

	BEST	BETTER
NORTON	Vortex Rapid Blend	Rapid Blend NEX
3M	Cut & Polish Unitized, Deburr and Finish PRO	EXL Unitized
Standard	800 & 900 Series	500 - 700 Series

Rapid Blend Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing metals and composites. Easily preformed for use on a wide variety of shapes/contours. Hold shape well; less wheel dressing. Non-metallic so no contamination of workpiece. Uniform construction maintains part tolerance; prevents cutting or gouging.

Best choice for light weld bead and weld spatter removal, heavy deburring and finishing applications



VORTEX RAPID BLEND ALUMINUM OXIDE

- Proprietary engineered Vortex aluminum oxide aggregate grain stays sharper longer for increased cut rate while still offering a fine finish
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing
- 3D wheel construction enables multi-dimensional grinding which saves time on multiple wheel changes
- Aggressive, fast stock removal cut rate while providing a fine finish



TIER:	BEST	BEST
GRIT:	Coarse	Medium
ABRASIVE:	Engineered A/O	Engineered A/O



TIER:	BEST	BEST
GRIT:	Coarse	Medium
ABRASIVE:	Engineered A/O	Engineered A/O

SIZE (D x T)	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #
1" x 1" x 3/16"	5	35,000	50	662611 32922	—
	8	35,000	50	662611 32923	—
2" x 1/8" x 1/8"	5	22,000	60	662611 32896	662544 25657 NS
	7	22,000	60	—	662544 10849 NS
	8	22,000	60	662611 32897	—
2" x 1/8" x 1/4"	5	22,000	60	662611 32898	662544 06346 NS
	7	22,000	60	—	662611 91446
	8	22,000	60	662611 32899	—
2" x 1/4" x 1/4"	3	18,000	60	—	662544 28456 NS
	5	22,000	60	662611 32900	662544 33504
	7	22,000	60	—	662611 080270
	8	22,000	60	662611 32901	—
2" x 1/2" x 1/4"	5	22,000	30	662611 32914	—
	8	22,000	30	662611 32915	—
2" x 1" x 1/4"	5	22,000	15	662611 32916	—
	7	22,000	15	—	662611 080269 NS
	8	22,000	15	662611 32917	—
3" x 1/8" x 1/4"	5	18,000	40	662611 32902	—
	5	18,000	40	—	662611 093448
	7	18,000	40	—	662611 91445
	8	18,000	40	662611 32903	—
3" x 1/8" x 3/8"	5	18,000	40	662611 32904	662544 33503 NS
	7	18,000	40	—	662544 01131 NS
	8	18,000	40	662611 32905	—

NS = Non-Stock items.

SIZE (D x T)	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #
3" x 1/4" x 1/4"	3	12,000	40	—	662544 28454 NS
	5	18,000	40	662611 32906	662544 14832
	7	18,000	40	—	662611 99696
	8	18,000	40	662611 32907	—
3" x 1/4" x 3/8"	3	12,000	40	—	662544 33505 NS
	5	18,000	40	662611 32908	662544 33506 NS
	7	18,000	40	—	662611 99697
	8	18,000	40	662611 32909	—
3" x 1/2" x 1/4"	5	18,000	20	662611 32912	662544 32925
	7	18,000	20	—	662611 080267
	8	18,000	20	662611 32913	—
	9	18,000	20	—	662544 33507 NS
3" x 1/2" x 3/8"	5	18,000	20	662611 32910	662544 33508
	7	18,000	20	—	662611 080266
	8	18,000	20	662611 32911	—
3" x 1" x 1/4"	5	18,000	10	662611 32918	—
	8	18,000	10	662611 32919	—
	5	16,000	5	662611 32920	—
4" x 1" x 1/4"	8	16,000	5	662611 32921	—
	5	12,000	4	662611 32924	699573 18950
6" x 1/2" x 1"	8	12,000	4	662611 32925	780727 67709
	5	12,000	2	662611 32926	776960 93919
6" x 1" x 1"	8	12,000	2	662611 32927	780727 13652

NS = Non-Stock items.

For Rapid Blend Unified Quick-Change discs please see Quick-Change disc section.



How to Grind & Blend in One Step! Non-Woven Discs Vs Grinding Wheels! ft. Vortex Rapid Blend Coarse
[youtube.com/watch?v=FgSLez3MKj8](https://www.youtube.com/watch?v=FgSLez3MKj8)



Better choice for light deburring and blending



RAPID BLEND NEX ALUMINUM OXIDE AND SILICON CARBIDE

- Uniform construction provides extra-long life and holds shape well for less wheel dressing
- Smear free resin binder formula provides smear-free finishes
- A great option for light deburring and blending applications

TIER: **BETTER**

TRADENAME: **RAPID BLEND NEX**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	2 DENSITY PART #	3 DENSITY PART #	4 DENSITY PART #	6 DENSITY PART #	8 DENSITY PART #
1 x 1 x 3/16	A/O	C	30,000	50					662610 14915
	A/O	M	18,000	50	662610 14891				
	A/O	M	30,000	50				662610 14908	662610 14924
	S/C	F	18,000	50	662610 14883				
	S/C	F	30,000	50				662610 14904	662610 14923
2 x 1/8 x 1/4	A/O	M	22,000	60					662610 14927
2 x 1/4 x 1/4	A/O	M	18,000	60	662610 14892				
	A/O	M	22,000	60					662610 14926
	A/O	F	22,000	60				662610 14901	
	S/C	F	18,000	60	662610 14884				
2 x 1/2 x 1/4	A/O	M	22,000	30					662610 14925
3 x 1/4 x 1/4	A/O	C	18,000	40					662610 14919
	A/O	M	18,000	40				662610 14909	662610 14930
	A/O	F	18,000	40			662610 15565	662610 14902	662610 14902
	S/C	F	12,000	40	662610 14886				
3 x 1/4 x 3/8	A/O	C	18,000	40					662610 14920
	A/O	M	12,000	40	662610 14895				
	A/O	M	18,000	40				662610 14910	662610 14933
	A/O	F	12,000	40			662610 14899		
	S/C	F	12,000	40	662610 14887	662610 16006			
3 x 1/2 x 1/4	A/O	M	12,000	20	662610 14893			662610 14928	
	A/O	M	18,000	20					
	S/C	F	12,000	20	662610 14885				
3 x 1/2 x 3/8	A/O	M	18,000	20					662610 14929
3 x 1 x 3/8	S/C	XC	18,000	10				662610 14914	
6 x 1/2 x 1	A/O	M	7,500	4					662610 14931
6 x 1 x 1	S/C	F	6,000	2	662610 14888				

For Rapid Blend Unified Quick Change discs please see Quick Change disc section.

Assemblies and Mandrels for Unified Wheels

FITS WHEEL CENTER HOLE	FOR WHEEL WIDTH	FOR WHEEL DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	PART #
Mandrel Assemblies for Unified Wheels and Discs On Edge								
3/16	1/8 – 1/2	1 – 2	1/4	2	7/16	994	1	662610 09852
1/4 – 5/16	Up to 1/2	Up to 2	1/4	2	5/8	932	1	662610 15146
1/4 – 5/16	Up to 1	Up to 2	1/4	2-1/2	5/8	932	1	662610 59422
				2-1/2	1	933	1	662610 59421
3/8	Up to 1/2	2 – 4	1/4	2-1/2	1	990	1	662610 09851
1/2	Up to 1	3 – 6	1/4	3-1/8	1-5/8	934	1	662610 09850
Threaded Mandrel for Unified Wheels								
3/16	1 x 1 x 3/16	1/4"	1-3/4"			948	5	662610 47584



MANDREL ASSEMBLY 662610**59421**



THREADED MANDREL 662610**47584**



MANDREL ASSEMBLY 662610**59422**



Portable file belt sanders have replaced tedious hand filing and sanding. First introduced in pneumatic, they are now also available in electric. Increasingly, tool manufacturers are introducing additional fixtures for additional applications. The belts listed are popular stock sizes, but additional sizes, specifications, backing materials, and edge scallops are available made-to-order.

Applications:

Light weld removal and blending, shape and contour sanding, surface preparation prior to coating and plating, removing cutting tool marks from molds and dies, general clean-up and finishing

Size Range:

1/8" to 1" wide, 12" to 30" long

Grit Range:

40 – 120

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

Machine Used:



PORTABLE FILE
BELT SANDER

Cross Reference Guide

	BEST	BEST	BETTER	GOOD	GOOD
NORTON	Blaze R980P	RedHeat R983	BlueFire R887D/R823P	Gemini R766	Gemini R283
3M	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	747D, 777F, 778F, 784F, 987F, 977F	577F, 551E	361F, 363F	241E, 244E, 251E, 261E
Hermes	CR456	—	RB48624YX, RB48644Z	RB377XY, SB378	RB530J, RB304J, RB306J
Klingspor	CS610	CS912	CS411X, CS416, CS409	CS412, CS413	CS412
SIA	2515, 2503	—	2800, 2803, 2815, 2829, 2824	—	—
VSM	XK875X, XK885Y, XK880Y	XK870X, XK870X	ZK713X, ZK713T, KK715X	LK719X, KK711X	KK711E
Sait	—	—	AZ-X	1AX, 2AX	LA-X
Sunmigh	—	—	—	P656W	—

Material-to-Product Recommendation Guide

	BEST	BEST	BETTER	GOOD	GOOD	
	Blaze R980P	RedHeat R983	BlueFire R887D	BlueFire R823P	Gemini R766	Gemini R283
Carbon Steel	◆	◆	◆	◆	◆	◆
Stainless Steel / Alloys	◆	◆	◆	◆	◆	◆
Cast Iron	◆	◆	◆	◆	◆	◆
Brass / Bronze	◆	◆	◆	◆	◆	◆
Aluminum	◆	◆	◆	◆	◆	◆



Best for stainless, cobalt, chrome, inconel, titanium, mild and carbon steel

BLAZE R980P CERAMIC ALUMINA

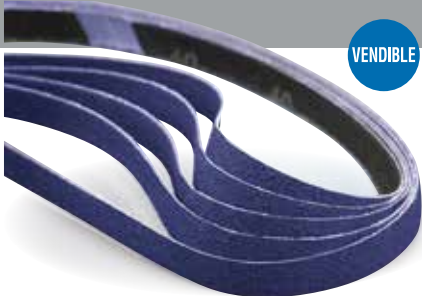
- Next-generation cooler cutting Norton SG ceramic alumina grain lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, inconel and titanium with better metal integrity
- Durable Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray, and better body retention, resulting in longer life and product consistency
- Lubricating grinding aid coating means cooler cut, burn-free grinding of heat-sensitive materials, minimized loading, and improved part finish and integrity



Exceptional performance, especially on hard-to-grind alloys

REDHEAT R983 CERAMIC ALUMINA

- Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency



VENDIBLE

Better choice for stainless and carbon steel

BLUEFIRE R887D/R823P ZIRCONIA ALUMINA

- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive zirconia belts
- Durable resin bond for excellent grain retention and product life
- Strong Y-weight polyester backing - R887D for heavy-duty stock removal applications; flexible X-weight polyester backing - R823P for moderate- to light-pressure applications



Good choice for difficult-to-grind materials (aluminum, brass, bronze, stainless, carbon steel, titanium, etc.)

GEMINI R766 ALUMINUM OXIDE

- Premium aluminum oxide abrasive blend is ideal when primary purchasing criteria is a good-performing, economically-priced, general-purpose belt
- Y-weight waterproof polyester backing withstands light- to moderately-demanding applications and provides extended life on dry grinding applications
- Resin bond system provides improved edge retention and 30% plus improvement in life versus key competitors



Good choice for stainless and carbon steel applications when initial price is the primary purchasing factor

GEMINI R283 ALUMINUM OXIDE

- P-graded premium aluminum oxide abrasive for consistent, cool cut
- Strong, semi-flexible, smooth X-weight rayon waterproof backing is designed for light- to moderate- pressure applications
- Durable resin coating provides excellent grain retention and product life



TIER:	BEST	BEST	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	REDHEAT R983	BLUEFIRE R887D/R823P	GEMINI R766	GEMINI R283
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
BACKING:	Y-Weight Polyester	Y-Weight Polyester	Y- or X-Weight Polyester	Y-Weight Polyester	X-Weight Rayon
OTHER:	Supersize	Supersize			

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #					
12" Belts												
1/8 x 12	40	50				666233	90000 NS					
	60	50	662544	05345 NS	662610	93029 NS						
	80	50		662544	91523 NS							
	120	50		662544	91524 NS							
1/4 x 12	40	50	662544	91520 NS								
	60	50	662611	96480 NS	780727	58896						
	80	50		662544	91526 NS	780727	82621	780727	66143			
	120	50	662610	63632 NS	780727	82622	780727	63175				
1/2 x 12	40	50	699573	98018	662544	91528 NS	662544	92522	666233	90006	780727	27557
	50	50	662610	43759	780727	18700						
	60	50	699573	98019	780727	18701	780727	28745	666233	90008 NS	780727	27555
	60	25 V					666233	73753				
	80	50	699573	98020	780727	18702	780727	28744	666233	90009	780727	27554
	80	25 V					666233	73754				
	100	50	662610	081180			662544	91534			780727	27553
	120	50	662610	42909	780727	00518 NS	780727	28742			780727	27552
1 x 12	60	50	662610	63641 NS			780727	53073			780727	73813

Additional sizes, grits and scalloped edge belts are available MTO (made-to-order). Contact your Norton representative for availability, order quantities and lead-times.

40 and 50 grit BlueFire belts are furnished in BlueFire R887D (Y-weight Polyester); 60-120 grits are supplied in BlueFire R823P (X-weight Polyester).

Joints - All belts are PG jointed; a butt joint joined with flexible tape for contour grinding.

V = Vendible package. Ideal for vending machines and small jobs. 5 belts per pack / 5 packs per carton. Order in multiples of 25.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Continued



		BEST		BEST		BETTER		GOOD		GOOD	
TIER:		BEST		BEST		BETTER		GOOD		GOOD	
TRADENAME:		BLAZE R980P		REDHEAT R983		BLUEFIRE R887D/R823P		GEMINI R766		GEMINI R283	
ABRASIVE:		Ceramic Alumina		Ceramic Alumina		Zirconia Alumina		Aluminum Oxide Blend		Aluminum Oxide	
BACKING:		Y-Weight Polyester		Y-Weight Polyester		Y- or X-Weight Polyester		Y-Weight Polyester		X-Weight Rayon	
OTHER:		Supersize		Supersize							
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #
13" Belts											
3/8 x 13	60	50	699573 45359	780727 45459	780727 40295	666233 90011	780727 32112				
	80	50	699573 92150	780727 74916	780727 36062	666233 90012	780727 71323				
18" Belts											
1/8 x 18	60	50	662610 80010			666233 90014 NS					
	80	50	662610 89120	780727 89083	780727 60595 NS	666233 90015 NS					
	120	50	662544 75215	780727 89084							
1/4 x 18	40	50	662610 27923	662611 98953	662544 92525	666233 90016 NS	662544 91543				
	60	50	699573 47249	780727 74684	780727 43583		780727 71000				
	80	50	699573 46155	780727 03284	780727 53075		780727 73921				
	80	25 V			666233 73748						
1/2 x 18	120	50	662610 85071	780727 85655	780727 73764						
	40	50	699573 98021	780727 66018	662544 44193	666233 90019	780727 27561				
	60	50	699573 98022	780727 18704	780727 28569	666233 90020	780727 27560				
	60	25 V			666233 73756						
	80	50	699573 98023	780727 18705	780727 28568	666233 90021 NS	780727 27559				
	80	25 V			666233 73757						
3/4 x 18	120	50	662610 41384	780727 18706	780727 28567		780727 27558				
	120	25 V			666233 73758						
	40	50	699573 98027	780727 62476	662544 92526	666233 90022	780727 81797				
	60	50	699573 98028	780727 45691	780727 09590	666233 90023	780727 39966				
	60	25 V			666233 73762						
	80	50	699573 98029		780727 58953	666233 90024	780727 32289				
80	25 V			666233 73763							
120	25 V			666233 73764							
20-1/2" Belts											
3/4 x 20-1/2	40	50	699573 98030	780727 14398	662544 57869	666233 90025	780727 27573				
	50	50	699573 44982	780727 18714	662544 92527						
	60	50	699573 98031	780727 18715	780727 28560	666233 90027 NS	780727 27571				
	60	25 V			666233 73765						
	80	50	699573 98032	780727 18716	780727 28559	666233 90028 NS	780727 27570				
	80	25 V			666233 73766						
	100	50	662610 55516		662610 38911		780727 27569				
	120	50	662610 44755	780727 27380 NS	780727 28557		780727 27575				
24" Belts											
1/4 x 24	40	50	662611 98631	780727 47823	662544 73499 NS						
	60	50	699573 45451	780727 56534	780727 28552		780727 27548				
	60	25 V			666233 73750						
	80	50	636425 96940	780727 18340	780727 67713						
1/2 x 24	120	50	662610 80367	780727 70718	780727 28550						
	40	50	699573 98024	780727 60092	662544 92528	666233 90032	780727 27568				
	50	50	662610 43757	780727 18707	662544 52237	666233 46910 NS					
	60	50	699573 98025	780727 18708	780727 28564	666233 90033	780727 27566				
	60	25 V			666233 73759						
	80	50	699573 98026	780727 18709	780727 28566	666233 90034	780727 27565				
1 x 24	80	25 V			666233 73760						
	100	50	662610 42203	780727 45021	780727 53076		662544 91545				
	120	50	662610 42565	780727 18710	780727 28565		780727 27564				
	40	50	699573 50019	662544 91531 NS							
	50	50	699573 44889 NS	780727 10374 NS							
	60	50	699573 53375 NS								
30" Belts	1 x 30	40	50	662610 53470			666233 90038	662611 89958 NS			
		60	50	699573 45985		780727 28583	666233 90039	662544 91549			
		80	50	699573 46105	780727 64439	780727 28582	666233 90040 NS	780727 27579			
		120	50	662611 93676	780727 81197	780727 66992		780727 27577			

Additional sizes, grits and scalloped edge belts are available MTO (made-to-order). Contact your Norton representative for availability, order quantities and lead-times.

40 and 50 grit BlueFire belts are furnished in BlueFire R887D (Y-weight Polyester); 60-120 grits are supplied in BlueFire R823P (X-weight Polyester).

Joints - All belts are PG jointed; a butt joint joined with flexible tape for contour grinding.

V = Vendible package. Ideal for vending machines and small jobs. 5 belts per pack / 5 packs per carton. Order in multiples of 25.



Portable belts are ideal for all your metal and woodworking applications. Choose 36 – 50 grits for rough/heavy-duty applications, 60 – 100 for intermediate, and 100 – 220 for finishing/polishing applications.

The belts listed are popular stock sizes, but additional sizes, specifications, and backing materials, are available made-to-order.

Applications:

Grinding and finishing all metals, blending welds, sanding and finishing wood, glass seaming, and polishing

Size Range:

3" to 4" wide, 15-1/2" to 24" long

Grit Range:

36 – 220

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

Machine Used:



BELT SANDER



IN-LINE DRUM SANDER

Cross Reference Guide

	BEST	BETTER	GOOD
NORTON	RedHeat R983	BlueFire R831	Gemini R215/ Metalite R255
3M	747D, 777F, 778F, 784F, 987F, 977F	577F	240DZ, 340A, 340D
Hermes	—	RB480	RB320
Klingspor	CS912	CS411	LS309XH
Sait	—	Z-H	1A-X, 2A-X, AO-X, LA-X
SIA	—	2800, 2829, 2925	2920, 2928, 2921, 2951, 2925
VSM	XK870X, XK870X	ZK713X	KK504X, KP510E

Material-to-Product Recommendation Guide

	BEST	BETTER	GOOD
	RedHeat R983	Bluefire R831	Gemini R215 Metalite R255
Wood		◆	◆
Carbon Steel / Stainless Steel	◆	◆	
Brass / Bronze / Aluminum		◆	◆

Exceptional performance, especially on hard-to-grind alloys



REDHEAT R983 CERAMIC ALUMINA

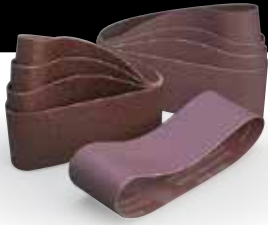
- Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency

Better choice for stainless steel and wood



BLUEFIRE R831 ZIRCONIA ALUMINA

- Premium, self-sharpening zirconia alumina abrasive provides superior cut on all surfaces, lasts substantially longer, and cuts faster than the next leading competitor in side-by-side comparisons
- Proprietary patented grain technology produces one of the finest scratch patterns in the industry for finer looking finish; open-coat design and strong Y-weight cotton backing for reduced loading and extended life
- Reversible butt splice allows belt to be used in either direction for longer life

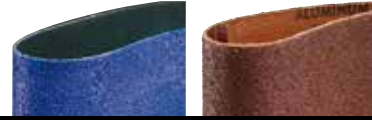


Good choice to minimize loading on wood and soft metals - where initial price is the main concern

GEMINI R215 / METALITE R255 ALUMINUM OXIDE

- Premium aluminum oxide abrasive for fast initial cut rate
- Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction

Portable Belts for Belt Sanders



TIER:	BETTER	GOOD
TRADENAME:	BLUEFIRE R831	GEMINI R215
ABRASIVE:	Zirconia Alumina	Aluminum Oxide
BACKING:	Y-Weight Cotton	X-Weight Cotton
JOINT:	Plyweld	Plyweld
GRAIN COATING:	Open Coat	Open Coat
OTHER:		



GOOD	GOOD
GEMINI R215	METALITE R255
Aluminum Oxide	Aluminum Oxide
X-Weight Cotton	X-Weight Cotton
Plyweld	Plyweld
Open Coat	Open Coat
	UPC Bar Coded

SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	STD. PKG.	PART #	PART #
3 x 18	36				5		780727 80447
	50	5/25*	076607 49259	076607 00964	10		780727 27994
	80	5/25*	076607 49258	076607 00968	10		780727 27993
	120	5/25*	076607 49256		10		780727 27992
3 x 21	36	5/25*	076607 49266	076607 01741			
	40				10		780727 27927
	50	5/25*	076607 49265	076607 01740	10		780727 27926
	60				10	780727 27925	
	80	5/25*	076607 49264	076607 02064	10		780727 27924
	100	5/25*	076607 49263		10		780727 27923
	120	5/25*	076607 49262	076607 02062	10		780727 27922
	220	5/25*		076607 05287			
3 x 24	36	5/25*	076607 49272	076607 01743	5		780727 81847
	40				10		780727 27937
	50	5/25*	076607 49271	076607 01742	10		780727 27936
	60				10	780727 27935	
	80	5/25*		076607 02067	10		780727 27934
	100	5/25*		076607 02066	10		780727 27933
4 x 24	120	5/25*	076607 49268	076607 02065	10		780727 27932
	36	5/25*	076607 49278	076607 01745	5		780727 80438
	40				10		780727 27947
	50	5/25*	076607 49277	076607 01744	10		780727 27946
	60				10	780727 27945	
	80	5/25*	076607 49276	076607 02069	10		780727 27944
	100	5/25*			10		780727 27943
	120	5/25*	076607 49274	076607 02068	10		780727 27942
	180	5/25*		076607 05285			

*Job Pack packing standards: 5 belts/Job Pack; 5 Job Packs per case. Order by number of packs, in multiples of 5 packs.

Portable Belts for Pneumatic In-Line Drum Sanders



TIER:	BEST	BETTER	GOOD
TRADENAME:	REDHEAT R983	BLUEFIRE R823P	GEMINI R215
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Aluminum Oxide
BACKING:	Y-Weight Polyester	X-Weight Polyester	X-Weight Cotton
JOINT:	Plyweld	Plyweld	Plyweld
GRAIN COATING:	Closed Coat/Supersize	Closed Coat	Open Coat

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #
3-1/2 x 15-1/2	36	10	780727 00783		780727 21997
	60	10	780727 18750		780727 22000
	80	10	780727 18751	780727 53074	780727 21995
	120	10	780727 18753		



A broad selection of sizes and grits for most dimensioning, intermediate grinding and polishing applications.

The belts listed are popular stock sizes, but additional sizes, specifications, and backing materials, are available made-to-order.

Applications:

Benchstand and Backstand Belts: grinding and deburring of all metals, heavy stock removal, blending, dimensioning and shaping, polishing.

Centerless, Conveyor and Platen Belts: intermediate grinding stainless and carbon, moderate-pressure applications, dimensioning and finishing.

Size Range:

1" to 10" wide, 36" to 132" long

Grit Range:

24 – 320

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

Machine Used:



BACKSTAND
BELT GRINDER



BENCHSTAND
GRINDER

Cross Reference Guide

	BEST	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
NORTON	Blaze R980P	RedHeat R983	BlueFire R821P	BlueFire R823P	BlueFire R884P	Gemini R766	Gemini R228
3M	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	747D, 777F, 778F, 784F, 987F, 977F	—	551E	561D	361F, 363F	241D, 251D, 341D
Hermes	CR454, CR456	CN464	—	RB486 X, RB346, RB486	RB48024YX, RB48444Z, RB485Z	RB377XY, SB378, RB34MJ	RB320X, HSB
Klingspor	CS610	CS912	CS411X	CS411X, CS416	CS411	CS412, CS413	CS310
SIA	2515, 2503	—	—	—	2820	—	2918, 2928
VSM	XK875X, XK885Y, XK880Y	XK870X, XK870X	—	ZK713X, KK715X	KK716, ZK713T	LK719X, KK711X	KK511X, KK711

Material-to-Product Recommendation Guide

	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
	Blaze R980P	BlueFire R884P	BlueFire R823P	BlueFire 821P	Gemini R766	Gemini R228
Aluminum		◆	◆		◆	
Cast Iron	◆		◆		◆	
Brass / Bronze		◆	◆		◆	
Die Castings	◆		◆		◆	
Carbon Steel	◆		◆		◆	◆
Glass / Ceramics	◆			◆	◆	
Stainless Steel and Alloys	◆	◆	◆		◆	
Wood		◆			◆	

Grit Selection Recommendation Guide

STOCK REMOVAL	INTERMEDIATE	FINISHING
24 – 50 grit	60 – 100 grit	120 – 320 grit

TECH TIP

Troubleshooting Guide

Problem	Correction	Problem	Correction
Loading	Decrease infeed pressure or belt speed	Belt breakage	Reduce belt tension
Shedding	Reduce applied pressure		Use less aggressive contact wheel
	Use a less aggressive contact wheel		Check tracking mechanism for belts tracking erratically
	Dress contact wheel if worn or damaged		
	Use entire surface of belt		



Best for mild and carbon steel, stainless, cobalt, chrome, inconel, titanium

BLAZE R980P CERAMIC ALUMINA

- Next-generation cooler cutting Norton SG ceramic alumina grain lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, inconel and titanium with better metal integrity
- Durable Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray, and better body retention, resulting in longer life and product consistency
- Lubricating grinding aid coating means cooler cut, burn-free grinding of heat-sensitive materials, minimized loading, and improved part finish and integrity



Exceptional performance, especially on hard-to-grind alloys

REDHEAT R983 CERAMIC ALUMINA

- Premium ceramic abrasive provides sharp cutting, exceptional life and value, especially on hard-to-grind alloys
- "Supersize" grinding-aid for longer life, cooler cut and minimized loading
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency



Better choice for heaviest-pressure applications

BLUEFIRE R821P/R823P/R884P ZIRCONIA ALUMINA

- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive zirconia belts
- Durable resin bond for excellent grain retention and product life
- R821P Y-weight cotton backing provides durability and even wear on coarser grit stock removal applications;
- R823 has flexible X-weight polyester waterproof backing to excel on light- to moderate-pressure, applications
- R884P has a durable Y-weight polyester waterproof cloth backing that excels on medium- to high pressure applications



Good choice for difficult-to-grind materials (aluminum, brass, bronze, stainless, carbon steel, titanium, etc.)

GEMINI R766 ALUMINUM OXIDE

- Premium aluminum oxide abrasive blend is ideal when primary purchasing criteria is a good-performing, economically-priced, general-purpose belt
- Y-weight waterproof polyester backing withstands light- to moderately-demanding applications and provides extended life on dry grinding applications
- Resin bond system provides improved edge retention and 30% plus improvement in life versus key competitors



Good choice for fine grit metalworking blending and polishing where initial price is the main concern

GEMINI R228 ALUMINUM OXIDE

- Premium aluminum oxide abrasive delivers fast initial cut rate
- Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction

1" to 6" wide, 36" to 72" long



TIER:	BEST	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	GEMINI R766	GEMINI R228
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
BACKING:	Y-Weight Polyester	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
OTHER:	Supersize				

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
1 x 42	36	50	662544 76825				780727 91710
	40	50		780727 26905			780727 20910
	50	50	662544 76826 NS	780727 26904		666233 90042	780727 20905
	60	50	699573 45486	780727 26903	780727 28596	666233 34502 NS	780727 20900
	80	50	662610 41539	780727 26902	780727 28594		780727 20895
	100	50	662610 43462		780727 28592		780727 20890
	120	50	662610 38660		780727 28590		780727 20885
	150	50			780727 28588		780727 20880
	180	50			780727 28586		780727 20875
	220	50			780727 00001		780727 20871
	240	50					780727 20870
	320	50					780727 20865
	1-1/2 x 60	36	10	699573 45578			
40		10	636425 95003				
50		10					780727 87807
60		10	699573 45631			666233 90045	
80		10	699573 45579			666233 90046 NS	
100		10			780727 65077		
120		10	662610 56493 NS		780727 26984		
2 x 48	24	10					780727 26130
	36	10	636425 92057	780727 27103		666233 90047	780727 21255
	40	10	699573 45193	780727 27102		666233 90048 NS	780727 21250
	50	10	699573 46716	780727 27101			780727 21245
	60	10	699573 44423	780727 27100	780727 28621	666233 90050	780727 21240
	80	10	699573 45100	780727 27099	780727 28619	666233 90051	780727 21235
	100	10	662610 52522		780727 28617		780727 21230
	120	10	662610 52520		780727 28615		780727 21225
	150	10			780727 28613		780727 23246
	180	10			780727 28611		780727 21223
	220	10			780727 28609		780727 63677
	320	10					780727 46387
	2 x 60	24	10				
36		10	699573 45196			666233 90052	
40		10	699573 94425	780727 27124			780727 21300
50		10					780727 62537
60		10	699573 44901	780727 27122		666233 90055 NS	780727 21290
80		10	636425 92574	780727 27121			780727 21285
100		10					780727 21280
120		10	662610 42738		780727 61958		
150		10					780727 44018
180		10			780727 02695		780727 20441
220		10			780727 06282 NS		780727 44020
240		10					780727 61862
320		10					780727 02825
2 x 72	24	10	662544 33969				
	36	10	699573 45460	780727 27147		666233 90057	780727 21335
	40	10	699573 46729	780727 27146		666233 90058 NS	
	50	10	699573 44966	780727 27145			780727 84894
	60	10	699573 45157	780727 27144	780727 28645	666233 90060 NS	780727 21325
	80	10	699573 44961	780727 27142	780727 28643		780727 21320
	100	10	662610 41897		662610 25537 NS		780727 23235
	120	10	662610 44095		780727 28639		780727 21318
	150	10			780727 61770 NS		780727 61973
	180	10			780727 63853		780727 18488
	220	10			780727 28633		780727 65601
	320	10					780727 21308

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts

Continued

1" to 6" wide, 36" to 72" long *continued*



TIER:	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	BLUEFIRE R884P	GEMINI R766	GEMINI R228
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
BACKING:	Y-Weight Polyester	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
OTHER:	Supersize					

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
2-1/2 x 48	36	10					666233 90061	780727 21540
	50	10		780727 27213				
	60	10					666233 90064	780727 21525
	80	10					666233 90065 NS	780727 21520
2-1/2 x 60	24	10				780727 37759 NS		
	36	10	699573 44963	780727 27235			666233 90066 NS	780727 21610
	40	10	699573 46523	780727 27234			666233 90067 NS	780727 21605
	50	10	699573 45300	780727 27233			666233 90068	780727 21600
	60	10	699573 45002	780727 27232	780727 28692	780727 21383 NS		780727 21595
	80	10	699573 46095	780727 27231	780727 28690		666233 90070	780727 21590
	100	10	662610 41380		780727 68991			780727 21585
	120	10			780727 28686			780727 21580
	180	10			780727 28682			780727 21570
	220	10			780727 78217 NS			780727 21565
4 x 36	36	10						780727 22110
	40	10						780727 22105
	50	10		780727 27475			666233 90073	780727 22100
	60	10			780727 28827		666233 90074	780727 22095
	80	10		780727 27473	780727 28825		666233 90075	780727 22090
	100	10			780727 28823			780727 22085
	120	10			780727 28821			780727 22080
	150	10						780727 22079
	180	10						780727 22075
	240	10						780727 22926
4 x 54	320	10						780727 22071
	36	10						780727 22185
	40	10						780727 22180
	50	10					666233 90078 NS	780727 22175
	60	10	662610 63419 NS	780727 27518	780727 25116 NS			780727 22170
	80	10	699573 45139 NS		780727 82996			780727 22165
	100	10						780727 22160
4 x 60	120	10			780727 28847			780727 22155
	24	10	662544 61488					780727 72342 NS
	36	10	699573 45298			780727 37955		
	40	10	699573 91732					780727 44693
	50	10	699573 46715					780727 61630
	60	10	636425 94485		780727 74790			780727 62861
	80	10	699573 45099		780727 65086			780727 84685
	100	10						780727 63161
120	10	662544 16188		780727 66229			780727 87840	
4 x 72	36	10				780727 25984 NS		
6 x 48	36	10	699573 45143	780727 27698			666233 90081	780727 22590
	40	10		780727 27697			666233 90082	
	50	10		780727 27696			666233 90083 NS	780727 22580
	60	10	699573 44422	780727 27695*	780727 28937*		666233 90084	
	80	10		780727 27694*	780727 28935*		666233 90085	780727 22570
	100	10			780727 28933*			780727 22565
	120	10			780727 28931*			780727 22560
	150	10			780727 70042			780727 22555
	180	10						780727 22550
	220	10						780727 22546
	240	10						780727 22545
	320	10						780727 22543

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts

Continued

1" to 6" wide, 36" to 72" long *continued*

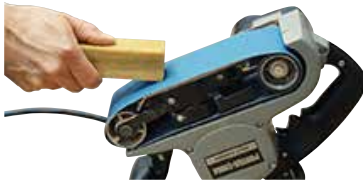


TIER:	BEST	BETTER	BETTER	BETTER	GOOD
TRADENAME:	BLAZE R980P	BLUEFIRE R821P	BLUEFIRE R823P	BLUEFIRE R884P	GEMINI R228
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide
BACKING:	Y-Weight Polyester	Y-Weight Cotton	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
OTHER:	Supersize				

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
6 x 54	60	10				780727 46982 NS	
6 x 60	36	10					780727 22680
	40	10		780727 27762			780727 22679 NS
	60	10	699573 45149	780727 28957*			780727 22665*
	80	10			780727 28955		780727 22660*
	100	10	662544 77452 NS				
120	10					780727 63882	

NS Non-Stock, contact your Norton representative for current order quantities and lead times.
* Std. Pkg. = 20 Belts

Belt Cleaning Stick



- This solid, rubber cleaning stick is designed to remove wood and other non-metallic materials that build up on belt surface during use
- Apply it to the face of the belt, while running, to remove unwanted materials and prolong the overall life of the belt up to 10 times

DESCRIPTION	STD. PKG.	PART #
1-3/8 x 1-3/8 x 6	10	07660 701717

TECH TIP

A light-bodied grease applied to a benchstand belt surface will reduce loading and greatly enhance the belt life and performance when grinding soft, malleable nonferrous materials such as aluminum, brass, bronze and copper.

Take Advantage of FastTrack Service!



For non-stock belts, FastTrack Service offers all the benefits of an ISO 9001 quality manufacturer and the advantages of a coated abrasives express belt service. As the industry's leading producer of abrasive material and backings, our FastTrack service offers an extensive range of Norton made-to-order belts including Blaze ceramic alumina, BlueFire zirconia alumina, and versatile aluminum oxide and silicon carbide belts.

Manufacturing Lead-times:

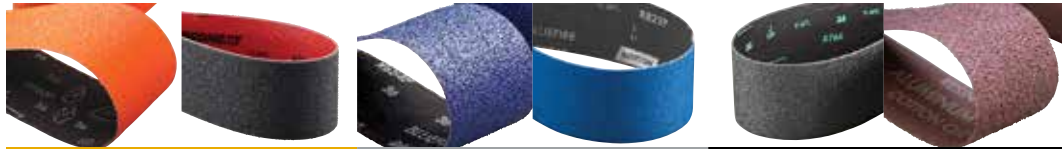
- Narrow belts (1/2" – 12" wide) two days
- Wide belts (14" – 52" wide) three days

Size Availability:

- Maximum width: 52"
- 1/2" and greater widths; 25" and greater lengths

Please see the FastTrack Service Made-to-Order Belts section of this catalog for complete details.

2" to 10" wide, over 70" long



TIER:	BEST	BEST	BETTER	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R980P	REDHEAT R983	BLUEFIRE R884P	BLUEFIRE R823P	GEMINI R766	GEMINI R228
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Zirconia Alumina	Zirconia Alumina	Aluminum Oxide Blend	Aluminum Oxide
BACKING:	Y-Weight Polyester	Y-Weight Polyester	Y-Weight Polyester	X-Weight Polyester	Y-Weight Polyester	X-Weight Cotton
OTHER:	Supersize	Supersize				

SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
2 x 132	36	10		780727 53086	780727 50016		666233 47337	
	40	10			780727 50015		666233 90089 NS	
	50	10		780727 40771	780727 50013			
	60	10			780727 50011		666233 90091 NS	780727 21445 NS
	80	10		780727 01958	780727 50008			780727 21440
	120	10				780727 28662		
3 x 79	50	10	662610 90276					
	60	10			780727 48280			
3 x 90	36	10	699573 46319					780727 85831
3 x 132	24	10			780727 50140			
	36	10	699573 44710	780727 53087 NS	780727 50138		666233 90093	780727 21900
	36	10			780727 50139			
	40	10	699573 44964	780727 01614 NS				
	50	10	699573 44763 NS	780727 03709	780727 50135			780727 21890
	60	10	699573 44958			780727 28794	666233 90096 NS	780727 21885
	80	10	699573 44764			780727 28792		780727 21880
	100	10				780727 28790		
	120	10				780727 28789		780727 21870
	180	10				780727 28785		780727 21860
4 x 79	36	10		662610 22622				
	40	10			780727 74955			
4 x 100	36	10			780727 68679			
4 x 132	24	10			780727 50289 NS			
	36	10	699573 43852	780727 39662	780727 50287		666233 26093	
	40	10					666233 90098 NS	
	60	10			780727 50281			
	80	10			780727 50279			780727 22385
	120	10						780727 22375
6 x 78-3/4	40	10			780727 25150			
6 x 79	36	10			780727 38105			
	80	10			780727 79322			
8 x 107	36	10						780727 22795
	50	10						780727 49887
	60	10						780727 22780*
	80	10						780727 22775*
10 x 70-1/2	36	10						780727 22840
	50	10						780727 22830 NS
	60	10					666233 47345 NS	780727 22825
	80	10						780727 22820

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

* Std. Pkg. = 20 Belts



A small selection of stock products in popular sizes are available for wide belt woodworking and metalworking applications.

Applications: **Metalworking**

Metalworking wide belts are used for plate dimensioning, slag grinding, machining, deburring, and other general metalworking applications. They are usually cloth and are closed coat.

Woodworking

Cloth woodworking wide belts are used for rough stock removal and dimensioning
Paper woodworking belts are used to upgrade the finish on furniture and other wood components.

Size Range:

Stock: 25" – 52" wide, 48" to 103" long

Grit Range:

Stock: 36 – 220

Abrasive Grain:

Zirconia Alumina, Aluminum Oxide

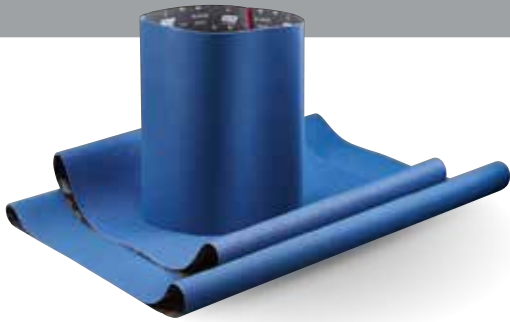
Metalworking Cloth Belt Recommendation Guide/Cross Reference

	TOTAL PERFORMANCE ←					→ INITIAL PRICE		
	BEST		BETTER		GOOD			
	H-wt. Polyester	Y-wt. Polyester	H-wt. Polyester	Y-wt. Polyester	X-wt. Polyester	Y-wt. Polyester	X-wt. Polyester	X-wt. Cotton
NORTON	Blaze R940P	Blaze R980P	BlueFire R840P	BlueFire R887D/R884P	BlueFire R823P	Gemini R766	Gemini R766X	Gemini R228
3M	966F, 984F, 994F, 997F	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	561F	577F, 561D	551E	361F, 363F	353F, 384F	241D, 251D, 341D
Ekamant/ Uneeda	—	PS991, PS992	PZ628	PZ528, PZ633	XZ677	PA631, PG730, PG830	XA911	XA167
Hermes	CB441Z	CR456	SB488YR	RB48624YX, RB48644Z, RB48024YX, RB48444Z, RB485Z	RB486	RB377XY, SB378	RB377XY	RB320X, HSB
Klingspor	—	CS610	CS811	CS409, CS411	CS411X, CS416	CS412, CS413	CS341, CS710	CS310
SIA	—	2515, 2503	C888DP	2803, 2815, 2829, 2824, 2820	—	—	2820	2918, 2928
VSM	XK888Z, XK877Z	XK875X, XK885Y, XK880Y	KK717	KK716	ZK713X, ZK713T, KK715X	LK719X, KK711X	LK719X, KK711X	KK511X

Woodworking Cloth and Paper Belt Recommendation Guide/Cross Reference

	TOTAL PERFORMANCE ←			→ INITIAL PRICE		
	BEST		BETTER	GOOD		
	Y-wt. Cotton	F-wt. Paper	Y-wt. Cotton	X-wt. Cotton	F-wt. Paper	F-wt. Paper
NORTON	Dust-Less R963	Dust-Less H975	BlueFire R831	Gemini R215	Dust-Less H295	Dust-Less H275
3M	960G, 970DZ, 990FZ, 991FZ	966UZ	—	240DZ, 340A, 340D	260UZ	364UZ
Ekamant/ Uneeda	—	—	XZ677	RKX, RKXO	—	ARKFO, EKA1000, EKABlack
Hermes	—	CB115	RB480	RB320	BW114	BW110, BW114, CB115
Klingspor	—	—	C409, CS411	LS309XH	PS22	PS29
SIA	—	—	2803, 2820, 2829	2920, 2928, 2921, 2951	1919	1909, 1918, 1919 CRS, 1993
VSM	XK760X, XK760Y	XP760	KK713X, KK715X	KK504X, KP510E	KK508E	KP709, KP520, KP508E, KP510E

Better choice for all metal and wood applications due to the cut rate and life of the proprietary Norton BlueFire grain



BLUEFIRE R884P/R823P ZIRCONIA ALUMINA CLOTH

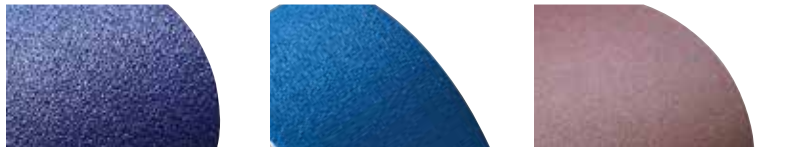
- Strong, self-sharpening zirconia alumina abrasive for fast, aggressive cut and 30% longer life than competitive zirconia belts
- Durable resin bond for excellent grain retention and product life
- R884P has a durable Y-weight polyester waterproof cloth backing that excels on medium- to high pressure metal applications
- R823 has flexible X-weight polyester waterproof backing to excel on light- to moderate-pressure metal applications

Good choice for abrasive planing and dimensioning of glued-up stock and banded particleboard



GEMINI R215 ALUMINUM OXIDE CLOTH

- Premium aluminum oxide abrasive for fast initial cut rate
- Heavy, durable X-weight cotton backing is ideal for heat sensitive applications
- Strong butt joint that allows the belt to be run in either direction



		TIER: BETTER		TIER: BETTER		TIER: GOOD	
		BLUEFIRE R884P		BLUEFIRE R823P		GEMINI R215	
		Zirconia Alumina		Zirconia Alumina		Aluminum Oxide	
		Y-Weight Polyester Cloth		X-Weight Polyester Cloth		X-Weight Cotton Cloth	
		Plyweld, RR		Plyweld, RR		Plyweld, RR	
SIZE (W x L)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
25 x 48	80	3		699573 44781			
25 x 60	80	3		699573 28117			
	120	5		699573 28115			
36 x 75	36	2	699573 50934				
	60	3	699573 50931				
	120	5		699573 29014			
	180	5		699573 44869			
37 x 60	50	3	699573 06219				
	80	3		699573 29019		699573 25709	
	100	5		699573 28103		699573 25708	
	120	5		699573 29018		699573 25707	
	150	5		699573 28102		699573 02955	
	180	5		699573 28101			
	220	5		699573 28100			
37 x 75	36	2	699573 50959				
	50	3	699573 05107				
	80	3	699573 50955			699573 25957	
	100	5				699573 23880	
	120	5		699573 07358		699573 25760	
	150	5				699573 05737	
	180	5		699573 06734			
52 x 75	120	5		699573 13510			

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Due to the wide varieties of machines and applications, the majority of wide belts are non-stock. Our FastTrack belt service is available on the majority of products with 3-day lead-time on orders up to two cases quantity.

TECH TIP

6" wide belts can be used on machines that normally use 37" wide belts.

FastTrack Service Made-to-Order Belts



For many non-stock belts, our FastTrack belt service offers all the benefits of an ISO 9001 quality manufacturer and the advantages of a coated abrasives express belt service. As the industry leader of abrasive belts, our FastTrack belt service has an extensive range of Norton made-to-order belts including Blaze ceramic alumina, BlueFire zirconia alumina, versatile aluminum oxide, and silicon carbide belts.

Manufacturing lead-time is two days for narrow belts (1/2" – 12" wide) and three days for wide belts (14" – 52" wide). Please see the FastTrack belt service chart below for complete details on availability and lead-time.

FastTrack Ordering Quantities and Lead-times

WIDTH*	GRIT SIZE	MINIMUM ORDER QUANTITY	CASE QUANTITY	MAXIMUM ORDER QUANTITY (EQUALS 2 CASES)	CONVERSION LEAD-TIMES
Narrow Belts					
1/2" through 1"	All	50	200	400	2
Over 1" through 5"	All	10	50	100	2
Over 5" through 9"	All	10	20	40	2
Over 9" through 14"	All	10	10	20	2
Wide Belts					
Over 14" through 20"	All	5	10	20	3
Over 20" through 52"	36 & coarser	2	2	4	3
Over 20" through 52"	40-80	3	3	6	3
Over 20" through 52"	100 & finer	5	5	10	3

* FastTrack belt service applies to belts 25" and greater in length. Maximum length for FastTrack belts is 350".

How to Place a FastTrack Belt Order

- Check the FastTrack product availability
- Include a full description of belt: quantity, size, Norton CAP code, and grit size. (FastTrack Service is limited to standard joints and flexes.)
- Send order electronically, fax, or phone to customer service
- When ordering a belt that does not have an existing part number, please call Customer Service to expedite part number creation

TIER	PRODUCT CAP CODE	SHAPE AVAILABILITY	GRIT SIZE	ABRASIVE GRAIN	BACKING	APPLICATIONS
Metalworking						
Best	R980P	Narrow, Wide	24 – 120	Norton Blaze Ceramic Alumina	Y-wt. Polyester	Latest-generation Norton SG grain, supersized and designed for high-performance grinding on stainless and other alloys
Best	R984-NA	Narrow, Wide	36 – 120	Norton SG Ceramic Alumina	Y-wt. Polyester	Norton SG grain for medium-pressure grinding and finishing heat-sensitive alloys
Best	R983	Narrow, Wide	36 – 120	Norton Red Heat Ceramic Alumina	Y-wt. Polyester	High performance grain chemistry, enhanced backing and supersize provide longer life and faster cut for stainless and tough-to-grind alloys.
Better	R884P	Narrow, Wide	24, 36 – 80	Norton BlueFire Zirconia Alumina	Y-wt. Polyester	High-performance zirconia alumina grain designed for medium- to high-pressure grinding
Better	R887D	Narrow, Wide	24, 36 – 120	Norton BlueFire Zirconia Alumina	Y-wt. Polyester	New, significantly improved-performance zirconia alumina grain, supersized and designed for medium- to high-pressure grinding of heat-sensitive alloys
Better	R823P	Narrow, Wide	60 – 220	Norton BlueFire Zirconia Alumina	X-wt. Polyester	High-performance zirconia alumina grain on lighter backing designed for light to medium grinding
Good	R766	Narrow, Wide	P24 – 80	Aluminum Oxide Blend	Y-wt. Polyester	Premium aluminum oxide blend product designed for a variety of applications including soft metals to hard-to-grind stainless and carbon steel
Good	R766X	Narrow, Wide	P60 – P400	Norton Gemini Aluminum Oxide	X-wt. Polyester	Quality, P-graded aluminum oxide and broad grit range for stock removal to finer finishing
Good	MX240	Narrow, Wide	P80 – P150	Aluminum Oxide	X-wt. Poly/Cotton	P-graded, heat-treated aluminum oxide X-weight cloth with strong, but flexible, cotton/polyester backing making it an ideal multi-purpose product
Good	R245	Narrow	P80 – P240, P320, P400	Aluminum Oxide	J-wt. Polyester	Aluminum oxide on flexible, lightweight polyester backing for moderate- to light- pressure applications on mild steel
Good	KF376	Narrow	P80 – P320, P400, P600	Aluminum Oxide	J-wt. Cotton	P-graded, heat-treated aluminum oxide with ceramic coating on a very flexible backing for use wherever flexibility and conformability are needed
Good	R445	Narrow	60 – 220	Silicon Carbide	X-wt. Polyester	Sharp, silicon carbide grain on medium polyester backing for grinding very hard materials – glass, stone, solid surface
Good	U243	Narrow, Wide to 12"	X80, X65, X45, X30, X22, X16	Aluminum Oxide	J-wt. Cotton	High-performance, multi-layered NORaX grain on very flexible backing for dry polishing applications
Woodworking						
Best	R963	Narrow, Wide	24 – 60, P80, 100 – 150	Norton SG Ceramic Alumina	Y-wt. Polyester	Norton SG ceramic alumina grain with anti-static coating for forest product applications (MDF, particleboard, plywood)
Best	R955P	Narrow	P24 – P120	Norton Red Heat Ceramic Alumina	Y-wt. Cotton	100% ceramic alumina abrasive with Y-weight cloth backing for dimensioning, intermediate sanding of wood
Better	R831	Narrow, Wide	24, 36 – 120	Norton BlueFire Zirconia Alumina	Y-wt. Cotton	Norton BlueFire open-coat product recommended for dry low-pressure applications or where loading is a problem
Good	R215	Narrow, Wide	50 – 180	Aluminum Oxide	X-wt. Cotton	Initial starting specification for all woodworking applications where loading is a problem
Good	R464P	Narrow, Wide	P36 – P180	Silicon Carbide	Y-wt. Polyester	Anti-static product for forest product applications (MDF, particle board, plywood) where loading is an issue
Good	R422	Narrow	50 – 120	Silicon Carbide	X-wt. Cotton	Initial starting specification for all woodworking applications where loading is not an issue
Best	H975	Narrow, Wide	60 – 220	Norton Red Heat Ceramic Alumina	F-wt. Paper	Ceramic alumina grain, antistatic coating, and open coat; the best choice for applications where loading is a problem (soft woods, etc.)
Better	H831	Wide	24, 36 – 120	Norton BlueFire Zirconia Alumina	F-wt. Paper	Durable zirconia alumina grain, antistatic coating, and open coat: the better choice for applications where loading is a problem (soft woods, etc.)
Good	H275B	Narrow, Wide	P60 – P220	Norton Adalox Aluminum Oxide	F-wt. Paper	Quality aluminum oxide grain, antistatic coating, and open coat make these an economical choice for all heavy-weight paper belt jobs
Better	H475	Narrow, Wide	P120 – P400	Norton Onyx Silicon Carbide	F-wt. Paper	Sharp silicon carbide and antistatic coating create finer finishes on hard materials and veneers where finish is critical



Norton non-woven belts are a combination of strong synthetic mesh and quality abrasive, bonded together by a smear-resistant adhesive. The open construction of non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

Watch for new and improved narrow belt and file belt joints.

Applications:

Removing surface defects, light edge burrs, parting lines, flashing, rust, oxides, corrosion, paints, and scale; blending mill marks, tool marks, uneven edges, and applying decorative finishes.

Abrasive Grain:

Engineered Aluminum Oxide, Aluminum Oxide

Grit Range:

Extra Coarse (Black), Coarse (Brown), Medium (Maroon), Fine (Green), Very Fine (Blue)

Machine Used:



PORTABLE FILE
BELT SANDER



BELT
SANDER



IN-LINE DRUM
SANDER



BENCHSTAND
GRINDER



BACKSTAND
BELT GRINDER

Application/Grit Recommendation Guide

	EXTRA COARSE	COARSE	MEDIUM	FINE	VERY FINE
	BEST Choice - Vortex Rapid Prep				
	BETTER Choice - Rapid Prep				
Scale Removal	◆				
Stock Removal		◆			
Heavy Deburring		◆			
Light Deburring			◆		
Light Finishing			◆		
Blending				◆	
Finishing					◆

Flex Key

LF: Low Flex; Highest Density; Stiffest

RF: Regular Flex; Low Stretch

XF: Extra Flexible; Low Stretch; Exceptional Conformability

Best choice for finishing and blending applications



VORTEX RAPID PREP ALUMINUM OXIDE

- Patented Vortex grain produces the most consistent cutting and finishing action combining the cutting power of a coarser grit with the finish of finer grits
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a uniformly thick layer of resin bond and grain for extended life, durability, and stiffness
- Proprietary Clean Bond resin technology and open coat guarantee smear-free finishes even on high nickel content alloys and minimize loading on aluminum and other soft metals


Better choice for finishing and blending applications



RAPID PREP ALUMINUM OXIDE

- Premium aluminum oxide abrasive grain coating provides up to 20% higher cut rate versus other surface conditioning belts
- Durable nylon fiber bonded to a strong Y-weight polyester backing with extremely low stretch is ideal for applications where low-stretch and durability are necessary
- Proprietary Clean Bond resin technology and open coat guarantee smear-free finishes even on high nickel content alloys and minimize loading on aluminum and other soft metals

File Belts

																			
GRIT/COLOR:				COARSE				MEDIUM				FINE				VERY FINE			
TIER:				BEST				BEST				BEST				BEST			
TRADENAME:				VORTEX RAPID PREP				VORTEX RAPID PREP				VORTEX RAPID PREP				VORTEX RAPID PREP			
ABRASIVE:				Engineered A/O				Engineered A/O				Engineered A/O				Engineered A/O			
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #		
1/4"	18"	XF	24	66261158548	66261158558	66261158578	66261158583 NS												
1/2"	12"	XF	24	66261158547	66261158555	66261158577 NS	66261158582 NS												
	18"	XF	24	66261158549	66261158561	66261158579	66261158584 NS												
	24"	XF	24	66261158550	66261158565	66261158580	66261158585												
3/4"	18"	XF	12	66261158552	66261158576	66261158581	66261158586												
TIER:				BETTER				BETTER				BETTER				BETTER			
TRADENAME:				RAPID PREP				RAPID PREP				RAPID PREP				RAPID PREP			
ABRASIVE:				Aluminum Oxide				Aluminum Oxide				Aluminum Oxide				Aluminum Oxide			
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #		
1/4	18	XF	24	66261011420	66261012524	66623333424	66623333511												
	24	XF	24	69957392606	66261097565	66623333425	66623333512												
1/2	12	XF	24	66261003177	66261006465	66623318175	66254499884												
	18	XF	24	66261055309	66261055310	66623333426	66261055311												
	24	XF	24	66261055312	66261008972	66254490859	66261019876												
3/4	18	XF	12	66261002111	66261015808	66254490858	66261003622												
	20-1/2	XF	12	662610083899	66261003260		66623333515 NS												
1	18	XF	12	66261007023	66261017898 NS	66623333429	66623333518												
	21	XF	12	66623333412 NS	66623336005 NS	66623333430 NS	66623333519												

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Pump Sleeve Belts

																							
GRIT/COLOR:				EXTRA COARSE				COARSE				MEDIUM				FINE				VERY FINE			
TIER:				BEST				BEST				BEST				BEST				BEST			
TRADENAME:				VORTEX RAPID PREP				VORTEX RAPID PREP				VORTEX RAPID PREP				VORTEX RAPID PREP				VORTEX RAPID PREP			
ABRASIVE:				Engineered A/O				Engineered A/O				Engineered A/O				Engineered A/O				Engineered A/O			
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #						
3-1/2	15-1/2	LF	8	66623333725	66623335042	66623335118	66623333665	66623335139															
3-1/2	15-1/2	RF	8		63642575499	77696045732	66261102432	66261102436															
TIER:				BETTER				BETTER				BETTER				BETTER							
TRADENAME:				RAPID PREP				RAPID PREP				RAPID PREP				RAPID PREP							
ABRASIVE:				Aluminum Oxide				Aluminum Oxide				Aluminum Oxide				Aluminum Oxide							
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #	PART #						
3-1/2	15-1/2	LF	8	66623333595	66261055324	66254444576	66623333452	66261055326															



Narrow Belts



				COARSE	MEDIUM	FINE	VERY FINE
GRIT/COLOR:							
TIER:				BEST	BEST	BEST	BEST
TRADENAME:				VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP	VORTEX RAPID PREP
ABRASIVE:				Engineered A/O	Engineered A/O	Engineered A/O	Engineered A/O
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #
1	132	RF	8	666233 35032	666233 35100	666233 35080	662611 106894
2	48	RF	10	776960 67453	666233 35103	662611 13853	662611 109542
	60	RF	8	666233 33627	636425 54551		666233 33691
	72	RF	8	666233 35036	666233 35105	666233 33653	666233 35134
3	132	RF	6	776960 06299	776960 06300	776960 24093	666233 33692
	132	RF	4	776960 06233	776960 06234	666233 33664	666233 33699
4	36	RF	6				666233 33701
	72	RF	4	699573 70664	699573 09696	780727 43985	
	132	RF	2			666233 33669	
6	48	RF	4	662611 102442	666233 35123		662611 102435
TIER:				BETTER	BETTER	BETTER	BETTER
TRADENAME:				RAPID PREP	RAPID PREP	RAPID PREP	RAPID PREP
ABRASIVE:				Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
WIDTH	LENGTH	FLEX	STD. PKG.	PART #	PART #	PART #	PART #
1	30	RF	12	662610 19801 NS	666233 36006 NS	666233 33431 NS	662610 101972 NS
	42	RF	12		662544 41289 NS	666233 33432 NS	666233 33521 NS
	60	RF	12				662610 55412
	64	RF	12		666233 01513 NS		662610 55413 NS
	72	RF	12	662611 94240	662610 06378 NS	662544 93830 NS	662610 05583
	132	RF	8	666233 14981 NS			
132	RF	10		662610 11414	662544 36886	666233 33525 NS	
1-1/2	60	RF	8	666233 33415 NS	662610 07644 NS		666233 03624 NS
2	34	RF	12	662610 06309 NS		666233 33437 NS	666233 33529 NS
	48	RF	10	662610 06504	662610 06648	666233 33438	666233 33531 NS
	60	RF	8	666233 33416	662611 89669	666233 33439 NS	666233 33532
	72	RF	8	662610 02571 NS	662610 07757 NS	666233 33440	662610 02307
	132	RF	6			662610 69525 NS	666233 33533
2-1/2	60	RF	6	662544 29365	662544 41491	666233 33441 NS	666233 33534
2-3/4	15-1/2	LF	10	666233 33417 NS	666233 33508 NS		666233 33535 NS
3	10-11/16	LF	12	662610 18076 NS	662610 67469 NS	666233 33443 NS	666233 33536 NS
	18	RF	10	662544 96043 NS	662544 28776 NS		662610 19836 NS
	21	RF	10	666233 33418 NS	662610 10870 NS	666233 33445 NS	666233 33537 NS
	24	RF	10	666233 14158 NS		666233 33446 NS	
	72	RF	6	666233 33419 NS	699573 96833	666233 33447	
	80	RF	4	666233 33420 NS	662610 07149 NS		666233 33542 NS
	90	RF	4	666233 33421 NS		666233 33449 NS	666233 33541 NS
	118	RF	4	666233 33422 NS	666233 33510 NS	666233 33450 NS	
	132	RF	4	662544 90470	662610 55322	666233 33451	666233 33543 NS
	24	RF	8	662544 95931 NS	662610 31667 NS		
4	36	RF	6		662610 02321 NS	666233 33454 NS	666233 33546 NS
	132	RF	2	662610 09056	662610 06898	666233 33455 NS	666233 33547
	168	RF	2		662610 09174 NS		666233 33548 NS
6	48	RF	4	662610 55330 NS	662610 55331	666233 33457	662610 55332 NS

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

If you do not see the Rapid Prep belts you need in our stock offering contact your Norton Representative for made-to-order availability.



Engineered for flexibility and fast cutting, cloth sheets and rolls have a longer life than paper. They tear cleanly and straight without shedding and are packed in a protective dispenser to eliminate waste and damage.

Categories:

All purpose, fine finishing, and screen-back

Applications:

Scouring and light deburring, scale and rust removal, blending and fine sanding, polishing lathe turnings, rolls and cylinders, and blending machine tool marks

Size Range:

Sheets: 9" x 11"

Rolls: 1" x 10 yds., 1-1/2" – 2" x 25 yds., 1" – 4" x 50 yds.

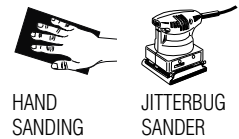
Grit Range:

40 – 600, coarse, medium, fine

Abrasive Grain:

Aluminum Oxide, Silicon Carbide

Machine Used:



HAND
SANDING

JITTERBUG
SANDER

Cross Reference Guide

	GOOD		
NORTON	Gemini K225	Metal R243	Screen-Bak Q421
3M	011K	211K, 314D	481W, 483W
Hermes	RB317	RB232J	GS91350, GS92400
Klingspor	LS309	KL361, LS309	—
Sait/United Abrasives	DA-F	EA-F	Sait-Screen
SIA	2915	2601, 2915, 2936	SIA-Screen
VSM	KK114F	KK505J, KK504X	—

Application/Starting Recommendation Guide

Durability/Stock Removal	Conformability	Waterproof
Fast Cut	Excellent Finish	Load Resistant
Gemini K225	Metal R243	Screen-Bak Durite Q421

Good choice for general-purpose metal and woodworking applications

GEMINI K225 ALUMINUM OXIDE

- Premium P-graded aluminum oxide abrasive for greater cut rate on general purpose metalworking application
- Flexible J-weight backing for superior conformability to complex surfaces and better finishes
- Advanced full resin bond system for exceptional grain adhesion for longer life

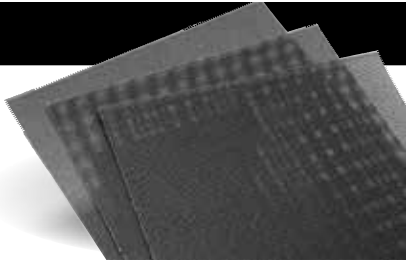
Good choice for small-volume metal and woodworking applications at a low initial price

METAL R243 ALUMINUM OXIDE

- Quality P-graded aluminum oxide abrasive grain delivers fast cut rate and consistent finish on metals
- Smooth, flexible J-weight cotton backing provides superior conformability to complex surfaces and better finishes
- Advanced full resin bond system provides exceptional grain adhesion for longer life on aluminum, fiberglass, composites, hard woods and soft woods



Good choice for sanding softer materials where loading is a major problem such as plastic, copper, brass, plaster, wood, and drywall



SCREEN-BAK Q421 SILICON CARBIDE

- P-graded silicon carbide for excellent cutting and non-loading properties
- Open weave screen for extreme resistance to loading when removing scale, rust and corrosion
- Open mesh design is waterproof and washable, allowing you to rinse and reuse

Cloth and Screen Rolls



		TIER: GOOD	GOOD	GOOD	GOOD	GOOD
		TRADENAME: GEMINI K225	GEMINI K225	GEMINI K225	GEMINI K225	GEMINI K225
		ABRASIVE: Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
		BACKING: J-Weight Cotton	J-Weight Cotton	J-Weight Cotton	J-Weight Cotton	J-Weight Cotton
		SIZE: 1" x 10 yds	1" x 50 yds	1-1/2" x 50 yds	2" x 50 yds	4" x 50 yds
GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
40	1		662610 58716 +	662610 58715 +	662610 58714 +	
50	1		662611 27728 +	662611 27730 +	662611 27732 +	
60	1		662611 27729 +	662611 27731 +	662611 27733 +	
80	1	662611 34298	662611 26276	662611 26288	662611 26299	
100	1	662611 34299	662611 26275	662611 26287	662611 26298	
120	1	662611 34300	662611 26274	662611 26286	662611 26297	662611 27285 *
150	1	662611 34301	662611 26273	662611 26285	662611 26296	
180	1	662611 34302	662611 26272	662611 26284	662611 26295	
220	1		662611 26271	662611 26283	662611 26294	
240	1	662611 34303	662611 26270	662611 26282	662611 26293	
280	1		662611 26269	662611 26281	662611 26292	
320	1	662611 34304	662611 26268	662611 26280	662611 26291	
400	1		662611 26267	662611 26279	662611 26290	
600	1		662611 26266	662611 26278	662611 26289	

+ 40 - 60 grit, are supplied in durable, but flexible X-weight cotton backing

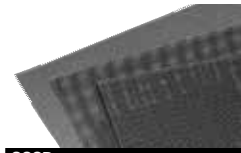
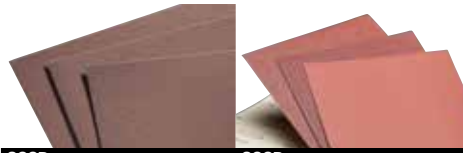
* Packaging Standards: 4" Roll Std. Pkg.: 6 rolls



		TIER: GOOD	GOOD	GOOD	GOOD	GOOD
		TRADENAME: METAL R243	METAL R243	METAL R243	SCREEN-BAK Q421	SCREEN-BAK Q421
		ABRASIVE: Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide	Silicon Carbide
		BACKING: J-Weight Cotton	J-Weight Cotton	J-Weight Cotton	Mesh	Mesh
		SIZE: 1" x 50 yds	1-1/2" x 50 yds	2" x 50 yds	1-1/2" x 25 yds	2" x 25 yds
		OTHER:			Waterproof	Waterproof
GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
60	1	662611 36178	662611 36190	662611 36203		
80	1	662611 36179	662611 36192	662611 36204	662611 07275 *	
100	1	662611 36180	662611 36194	662611 36205		
120	1	662611 36181	662611 36195	662611 36206	662611 07270 *	662611 49811 *
150	1	662611 36182	662611 36196	662611 36207		
180	1	662611 36186	662611 36199	662611 36208	662611 07265 *	
240	1	662611 36187	662611 36200	662611 36209		
320	1	662611 36188	662611 36201	662611 36210		
400	1	662611 36189	662611 36202	662611 36211		

* Packaging Standards: Screen-Bak Q421 Std. Pkg.: 10 rolls

Cloth Sheets



TIER:	GOOD	GOOD
TRADENAME:	GEMINI K225	METAL R243
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
BACKING:	J-Weight Cotton	J-Weight Cotton
OTHER:		

TIER:	GOOD
TRADENAME:	SCREEN-BAK Q421
ABRASIVE:	Silicon Carbide
BACKING:	Mesh
OTHER:	Waterproof

SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PKG./CASE	PART #
9 x 11	40	25/125	66261 058713+			
	50	25/125	66261 101862+			
	60	25/125	66261 101861+			
	80	25/125	66261 126340	66261 179998	25/125	66261 100960
	100	50/250	66261 126339	66261 181503	25/125	66261 100955
	120	50/250	66261 126338	66261 181504	25/125	66261 100950
	150	50/250	66261 126337	66261 181505	25/125	66261 100945
	180	50/250	66261 126336	66261 180005	25/125	66261 100940
	220	50/250	66261 126335		25/125	66261 100935
	240	50/250	66261 126334	66261 181507		
	280	50/250	66261 126333			
	320	50/250	66261 126332	66261 180006	25/125	66261 100920
	400	50/250	66261 126331	66261 181509	25/125	66261 100915
	600	50/250	66261 126330			
	Coarse	25/125				
	Medium	50/250				
	Fine	50/250				

+ 40 - 60 grit are supplied in durable, but flexible X-weight cotton backing





Paper sheets and rolls are engineered for optimum performance when sanding metal, wood, composites and painted surfaces. The sheets are packed in protective packaging to eliminate waste and permit easy, neat storage.

Categories:
Applications:

All purpose, wood sanding, stearated (non-loading), waterproof, and heavyweight
Light-duty metal sanding, primer sanding, defect removal from painted surfaces, filler sanding, sanding and finishing of composites and fiberglass, bare wood sanding, sanding between sealer coats

Size Range:
Grit Range:

Full Sheets, Cut Sheets, File Strips and Rolls
36 – 2500

Abrasive Grain:
Paper Weights:
Machine Used:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide, and Garnet
Heavyweight – E; Lightweight – A through D



HAND
SANDING



JITTERBUG
SANDER



SANDING
BOARD

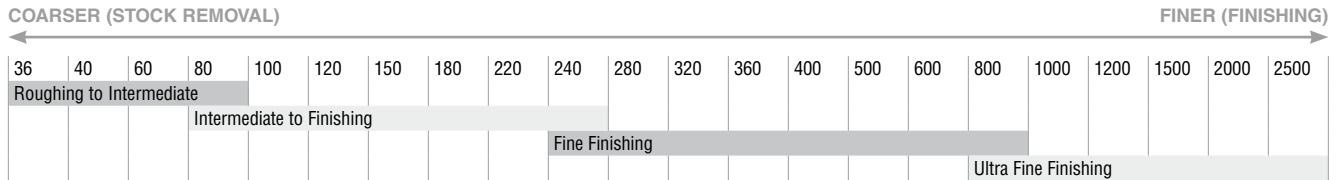
Material-to-Product Recommendation Guide

	BEST			BETTER			GOOD					
	Blaze A995	Dry Ice A975	A2750P	Black Ice T214	Black Ice T401	A259PS	Durite A475	Blue-Bak T414	Gold Reserve A296	Garnet A511, A513, A514	TufBak T461	Other
Unfinished Metal	◆	◆	◆						◆			
Primed / Painted Surfaces / Between Coats	◆	◆	◆				◆		◆			
Fiberglass / Composites	◆	◆	◆				◆		◆			
Bare Wood	◆	◆	◆							◆		
Clear Coat Sanding				◆	◆							
Sealer Sanding	◆	◆	◆				◆		◆			
Lacquer Sanding				◆	◆			◆			◆	
Wet Sanding				◆	◆			◆			◆	
Paint Stripping	◆	◆	◆			◆	◆					
All Purpose	◆	◆	◆			◆						A212, A213, A211

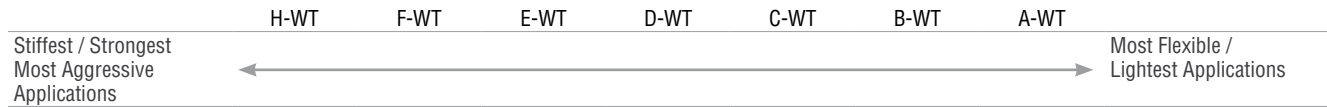
Cross Reference Guide

NORTON	3M	Hermes	Klingspor	Mirka	SIA	VSM
STEARATED (NON-LOADING)						
Blaze A995	732U, 737U, 755L, 775L	CR116	—	—	—	—
Dry Ice A975	334U	—	PS36	—	Siaprime 5550	—
A2750P	216U, 255L, 236U, 260L, 334U	VC154-LL	PS33, PS73W	Q-Silver, Royal Micro	1940, 1944, 1950	—
A259PS	216U, 255L, 236U, 260L, 334U	—	—	—	—	—
Durite A475	405N, 414N, 415U, 426U, 435U	SF168	PL35, PS14	CaratFlex, PolarStar	1748	CP131A
Gold Reserve A296	216U, 236U, 316U, 315U, NX	VC154-LL	PS33, PS73W	Q-Silver, Royal Micro, Bulldog Gold	19,401,950	MP10
WATERPROOF						
Blue Ice T214	213Q	WAFlex28	—	—	1913, 1951, 1600	—
Blue Ice T401	401Q, 414Q, 486Q	WSFlex16	PL35	Waterproof (A)	—	CP918A
Blue-Bak T414	413Q	WSFlex 16	PS14	Waterproof (A)	—	CP918A/C
TufBak T461	431Q	WSFlex 18	PS14	—	1727	CP918A/C
ALL PURPOSE/WOOD						
A211	230U, 240N, 346U	—	—	—	—	—
A212	210N	—	PL31	—	—	—
A213	230N	—	PL31	—	—	—
Garnet A511	110N	—	PS10	—	1400	—
Garnet A513	130N	GCAB	—	—	—	—
Garnet A514	140N	GCAB	—	—	—	—
HEAVYWEIGHT PAPER						
BlueFire H875P	740I, 745I, 750U, 751U, 751I	BW110	PS36	Royal CRS. Cut	1820, 1919, 1948	KP510E, KP709

Application/Grit Recommendation Guide



Recommended Backing Weight



Paper Rolls



Best choice for fast cut rate and maximum dust extraction

BLAZE A995 MULTI-AIR CYCLONIC CERAMIC ALUMINA

- P-graded next-generation ceramic aluminum oxide abrasive for fastest cut rate and longest life with innovative spiral hole design to optimize dust extraction
- Proprietary D-weight Polyester-reinforced, flexible latex-saturated backing for 100% improvement in tear strength and edge durability providing longer life in all applications
- Waterbased, non-loading (No-Fil) stearate resists clogging and increases roll life; hook and loop back for easy mounting and changing



Best choice for the most demanding dry sanding applications

DRYICE A975 CERAMIC ALUMINA

- P-graded, 100% SG ceramic alumina abrasive delivers fastest cut rate and longest life of any paper roll; available in Multi-Air Cyclonic version with laser-cut, spiral, vacuum-hole design to maximizes dust extraction
- Unique fiber reinforced, flexible B-or C- Weight latex saturated paper backing for 50% - 60% improvement in tear strength while retaining flexibility; perforated for easy sizing
- Water-based non-pigmented stearate No-Fil coating provides improved load resistance and no color transfer to work



Better choice for high performance dry sanding applications

A2750P ALUMINUM OXIDE

- Premium P-graded, heat treated, toughened aluminum oxide abrasive delivers superior life, fast cut rate, consistent finish
- Unique fiber reinforced, flexible B-weight latex saturated backing provides 50% - 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil coating provides maximum load resistance; available in Multi-Air Cyclonic version for maximum dust collection



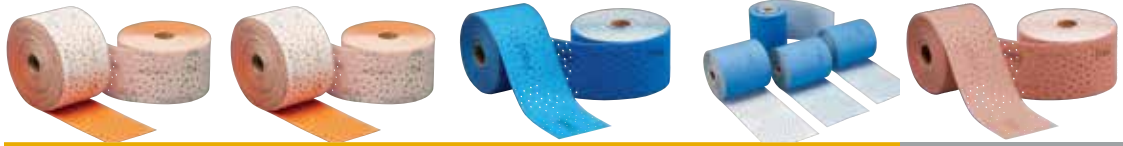
Good choice and value for dry sanding and finishing aluminum, fiberglass, composites, hard woods and soft woods

GOLD RESERVE A296 ALUMINUM OXIDE

- P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent surface finish
- Strong C-weight paper backing resists tearing while staying conformable and flexible
- Water-based, non-loading No-Fil stearate coating minimizes clogging and increases disc life

Paper Rolls *continued*

Hook and Loop
Paper Rolls
Multi-Air
Cyclonic



TIER:	BEST	BEST	BEST	BEST	BETTER
TRADENAME:	BLAZE A995 NO-FIL MULTI-AIR CYCLONIC	BLAZE A995 NO-FIL MULTI-AIR CYCLONIC	DRY ICE A975 NO-FIL MULTI-AIR CYCLONIC	DRY ICE A975 NO-FIL MULTI-AIR CYCLONIC	A2750P NO-FIL MULTI-AIR CYCLONIC
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide
BACKING WEIGHT:	D-Weight.	D-Weight.	C- & B-Weight	C- & B-Weight	B-Weight
BACKING ATTACHMENT:	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop	Hook & Loop
OTHER:	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated	P-Graded; Perforated
SIZE:	2-3/4" x 13 yd	2-3/4" x 9 yd	2-3/4" x 13 yd	4-1/2" x 13 yd	2-3/4" x 13 yd
GRIT	PKG./CASE	PART #	PART #	PART #	PART #
40	1/4		699573 65500		
80	1/4	699573 08899		636425 06113	662611 56064
120	1/4	699573 08900		636425 06114	662611 56065
150	1/4	699573 08901		636425 06117	
180	1/4	699573 08902		636425 06118	662611 56067
220	1/4	699573 08903		636425 06119	636425 04663
240	1/4			636425 06120	662611 56068
320	1/4			636425 06121	662611 56070
400	1/4			636425 06122	662611 56071
500	1/4			636425 06123	
600	1/4			636425 06124	

2-3/4" wide hook and loop paper rolls are perforated at 2-3/4" and 4-1/2" wide rolls are perforated every 4-1/2" which allow use on all standard lengths of hand blocks and file boards. Additional grit sizes available, contact your Norton rep for more details.

Hook and Loop
Paper Rolls



TIER:	BEST	
TRADENAME:	DRY ICE A975 NO-FIL	
ABRASIVE:	Ceramic Alumina	
BACKING WEIGHT:	C- & B-Weight	
BACKING ATTACHMENT:	Hook & Loop	
OTHER:	P-Graded; Perforated	
SIZE:	2-3/4" x 13 yd	
GRIT	PKG./CASE	PART #
80	1/4	636425 06261
120	1/4	636425 06259
150	1/4	636425 06258 NS
180	1/4	636425 06257
220	1/4	636425 06256
320	1/4	636425 06255
400	1/4	666233 29518
500	1/4	666233 29547
600	1/4	666233 29548

2-3/4" wide hook and loop paper rolls are perforated every 2-3/4" which allows use on all standard lengths of hand blocks and file boards.

Additional grit sizes available, contact your Norton rep for more details.

NS Non-Stock, contact your Norton representative for current order quantities and lead times.

Paper Rolls *continued*

PSA (Pressure Sensitive Adhesive) Paper Rolls



TIER:	BEST	BEST	BEST	BETTER	BETTER	BETTER	BETTER	GOOD
TRADENAME:	DRY ICE A975 NO-FIL	DRY ICE A975 NO-FIL	DRY ICE A975 NO-FIL	A275 OP NO-FIL	A275 OP NO-FIL	A275 OP NO-FIL	A275 OP NO-FIL	GOLD RESERVE A296 NO-FIL
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
BACKING WEIGHT:	C-Weight.	C-Weight.	B-Weight.	B-Weight.	B-Weight.	B-Weight.	B-Weight.	C-Weight
BACKING ATTACHMENT:	PSA	PSA	PSA	PSA	PSA	PSA	PSA	PSA
OTHER:	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded	P-Graded
SIZE:	2-3/4" x 25 yd	2-3/4" x 30 yd	2-3/4" x 45 yd	2-3/4" x 25 yd	2-3/4" x 30 yd	2-3/4" x 45 yd	4-1/2 x 10 yd	2-3/4" x 25 yd
GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #	PART #	PART #
80	1/5	662611 49566			662611 31691		662611 31697	636425 06153
100	1/5					662611 31690	662611 31696	
120	1/5		662611 49564			662611 31689	662611 31695	636425 06152
150	1/5			662611 49563			662611 31688	662611 31694
180	1/5			662611 49562			662611 31687	662611 31693
220	1/5			662611 49561			662611 31686	662611 31692
240	1/5						662611 31685	
320	1/5			662611 49558			662611 31683	636425 06148
400	1/5			662611 49557			662611 31681	636425 06147
600	1/5						662611 31679	

Additional attachment options available as non-stock, contact your Norton rep for more details.

Roll Accessories



PSA Roll Dispenser

- Heavy-duty wire dispenser has a vinyl coating to protect the work surface
- Accommodates two 2-3/4" PSA rolls; stackable for multi-grit operations. Attach to wall or mount on cabinet

DESCRIPTION	STD. PKG.	PART #
PSA Roll Dispenser	1	636425 42773

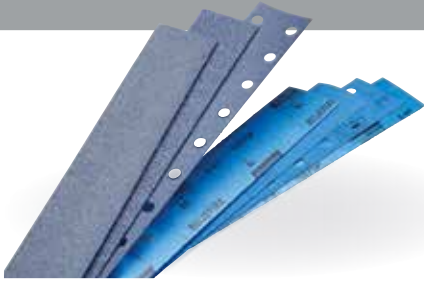
PSA/Block & Loop Sanding Blocks

- Ergonomically-shaped flexible foam blocks used with 2-3/4" rolls, fit comfortably in your hand
- Firm block produces a truly flat surface
- The soft block is designed for flat surfaces and contours

SIZE	DESCRIPTION	BACKING ATTACHMENT: PSA		Hook & Loop
		STD. PKG.	PART #	PART #
2-3/4 x 5	Soft	5	636425 42090	636425 42092
2-3/4 x 5	Firm	5	636425 42091	636425 42093
2-3/4 x 7-3/4	Soft	5		636425 42095
2-3/4 x 7-3/4	Firm	5	636425 42094	

Paper File Strips

Better choice for soft material applications



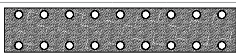
BLUEFIRE H875P ZIRCONIA ALUMINA

- Strong zirconia alumina plus abrasive provides 2 - 3 times life over aluminum oxide products
- Strong E-weight paper, synthetically-coated for excellent durability and chip resistance plus superior bond system optimizes grain adhesion and extends product life
- Non-stearated (no anti-loading agents); non-contamination often required for prime auto and aerospace paint applications

Paper File Strips
PSA (Pressure Sensitive Adhesive)
and Non-PSA

TIER:	BETTER	BETTER	BETTER	BETTER	BETTER	BETTER	BETTER	BETTER	GOOD
TRADENAME:	A2750P NO-FIL	A2750P NO-FIL	A2750P NO-FIL	A2750P NO-FIL	BLUEFIRE H875P NO-FIL	BLUEFIRE H875P NO-FIL	BLUEFIRE H875P NO-FIL	BLUEFIRE H875P NO-FIL	GOLD RESERVE A296 NO-FIL
ABRASIVE:	A/O	A/O	A/O	A/O	Z/A	Z/A	Z/A	Z/A	A/O
BACKING WEIGHT:	B-Weight	B-Weight	B-Weight	B-Weight	E-Weight	E-Weight	E-Weight	E-Weight	C-Weight
BACKING ATTACHMENT:	Non-PSA	PSA	Hook/Loop	Hook/Loop Vac	Non-PSA	PSA	Hook/Loop	Hook/Loop	Hook/Loop
OTHER:	P-Graded	P-Graded	P-Graded	P-Graded					

SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PKG./CASE	PART #	PART #	PKG./CASE	PART #
2-3/4 x 16	100	50/500									662611 31657
	120	50/500									662611 31656
	180	50/500									662611 31654
2-3/4 x 16-1/2	36						50/250		662611 23610	25/125	662611 23616
	40						50/250		662611 23609	25/125	662611 23615
	80	50/500		662611 31640		662611 31646	50/250		662611 23608	25/125	662611 23614
	100	50/500		662611 31639		662611 31645					636425 06237*
	120	50/500				662611 31644					636425 06238*
	150	50/500			662611 31637	662611 31643					636425 06239*
	180	50/500			662611 31636	662611 31642					636425 06240*
	220	50/500				662611 31641					636425 06241*
2-3/4 x 17-1/2	36						50/250	662611 23622			
	40						50/250	662611 23621			
	80	50/500	662611 31652				50/250	662611 23620			
	100	50/500	662611 31651				50/250	662611 26512			
	120	50/500	662611 31650								
	150	50/500	662611 31649								
	180	50/500	662611 31648				50/250	662611 26511			
220	50/500	662611 31647									



VACUUM HOLE PATTERN FOR
2-3/4 X 16 FILE STRIPS
* 25/125

Sanding Boards



PSA/Non-PSA Sanding Board

- This sanding board has a cushioned surface
- Spring clips mounted at each end securely hold 2-3/4" x 16-1/2" PSA file strips and 2-3/4" x 17-1/2" non-PSA file strips



Hook and Loop and Non-PSA Sanding Board

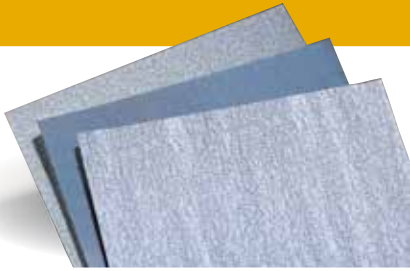
- Lightweight, rugged design for easy sanding of plastic fillers
- Spring clips mounted at each end securely hold 2-3/4" x 16-1/2" hook and loop file strips and 2-3/4" x 17-1/2" non-PSA file strips
- Air file shoe eliminates the need for clips. The quick-change backing positively locks and unlocks for fast use.



DESCRIPTION	STD. PKG.	PART #
PSA/Non-PSA File Strip Sanding Board	6	636425 42724
Hook and Loop/Non-PSA File Strip Sanding Board	5	636425 52836
Hook and Loop Air File Shoe	5	636425 52835

Stearated (Non-Loading) 9" x 11" Sheets

Best choice for moderate material removal



A259PS NO-FIL ALUMINUM OXIDE

- Premium heat-treated abrasive offers faster cut and long sanding life
- Open coat, non-pigmented, water-based stearate coating prevents color transfer and minimizes loading
- Increased backing weight, fiber-reinforcement and latex saturation offers better grain retention and tear-resistance yet is highly flexible for easy folding and unfolding

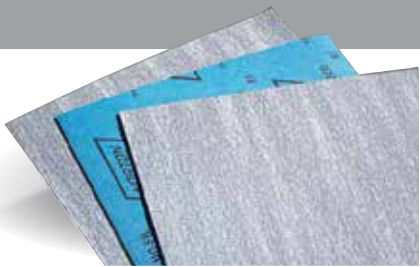
The better choice for sanding painted surfaces, composites, plastics or any material that tends to load



A2750P NO-FIL ALUMINUM OXIDE

- Premium, P-graded, heat-treated aluminum oxide abrasive for consistent surface finish, exceptional performance on all surfaces and coatings
- Unique fiber-reinforced, B-weight latex-saturated backing for 50 - 60 percent improvement in tear strength, exceptional flexibility, can be folded without cracking
- Non-pigmented, water based stearate (anti-clog) coating, open coat for best resistance to clogging and loading during sanding

The better choice for gel coats, hard composite substrates, abrasion-resistant coatings, and woodworking applications



DURITE A475 NO-FIL SILICON CARBIDE

- P-graded, silicon carbide abrasive for easy penetration of the hardest surfaces
- Water based stearate, non-pigmented, No-Fil coating resists loading for the longest usable product life; no color transfer to work
- Fiber-reinforced, latex paper backing provides flexibility and resistance to tearing

Good choice for finishing painted surfaces, composites, plastics, or any material that tends to load

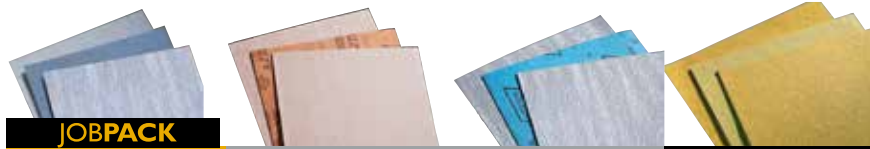


GOLD RESERVE A296 NO-FIL ALUMINUM OXIDE

- P-graded premium aluminum oxide abrasive produces a quick, cool cut and a more consistent scratch pattern
- Water-based, non-loading (No-Fil) stearate resists clogging and increases life
- Strong C-weight latex/paper backing resists tearing while staying conformable and flexible

Stearated (Non-Loading) 9" x 11" Sheets *continued*

9 x 11
Paper Sheets



JOBPACK						
TIER: BEST		BETTER		BETTER		GOOD
TRADENAME: A259PS NO-FIL		A2750P NO-FIL		DURITE A475 NO-FIL		GOLD RESERVE A296 NO-FIL
ABRASIVE: Aluminum Oxide		Aluminum Oxide		Silicon Carbide		Aluminum Oxide
BACKING WEIGHT: C- & B-Weight		B-Weight		B-Weight		C-Weight
OTHER: P-Graded		P-Graded		P-Graded		P-Graded
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #
9 x 11	80	50/250	076607 68174 *	662611 31634	662544 87393	636425 97878
	100	100/500	076607 68173 *	662611 31633	662544 87394	636425 97877
	120	100/500	076607 68172 *	662611 31632	662544 87395	636425 97876
	150	100/500	076607 68171 *	662611 31631	662544 87396	636425 97875
	180	100/500	076607 68168 *	662611 31630	662544 87397	636425 97874
	220	100/500	076607 68167 *	662611 31629	662544 87398	636425 97873
	240	100/500		662611 31628	662544 87399	636425 97872
	280	100/500		662611 31627		
	320	100/500	076607 68166 *	662611 31626	662544 87400	636425 97871
	400	100/500	076607 68165 *	662611 31624		636425 97870
	500	100/500		662611 31623		
	600	100/500		662611 31622		
	800	100/500		662611 31621		
	1000	100/500		662611 31620		
	1200	100/500		662611 31619		
	1500	100/500		662611 31618		

* Packaging Standards: A259PS Job Packs: 20 sheets per pack / 10 packs per standard package for a total of 200 sheets

Rubber Hand Sanding Blocks

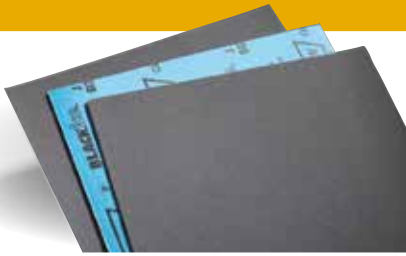
- Resilient rubber blocks that conform well to mild contours and flat surfaces

DESCRIPTION	STD. PKG.	PART #
2-3/4 x 5	5	076607 01889



Waterproof 9" x 11" Sheets

Best choice for superior cut and life in wet applications



BLACK ICE T214 ALUMINUM OXIDE WATERPROOF

- Premium, P-graded, heat-treated aluminum oxide abrasive for ultimate cut and life in wet applications
- Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling

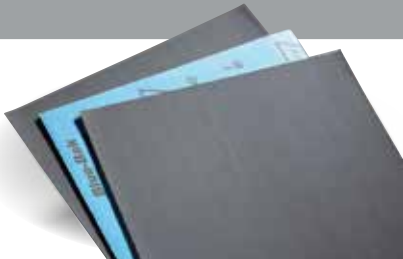
Best choice for superior finish in wet applications



BLACK ICE T401 SILICON CARBIDE WATERPROOF

- Premium, JIS graded ultra-fine silicon carbide abrasive provides the ultimate finish in wet applications
- Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling

Better choice for wet finishing applications



BLUE-BAK T414 SILICON CARBIDE

- Sharp, ANSI graded silicon carbide abrasive for exceptional finishes in wet applications
- Strong resin bond for longer life in wet applications
- High-strength B-weight waterproof latex paper backing is extremely flexible, environmentally stable, and resists humidity-caused curling

Good choice for medium material removal in wet applications

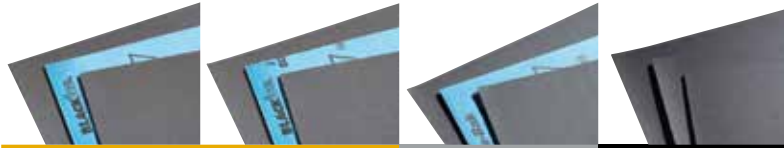


TUFBAK T461 SILICON CARBIDE

- ANSI graded silicon carbide abrasive for fast cutting with excellent finish in wet applications
- Advanced resin bond system for excellent flexibility and abrasive adhesion
- Strong, waterproof C-weight backing is ideal for more aggressive applications while being environmentally stable, resists product curl in humidity

Waterproof 9" x 11" Sheets *continued*

9 x 11
Paper Sheets



		BEST		BETTER		GOOD	
		BLACK ICE T214		BLACK ICE T401		BLUE-BAK T414	
		Aluminum Oxide		Silicon Carbide		Silicon Carbide	
		B-Weight		B-Weight		C-Weight	
		P-Graded		JIS Graded		ANSI Graded	
SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #
9 x 11	60	50/250					662611 01175
	80	50/250					662611 01170
	100	50/250					662611 01165
	120	50/250					662611 01160
	150	50/250					662611 01155
	180	50/250					662611 01150
	220	50/250		662611 39389		662611 39367	
	240	50/250		662611 39388		662611 39366	662611 30331
	280	50/250				662611 39365	
	320	50/250		662611 39386		662611 39364	662611 30332
	360	50/250				662611 39363	
	400	50/250		662611 39385		662611 39362	662611 30333
	500	50/250		662611 39384		662611 39361	
	600	50/250		662611 39383		662611 39360	662611 30334
	800	50/250		662611 39382			
	1000	50/250			662611 39381		
	1200	50/250			662611 39380		
	1500	50/250			662611 39379		
	2000	50/250			662611 39378		
	2500	50/250			662611 39377		

Waterproof Sanding Blocks – with “Grabbing” Power



Dual Density Wet Sanding Block

- No adhesive required: simply wrap a 5-1/2" x 9" (9" x 11" cut in half) sheet around the block
- The dense side is for more aggressive blocking, while the soft side is for color sanding
- Equalizes sanding pressure for fine grit applications

Holey Block

- No adhesive required: simply wrap a 5-1/2" x 9" (9" x 11" cut in half) sheet around the block
- A rugged, semi-rigid, multi-purpose sanding block engineered for flat to medium curved surfaces
- A tactical hole pattern side provides numerous cutting edges to create a 30% faster cut rate
- The plain side provides firmness and a comfortable, easy-to-hold surface

DESCRIPTION	STD. PKG.	PART #
Wet Sanding Block	12	636425 03728
Holey Block	8	636425 03729

All-Purpose 9" x 11" Paper Sheets

Good choice for your wood, metal or composite sanding projects



A211/A212/A213 ALUMINUM OXIDE

- P-graded, aluminum oxide grain, open-coat provides aggressive, long-lasting cutting action
- Use for dry, general purpose hand sanding on hardwood, metal, and composites
- Available in multiple backing weights: A212 A-weight; A213 C-weight, A211 D-weight

Good choice for use on soft woods such as pine



A513/A511 GARNET

- Natural garnet abrasive is ideal for soft woods, such as pine, and produces an excellent, consistent finish
- Use dry on bare wood prior to coating
- Available in two backing weights: A511 A-wt. and A513 C-wt. for heavy-duty to light-duty hand sanding

9 x 11
Paper Sheets



TIER:	GOOD	GOOD	GOOD	GOOD	GOOD	GOOD	GOOD
TRADENAME:	A211	A213	A212	JOBPACK MULTISAND A213/A212	A513	A511	JOBPACK WOODSAND A513/A511
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Garnet	Garnet	Garnet
BACKING WEIGHT:	D-Weight	C-Weight	A-Weight	D-, C- & A-Weight	D- & C-Weight	A-Weight	D-, C- & A-Weight
OTHER:	P-Graded	P-Graded	P-Graded	P-Graded			

SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #	PART #	PART #	PART #	PART #	PART #
9 x 11	36	25/125	662611 00335						
	40	25/125	662611 00330						
	50	50/250	662611 00325						
	60	50/250		662611 00320			662611 01560		
	80	50/250		662611 00315			662611 01555	662611 01505	076607 01584*
	100	100/500		662611 00295		076607 00358*	662611 01535	662611 01500	076607 01583*
	120	100/500		662611 00290		076607 00357*	662611 01530	662611 01495	076607 01582*
	150	100/500		662611 00285		076607 00356*	662611 01525	662611 01490	076607 01581*
	180	100/500			662611 00245	076607 00355*		662611 01489	076607 01580*
	220	100/500			076607 00156	076607 00354*		662611 01488	076607 01579*
	Asst+	100/500				076607 00365*			

* Packaging Standards: Job Packs: 25 sheets per pack / 10 packs per standard package for a total of 250 sheets
+ Assorted contains 6 each of 60, 100, 150 grit and 7 each of 220 grit

3-2/3 x 9
Paper Cut Sheets



TIER:	GOOD	GOOD
TRADENAME:	GOLD RESERVE A296 NO-FIL	A213
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
BACKING WEIGHT:	C-Weight	C-Weight
OTHER:	P-Graded	P-Graded

SIZE (W x L)	GRIT	PKG./CASE	PART #	PART #
3-2/3 x 9	60	100/100		662611 02925
	80	100/100	780727 48788	662611 02920
	100	100/100		662611 02900
	180	100/100	780727 48540	
	220	100/100	780727 48789	

Hook and Loop Cut Sheets - Perforated

Best choice for easy sanding of hard-to-reach areas

NORTON SUPERFLEXIBLE FILM

- Durable yet flexible film backing conforms better to surfaces and contours, preventing "over sanding" or "burn through"
- Anti-loading stearate for optimum performance and long life
- Consistent scratch pattern and even finish



TIER: **BEST**

TRADENAME: **SUPERFLEXIBLE**

ABRASIVE: Aluminum Oxide

BACKING WEIGHT: 3 mil Polyester Film

OTHER: P-Graded

SIZE (D)	GRIT	PKG./CASE	COLOR	PART #
6-11/16 x 5-1/8	P1500	25/100	Rose	666233 90555
	P1200	25/100	Amber	666233 90554
	P800	25/100	Citrine	666233 90552
	P600	25/100	Turquoise	666233 90551
	P400	25/100	Sapphire	666233 90550

Norton Sanding Pads for SuperFlexible Film

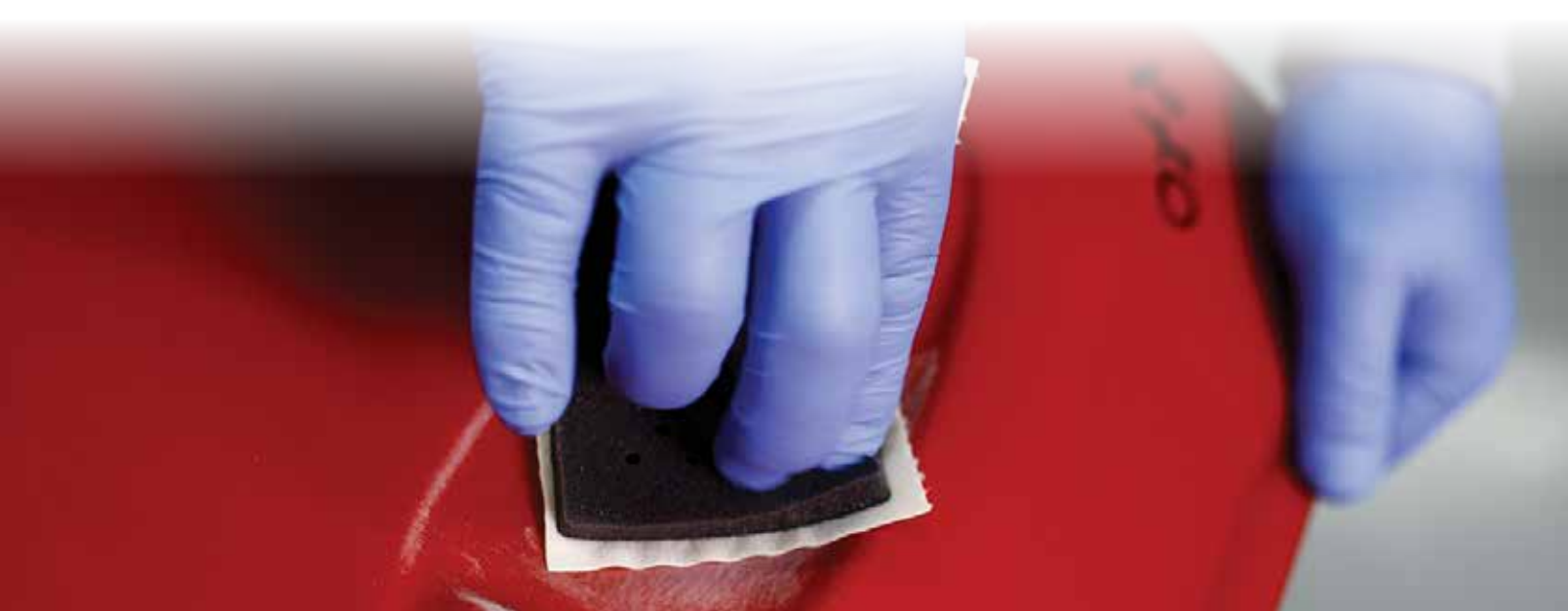
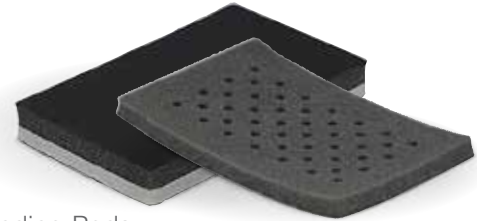
The pads are made using very soft foam, specifically for hook and loop sheets and discs. The sanding pad's structure minimizes aggressive scratches and reduces peeling, reducing the need to change the backing pad frequently.

Soft Sanding Pads

PART #	APPLICATION	PKG/CS QTY
Soft Sanding Pad		
780727 42353	Manual sanding of hard-to-reach areas	8/1

Rigid/Soft Sanding Pads

PART #	APPLICATION	PKG/CS QTY
Rigid/Soft Sanding Pad		
780727 42355	Manual sanding of larger areas	4/1





Surface finishing rolls are made of a non-woven nylon web impregnated with abrasive grain and resin bond.

Applications:

Light- to heavy-duty cleaning, deburring, blending, polishing, and finishing of metal, wood, composite, plastics, stone, solid surface and painted surfaces.

Abrasive Grain:

Aluminum Oxide, Silicon Carbide

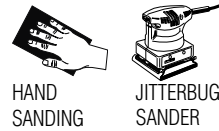
Grit Range:

Medium (M), Fine (F), Very Fine (VF), Ultra Fine (UF), Micro Fine (MF)

Roll Features:

- Economical alternative to cut pads
- Can be cut to specific sizes

Machine Used:



HAND
SANDING

JITTERBUG
SANDER

Application/Grit Recommendation Guide

MORE AGGRESSIVE, ROUGHER FINISH

LESS AGGRESSIVE, FINER FINISH



	#740	#644	#747	#635	#851	#777	HIGH STRENGTH
PRODUCT #:	#740	#644	#747	#635	#851	#777	HIGH STRENGTH
COLOR:	Dark Tan	Maroon	Maroon	Gray	Gray	Maroon	Maroon
DESCRIPTION:	Heavy Duty	GP – Fine	GP Plus – Very Fine	Clean & Finish	General Cleaning	General Purpose	High Strength
ABRASIVE:	AO	AO	AO	SC	SC	AO	AO
GRIT SIZE:	Medium 100 - 150	Fine 180 - 220	Very Fine 240 - 360	Ultra Fine 400 - 600	Very Fine 240 - 360	Very Fine 240 - 360	Medium 100 - 150
STEEL WOOL EQUIVALENT:	4 Extra Coarse	2 Medium Coarse	1 Medium	00 Very Fine	00 Very Fine	1 Medium	4 Extra Coarse
APPLICATIONS:	<ul style="list-style-type: none"> • Smear-free Clean Bond technology • 2X life • Most durable and aggressive cutting pad • Heavy-duty removal <ul style="list-style-type: none"> » rust » oxidation • Deburring 	<ul style="list-style-type: none"> • Cleaning and deburring <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Light cleaning, deburring and finishing <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Light cleaning and finishing of most surfaces <ul style="list-style-type: none"> » steel, aluminum » denibbing plastic » scuffing acrylics 	<ul style="list-style-type: none"> • Light cleaning and finishing of most surfaces <ul style="list-style-type: none"> » steel, aluminum » denibbing plastic » scuffing acrylics 	<ul style="list-style-type: none"> • Light cleaning, deburring and finishing <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Moderate deburring and surface blending

SIZE (W x L)	COLOR	DESCRIPTION	ABRASIVE	GRIT SIZE	STD. PKG.	TIER: BEST BETTER	
						PART #	PART #
Non-Woven Rolls							
4" x 30 Ft.	Maroon	High Strength Roll	A/O	M	3	662610 06358 NS	
	Dark Tan	740 Heavy-Duty Roll	A/O	M	3		662610 10081
	Maroon	644 General Purpose Fine Roll	A/O	F	4		662610 58364
	Maroon	High Strength Very Fine Roll	A/O	VF	4	662610 06373	
	Maroon	777 General Very Fine Roll	A/O	VF	4		662610 58361
	Maroon	747 General Purpose Plus Roll	A/O	VF	4		662610 51701
	Gray	851 General Cleaning Roll	S/C	VF	4		662610 58360
	Gray	635 Clean & Finish Roll	S/C	UF	5		662610 58357
6" x 30 Ft.	Maroon	High Strength Roll	A/O	M	2	662610 05182	
	Maroon	747 General Purpose Plus Roll	A/O	VF	3		662610 16430
	Maroon	High Strength Very Fine Roll	A/O	VF	3	662610 04281	
	Maroon	777 General Very Fine Roll	A/O	VF	3		662610 58376
	Gray	851 General Cleaning Roll	S/C	VF	3		662610 58377
2" x 15 Ft. Handy Roll Pack	Assorted	1 each A/O Fine, A/O VF, SC MF	–	–	1		662610 08108

NS Non-Stock, contact your Norton representative for current order quantities and lead times.



Flexible, abrasive sanding sponges for a wide variety of curved, contoured or flat surface applications on wood, metal, paint, plastic, ceramics and drywall.

Applications:

Light stock removal, sanding sealer and wash-coats, touch-up or repair of primer, sanding contours and intricate shapes, and finishing

Benefits:

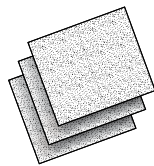
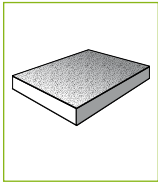
- Can be used wet or dry
- Clog resistant, washable, reusable
- Easy to use, can be folded without cracking
- Conformable
- Generate a consistent surface finish

Machine Used:



HAND
SANDING

Why Choose Abrasive Sponges Versus Conventional Sheets?



Eliminate Clogging

- The combination of flexible foam backing material and abrasive grit adhesion continually releases sanded material
- Any clogging can be washed out

Pressure Control

- Foam backing allows optimum pressure distribution to prevent sanding through surfaces
- Pressure spots are eliminated providing even surface pattern

Adapt to Contours

- Flexible foam allows adaptability to contours, shapes or areas of limited access
- No folding or buckling results in an even pattern without scratching

Surface Finishing Chart – Contour Sponges versus Sheets

	← COARSER → FINER →												
SHEETS	P150	P180	P220	P280	P320	P400	P500	P600	P800	P1000	P1200	P1500	P2000
SPONGES	Medium 60		Fine 100		Extra Fine 150		Super Fine 180		Ultra Fine 220		Micro Fine 280/320		

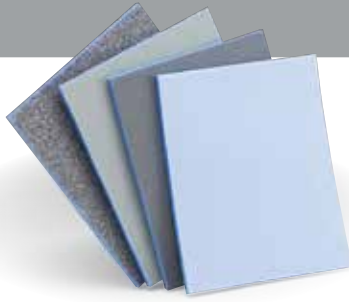
Surface Finishing Chart – Sponges versus Sheets

	← COARSER → FINER →													
SHEETS	P80	P100	P120	P150	P180	P220	P280	P320	P400	P500	P600	P800	P1000	P1200
SPONGES	Extra Coarse 36		Coarse 60		Medium 80 - 120		Fine 120 - 150		Very Fine 180 - 220				Micro Fine 280 - 320	

Cross Reference Guide

	BETTER	GOOD	GOOD	GOOD	GOOD	GOOD
NORTON	SoftTouch	Contour	Small Area	Profile	Sealer Sanding	Flexible
3M	Softback	Contour	Full Size	High Flexibility	Woodworking	Pro Pads
Hermes	Single Side	–	Four Sided	–	Two Sided	–
Klingspor	–	–	–	–	Foam Sanding Pad	–
SIA	Flat Pad	–	Standard Block	–	Standard Pad	–

For hand-sanding or finishing flat, curved, contoured and hard-to-reach areas on wood, metal, composites, paint and solid surfaces



SOFTTOUCH CONTOUR SPONGES – COATED 1 SIDE

- Superior flexibility
- Premium foam substrate provides for an extremely smooth and uniform sanded surface

SIZE (W x L x T)	GRIT	STD. PKG.	PART #
4-1/2 x 5-1/2 x 3/16	60 Medium	80	076607 03074
	100 Fine	80	076607 03075
	180 Super Fine	150	076607 03076
	220 Ultra Fine	80	076607 03077
	280 Micro Fine	80	076607 03078

Good for sanding small diameters and contours

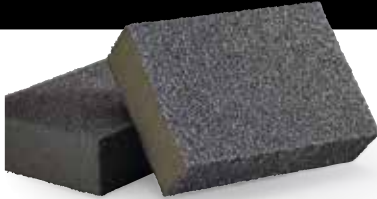


CONTOUR SPONGES – COATED 1 SIDE

- Thin, flexible; good for sanding small diameters and contours such as ceramics, spindles, turnings and railings

SIZE (W x L x T)	GRIT	STD. PKG.	PART #
4-1/2 x 5-1/2 x 3/16	100 Fine	100	076607 02257
	150 Extra Fine	100	076607 02256
	220 Ultra Fine	100	076607 02255

Good for a wide variety of materials and sanding applications where moderate flexibility is needed



SMALL AREA GENERAL PURPOSE SPONGES – COATED 4 SIDES

- Medium to firm density open cell polyurethane foam provides uniform support and moderately aggressive cutting action while generating a smooth surface

SIZE (W x L x T)	GRIT	STD. PKG.	PART #	BULK PKG.	PART #
4 x 2-3/4 x 1	36/80	24	076607 49505	250	076607 04735
	Ex. Coarse/Med				
	80/80	24	076607 49507	250	076607 01875
	Med/Med				
	80/120	24	076607 49504	250	076607 02600
	Med/Fine				
	120/120	24	076607 49506		
	Fine/Fine				

Good for corners and flat surfaces on wood, metal, plastic and paint

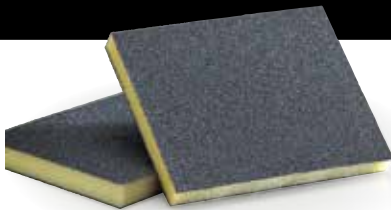


PROFILE SPONGES – COATED 3 SIDES

- Ideal for cabinet sanding of raised profile doors

SIZE (W x L x T)	GRIT	STD. PKG.	PART #
4 x 2-3/4 x 1/2	100 Medium	500	636425 36313

Good for sanding primers, sealers and between coats on furniture and cabinets



SEALER SANDING SPONGES – COATED 2 SIDES

- Very flexible; silicon carbide abrasive for sanding primers, sealers and between coats on furniture and cabinets

SIZE (W x L x T)	GRIT	BULK PKG.	PART #
4-3/4 x 3-3/4 x 1/2	36 Extra Coarse	250	636425 02538
	60 Coarse	250	636425 52870
	100 Medium	250	636425 52869
	220 VeryFine	250	636425 52868

Ideal for final sanding of surfaces, primer sanding, and between coats sanding



FLEXIBLE ABRASIVE SPONGES – COATED 1 SIDE

- Best initial price point for abrasive sponges

SIZE (W x L x T)	GRIT	STD. PKG.	PART #	BULK PKG.	PART #
3 x 4 x 1/2	60 Coarse	48	076607 04068	108	076607 01110
	80 Medium	48	076607 04067	108	076607 04070
	100 Medium	48	076607 04066	108	076607 00950
	150 Fine	48	076607 04065	108	076607 00949
	220 Very Fine			108	076607 04069

Non-Woven Hand Pads and Sponges



Surface finishing hand pads are made of a non-woven nylon web impregnated with abrasive grain and resin bond.

Applications: Light- to heavy-duty cleaning, deburring, blending, polishing, and finishing of metal, wood, composite, plastics, stone, solid surface and painted surfaces.

Abrasive Grain: Aluminum Oxide, Silicon Carbide
Grit Range: Medium (M), Fine (F), Very Fine (VF), Ultra Fine (UF), Micro Fine (MF), Non-Abrasive (-)

Hand Pad Features:

- Flexible; conform to work surface
- Gentle action easily removes flashing or burrs without affecting dimension of workpiece
- Non-loading; constant supply of new cutting edges
- Non-rusting; no workpiece contamination
- Resilient construction; long life, increased productivity; solvent resistant; waterproof

Sponge Pad Features:

- Non-woven material is laminated to a long-lasting sponge for the convenience of 2 pads in one
- Superior replacement for steel wool

Machine Used:



HAND
SANDING



JITTERBUG
SANDER

Application/Grit Recommendation Guide

	MORE AGGRESSIVE, ROUGHER FINISH							LESS AGGRESSIVE, FINER FINISH			
PRODUCT #:	#740	#746	#644	#747	#796	#635	#748	THIN-FLEX VF	THIN-FLEX UF	THIN-FLEX BP	#456
COLOR:	Dark Tan	Gray	Maroon	Maroon	Green	Gray	Gray	Maroon	Gray	Gold	White
DESCRIPTION:	Heavy Duty	Blending	GP - Fine	GP Plus - Very Fine	Scouring	Clean & Finish	Final Shine	Cleaning	Cleaning	Blend Prep	Cleaning
ABRASIVE:	AO	SC	AO	AO	AO	SC	SC	AO	SC	AO	Non-Abrasive
GRIT SIZE:	Medium 100 - 150	Medium 100 - 150	Fine 180 - 220	Very Fine 240 - 360	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro Fine 800 - 1200	Very Fine 240 - 360	Ultra Fine 400 - 600	Micro-Fine 800 - 1200	Non-Abrasive ----
STEEL WOOL EQUIVALENT:	4 Extra Coarse	3 Coarse	2 Medium Coarse	1 Medium	0 Fine	00 Very Fine	00 Very Fine	00 Very Fine	000 Extra Fine	000 Extra Fine	0000 Super Fine
APPLICATIONS:	<ul style="list-style-type: none"> • Smear-free Clean Bond technology • 2X life • Most durable and aggressive cutting pad • Heavy-duty removal <ul style="list-style-type: none"> » rust » oxidation • Deburring 	<ul style="list-style-type: none"> • Blending and deburring <ul style="list-style-type: none"> » welds » aluminum » stainless 	<ul style="list-style-type: none"> • Cleaning and deburring <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Light cleaning, deburring and finishing <ul style="list-style-type: none"> » machinery » metal parts » plastic » solid surface » stone 	<ul style="list-style-type: none"> • Removing stains, marks, rust, corrosion or oxidation from stainless equipment • Light cleaning of metal surfaces 	<ul style="list-style-type: none"> • Light cleaning and finishing of most surfaces <ul style="list-style-type: none"> » steel, aluminum » denibbing plastic » scuffing acrylics 	<ul style="list-style-type: none"> • Final finishing <ul style="list-style-type: none"> » final rub on wood » final blend on metal » final finish on plastics and acrylics 	<ul style="list-style-type: none"> • Maximum flexibility for consistent finishes • Cleaning, blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	<ul style="list-style-type: none"> • Maximum flexibility for consistent finishes • Cleaning, blending, finishing, and deburring in woodwork, metalwork, MRO, and synthetic applications 	<ul style="list-style-type: none"> • Fine cleaning <ul style="list-style-type: none"> » Fine polishing (most surfaces) » Top coat finishing (water-based and solvent) 	<ul style="list-style-type: none"> • Scratch-free cleaning <ul style="list-style-type: none"> » metal » fiberglass » stone » solid surface » ceramic • Wood <ul style="list-style-type: none"> » high-lighting » rubbing

Cross Reference Guide

	COARSER							FINER		
NORTON	#740	#746	#644	#747/847	#796	#635	#748	Thin-Flex VF	Thin Flex UF	#456
3M	7440	7446	64659	7447/8447 Production Hand Pad	96	64660	7448	Multi-Flex Maroon	Multi-Flex Gray	7445
Camel	Tan	—	—	Maroon	Green	—	Gray	—	—	White
Mirka	—	—	—	Maroon/Red VF	—	—	—	Mirlon Total Maroon	Mirlon Total Gray	—
Sait	Brown	—	—	Maroon	Green	—	Gray	—	—	—
SIA	6912 Brown	6712 Grey	—	6912 Maroon	6312 Green	—	—	—	—	—
Standard	HD-Tan AO	—	—	GP-Maroon VF	Green-AO	HP-VF	UF Gray	—	—	Cleaning White

SIZE (W x L)	COLOR	DESCRIPTION	ABRASIVE	GRIT SIZE	STD. PKG.	TIER: BEST	BETTER
						PART #	PART #
Hand Pads							
4-1/2 x 9	Maroon	Thin Flex Cleaning Pad	A/O	VF	25	666233 98062	
	Grey	Thin Flex Cleaning Pad	S/C	UF	25	666233 98063	
6 x 9	Dark Tan	740 Heavy-Duty Pad	A/O	Med	40	662610 74000	
	Gray	746 Blending Pad	S/C	Med	40		662610 74600
	Maroon	777 General Purpose Very Fine Pad	A/O	VF	60		662610 77700
	Maroon	747 General Purpose Plus Pad	A/O	VF	60	662610 74700	
	Maroon	847 General Purpose Plus Perforated Pad	A/O	VF	60	662610 84700	
	Green	796 Scouring Pad	A/O	VF	60		662610 79600
	Lt. Green	696 Food Pro Pad	A/O	VF	60		662610 69600
	Gray	851 General Cleaning Pad	S/C	VF	40		662610 85100
	Gray	635 Clean & Finish Pad	S/C	UF	60		662610 63500
	Gray	748 Final Shine Pad	S/C	MF	60		662610 74800
	White	456 Cleaning Pad	None	-	60		662610 45600
Hand Pad Holder							
3-1/4 x 5-1/2	N/A	Hand Pad Holder			10		662610 47583



Hand Pad Holder



THIN and FLEXIBLE: Perfect for Tight Spots

Norton Bear-Tex Thin-Flex High-Performance Hand Pads

- Achieve performance benefits of a coarse and fine grain product in one hand pad; fast cut and definitively better finish than competing pads
- Extremely thin and conformable; ideal for deburring, cleaning, blending, and finishing contoured surfaces and tight spaces
- Special coated web design for superior and constant cutting action without added effort from user
- Versatile; ideal for woodworking, metalworking, maintenance operations, and synthetics fabrication

Rotolo Foam Sanding Pads

Application/Grit Recommendation Guide

← COARSER												FINER →														
120	150	180	220	240	280	320	400	500	600	800	1000	120	150	180	220	240	280	320	400	500	600	800	1000			
Cleaning/Repairing			Final Sanding			Feather Edging			Basecoat Sanding			Clearcoat Sanding														

The better choice for fine sanding flat and curved surfaces



A2750P NO-FIL ROTOLO FOAM ROLLS

- Premium, P-graded, heat-treated aluminum oxide abrasive for consistent surface finish, exceptional performance on all surfaces and coatings
- Foam backing is perfect for hand sanding primer without leaving finger marks; 50% – 60% improvement in tear strength versus conventional paper rolls; perforated for easy sizing
- Non-pigmented, water-based stearate No-Fil coating, open coat for best resistance to clogging and loading during sanding

TIER: **BETTER**
 TRADENAME: **A2750P ROTOLO**
 ABRASIVE: Aluminum Oxide
 OTHER: P-Graded

SIZE (W x L)	GRIT SIZE	ROLLS/STD. PKG.	PART #
4-1/2" x 82"	120	2	780727 35316
	150	2	780727 57584
	180	2	780727 57599
	220	2	780727 57600
	320	2	666233 57606
	400	2	666233 57608
	500	2	666233 57611
	600	2	666233 57612
	800	2	666233 57613
	1000	2	666233 57616

Perforated every 5-1/2"



Flexible Diamond-Coated Hand Pads

Norton flexible diamond coated hand pads combine the durability and aggressiveness of diamond, with a flexible backing.

Applications:

Diamond coated hand pads: shaping, rapid stock removal, touch-up and repair on ceramics, stone, marble, glass, composites and hard materials; polishing of dies and molds
Quadroflex diamond hand pads: surface conditioning, repairs, and removing flash and burrs on aircraft composites and windmill blades

Size Range:

3-1/2" x 2-1/8"

Grit Range:

60 – 1500

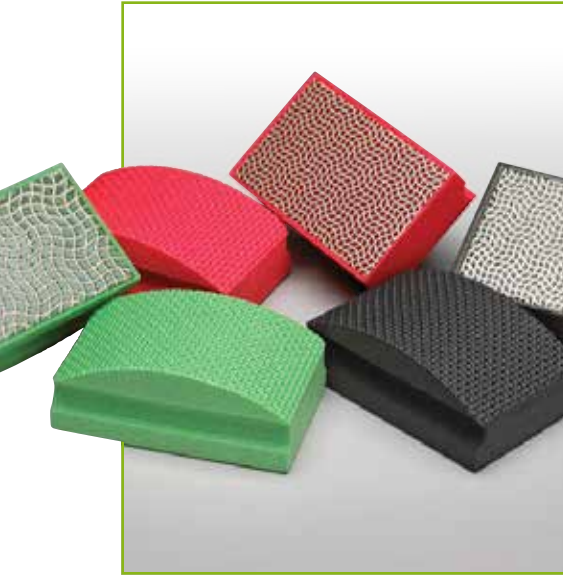
Abrasive Types:

Diamond

Machine Used:



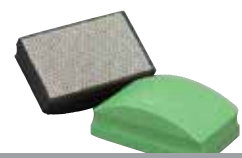
HAND
SANDING



Better choice for shaping, rapid stock removal, surface conditioning, touch-up, repair, and polishing

FLEXIBLE DIAMOND-COATED HAND PADS – CONVENTIONAL AND QUADROFLEX CURVED

- Durable yet lightweight conformable backing is adaptable to a variety of shapes and conditions with long lasting performance; offers a uniform finish for improved surface quality
- Can be used wet or dry; color-coded by grit size for easy identification
- Conventional hand pads with precision dot pattern for an aggressive, consistent, fast cut rate and reduced dust and loading; Quadroflex curved hand pads offer ergonomic advantages and longest life for lowest overall total cost



			TIER BETTER		TIER BETTER	
			DIAMOND COATED HAND PADS		QUADROFLEX CURVED DIAMOND COATED HAND PADS	
			ABRASIVE: Diamond		ABRASIVE: Diamond	
SIZE (L x W)	COLOR	MESH	STD. PKG.	PART #	PART #	
3-1/2 x 2-1/8	Green	60	1	662603 06360	690141 21517	
	Black	120	1	662603 06361	690141 21518	
	Red	200	1	662603 06362	690141 23529	
	Yellow	400	1	662603 05852	690141 23530	
	White	800	1	662603 06363	690141 23531	
	Blue	1500	1	662603 06364		
	Kit (one each of above)			1	662603 07720	

power...
**IN THE PALM OF
YOUR HAND**

Portable Tools and the specialty abrasive products to go along with them. Access hard-to-reach areas with ease with the Norton line of specialty products.





Put the world right in the palm of your hand with our 2" and 3" Norton Mini Angle Sanders. Small, compact enough to get into those hard-to-reach areas, and powerful enough to finish the job fast and efficiently.

Specifications for:

Weight of tool:

Compressed air:

Maximum permissible operating pressure:

Horsepower:

Free speed:

Air consumption @90psi:

Noise characteristic value in accordance with EN ISO 15744 (ISO 15744):

- A-weighted sound pressure level at workstation
- A-weighted sound power level
- Peak C-weighted instantaneous sound pressure level at workstation

Measurement uncertainty (Standard):

Vibration value according to EN ISO 28927-3:

Recommended lubrications:

Sanding tool specifications:

Applications and suitability:

2" Mini Angle Air Sander 3" Mini Angle Air Sander

1.6 lbs. (0.742kg)

6.2 bar (90psi)

6.2 bar (90psi)

.45

22,000 rpm

85 liters/min (3 CFM)

87.3 dB

98.3 dB

<130 dB

3.00 m/s²

0.84 m/s²

Air oil 20#

Pad Size 2" Collet

Collet Chuck 1/4" (6mm)

Surface preparation, grind welds, spot sanding and light-duty finishing applications.

1.8 lbs. (0.816kg)

6.2 bar (90psi)

6.2 bar (90psi)

.9

20,000 rpm

116 liters/min (4.1 CFM)

83.2 dB

94.2 dB

<130 dB

5.92 m/s²

1.09 m/s²

Air oil 20#

Pad size 3" Collet

Collet Chuck 1/4" (6mm)



Put the power right in the palm of your hand with our Mini Angle Sanders

MINI ANGLE SANDERS

- A double-bearing spindle generates superb concentricity, reducing vibrations allowing for longer use and finer finishes
- Finesse your projects by having the ultimate control in both precision and power with the speed regulator
- Get better tool handling along with reduced fatigue with the ergonomic and streamlined non-slip grip

DESCRIPTION	STD. PKG.	PART #
Mini Angle Sanders and Kits		
2" Mini Angle Sander	1	662611 50076
2" Kit Includes:	1	662611 50077
• 1 – 2" Sander		
• 25 – 2" 36 Grit Blaze R980P 3-Ply TR Discs (662611 62318)		
• 50 – 2" Medium Grit Rapid Prep Non-Woven TR Discs (662610 09190)		
• 1 – 2" Medium Density Back-Up Pad (662610 55103)		
3" Mini Angle Air Sander	1	699573 82154
3" Kit Includes:	1	699573 82155
• 1 – 3" Sander		
• 25 – 3" 36 Grit Blaze R980P 3-Ply TR discs (662611 62328)		
• 25 – 3" Medium Grit Rapid Prep Non-Woven TR discs (662610 17522)		
• 1 – 3" Medium Density Back-Up Pad (662610 55105)		





Mini-flap discs are ideal for use in tight spaces. They feature layered flaps which wear away evenly during use exposing new abrasive grain. The lightweight plastic backing helps to absorb vibration. They can help eliminate the conventional 2-step process in grinding edges and removing welds and rust.

- Applications:** Grinding, stock removal, edge chamfering/beveling, weld blending, deburring/deflashing, rust removal, blending, cleaning, and finishing in small areas or tight spots.
- Size Range:** 2" and 3" Quick-Change
- Grit Range:** 36 – 120
- Abrasive Grain:** Ceramic Alumina, Zirconia Alumina
- Abrasive Flaps:** Polyester
- Attachment:** TR (Type III) and TS (Type II)
- Backing Plate Material:** Extra Heavy-Duty Plastic
- Machine Used:**



Best choice for beveling, blending, deburring, and stock removal in tight spaces



BLAZE R980P CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain lasts 50% – 200% longer than many flap discs on stainless steel, cobalt, chrome, Inconel, titanium and other hard-to-grind materials
- Flexible, high-strength, plastic backing plates absorb vibration for optimized ergonomics
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably faster cut rate

Better choice for blending, deburring, and stock removal in tight places



BLUEFIRE R860 ZIRCONIA ALUMINA

- High-performance zirconia alumina abrasive for aggressive cut and long life
- Flexible, high-strength, plastic backing plates absorb vibration for optimized ergonomics
- Polyester flaps for improved durability and minimal loading on aluminum



TIER:	BEST	BETTER	BEST	BETTER		
TRADENAME:	BLAZE R980P	BLUEFIRE R860	BLAZE R980P	BLUEFIRE R860		
ABRASIVE:	Ceramic Alumina	Zirconia Alumina	Ceramic Alumina	Zirconia Alumina		
FLAP:	Polyester	Polyester	Polyester	Polyester		
BACKING MATERIAL:	Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic	Extra Heavy-Duty Plastic		
ATTACHMENT:	TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)		
SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #
2	36	10	776960 90145	776960 90165		776960 90175
	40	10	776960 90146	776960 90166		776960 90176
	60	10	776960 90147	776960 90167	776960 90157	776960 90177
	80	10	776960 90148	776960 90168	776960 90158	776960 90178
	120	10	776960 90149	776960 90169	776960 90159	776960 90179
3	36	10	776960 90150	776960 90170	776960 90160	776960 90180
	40	10	776960 90151	776960 90171	776960 90161	776960 90181
	60	10	776960 90152	776960 90172	776960 90162	776960 90182
	80	10	776960 90153	776960 90173	776960 90163	776960 90183
	120	10	776960 90154	776960 90174	776960 90164	776960 90184



DESCRIPTION	MAX. RPM	STD. PKG.	TR (TYPE III)	TS (TYPE II)
Mini Flap Disc Back-up Pads				
2" and 3" Medium Density Back Up Pads	30,000	1	088341 64922	088341 68539



Tool-free, twist-on and -off fastening systems make fast work of disc changes to maximize productivity by minimizing downtime.

Applications:

Fiber and NorKut trimmable hard plastic discs: welding, grinding and blending; heavy metal removal; light deburring and finishing
Cloth discs: light- to medium-pressure grinding; blending, leveling and finishing applications; for use on contours or flat surfaces
Diamond: Grinding ceramic, glass, composites, carbide and ceramic coatings, fiberglass, and reinforced plastics

Size Range:

3/4" – 4" diameter

Grit Range:

24 – 320

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide, Silicon Carbide, Diamond

Backing:

Fiber, cloth, or polymer

Cloth Flex:

3-ply (more aggressive), 2-ply (standard),

Attachment:

Type TS (II), Type TR (III), and Type TP (I)

Back-up Pads:

Rubber with hardness variations for different applications

Machine Used:



MINI ANGLE SANDER

Coated Abrasive Quick-Change Disc Availability



Fiber

- The most heavy-duty discs with resin over resin construction on heavy-duty vulcanized fiber backing
- Premium grain for applications from heavy stock removal to surface blending



Cloth 3-Ply

- These heavy-duty, 3-ply polyester laminate construction discs are the most aggressive and durable cloth discs on the market



NorKut

- Unique polymer backing resists cracking and breakage and can be cut down up to the 1" core
- Use the cores to grind "pinch" welds and other hard-to-reach areas



Cloth 2-Ply

- Our standard 2-ply laminate construction creates an aggressive and durable cloth disc for flat surfaces



Diamond

- Unique, aggressive, diamond grain pattern on a flexible cloth backing

Quick-Change Attachment Systems and Cross Reference Guide

Each system enables quick, safe disc changes, reducing downtime and operating expenses.

Type TS (Type II)

- Features a turn-on/turn-off style fastener
- Fastener is made of metal



Type TR (Type III)

- Features a roll-on/roll-off style fastener
- Fastener is made of plastic



Type TP (Type I)

- Features a snap-on/snap-off style fastener
- Fastener is made of nylon

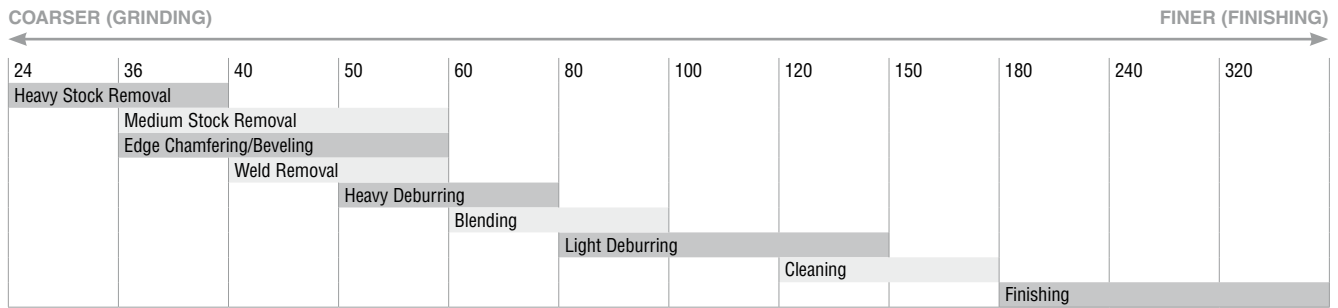


NORTON	Type TS (Type II)	Type TR (Type III)	Type TP (Type I)
3M	Roloc TS/TSM	Roloc TR	Roloc TP
Standard	TS (SocAtt)	TR (Lockit)	TP (ClickOn)
Superior	Type S	Type R	–
Arc	Type S	Type R	Type P
Pferd	Type CD	Type CDR	–
Sait	SAIT-LOK	SAIT-LOK-R	–
Camel	Turn On	Roll On	–
Klingspor	QMC	QRC	–
Garryson	Type S	Type R	–

Material/Application-to-Product Recommendation Guide

	BEST Blaze R980P	BETTER BlueFire R887D	BlueFire R860	GOOD Gemini R766 Merit R422	
Stainless Steel / Titanium / Super Alloys	◆	◆		◆	
Mild Carbon Steel / Welds			◆	◆	
Ferrous Metals / Cast Iron			◆	◆	
Brass / Bronze / Aluminum			◆	◆	
Paint / Glue / Adhesive				◆	
Concrete / Stone / Fiberglass					◆

Application/Grit Recommendation Guide



Cross Reference Guide

	TOTAL PERFORMANCE ←			→ INITIAL PRICE	
	BEST	BETTER		GOOD	
Abrasive Backing	Ceramic Alumina Fiber BlazeX F970, Blaze F980	Ceramic Alumina Cloth Blaze R980P	Zirconia Alumina Cloth BlueFire R860, R887D	Aluminum Oxide Cloth Gemini R766	Silicon Carbide Cloth Merit R422
3M	782C, 785C, 787C, 982C, 985C, 987C, 988C	963G/H, 966F, 967F, 997F, 984F, 784F, 947A	561D	361F, 363F	421A, 441D, 461F
Standard	Ceramic, Ceramic Pro	Ceramic Pro, Ceramic	Zirconia	A/O Extra, A/O Pro	Silicon Carbide
Superior	—	Ceramic G.A.	Premium Zirc	A/O with Grinding Aid	—
Arc	—	—	Zirconia/Y Standard	A/O/X Plus Coolant	—
Pferd	CO, CO Cool	Ceramic	ZA Z	Aluminum Oxide A-Plus, Aluminum Oxide A-INOX-FORTE	Silicon Carbide SiC
Sait	7S,7A, 9S	—	Z	3A	C-W
Camel	Ceramic	—	Zirconia AO	—	—
Klingspor	CS570, FS966	CS610	Alumina Zirconia	—	CS333X
Garryson	—	Ceramic	—	—	—



Best choice for stainless steel, titanium, and super alloys

BLAZEX F980 CERAMIC ALUMINA

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Strong fiber backing for strength and tear resistance
- Supersized design for stainless steel and hard-to-grind materials



For tough applications and stainless steel

BLAZE F980 CERAMIC ALUMINA FIBER

- 100% ceramic grain constantly exposes sharper edges to deliver highest productivity at lowest overall costs vs. competitive lower-ratio ceramic discs
- Strong fiber backing, heavier and more rigid than conventional cloth discs, adds strength and tear resistance, and allows additional pressure for better results when grinding difficult materials
- Advanced self-lubricating grain treatment provides coolest cut and significantly faster cut rates; excels on hard-to-grind materials like 300 and 400 Series stainless and exotic alloys



Best choice for carbon steel and other soft-to-grind materials

BLAZEX F970 CERAMIC ALUMINA FIBER

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Heavier fiber backing for additional strength and tear resistance
- Non-supersized design for carbon steel and soft-to-grind materials



	BEST	BEST	BEST
TRADENAME:	BLAZEX F980	BLAZE F980	BLAZEX F970
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
BACKING:	Fiber – Heavy Duty	Fiber – Heavy Duty	Fiber – Heavy Duty
OTHER:	Supersize	Supersize	–
ATTACHMENT:	TR (Type III)	TR (Type III)	TR (Type III)



SIZE (D)	GRIT	STD. PKG.	PART #
2	24	25	776960 90139
	36	25	662610 58704
	50	25	662610 58705
	60	25	662610 58706
	80	25	662610 58707
3	24	25	776960 90140
	36	25	662610 58708
	50	25	662610 58709
	60	25	662610 58711
	80	25	662610 58712

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.

TECH TIP

Use the new next generation Norton BlazeX F970 fiber quick-change discs for carbon steel jobs.



Best choice for tough applications, titanium, super alloys, and stainless steel (3-ply) or contoured surfaces (2-ply)

BLAZE R980P CERAMIC ALUMINA

- 100% ceramic grain constantly exposes sharper edges to deliver highest productivity at lowest overall costs vs. competitive lower-ratio ceramic discs
- Improved resin bond system maximizes grain retention for longer product life
- Advanced self-lubricating grain treatment provides coolest cut with significantly faster cut rates while minimizing loading on hard-to-grind materials



Better choice for soft metals, wood, stainless steel, and carbon

BLUEFIRE R860 ZIRCONIA ALUMINA

- Premium, versatile, self-sharpening zirconia grain provides aggressive cut and up to 30% longer life versus competitive zirconia discs
- 2-ply polyester backing for improved durability and reducing loading on aluminum
- Durable Y-weight, polyester waterproof backing stands up to demanding applications: high-pressure and hard-to-grind exotic alloys



Better choice for stainless steel, titanium and other exotic alloys

BLUEFIRE R887D ZIRCONIA ALUMINA

- Self-sharpening, zirconia alumina abrasive with supersized grinding aid provides cooler cut, and longer life on hard-to-grind materials
- Durable, Y-weight, 2-ply polyester waterproof blend back stands up to these demanding applications
- Minimized heat build-up allows these discs to outlast conventional aluminum oxide and zirconia alumina discs in many applications



Good choice when initial price is the primary consideration

GEMINI R766 ALUMINUM OXIDE

- Versatile aluminum oxide abrasive for aggressive cut and longer life than competitive aluminum oxide discs
- Durable Y-weight 2-ply polyester backing and coating for additional life and faster cut rate on moderately-demanding applications
- Good choice when initial price is the primary purchasing consideration



Good choice for non-ferrous materials

MERIT R422 SILICON CARBIDE

- Sharp, silicon carbide abrasive provides high initial cut and penetration to resist loading on soft metals
- Strong, X-weight, 2-ply cotton backing construction for extended durability and reduced edge wear
- When completion time is important, sharp silicon carbide abrasive gets non-ferrous blending jobs done quickly

Ceramic Alumina Quick-Change Cloth Discs



TIER:	BEST	BEST	BEST	BEST
TRADENAME:	BLAZE R980P	BLAZE R980P	BLAZE R980P	BLAZE R980P
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
BACKING:	Polyester 3-Ply Heavy-Duty	Polyester 3-Ply Heavy-Duty	Polyester 2-Ply Standard	Polyester 2-Ply Standard
OTHER:	Supersize TS (Type II)	Supersize TR (Type III)	Supersize TS (Type II)	Supersize TR (Type III)
ATTACHMENT:				

SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #
1-1/2	36	100	662611 62307	662611 62308	636425 95401	
	50	100	662611 62309	662611 62310		
	60	100	662611 62311	662611 62312	636425 95447	636425 95468
	80	100	662611 62313	662611 62314	636425 95450	
2	120	100	662610 43379	662610 43380	662610 43416	
	36	25	662611 62317	662611 62318	636425 95452	636425 95470
	50	25	662611 62319	662611 62320	636425 95456	636425 95472
	60	25	662611 62321	662611 62322	636425 95458	636425 95476
	80	25	662611 62323	662611 62324	636425 95459	636425 95478
	100	25	662610 43382	662610 43383		662610 43419
3	120	25	662610 43384	662610 43386	662610 43420	662610 43421
	36	25	662611 62327	662611 62328	636425 95460	636425 95479
	50	25	662611 62329	662611 62330	636425 95462	636425 95480
	60	25	662611 62331	662611 62332	636425 95463	636425 95481
	80	25	662611 62333	662611 62334	636425 95464	636425 95493
	100	25	662610 43389	662610 43390		662610 43423
	120	25	662610 43391	662610 43392	662610 43424	662610 43425

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.



Quick-Change Test Kit “D”

- Part # 088341**65001**
- Includes 150 discs, assorted grits, in 1", 2", and 3" diameters and 3" back-up pads
- Primarily aluminum oxide cloth quick-change discs
- Several zirconia alumina and aluminum oxide FlexEdge discs are included



Zirconia Alumina Quick-Change Cloth Discs



TIER:	BETTER	BETTER	BETTER	BETTER	BETTER
TRADENAME:	BLUEFIRE R860	BLUEFIRE R860	BLUEFIRE R887D	BLUEFIRE R887D	BLUEFIRE R887D
ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING:	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard
OTHER:			Supersize	Supersize	Supersize
ATTACHMENT:	TS (Type II)	TR (Type III)	TS (Type II)	TR (Type III)	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	PART #	PART #
1	50	100				08834167095 NS	08834167011 NS
	60	100	66261138608			08834167096 NS	08834167012 NS
	80	100	66261138607			08834167097	08834167013 NS
	120	100				08834167099	08834167015 NS
1-1/2	36	100	66261138624	66261121041		08834167102	08834167018 NS
	50	100				08834167103	08834167019 NS
	60	100	66261138621	66261121043	08834167061	08834167104	
	80	100	66261138620	66261121044	08834167062	08834167106	
2	24	100	66261138638*	66261138672*			
	36	100	66261138637*	66261138671	08834167065	08834167107	08834167023
	40	100			08834167066	08834167108	
	50	100	66261138635*	66261138670*	08834165583	08834167109	08834167025
	60	100	66261138634*	66261121048*	08834167068	08834167110	08834167026
	80	100	66261138633*	66261121049*	08834167069	08834167111	08834167027
	120	100			08834167071	08834167113	08834167029
3	24	50	66261138665*	66261138675*			
	36	50	66261138664*	66261138674*	08834167072	08834167114	08834167030
	40	50			08834167073		
	50	50	66261138662*	66261138673*	08834167074	08834167116	08834167032
	60	50	66261138661*	66261121053*	08834167075	08834167117	08834167033
	80	50	66261138660*	66261121054*	08834167076	08834167118	08834167034
4	120	50			08834167078	08834167120	
	36	50			08834167079		
	50	50	66261138681*				
	60	50	66261137343*				08834167040 NS
	80	50	66261138679*		08834167083 NS		
	120	50			08834167085 NS		

* Standard Package = 25 discs

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

BlueFire R860

Proprietary new grain shape and chemistry for faster cutting and longer life on a wide range of materials.



Aluminum Oxide Quick-Change Cloth Discs



TIER:	GOOD	GOOD	GOOD
TRADENAME:	GEMINI R766	GEMINI R766	GEMINI R766
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
BACKING:	Polyester 2-Ply Standard	Polyester 2-Ply Standard	Polyester 2-Ply Standard
ATTACHMENT:	TS (Type II) 	TR (Type III) 	TP (Type I)

SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #	
3/4	40	100			699573 99739	
	50	100	699573 99604		699573 99740	
	60	100	699573 99605	699573 99673	699573 99741	
	80	100	699573 99606	699573 99674	699573 99742	
1	36	100	699573 99614	699573 99682	699573 99750	
	40	100			699573 99751	
	50	100	699573 99616		699573 99752	
	60	100	699573 99617	699573 99685	699573 99753	
	80	100	699573 99618	699573 99686	699573 99754	
	100	100	699573 99619	699573 99687	699573 99755	
	120	100	699573 99620	699573 99688	699573 99756	
	180	100	699573 99622	699573 99690	699573 99758	
	240	100	699573 99623	699573 99691	699573 99759	
	1-1/2	36	100	699573 99626	699573 99694	699573 99762
40		100	699573 99627	699573 99695	699573 99763	
50		100	699573 99628	699573 99696	699573 99764	
60		100	699573 99629	699573 99697	699573 99765	
80		100	699573 99630	699573 99698	699573 99766	
100		100	699573 99631	699573 99699		
120		100	699573 99632	699573 99700	699573 99768	
150		100			699573 99769	
180		100	699573 99634	699573 99702	699573 99770	
240		100	699573 99635	699573 99703		
2	24	100	699573 99637	699573 99705	699573 99773	
	36	100	699573 99638	699573 99706	699573 99774	
	40	100	699573 99639	699573 99707	699573 99775	
	50	100	699573 99640	699573 99708	699573 99776	
	60	100	699573 99641	699573 99709	699573 99777	
	80	100	699573 99642	699573 99710	699573 99778	
	100	100	699573 99643	699573 99711	699573 99779	
	120	100	699573 99644	699573 99712	699573 99780	
	150	100	699573 99645	699573 99713	699573 99781	
	180	100	699573 99646	699573 99714	699573 99782	
	240	100	699573 99647	699573 99715	699573 99783	
	320	100	699573 99648	699573 99716	699573 99784	
	3	24	50	699573 99649	699573 99717	699573 99785
		36	50	699573 99650	699573 99718	699573 99786
40		50	699573 99651	699573 99719	699573 99787	
50		50	699573 99652	699573 99720	699573 99788	
60		50	699573 99653	699573 99721	699573 99789	
80		50	699573 99654	699573 99722	699573 99790	
100		50	699573 99655	699573 99723	699573 99791	
120		50	699573 99656	699573 99724	699573 99792	
150		50	699573 99657	699573 99725		
180		50	699573 99658	699573 99726	699573 99794	
240		50	699573 99659	699573 99727	699573 99795	
320		50	699573 99660	699573 99728	699573 99796	
4		36	50	699573 99661	699573 99729	
		50	50		699573 99731	
	60	50	699573 99664		699573 99800	
	80	50		699573 99733		

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.

Quick-Change Discs – Cloth, Specialty

Silicon Carbide Quick-Change Cloth Discs



TIER:	GOOD	GOOD	GOOD
TRADENAME:	MERIT R422	MERIT R422	MERIT R422
ABRASIVE:	Silicon Carbide	Silicon Carbide	Silicon Carbide
BACKING:	Cotton Standard	Cotton Standard	Cotton Standard
ATTACHMENT:	TS (Type II)	TR (Type III)	TP (Type I)



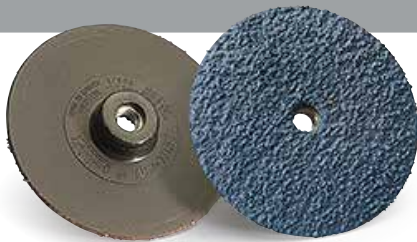
SIZE (D)	GRIT	STD. PKG.	PART #	PART #	PART #
2	40	100	088341 65252 NS	088341 64275 NS	
	60	100	088341 65254	088341 64163 NS	088341 62168 NS
	80	100	088341 65255	088341 66155 NS	088341 62169 NS
	120	100		088341 64837 NS	088341 62171 NS
	180	100	088341 65259 NS	088341 67313 NS	088341 62173 NS
3	40	50	088341 65267 NS	088341 64277 NS	
	60	50		088341 64850 NS	
	80	50		088341 66159 NS	088341 62188 NS
	120	50	088341 65272 NS	088341 66160 NS	088341 62190 NS
	180	50		088341 68177 NS	

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

Quick-Change back-up pads shown at the end of the Quick-Change Disc section.

Specialty Quick-Change Discs

Better choice for hard-to-grind areas where flexibility is not required



NORKUT ZIRCONIA ALUMINA POLYMER

- Durable zirconia alumina grain is resin bonded to a unique polymer backing which resists cracking and breaking; can be trimmed to the 1 Inch core
- Used with a quick change mandrel: 7/16-20 threaded for hand-held pneumatic grinders or 1/4 inch mandrel for automotive drills
- Use for deburring and blending; use the core to grind pinch welds and other hard-to-reach areas

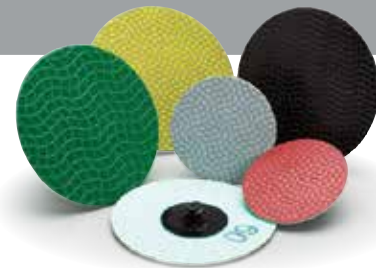
TIER:	BETTER
TRADENAME:	NORKUT
ABRASIVE:	Zirconia Alumina
BACKING:	Extra HD Polymer
ATTACHMENT:	Threaded Hole

SIZE (D)	GRIT	STD. PKG.	PART #
NorKut Discs			
3	24	20	636425 03656
	36	20	636425 03657
	50	20	636425 03658

TIER:	BETTER
ATTACHMENT:	Threaded Hole

SIZE (D)	STD. PKG.	PART #
Mandrels		
7/16-20 Mandrel	5	636425 03659
1/4" Mandrel	5	636425 03660

Better choice for improved cut rate and finish on ceramics, glass, fiberglass, composites, carbide, and other tough metals and coatings



D7210 DIAMOND QUICK-CHANGE TR (TYPE III)

- Unique, durable diamond abrasive pattern increases life and lowers costs versus standard coated and diamond discs; color-coded backing for easy grit/application identification
- Removes rust and scale on other material; producing metallurgical stamps and coupons

SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Diamond Coated Quick-Change TR (Type III) Discs				
2	Green	60	12	662603 11778
	Black	120	12	662603 11779
	Red	200	12	662603 11780
	Yellow	400	12	662603 11781
	White	800	12	662603 11782

SIZE (D)	COLOR	MESH	STD. PKG.	PART #
Flexible Diamond Coated Quick-Change TR (Type III) Discs				
3	Green	60	12	662603 11783
	Black	120	12	662603 11784
	Yellow	400	12	662603 11786



Non-woven quick-change discs are a combination of strong synthetic mesh and quality abrasives, bonded together by a smear-resistant adhesive. The open construction of the non-woven material enables aggressive cutting action and improved surface finish while maintaining its non-loading feature.

- Applications:** Medium-light stock removal, beveling, deburring/deflashing, rust removal, blending, cleaning and finishing, polishing, and decorative finishing
- Size Range:** 3/4" – 4" diameter
- Grit Range:** X-Coarse, Coarse, Medium, Fine, Very Fine, Super Fine
- Abrasive Grain:** Ceramic Alumina, Engineered Aluminum Oxide, Aluminum Oxide, Silicon Carbide
- Attachment:** Quick-Change Type TR (Type III), Type TS (Type II)
- Back-up Pads:** Rubber with hardness variations for different applications
- Machine Used:**



MINI ANGLE SANDER

Quick-Change Attachment Systems and Cross Reference Guide

Each system enables quick, tool-free, safe disc changes, reducing downtime and operating expenses.

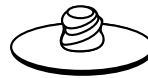
Type TS (Type II)

- Features a turn-on/turn-off style fastener
- Fastener is made of metal



Type TR (Type III)

- Features a roll-on/roll-off style fastener
- Fastener is made of plastic



NORTON	TS	TR
3M	Roloc TS/TSM	Roloc TR
Standard	TS (SocAtt)	TR (Lockit)
Superior	Type S	Type R
Arc	Type S	Type R
Pferd	Type CD	Type CDR
Sait	SAIT-LOK	SAIT-LOK-R
Camel	Turn On	Roll On
Klingspor	QMC	QRC
Garryson	Type S	Type R

Application/Grit Recommendation Guide

MOST AGGRESSIVE ←

→ LEAST AGGRESSIVE

NORTON	Rapid Strip	Vortex Rapid Blend Deburring & Blending	Vortex Rapid Prep	Rapid Prep	HS Buffing, Buffing	Rapid Polish
Scale Removal	First Choice					
Stock Removal	First Choice	Second Choice				
Heavy Deburring	Second Choice	First Choice				
Light Deburring		First Choice	Second Choice			
Light Finishing			First Choice	Second Choice		
Blending			First Choice	Second Choice		
Cleaning			Second Choice	First Choice		
Finishing				First Choice	Second Choice	
Polishing						First Choice

Cross Reference Guide

	STRIPPING		HEAVY/LIGHT DEBURRING		LIGHT DEBURRING/BLENDING/CLEANING/FINISHING		
	BEST	BETTER	BEST	BETTER	BEST	BETTER	BEST
NORTON	Blaze Rapid Strip	Rapid Strip	Vortex Rapid Blend	Rapid Blend, Deburring & Blending	Vortex Rapid Prep	Rapid Prep	HS Buffing
3M	Clean and Strip XT PRO, Clean and Strip XT PRO Extra Cut	Clean & Strip Clean Strip XT	Deburr and Finish PRO	EXL Unitized	SE	Surf Cond, SL	–
Standard	–	Cleaning Disc	–	500-900 Series Unitized	–	FE, GP, RC	Buff & Blend - HS, Buff & Blend
Fiberal/SIA	–	–	–	–	–	Meteor, Type B & C	–
Superior	–	Type R	–	XL Unitized	–	FD, GD, CC	HS, HD A/O
Arc	–	Arcstrip	–	–	–	Surface Cond	Blend & Finish
Pferd	–	Policlean	–	–	–	Finishing Disc - Hard & Soft	–
Sait	–	SAIT-Strip	–	–	–	HD, GP	Sand-Light Blending
Camel	–	EZ Strip - Black	–	–	–	–	–
Klingspor	–	–	–	–	–	–	–
Garryson	–	–	–	–	–	Surface Cond	–
Bibielle	–	Strip-It Black	–	BUR Unitized	–	DCR	–

Abrasive/Grit/Density Key

ABRASIVE	SILICON CARBIDE			ALUMINUM OXIDE		CERAMIC ALUMINA
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN			MORE DURABLE, LONGER LASTING, POLISHED FINISH		
GRIT SIZE	XC (50)	C (60-80)	M (100-150)	F (180-220)	VF (240-360)	SF (400-600)
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH			REDUCED CUT RATE, FINER FINISH		
DENSITY	2			9		
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING			HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH		

Quick-Change Stripping Discs



Best choice for removing coatings on a variety of substrates, such as wood, metal and plastics

BLAZE RAPID STRIP CERAMIC ALUMINA

- Blaze ceramic grain cuts 2X faster than competitive discs; leaves a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as coating, painting and soldering
- Open web construction for minimal loading; great alternative to wire brushes
- Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish



Better choice for removing coatings on a variety of substrates, such as wood, metal and plastics

RAPID STRIP SILICON CARBIDE

- Sharp silicon carbide abrasive provides fast aggressive cutting action
- Open web construction for minimal loading; great alternative to wire brushes
- Advanced resin bond prevents shedding, snagging, gouging, and rework



TIER: **BEST**
 TRADENAME: **BLAZE RAPID STRIP**
 ABRASIVE: Ceramic Alumina
 GRADE: XC
 ATTACHMENT: TR (Type III)

TIER: **BETTER**
 TRADENAME: **RAPID STRIP**
 ABRASIVE: Silicon Carbide
 GRADE: XC
 ATTACHMENT: TR (Type III)



SIZE (DIAMETER)	MAX. RPM	STD. PKG.	PART #	STD. PKG.	PART #
2	15,500	25	666233 03912	10	662610 13402
3	12,000	25	662610 96557	10	662610 13403
4 TR+	8,000	5	666233 03921*	5	662610 16580*

*TR+ attachment show in the group image above

Quick-Change back-up pads shown at the end of this section.

3D Unified Quick-Change Deburring & Blending Discs

Best technology for heavy deburring and finishing



BLAZE RAPID BLEND CERAMIC ALUMINA

- Blaze SG ceramic alumina grain provides quickest cut rate and up to 8X longer life than competitive aluminum oxide discs
- Superior resin chemistry resists shedding when used on sharp edges; ideal for deburring
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus competitive discs with one bottom layer of abrasive

Best choice for weld blending, polishing and deburring



VORTEX RAPID BLEND ALUMINUM OXIDE

- Patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit with the finish of finer grits
- Special resin bond for consistent performance with no smearing
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus competitive discs with one bottom layer of abrasive

Better choice for light deburring, blending, and cleaning



RAPID BLEND NEX ALUMINUM OXIDE

- Quality aluminum oxide delivers durability and long life
- Resin formula delivers smear-free finishes
- Abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used – versus competitive discs' one bottom layer of abrasive

TECH TIP

3D Construction

- The 3D construction means the abrasive is distributed throughout the entire disc (top, bottom and side) so all three faces can be used versus discs with one single bottom layer of abrasive.



It is the user's responsibility to refer to and comply with ANSI B7.1



How to Grind & Blend in One Step!
Non-Woven Discs

[youtube.com/watch?v=FgSLez3MKj8](https://www.youtube.com/watch?v=FgSLez3MKj8)

3D Unified Quick-Change Deburring & Blending Discs

3D Unified Quick-Change
Deburring & Blending TS Discs



TIER:	BEST	BEST
TRADENAME:	BLAZE RAPID BLEND	VORTEX RAPID BLEND
ABRASIVE:	Ceramic Alumina	Engineered Aluminum Oxide
ATTACHMENT:	TS (Type II)	TS (Type II)



For unified wheels with arbor holes or spindle mounts, see the Non-woven Unified Wheel section. Quick-Change back-up pads shown at the end of this section.

SIZE (D x T)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #
1 x 1/4	Ceramic Alumina	XC	1	35,000	100	666233 13920	
1-1/2 x 1/4	Ceramic Alumina	XC	1	35,000	80	666233 13922 NS	
2 x 1/8	Aluminum Oxide	C	5	30,000	40		662611 32884
	Aluminum Oxide	C	8	30,000	40		662611 32885
2 x 1/4	Ceramic Alumina	XC	1	22,000	25	666233 13925	
	Aluminum Oxide	C	5	30,000	60		662611 32886
	Aluminum Oxide	C	8	30,000	60		662611 32887
	Aluminum Oxide	M	1	22,000	25		662544 97070
3 x 1/8	Aluminum Oxide	C	5	22,000	40		662611 32890
	Aluminum Oxide	C	8	22,000	40		662611 32891
3 x 1/4	Ceramic Alumina	XC	1	15,000	25	666233 13931	
	Aluminum Oxide	C	5	22,000	40		662611 32894
	Aluminum Oxide	C	5	22,000	40		662611 32895
	Aluminum Oxide	M	1	15,000	25		662544 97069

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

3D Unified Quick-Change Deburring & Blending TR Discs



TIER:	BEST	BEST	BETTER
TRADENAME:	BLAZE RAPID BLEND	VORTEX RAPID BLEND	RAPID BLEND NEX
ABRASIVE:	Ceramic Alumina	Engineered Aluminum Oxide	Aluminum Oxide
ATTACHMENT:	TR (Type III)	TR (Type III)	TR (Type III)



SIZE (D x T)	ABR.	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #	PART #	PART #	
1 x 1/4	Ceramic Alumina	XC	1	35,000	100	666233 13919			
1-1/2 x 1/4	Ceramic Alumina	XC	1	35,000	80	666233 13921 NS			
2 x 1/8	Aluminum Oxide	C	5	30,000	40		662611 32882		
	Aluminum Oxide	C	8	30,000	40		662611 32883		
	Aluminum Oxide	M	4-6	22,000	60		662544 25632 NS		
	Aluminum Oxide	M	7-9	22,000	60		662544 33509 NS		
2 x 3/16	Aluminum Oxide	M	2-3	22,000	60		662544 28236 NS		
2 x 1/4	Ceramic Alumina	XC	1	22,000	25	666233 13923			
	Aluminum Oxide	C	7-9	22,000	60			662610 14921	
	Aluminum Oxide	M	1	22,000	25		662544 97067		
	Aluminum Oxide	M	2-3	22,000	60		662544 28237	662610 14897	
	Aluminum Oxide	M	4-6	22,000	60		662544 13660	662610 14911	
	Aluminum Oxide	M	7-9	22,000	60		662544 33510	662610 14935	
	Silicon Carbide	F	2	22,000	60			662610 14889	
	Silicon Carbide	F	3	22,000	60			662610 17306	
	3 x 1/8	Aluminum Oxide	C	5	22,000	40		662611 32888	
		Aluminum Oxide	C	8	22,000	40		662611 32889	
Aluminum Oxide		M	4-6	15,000	40		662610 93556		
Aluminum Oxide		M	7-9	15,000	40		662610 90909		
3 x 3/16	Aluminum Oxide	M	7-9	15,000	40		662544 28239 NS		
3 x 1/4	Ceramic Alumina	XC	1	15,000	25	666233 13930			
	Aluminum Oxide	C	5	22,000	40		662611 32892		
	Aluminum Oxide	C	8	22,000	40		662611 32893		
	Aluminum Oxide	C	7-9	15,000	40			662610 14922	
	Aluminum Oxide	M	1	15,000	25		662544 97068		
	Aluminum Oxide	M	2-3	15,000	40		662544 28238	662610 14898	
	Aluminum Oxide	M	4-6	15,000	40		662544 13661	662610 14912	
	Aluminum Oxide	M	7-9	15,000	40		662544 06395	662610 14936	
	Aluminum Oxide	F	4-6	15,000	40			662610 15419	
	Silicon Carbide	F	2	15,000	40			662610 14890	
	Silicon Carbide	F	3	15,000	40			662610 16005	

NS Non-stock, contact your Norton representative for current order quantities and lead-times.

Quick-Change Surface Preparation Discs

Best choice for aggressive stock removal and blending in one step



RAPID PREP XHD

- Coarse and Medium discs solve your most aggressive stock removal and blending challenges, remove weld lines, weld spatter, weld discoloration and blend surfaces in a single step
- Improve cut control and surface blending over traditional coated discs with our unique combination of a conformable fiber matrix and premium ceramic grain
- XHD Coarse discs for aggressive weld removal and surface blending on steels and Medium discs on softer metals/ alloys

TIER: **BEST**
 TRADENAME: **RAPID PREP XHD**
 ABRASIVE: Ceramic Alumina
 ATTACHMENT: TR (Type III)



SIZE (DIAMETER)	MAX. RPM	STD. PKG.	PART #
Coarse			
2	20,000	50	662611 70271
3	18,000	25	662611 70273
4	12,000	25	662611 70274
Medium			
2	20,000	50	662611 70285
3	18,000	25	662611 70286
4	12,000	25	662611 70287



Quick-Change Surface Preparation Discs

Best choice for finishing and blending applications



VORTEX RAPID PREP





- Proprietary engineered Vortex aluminum oxide abrasive grain and coating method combine maximum cutting speed with the consistent finish of finer grits to reduce process times by 50+% by combining multiple grit sequences to 1 step
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life and provides added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

Better choice for finishing and blending applications



RAPID PREP ALUMINUM OXIDE

- Quality aluminum oxide abrasive grain coating provides up to 20% higher cut rate and 50% better performance than competitive products
- Thick layer of grain throughout the product extends life; grain does not sit on top of fibers as it does with other competitive products
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

TIER:	BEST	BETTER	BEST	BETTER
TRADENAME:	VORTEX RAPID PREP	RAPID PREP	VORTEX RAPID PREP	RAPID PREP
ABRASIVE:	Engineered A/O	Aluminum Oxide	Engineered A/O	Aluminum Oxide
ATTACHMENT:	TR (Type III)	TR (Type III)	TS (Type II)	TS (Type II)
				

SIZE (DIAM.)	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
Extra Coarse						
3/4	25,000	50	666233 25001	666233 40002	666233 35324	
1	25,000	50	666233 25004		666233 25003	666233 40006
1-1/2	20,000	50	666233 25007	666233 40011	666233 25006	666233 40010
2	20,000	50	666233 35326	662610 16373	666233 35325	662610 17819
3	18,000	25	666233 35327	662610 16994	666233 25010	662610 17818
4	12,000	25	666233 35329	662610 16374		
Coarse						
3/4	25,000	50	666233 25013	666233 40021	666233 35410	662610 09515
1	25,000	50	666233 25015	666233 40023	666233 35537	662610 24310
1-1/2	20,000	50	666233 35411	662610 047579	666233 25017	666233 40026
2	20,000	50	666233 35414	662610 09191 NS	666233 35413	662610 09183
3	18,000	25	666233 35417	662610 09194	666233 35416	662610 09186
4	12,000	25	666233 35419	662610 08822		
Medium						
3/4	25,000	50	666233 25020	666233 40032	666233 35420	662544 28059
1	25,000	50	666233 35422	662544 82331	666233 35421	662544 82327
1-1/2	20,000	50	666233 35424	662544 82332	666233 35423	662544 82328
2	20,000	50	666233 35427	662610 09190*	666233 35426	662610 09182
3	18,000	25	666233 35430	662610 17522	666233 35429	662610 09185
4	12,000	25	666233 35432	662610 08821		662610 55350
Fine						
3/4	25,000	50	666233 25026	666233 40058	666233 25025	
1	25,000	50	666233 25029	666233 40064	666233 25028	666233 40062
1-1/2	20,000	50	666233 25032	666233 40070 NS	666233 25031	666233 40068
2	20,000	50	666233 25035	666233 40077	666233 25034	666233 40074
3	18,000	25	666233 25038	666233 40085	666233 25037	666233 40082
4	12,000	25	666233 25041	666233 40092		
Very Fine						
3/4	25,000	50	666233 25044	666233 40044	666233 25043	666233 40042
1	25,000	50	666233 25047	662544 82339	666233 25046	662544 82335
1-1/2	20,000	50	666233 25050	662544 82340	666233 25049	662544 82336
2	20,000	50	666233 35433	662610 09189*	666233 25052	662544 82337
3	18,000	25	666233 35437	662610 09192	666233 35436	662610 09184
4	12,000	25		666233 40053		
Super Fine						
2	20,000	50		662610 091459		
3	18,000	25		662610 091460		

* 25 per standard package.

NS Non-stock, contact your Norton representative for current order quantities and lead-times.



Quick-Change Buffing/Polishing Discs

Best choice for light removal of paint or rust



HIGH STRENGTH BUFFING DISCS

- Aluminum oxide grain delivers a combination of consistent cut rate and uniform finish
- Tough yet conformable high-strength discs are smear-proof and resist tearing on burrs and sharp edges
- Our strongest non-woven buffing and polishing disc

Better choice for finishing to a mirror like shine



RAPID POLISH

- Quick-change discs with premium quality pressed hardened felt for polishing to a mirror like finish
- Use with our without polishing compound
- Soft padding is Ideal for final finishing with no vibration

Good choice for light removal of rust, coatings or oxidation



MERIT BUFFING/POLISHING DISCS

- This aluminum oxide grain and resin bond combination produce a smooth cut rate and smear-free, uniform finish
- Non-woven nylon fibers are laminated to tough yet conformable nylon backing that resists tearing on burrs and sharp edges
- Designed for light removal of coatings oxidation or rust without affecting the base product

TIER:	BEST	BEST	GOOD	GOOD	BETTER
TRADENAME:	HIGH-STRENGTH	HIGH-STRENGTH	MERIT BUFFING/ POLISHING	MERIT BUFFING/ POLISHING	RAPID POLISH
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Felt
BACKING:			Nylon Laminated	Nylon Laminated	
ATTACHMENT:	TR (Type III)	TS (Type II)	TR (Type III)	TS (Type II)	TR (Type III)

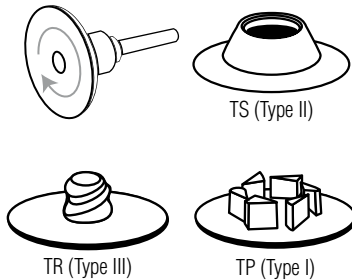
SIZE (D)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	MAX. RPM	STD. PKG.
1-1/2	M	20,000	100			08834166368	08834166392		
	F	20,000	100			08834166369			
2	C	18,000	50	77696000149		08834161649	08834166394		
	M	18,000	50	08834164064	08834164244 NS	08834166303	08834166395	-	50
	F	18,000	50			08834166304	08834166396		
3	VF	18,000	50	08834163987 NS	08834164245 NS	08834166305	08834166405		
	C	12,000	25	77696000150		08834161651	08834166397		
	M	12,000	25	08834164065	08834164252 NS	08834166308	08834166398	-	50
	F	12,000	25			08834166309	08834166399		
	VF	12,000	25	08834163559 NS			08834166403		

NS Non-stock, contact your Norton representative for current order quantities and lead times.

See page 80 for Rapid Polish Compound Stick.

Quick-Change Back-up Pads

- Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications
- Soft density pads are used for contours and fine finishing work



SIZE (DIAMETER)	DENSITY	MAX. RPM	STD. PKG.	TS (TYPE II)	TR (TYPE III)	TP (TYPE I)
Quick-Change Back-up Pads						
9/16		40,000	1	662610 54014 NS		662610 54013 NS
3/4	Medium	40,000	1	088341 64206	088341 64038	088341 64001
1	Medium	40,000	1	088341 64651	088341 64037	088341 64002
1-1/2	Hard	30,000	1	088341 64622		088341 63996 NS
2	Medium	30,000	1	088341 64146	088341 61174	088341 64003
	Hard	30,000	1	088341 64624	088341 64643	088341 63997
	Medium	30,000	1	088341 64198	088341 64922	088341 64004
3	Soft	30,000	1	088341 61625	088341 64641	088341 63949 NS
	Hard	20,000	1	088341 61626	088341 64036	088341 63998
	Medium	20,000	1	088341 64113	088341 64949	088341 64005
4	Soft	20,000	1	088341 64626	088341 64644 NS	088341 63948 NS
	Medium	15,000	1	088341 64135	088341 64655	
4 TR+	Medium	8,000	1		636425 55106	
Vendible Quick-Change Back-up Pads						
2	Medium	30,000	5	6662334 1082	6662334 1083	
3	Medium	20,000	5		6662334 1085	

All Quick-Change back-up pads have a 1/4" solid steel shank.

NS Non-stock. Contact your Norton representative for current order quantities and lead times.

Vendible back-up pad Std. Pkg. Qty: 1 pad per pack; 5 packs per carton. Order in multiples of 5.



Replacement Medium Density Rubber Pads for Quick-Change TP (Type I) Back-up Pads

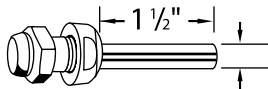
- When the rubber pad has worn away, but the steel components of your quick-change back-up are still serviceable, order these replacement rubber pads.

SIZE (D)	MODEL #	STD. PKG.	PART #
Quick-Change Replacement Rubber Back-up Pads			
3/4	RR75	1	088341 64008 NS
4	RR40	1	088341 64013 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Replacement Assemblies and Shanks for Quick-Change Back-up Pad

- Assemblies replace all the steel components of a quick-change back-up pad. This shank replaces the screw-in 1/4" solid steel shank only.



DESCRIPTION	STD. PKG.	PART #
Replacement Mandrels and Nut Assembly		
TP (Type I) Assembly RMN3 for 3 - 4	1	088341 64016 NS
TS (Type II) & TR (Type III) Replacement 1/4" Shank	1	088341 64303

NS Non-stock. Ask your Norton representative for current order quantities and lead-times

Extension Mandrels and Assembly

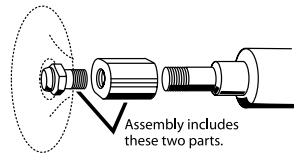


DIAMETER	MODEL #	LENGTH	STD. PKG.	PART #
Extension Mandrels and Assembly - TP (Type I)				
3/4 - 2	EMN-14	4"	1	088341 64017 NS
3/4 - 2	EMN-16	6"	1	088341 64018 NS
3/4 - 2	EMN-18	8"	1	088341 64019 NS
3 - 4	EMN-34	4"	1	088341 64020 NS
3 - 4	EMN-36	6"	1	088341 64026 NS
3 - 4	EMN-38	8"	1	088341 64021 NS

All extension mandrels are non-stock, Contact your Norton representative for current order quantities and lead-times.

MNA-1 Pad Adapters

- Convert a TP (Type I) back-up pad 1/4" diameter solid shank to a threaded shank

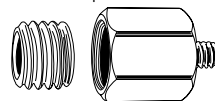


DISC DIAMETER	MODEL NO.	STD. PKG.	PART #
MNA-1 Pad Adapters - TP (Type I)			
3/4 - 2	MNA 1/4-20 THD.	1	088341 61176 NS
3/4 - 2	MNA 3/8-24	1	088341 64055 NS
3/4 - 2	MNA 5/8-11	1	088341 63001 NS
3 - 4	MNA 1/4-20	1	088341 63002 NS
3 - 4	MNA 5/8-11	1	088341 64028 NS

All pad adapters are non-stock. Contact your Norton representative for current order quantities and lead-times.

MNA-23 Pad Adapters

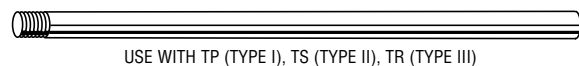
- For use on a right angle grinder: convert TS (Type II) and TR (Type III) back-up pad 1/4" diameter solid shanks to threaded shanks.
- The larger 5/8"-11 adapter (for 4-1 1/2" discs) is used alone to convert to a 5/8"-11 thread.
- The 3/8"-24 insert (for 4" discs) is screwed into the 5/8"-11 adapter to create a 3/8"-24 thread adapter.



DISC DIAMETER	MODEL #	STD. PKG.	PART #
MNA-23 Pad Adapters - TS (Type II) and TR (Type III)			
3/4 - 4	MNA-23 3/8"-24 and 5/8"-11 THD.	1	088341 62764 NS

NS Non-stock. Ask your Norton representative for current order quantities and lead-times

1/4" Diameter Extension Mandrel



MODEL NO.	LENGTH	STD. PKG.	PART #
1/4" Diameter Extension Mandrel 1/4-20 Thread			
EM-144	4"	1	088341 54185
EM-146	6"	1	088341 54186
EM-148	8"	1	088341 54187



Our new Norton pneumatic die grinder quickly and comfortably accomplishes many portable applications without changing machines – including jobs for abrasive specialties (cartridge and spiral rolls...), small diameter flap wheels, mounted points, and carbide burrs.

- Weight of tool:** 1.4 lbs.
- Compressed air:** 6.2 bar (90psi)
- Maximum permissible operating pressure:** 6.2 bar (90psi)
- Recommended operating pressure:** 6.2 bar (90psi)
- Horsepower:** 0.9HP
- Free speed:** 25,000 rpm
- Air consumption @90psi:** 85 l/min (3 CFM)
- Noise characteristic value in accordance with EN ISO 15744 (ISO 15744):**
 - A-weighted sound pressure level at workstation 87.3 dB
 - A-weighted sound power level 98.3 dB
 - Peak C-weighted instantaneous sound pressure level at workstation < 130 dB
 - Measurement uncertainty (Standard) 3 dB
- Vibration value according to EN ISO 28927-12: Measurement uncertainty (Standard):** 3.00 m/s²
0.84 m/s²
- Recommended lubrications:** Air drill oil 20#
- Sanding tool specifications:** Pad Size 2" Collet
Chuck 1/8" (3 mm) and 1/4" (6 mm)
- Applications and suitability:** Final surface finishing, chamfering, deburring of architectural millwork, sheet metal and surface prep, zinc casting, aluminum products, injection molds, etc.; general sanding and polishing.

Put the power right in the palm of your hand with our die grinder



PNEUMATIC DIE GRINDER

- Comfortable during prolonged use thanks to vibration-limiting technology, ergonomic design, and streamlined non-slip grip
- Adaptable to the needs of each job with speed regulation and two collet inserts in 1/8" and 1/4"
- Compatible with many accessories including cartridge rolls, spiral rolls, square pads, cross pads, overlap slotted discs, flap wheels, mounted points and carbide burrs

DESCRIPTION	STD. PKG.	PART #
Norton Pneumatic Die Grinder		
Single Die Grinder with 1/8" and 1/4" collets	1	699573 08000
Die Grinder Kit*	1	699573 08001
Kit includes:		
1 die grinder with 1/8" and 1/4" collets		
100 – 3/8" x 1-1/2" x 1/8", 80 grit Merit R228 cartridge rolls (088341 80232)		
1- M9 cartridge roll mandrel (088341 81209)		
10 – 1" x 1" x 1/4" shank, 60 grit Blaze R920 flap wheels (662611 51170)		
5 – 1" x 1" W220, 1/4" x 1-1/2" spindle Gemini 38A60-P mounted points (614636 24566)		
1 – 1/2" x 1" SF5 Double-Cut carbide burr (699573 08021)		



How to Use a
Pneumatic Die Grinder
nortonsga.us/44yj2
Or Visit
nortonsga.us/diegrinder



Cartridge rolls are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive. A valuable abrasive tool for reaching into corners, where larger diameter tools cannot work

Applications:

Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing or removing machine tool marks, and edge breaking.

Stock Shapes:

Cartridge rolls, half-glued

Grit Range:

36 - 320

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide

Backing:

X-weight cotton, X-weight poly-cotton

Construction:

All cartridge roll part numbers shown are resin bond, half-glued. Quarter and full glue are also available for quotation as made-to-order products.

Maximum RPM:

1/8" to 1/2" - 23,000

5/8" to 1" - 18,000

1" to 1-1/2" - 15,000

Machine Used:



Application/Grit Recommendation Guide

COARSER (GRINDING) ←					→ FINER (FINISHING)				
36	40	50	60	80	120	180	240	320	
Blending Out Heavy Machine Marks									
Removing Heavy Burrs									
Applying Heavy Scratch Pattern									
Removing Flash/Parting Lines									
Removing Rust/Scale/Pit Marks									
		Preparing Metal for Painting							
		Blending Out Medium Machine Marks							
				Blending Metal Surfaces					
				Applying Light Scratch Pattern					
						Fine Blending and Cleaning			
							Metal Finishing and Polishing		

Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel



BLAZE R920 CERAMIC ALUMINA

- Premium ceramic alumina abrasive grain provides greatest productivity with significantly faster cut rates; resists wear resulting in 50% – 300% longer life; supersized for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Constructed of rolled and half-glued abrasive strips that break down to expose next layer of abrasive

Better choice for accessing tight areas and where long life & fast cut are required



PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide or zirconia alumina alternatives
- Improved resin bond system provides longer life; supersized for cool cutting
- Versatile X-weight poly cotton backing for flexibility and life

Good starting specification for flash removal, polishing, or removing machine tool marks and edge breaking on all types of metal



MERIT R228 ALUMINUM OXIDE

- Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Constructed of rolled and half-glued abrasive strips that break down to expose next layer of abrasive



TIER:	BEST	BETTER
TRADENAME:	BLAZE R920	PINK R928
ABRASIVE:	Ceramic Alumina	Ceramic Alumina
OTHER:	Supersize	Supersize

SIZE (D x L x H)	GRIT	STD. PKG.	PART #	PART #
1/4 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	662611 94384	699573 39765
	80	100	662611 94394	699573 39766
	120	100	662611 94397	699573 39767
3/8 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	662611 94392	699573 39768
	80	100	662611 94395	699573 39769
	120	100	662611 94398	699573 39770
1/2 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	662611 94393	699573 39771
	80	100	662611 94396	699573 39772
	120	100	662611 94399	699573 39774



TIER:	GOOD
TRADENAME:	MERIT R228
ABRASIVE:	Aluminum Oxide

SIZE (D x L x H)	GRIT	STD. PKG.	PART #	
3/16 x 3/4 x 3/32 3/16 x 1 x 3/32 Use M-2E Mandrel	80	100	088341 80005	
	60	100	088341 80023	
	80	100	088341 80024	
	100	100	088341 80025	
	120	100	088341 80026	
	150	100	088341 80027	
1/4 x 3/4 x 1/8 Use M-3 or M-7 Mandrel	180	100	088341 80028	
	240	100	088341 80030	
	80	100	088341 80043	
	1/4 x 1 x 1/8 Use M-4 or M-8 Mandrel	50	100	088341 80060
		60	100	088341 80061
		80	100	088341 80062
100		100	088341 80063	
120		100	088341 80064	
150		100	088341 80065	
1/4 x 1-1/2 x 1/8 Use M-9 Mandrel	180	100	088341 80066	
	320	100	088341 80070	
	50	100	088341 80079	
	60	100	088341 80080	
	80	100	088341 80081	
	100	100	088341 80082	
1/4 x 2 x 1/8 Use M-10 Mandrel	120	100	088341 80083	
	150	100	088341 80084	
	180	100	088341 80085	
	320	100	088341 80089	
	80	100	088341 80100	
	120	100	088341 80102	
5/16 x 1 x 1/8 Use M-4 or M-8 Mandrel	80	100	088341 80138	
	120	100	088341 80140	
5/16 x 1-1/2 x 1/8 Use M-9 Mandrel	80	100	088341 80157	



TIER:	GOOD
TRADENAME:	MERIT R228
ABRASIVE:	Aluminum Oxide

SIZE (D x L x H)	GRIT	STD. PKG.	PART #	
3/8 x 3/4 x 1/8 Use M-7 Mandrel	120	100	088341 80197	
	3/8 x 1 x 1/8 Use M-8 Mandrel	60	100	088341 80213
		80	100	088341 80214
		100	100	088341 80215
		120	100	088341 80216
		150	100	088341 80217
		180	100	088341 80218
	3/8 x 1-1/2 x 1/8 Use M-9 Mandrel	240	100	088341 80220
		36	100	088341 80228
		40	100	088341 80229
		50	100	088341 80230
		60	100	088341 80231
80		100	088341 80232	
3/8 x 2 x 1/8 Use M-10 Mandrel	100	100	088341 80233	
	120	100	088341 80234	
	180	100	088341 80236	
	240	100	088341 80238	
	320	100	088341 80240	
	60	100	088341 80250	
1/2 x 1 x 1/8 Use M-8 Mandrel	80	100	088341 80251	
	120	100	088341 80253	
	50	100	088341 80287	
	60	100	088341 80288	
	80	100	088341 80289	
	120	100	088341 80291	
1/2 x 1 x 1/8 Use M-8 Mandrel	150	100	088341 80292	
	180	100	088341 80293	
240	100	088341 80295		

Continued

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Continued

Refer to the back of this section for mandrels.



TIER: **GOOD**
 TRADENAME: **MERIT R228**
 ABRASIVE: Aluminum Oxide

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8 Use M-9 Mandrel	40	100	088341 80305
	50	100	088341 80306
	60	100	088341 80307
	80	100	088341 80308
	100	100	088341 80309
	120	100	088341 80310
	150	100	088341 80311
1/2 x 2 x 1/8 Use M-10 Mandrel	180	100	088341 80312
	240	100	088341 80314
	320	100	088341 80316
	60	100	088341 80326
	80	100	088341 80327
	120	100	088341 80329
	1/2 x 2 x 3/16 Use M-17 Mandrel	60	100
80		100	088341 80653
120		100	088341 80338
5/8 x 1 x 3/16 Use M-15 Mandrel	80	100	088341 80364
	60	100	088341 80275
5/8 x 1-1/2 x 1/8 Use M-9 Mandrel	80	100	088341 80789
	60	100	088341 80382
5/8 x 1-1/2 x 3/16 Use M-16 Mandrel	80	100	088341 80383
	60	100	088341 82505
5/8 x 2 x 1/8 Use M-10 Mandrel	80	100	088341 81080
	60	100	088341 80401
5/8 x 2 x 3/16 Use M-10 Mandrel	80	100	088341 80402
	80	100	088341 80469
3/4 x 1 x 1/8 Use M-8 Mandrel	80	100	088341 80459
	120	100	088341 80461

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.
Continued



TIER: **GOOD**
 TRADENAME: **MERIT R228**
 ABRASIVE: Aluminum Oxide

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/4 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	088341 80490
	80	100	088341 80527
	120	100	088341 80487
3/4 x 1-1/2 x 3/16 Use M-16 Mandrel	50	100	088341 80476
	60	100	088341 80477
	80	100	088341 80478
	120	100	088341 80480
3/4 x 1-1/2 x 1/4 100/box 400/case Use M-21 Mandrel	180	100	088341 80482
	60	100	088341 80489
	80	100	088341 80358
	120	100	088341 80488
3/4 x 2 x 1/8 Use M-10 Mandrel	150	100	088341 82807
	60	100	088341 80791
3/4 x 2 x 3/16 Use M-17 Mandrel	40	100	088341 80494
	60	100	088341 80496
	80	100	088341 80497
	100	100	088341 80498
3/4 x 2 x 1/4 Use M-22 Mandrel	120	100	088341 80499
	60	100	088341 80506
	80	100	088341 81297
	100	100	088341 80509
1 x 1-1/2 x 1/8 Use M-9 Mandrel	120	100	088341 80507
	80	100	088341 80584
1 x 1-1/2 x 1/4 Use M-21 Mandrel	60	100	088341 80587
	80	100	088341 80583
1 x 2 x 3/16 Use M-17 Mandrel	60	100	088341 80591
	80	100	088341 80592
1 x 2 x 1/4 Use M-22 Mandrel	60	100	088341 80603
	80	100	088341 80606

Refer to the back of this section for mandrels.



Spiral rolls are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive.

Applications:

Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking.

Shapes:

Full taper (all stock part numbers), half taper, and sidewall taper

Grit Range:

36 - 240

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide

Backing:

X-weight cotton, X-weight poly cotton

Construction:

All spiral roll part numbers shown are full tapered, resin bond, half glued
Half-tapered and sidewall-tapered are available for quotation as made-to-order products
Quarter and full glue are also available for quotation as made-to-order products

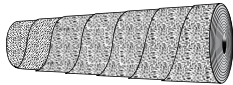
Maximum RPM:

1/8" to 1/2" - 23,000

5/8" to 1" - 18,000

1" to 1-1/2" - 15,000

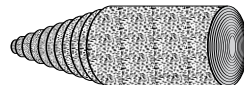
Machine Used:



Full Taper

- Especially useful for grinding/polishing of channels, fillets and radii, and deburring small holes
- Full taper used when the area to be finished is hard to reach with a full cartridge roll
- The tapered roll conforms to smaller areas
- Fits into irregular concaves, contours, channels

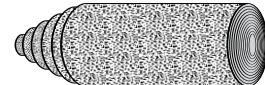
All part numbers shown are full tapered



Half Taper

- Used when the area to be finished is not narrow but a beginning point on the roll is needed
- The portion of the roll that is not tapered is then used to finish off the sides

Available for quotation as made-to-order products



Sidewall Taper

- The portion of the roll that is tapered guides the roll down to the area to be finished
- The sidewall then finishes off the sides

Available for quotation as made-to-order products

Application/Grit Recommendation Guide

COARSER (GRINDING)					FINER (FINISHING)			
36	40	50	60	80	120	180	240	320
Blending Out Heavy Machine Marks								
Removing Heavy Burrs								
Applying Heavy Scratch Pattern								
Removing Flash/Parting Lines								
Removing Rust/Scale/Pit Marks								
		Preparing Metal for Painting						
		Blending Out Medium Machine Marks						
				Blending Metal Surfaces				
				Applying Light Scratch Pattern				
						Fine Blending and Cleaning		
							Metal Finishing and Polishing	



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the premium, sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant; supersized for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive



Better choice for accessing tight areas and where long life and fast cut are required

PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide or zirconia alumina alternatives
- Improved resin bond system provides longer life; supersized for fast cutting
- Versatile X-weight poly cotton backing for flexibility and life



Good choice for cooler grinding/polishing of channels, fillets and radii, and deburring small holes at a low initial price

MERIT R228 ALUMINUM OXIDE

- Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive





TIER:	BEST	BETTER	GOOD
TRADENAME:	BLAZE R920	PINK R928	MERIT R228
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Aluminum Oxide
OTHER:	Supersize	Supersize	

SIZE (D x L x H)	GRIT	STD. PKG.	PART #	PART #	PART #
3/8 x 1 x 1/8 Use M-8 Mandrel	60	100			088341 81714
	80	100			088341 81715
	120	100			088341 81717
3/8 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100	662611 94481	699573 39775	088341 81724
	80	100	662611 94490	699573 39785	088341 81708
	120	100	662611 94491	699573 39787	088341 81727
	180	100			088341 81709
1/2 x 1 x 1/8 Use M-8 Mandrel	60	100			088341 81734
	80	100			088341 81735
	120	100			088341 81737
1/2 x 1-1/2 x 1/8 Use M-9 Mandrel	50	100			088341 81743
	60	100	662611 94484	699573 39790	088341 81744
	80	100	662611 94492	699573 39791	088341 81745
	100	100			088341 81746
	120	100	662611 94495	699573 39792	088341 81747
	180	100			088341 81749
1/2 x 2 x 1/8 Use M-10 Mandrel	240	100			088341 81750
	60	100			088341 81754
	80	100			088341 81755
5/8 x 1-1/2 x 1/8 Use M-9 Mandrel	120	100			088341 81757
	100	100			088341 81776
	80	100			088341 81444
5/8 x 1-1/2 x 3/16 Use M-16 Mandrel	80	100			088341 80886
	80	100			088341 81808
3/4 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100			088341 81808
	80	100			088341 81809
	120	100			088341 81811
3/4 x 2 x 3/16 Use M-17 Mandrel	60	100			088341 81820
	60	100		699573 39790	088341 81240
1 x 1-1/2 x 1/8 Use M-9 Mandrel	60	100			088341 81878
1 x 2 x 3/16 Use M-17 Mandrel	60	100			088341 81878
	80	100			088341 81879

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Refer to the back of this section for mandrels.

Square & Cross Pads, Overlap Slotted Discs



Square pads, cross pads and overlap slotted discs are all used on high-speed pneumatic tools for deburring, blending, cleaning, and polishing applications. All of these abrasive specialties are designed for applications in small, tight, hard-to-access locations on parts that are being finished.

Benefits:

Variety of shapes and sizes to fit application and part geometry
Shapes provide flexibility for the application, while eliminating aggressiveness of the sanding action
Cross pads allow visibility of the surface while sanding, to ensure correct amount of material is removed

Grit Range:

50 – 180

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide

Backing:

X-weight cotton, X-weight poly-cotton

Construction

Standard quick-change eyelet for easy mounting and removal on quick-change mandrel minimizes downtime; Mandrel use increases range and versatility

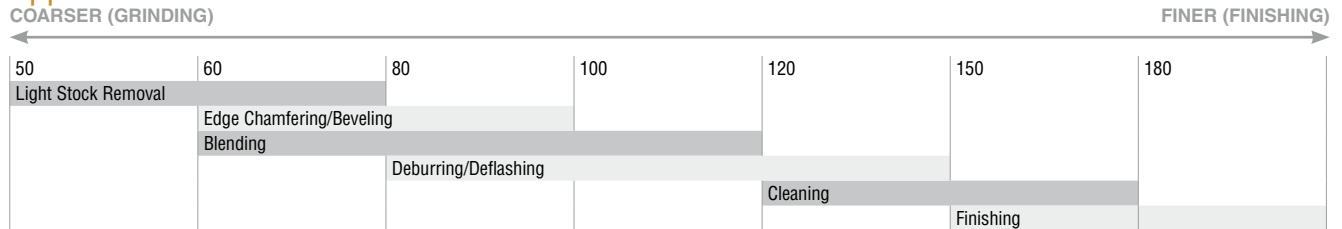
Maximum RPM:

1" Diameter – 25,000 3" Diameter – 12,000 to 14,000
1-1/2" to 2" Diameter – 18,000 to 23,000 4" Diameter – 8,000 to 12,000
2-1/2" Diameter – 14,000 to 18,000 5" to 6" Diameter – 5,500 to 7,500

Machine Used:



Application/Grit Recommendation Guide



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel



BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the sharp, longest-lasting ceramic abrasive grains and advanced supersize grinding aid for cool cutting
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Corners wear down consistently, exposing fresh abrasive; as these become round, they become less aggressive and run even smoother, with less stock removal – to retain workpiece shape

Better choice for accessing tight areas and where long life & fast cut are required



PINK R928 CERAMIC ALUMINA

- Excellent option for reaching into corners and small areas, ceramic grain provides better performance than aluminum oxide and zirconia alternatives
- Improved resin bond system provides longer life; supersized for cool cutting
- Versatile X-weight poly cotton backing for flexibility and life

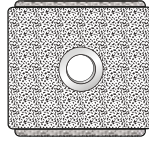
Good for most ID deburring and polishing applications



MERIT R228 ALUMINUM OXIDE

- Versatile, quality aluminum oxide abrasive grain ensures good cut rate
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Corners wear down consistently, exposing fresh abrasive; as these become round, they become less aggressive and run even smoother, with less stock removal – to retain workpiece shape

Square & Cross Pads, Overlap Slotted Discs



Square Pads

- Corners wear down consistently exposing fresh abrasive; the pad becomes round for less aggressive stock removal
- Grind almost as fast as hard wheels, but are much smoother and easier to control
- For quick blending of channels, fillets, corners, or spotting flat surfaces

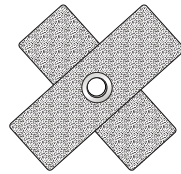


		TIER: BEST		BETTER		GOOD		
		TRADENAME: BLAZE R920		PINK R928		MERIT R228		
		ABRASIVE: Ceramic Alumina		Ceramic Alumina		Aluminum Oxide		
		OTHER: Supersize		Supersize				
SIZE (L x W x T)	EYELET	GRIT	STD. PKG.	PART #	PART #	PART #		
1 x 1 x 6 ply	8-32	80	100			088341	84826	
1 x 1 x 8 ply		80	100			088341	84124	
1-1/2 x 1-1/2 x 1/2	1/4-20	60	100			088341	84463	
		80	100			088341	84125	
2 x 2 x 1/2	1/4-20	60	100	662611	94520	699573	40138	
		80	100	662611	94552		088341	84397
		120	100	662611	94554	699573	40141	
2 x 2 x 3/4	1/4-20	80	100			088341	84394	
3 x 3 x 1/4	1/4-20	60	100	662611	94531			
		120	100	662611	94556			
3 x 3 x 1/2	1/4-20	50	100			088341	82152	
		60	100	662611	94528	699573	40146	
		80	100	662611	94557		088341	84336

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Refer to the back of this section for mandrels.

Square & Cross Pads, Overlap Slotted Discs



Cross Pads

- The shape of cross pads enables you to see through to the contact area, and provides greater flexibility than square pads to conform to variable internal diameters
- Used for close-tolerance polishing of small radii and channels, deburring, and finishing of bell-mouth configurations
- All pads are furnished with standard quick-change eyelet, as listed
- Plain hole sizes must be specified and are available for quotation as made-to-order products



TIER:	BEST	GOOD
TRADENAME:	BLAZE R920	MERIT R228
ABRASIVE:	Ceramic Alumina	Aluminum Oxide
OTHER:	Supersize	

SIZE (L x W x T)	PLY	EYELET	GRIT	STD. PKG.	PART #	PART #
3/4 x 3/4 x 3/8	8	3-48	80	100		088341 85578
1 x 1 x 3/8	8	3-48	60	100		088341 84943
			80	100		088341 85519
			100	100		088341 84195
			120	100		088341 85164
1-1/2 x 1-1/2 x 1/2	8	8-32	60	100	662611 94496	088341 84258
			80	100	662611 94508	088341 84465
			100	100		088341 82196
			120	100	662611 94511	088341 82148
2 x 2 x 1/2	8	8-32	60	100		088341 82156
			80	100		088341 82157
			120	100		088341 82132
2 x 2 x 3/4	8	8-32	60	100	662611 94502	088341 84128
			80	100	662611 94513	088341 84194
			120	100	662611 94516	
2-1/4 x 2-1/4 x 1/2	8	8-32	80	100		088341 84402
2-1/2 x 2-1/2 x 3/4	8	8-32	80	100		088341 84206
3 x 3 x 1	8	1/4-20	60	100	662611 94504	088341 82135
			80	100	662611 94549	088341 84119
			120	100	662611 94551	088341 84116
3 x 3 x 1	8	1/4-20	60	100		
			80	100		088341 82140
			120	100		
3 x 3 x 1-1/2	10	1/4-20	80	100		088341 82184
4 x 4 x 1	8	1/4-20	60	100		088341 84142
			80	100		088341 84135
			120	100		088341 84377

* Pink R928 3 x 3 x 1 are 8 ply.

Ceramic Alumina and Alumina Oxide cross pads are also available upon request as made-to-order products.

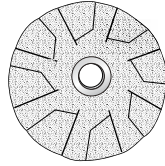
Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Refer to the back of this section for mandrels.

Square & Cross Pads, Overlap Slotted Discs



Overlap Slotted Discs



Overlap Slotted Discs

- Used for deburring and polishing radii, holes and cylinder walls
- Our "2 to a set" configuration cuts on the inward motion only
- The "4 to a set" configuration, assembled back to back, cuts on both the inward and outward motions
- All discs are furnished with standard quick-change eyelet
- Plain hole sizes must be specified and are available for quotation as made-to-order products



TIER:	BEST	GOOD
TRADENAME:	BLAZE R920	MERIT R228
ABRASIVE:	Ceramic Alumina	Aluminum Oxide
OTHER:	Supersize, 2 Per Set	2 Per Set

DIA.	EYELET	GRIT	STD. PKG.	PART #	PART #
1	8-32	60	100		088341 84346
		80	100		088341 84019
		100	100		088341 84224
		120	100		088341 84151
1-1/4	8-32	60	100		088341 84270
		80	100		088341 84065
		100	100		088341 84291
		120	100		088341 84084
1-1/2	8-32	60	100	662611 95051	088341 84066
		80	100	662611 95368	088341 84079
		100	100		088341 84279
		120	100		088341 86035
1-3/4	8-32	60	100		088341 84655
		80	100		088341 84042
2	8-32	60	100	662611 95054	
		80	100	662611 95055	088341 84076
		100	100		088341 84145
		120	100	662611 95056	
2-1/2	8-32	80	100		088341 84444
3	1/4-20	60	100	662611 95057	088341 84041
		80	100	662611 95058	088341 84077
		100	100		088341 84082
		120	100		088341 84344
4	1/4-20	60	100		088341 84000
		120	100		088341 85155
4-1/2	1/4-20	100	100		088341 84431

All overlap slotted discs are available (made-to-order) reinforced with a fiber washer

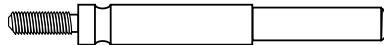
Ceramic Alumina and Alumina Oxide overlap slotted discs are also available upon request as made-to-order products.

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Quick-Change Mandrels for Overlap Slotted Discs, Square and Cross Pads

CROSS PAD SIZE DIA.	SQUARE PAD SIZE DIA.	OVERALL LENGTH	MODEL NO.	THD. SIZE	PART #
1/4, 3/8, and 1/2 wide		2-1/2	MM48-4	3-48	088341 83162
3/4, 1 wide	Up thru 1-1/2 sq. x 1/2 thick 2 sq. x 1/4 or 3/8 thick	3	MM32-4	8-32	088341 83163
		4	MM-32-4-4	8-32	088341 21680
		6	MM-32-4-6	8-32	088341 21681
All pads 2-1/2 x 1-1/2 and larger	2 sq. x 1/4 or 1/2 thick and larger	3	MM20-4	1/4-20	088341 83164

For overlap slotted discs, choose a mandrel with the same thread size as the disc



QUICK-CHANGE MANDREL



EXTENDED MANDREL



Best product for blending and polishing contours when smooth running is a primary concern. Used for finishing hard-to-reach areas, removing parting lines, imperfections, and burrs on all surfaces.

Benefits:

Spiral construction avoids shadow marks and provides smooth, chatter-free cutting action. Achieves close tolerances when finishing curved, contoured, and hard-to-reach areas. Fast cutting and removes toughest metal. Bands are easily removed and replaced.

Grit Range:

24 - 320

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide

Backing:

X-weight cotton

Other:

Use with rubber expanding drum

Machine Used:



DIE GRINDER

Application/Grit Recommendation Guide

← COARSER (GRINDING)					FINER (FINISHING) →				
24	36	40	50	60	80	120	180	240	320
Heavy Stock Removal									
Blending Out Heavy Machine Marks									
Removing Heavy Burrs									
Applying Heavy Scratch Pattern									
Removing Flash/Parting Lines									
Removing Rust/Scale/Pit Marks									
			Preparing Metal for Painting						
			Blending Out Medium Machine Marks						
					Blending Metal Surfaces				
					Applying Light Scratch Pattern				
							Fine Blending and Cleaning		
								Metal Finishing and Polishing	



Best choice for hard-to-grind materials including super alloys (cobalt, inconel, and titanium) and stainless steel

BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the next-generation of sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant
- Advanced, full resin bond system designed to promote exceptional grain retention for additional product life
- X-weight cotton backing and spiral construction avoid shadow marks and provide smooth, chatter-free cutting action



Good starting specification for all types of metal

MERIT R228 ALUMINUM OXIDE

- Tough and durable quality aluminum oxide abrasive removes tough metal
- X-weight cotton backing and spiral construction avoid shadow marks and provide smooth, chatter-free cutting action
- Achieves close tolerances on curved, contoured, and hard-to-reach areas



TIER: **BEST**
 TRADENAME: **BLAZE R920**
 ABRASIVE: Ceramic Alumina
 OTHER: Supersize

SIZE (D x W)	GRIT	STD. PKG.	PART #
1/2 x 1	80	100	662611 46014
3/4 x 1	60	100	662611 46017
	80	100	662611 46018
1 x 1	60	100	662611 46021
	80	100	662611 46022
1-1/2 x 1-1/2	60	100	662611 46025
	80	100	662611 46026
2 x 2	60	100	662611 46029
	80	100	662611 46030
3 x 3	60	50	662611 46033
	80	50	662611 46034



TIER: **GOOD**
 TRADENAME: **MERIT R228**
 ABRASIVE: Aluminum Oxide

SIZE (D x W)	GRIT	STOCK PKG. QTY.	NON-STOCK MOQ	PART #
3/8 x 1	80	100/box	300	088341 96645
1/2 x 1/2	50	100/box	300	088341 96228
	80	100/box	300	088341 96179
	100	100/box	300	088341 96189
	120	100/box	300	088341 96069
	180	100/box	300	088341 96209
1/2 x 1	36	100/box	300	088341 96591
	60	100/box	300	088341 96212
	80	100/box	300	088341 96215
1/2 x 2	80	100/box	200	088341 96669
3/4 x 3/4	60	100/box	300	088341 96168
	80	100/box	300	088341 96161
3/4 x 1	36	100/box	300	088341 96261
	50	100/box	300	088341 96515
	60	100/box	300	088341 96070
	80	100/box	300	088341 96071
	120	100/box	300	088341 96219
3/4 x 1-1/2	60	100/box	300	088341 96554
	80	100/box	300	088341 96249
3/4 x 2	80	100/box	200	088341 96756



TIER: **GOOD**
 TRADENAME: **MERIT R228**
 ABRASIVE: Aluminum Oxide

SIZE (D x W)	GRIT	STOCK PKG. QTY.	NON-STOCK MOQ	PART #
1 x 1	36	100/box	300	088341 96072
	40	100/box	300	088341 96073
	50	100/box	300	088341 96184
	60	100/box	300	088341 96075
	80	100/box	300	088341 96074
	120	100/box	300	088341 96177
1 x 1-1/2	36	100/box	200	088341 96525
1 x 2	80	100/box	200	088341 96268
1 x 3	36	100/box	100	088341 96665
	50	100/box	100	088341 97688
	60	100/box	100	088341 96676
1-1/2 x 1-1/2	120	100/box	100	088341 96197
	36	100/box	200	088341 96164
	50	100/box	200	088341 96176
	60	100/box	200	088341 96091
3 x 3	80	100/box	200	088341 96165

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Continued



TIER: **GOOD**

TRADENAME: **MERIT R228**

ABRASIVE: Aluminum Oxide

SIZE (D x W)	GRIT	STOCK PKG. QTY.	NON-STOCK MOQ	PART #
1-1/2 x 2	60	100/box	200	088341 96067
	80	100/box	200	088341 96533
1-1/2 x 3	60	100/box	100	088341 96703
	80	100/box	100	088341 96809
	120	100/box	100	088341 96343
2 x 1	80	100/box	200	088341 96166
	120	100/box	200	088341 96595
2 x 2	36	100/box	200	088341 96110
	60	100/box	200	088341 96173
2-1/4 x 3	36	100/box	100	088341 97140
	50	100/box	100	088341 96620
	80	100/box	100	088341 96270
	120	100/box	100	088341 96729
	150	100/box	100	088341 95857



TIER: **GOOD**

TRADENAME: **MERIT R228**

ABRASIVE: Aluminum Oxide

SIZE (D x W)	GRIT	STOCK PKG. QTY.	NON-STOCK MOQ	PART #
3 x 2	80	100/box	100	088341 96265
3 x 3	36	100/box	100	088341 96262
	50	100/box	100	088341 96253
	60	100/box	100	088341 96188 NS
	80	100/box	100	088341 96159
	100	100/box	100	088341 96250

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Expanding Rubber Drums

Spiral Bands are easily removed and replaced on the rubber expanding drum.



TIER: **GOOD**

TRADENAME: **RUBBER**

EXPANDING DRUMS

DRUM DIAMETER	WIDTH	SHANK DIAMETER	MAX. RPM	STD. PKG.	PART #
1/4	1/2	1/8	30,000	1	088341 96030
3/8	1/2	1/4	30,000	1	088341 96944 NS
3/8	1	1/8	18,000	1	088341 96011 NS
1/2	1/2	1/4	30,000	1	088341 96904
1/2	1	1/4	15,000	1	088341 96906
1/2	1-1/2	1/4	12,000	1	088341 96907
1/2	2	1/4	10,000	1	088341 96908
3/4	1/2	1/4	27,000	1	088341 96909 NS
3/4	3/4	1/4	24,000	1	088341 96910 NS
3/4	1	1/4	17,000	1	088341 96911
3/4	1-1/2	1/4	10,000	1	088341 96912
3/4	2	1/4	10,000	1	088341 96913

NS Non-stock, contact your Norton representative for current order quantities and lead-times.



TIER: **GOOD**


TRADENAME: **RUBBER**

EXPANDING DRUMS

DRUM DIAMETER	WIDTH	SHANK DIAMETER	MAX. RPM	STD. PKG.	PART #
1	1/2	1/4	20,000	1	088341 96914 NS
1	1	1/4	18,000	1	088341 96916
1	1-1/2	1/4	10,000	1	088341 96917
1	2	1/4	8,000	1	088341 96918
1-1/2	1	1/4	12,000	1	088341 96921
1-1/2	1-1/2	1/4	10,000	1	088341 96922
1-1/2	2	1/4	8,000	1	088341 96923
2	1	1/4	11,000	1	088341 96926
2	1-1/2	1/4	8,000	1	088341 96927
2	2	1/4	6,000	1	088341 96928
3	1	3/8	3,000	1	088341 96929 NS
3	2	3/8	3,000	1	088341 96930 NS
3	3	3/8	3,000	1	088341 96931



Tapered cone points are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive. Tapered cone points are similar to cartridge rolls but their shape lends greater accessibility to many difficult-to-reach work areas. They are used for deburring holes and in close tolerance work areas.

- Applications:** Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking.
- Grit Range:** 50 - 320
- Abrasive Grain:** Aluminum Oxide
- Backing:** X-weight cotton
- Construction:** Popular sizes and mandrels are listed, with additional sizes available upon request as made-to-order products
Ceramic alumina and silicon carbide cone points are available upon request as made-to-order products
- Maximum RPM:** 1/8" to 1/2" – 23,000
5/8" to 1" – 18,000
1" to 1-1/2" – 15,000
- Machine Used:**  DIE GRINDER

Application/Grit Recommendation Guide

COARSER (GRINDING) ←									→ FINER (FINISHING)
36	40	50	60	80	120	180	240	320	
Blending Out Heavy Machine Marks									
Removing Heavy Burrs									
Applying Heavy Scratch Pattern									
Removing Flash/Parting Lines									
Removing Rust/Scale/Pit Marks									
		Preparing Metal for Painting							
		Blending Out Medium Machine Marks							
				Blending Metal Surfaces					
				Applying Light Scratch Pattern					
						Fine Blending and Cleaning			
							Metal Finishing and Polishing		



Good starting specification for flash removal, polishing, or removing machine tool marks and edge breaking on all types of metal in difficult-to-reach work areas

MERIT R228 ALUMINUM OXIDE TAPERED CONE POINTS

- Quality aluminum oxide abrasive delivers long life
- X-weight cotton cloth provides extended durability, conformability, and superior wear resistance; strong resin bond system provides good grain retention and life
- Full taper construction consisting of rolled and half-glued abrasive strips that break down to expose next layer of abrasive

TIER: GOOD			
TRADENAME: MERIT R228			
ABRASIVE: Aluminum Oxide			
SIZE (D x L)	GRIT	STD. PKG.	PART #
3/16 x 1 Use K-110 Mandrel	60	500	088341 86893
	80	500	088341 80918
	100	500	088341 82197
	120	500	088341 82199
	150	500	088341 82200
	180	500	088341 86894
	240	500	088341 86895
	320	500	088341 82855

TIER: GOOD			
TRADENAME: MERIT R228			
ABRASIVE: Aluminum Oxide			
SIZE (D x L)	GRIT	STD. PKG.	PART #
5/16 x 1-1/2 Use B-20 Mandrel	80	500	088341 80873
	100	500	088341 82043
	120	500	088341 82717
	150	500	088341 86890
	240	500	088341 82044
	320	500	088341 82537

Refer to next page for mandrels.

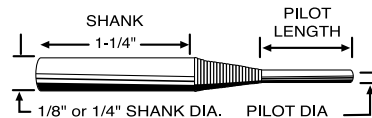
Cartridge and Spiral Roll Mandrels

MODEL #	PILOT DIA.	PILOT LENGTH	SHANK DIA.	SHANK LENGTH	OVERALL LENGTH	PART #
Cartridge and Spiral Roll Mandrels						
M-2E	3/32	3/4	1/4	1	3	088341 83799 NS
M-2	3/32	1	1/8	1	3	088341 81202
M-3	1/8	1/2	1/8	1	2-1/2	088341 81203
M-4	1/8	3/4	1/8	1	2-1/2	088341 81204
M-5	1/8	1	1/8	1	2-3/4	088341 81205
M-6	1/8	1-1/2	1/8	1	2-1/2	088341 81206 NS
M-7	1/8	1/2	1/4	1-1/4	2-1/4	088341 81207
M-8	1/8	3/4	1/4	1-1/4	2-1/2	088341 81208
M-9	1/8	1	1/4	1-1/4	2-3/4	088341 81209
M-10	1/8	1-1/2	1/4	1-1/4	3-1/4	088341 81210
M-11	1/8	2	1/4	1-1/4	4	088341 81211 NS
M-12	3/16	1/2	1/8	1-1/4	2-1/4	088341 81212 NS
M-13	3/16	3/4	1/8	1-1/4	2-1/2	088341 81213 NS
M-14	3/16	1/2	1/4	1-1/4	2-1/2	088341 81214 NS
M-16	3/16	1	1/4	1-1/4	3	088341 81216
M-17	3/16	1-1/2	1/4	1-1/4	3-1/2	088341 81217
M-18	3/16	2	1/4	1-1/4	4	088341 81218
M-19	1/4	1/2	1/4	1-1/4	2-1/2	088341 81219 NS
M-21	1/4	1	1/4	1-1/4	3	088341 81221
M-22	1/4	1-1/2	1/4	1-1/4	3-1/2	088341 81222
M-23	1/4	2	1/4	1-1/4	4	088341 81223 NS
M-24	5/16	3/4	1/4	1-1/4	2-3/4	088341 81224 NS
M-25	5/16	1	1/4	1-1/4	3	088341 81225 NS
M-26	5/16	1-1/2	1/4	1-1/4	3-1/2	088341 81226 NS
M-27	5/16	2	1/4	1-1/4	4	088341 81227 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.
Standard Package = 1

Recommended Pilot Length for Mandrels

3/4 Roll Length	Use 1/2 Pilot
1 Roll Length	Use 3/4 Pilot
1-1/2 Roll Length	Use 1 Pilot
2 Roll Length	Use 1-1/2 Pilot



Extra Shank Length Mandrels for Cartridge Rolls and Spiral Rolls

MODEL #	SHANK LENGTH	OVERALL LENGTH	PART NO.
Extras Shank Length Mandrels			
M-8-4	4	5-1/4	088341 80116
M-8-6	6	7-1/4	088341 80122
M-9-2.5	2-1/2	4	088341 80096
M-9-3	3	4-1/2	088341 80129
M-9-4	4	5-1/2	088341 80074 NS
M-9-6	6	7-1/2	088341 80131
M-10-4	1-3/4	4	088341 80092 NS
M-10-6	3-3/4	6	088341 80145

All Extra Shank Length mandrels are 1/4" diameter

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.
Standard Package = 1

Tapered Cone Point Mandrels

DESCRIPTION	SHANK	PART #
Cone Point Mandrels		
A-10	1/4	088341 81300
B-20	1/4	088341 81301
C-30	1/4	088341 81302
D-40	1/4	088341 81303
E-50	1/4	088341 81304
F-60	1/4	088341 81305
G-70	1/4	088341 81306
I-90	1/4	088341 81308
K-110	1/8	088341 81310

Standard Package = 1





These test kits feature the most popular range and sizes of our coated specialty products in convenient kit formats. Ideal for small job shops, or for travelling to a job site. Our cartridge roll kits are great when you need a small quantity, but a wide range of grits and sizes



Ceramic Alumina Cartridge Roll Test Kit

- Part # 662610**66726**
- Kit includes a variety of our ceramic alumina cartridge rolls, spiral rolls and mandrels in popular sizes and grits.



Aluminum Oxide Cartridge Roll Test Kit "CR"

- Part # 088341**181061**
- Includes over 120 pieces of our most popular sizes, grits and shapes with their appropriate mandrels.



Porting Test Kit "APK-MO"

- Part # 088341**169032**
- The samples in this kit highlight specialties for general metal and wood working polishing and finishing applications.

Cross Buffs

Best choice for blending, cleaning and polishing



CROSS BUFFS

- Unique design is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- Premium aluminum oxide grain for excellent cutting and finishing
- Firm durable web for high resistance to tearing on burrs and sharp edges

TIER: **BEST**
 TRADENAME: **HIGH STRENGTH**
 ABRASIVE: Aluminum Oxide
 ATTACHMENT: 8-32 Eyelet

SIZE (D x W)	GRIT	PLY	STD. PKG.	PART #
1-1/2 x 1/2	Medium	2	100	088341 89308
	Very Fine	2	100	088341 89307 NS
	Very Fine	3	100	088341 89309 NS

8-32 eyelets: Attach to MM32-4 mandrel. Part No. 088341**83163** (See description at end of Overlap Lotted Disc Section)
 NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Surface Preparation Stars

The perfect item for ID work



MERIT SURFACE PREPARATION STARS

- Star shape design is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- Premium aluminum oxide grain for excellent cutting and finishing
- Firm durable web for high resistance to tearing on burrs and sharp edges

TIER: **GOOD**
 TRADENAME: **MERIT SURFACE PREP**
 ABRASIVE: Aluminum Oxide
 ATTACHMENT: 1/4-20 Eyelet

SIZE (D x EYELET)	GRIT	STD. PKG.	PART #
1-1/2 x 1/4-20	C	100	088341 85923
	VF	100	088341 85925
2 x 1/4-20	C	100	088341 85926 NS
	M	100	088341 85927 NS
3 x 1/4-20	VF	100	088341 85928 NS
	C	100	088341 85929 NS
4 x 1/4-20	M	100	088341 85678 NS
	VF	100	088341 85931 NS
4 x 1/4-20	M	100	088341 85933 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.
 1/4-20 eyelets attach to MM20-4 mandrel, Part # 088341**83164** (See description at end of Overlap Slotted Disc Section.)

Non-Woven 1/4" Steel Shank Disc Wheels

Best choice for all of your tough stripping needs on all kinds of surfaces



BLAZE RAPID STRIP DISCS

- Ceramic alumina grain provides 2X cut rate, 2X life over silicon carbide products
- Advanced resin bond does not shed on rust-encrusted pieces, and prevents gouging and rework; does not snag when used for deburring
- Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering

Best choice for light deburring and finishing



DISC WHEELS

- Durable, longer lasting aluminum oxide abrasive leaves a more polished finish
- Discs are ganged together to form a wheel that is tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- These wheels are mounted on a 1/4 inch steel mandrel embedded in a strong epoxy core



TIER: **BEST**
 TRADENAME: **BLAZE RAPID STRIP**
 ABRASIVE: Ceramic Alumina

SIZE (D x 1/4 SHANK)	GRIT	PLY	MAX. RPM	STD. PKG.	PART #
4	Extra Coarse	1 Ply	8,000	5	776960 05713 NS
4	Extra Coarse	2 Ply	8,000	5	666233 75051 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.



TIER: **BEST**
 TRADENAME: **HIGH-STRENGTH**
 ABRASIVE: Aluminum Oxide

SIZE (D x 1/4 SHANK)	GRIT	PLY	MAX. RPM	STD. PKG.	PART #
2	Medium	2 Ply	12,000	10	088341 31551
2	Medium	4 Ply	12,000	10	088341 31554
3	Medium	2 Ply	8,000	10	088341 31558
	Very Fine	3 Ply	8,000	10	088341 31560
3	Medium	4 Ply	8,000	10	088341 31496
	Fine	5 Ply	8,000	10	088341 31557
	Very Fine	5 Ply	8,000	10	088341 31497
4	Fine	3 Ply	6,000	10	088341 31562 NS
4	Medium	4 Ply	6,000	10	088341 31564
5	Medium	2 Ply	4,000	10	088341 31567 NS
5	Medium	4 Ply	4,000	10	088341 31570
	Fine	5 Ply	4,000	10	088341 31571 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.
 Disc wheels are constructed by number of plies.



Flap wheels are an ideal choice for a wide variety of blending, deburring and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away, continually exposing fresh abrasives.

Applications:

Used for a wide range of metal fabrication and welding applications including stock removal, blending, deburring, cleaning, finishing, and polishing

Size Range:

Flap wheels with mounted steel shanks: 3/8" - 3" diameter

Flap wheels with mounted 1/4"-20 thread: 1" - 3" diameter

Flap wheels with arbor holes: 3" - 16" diameter

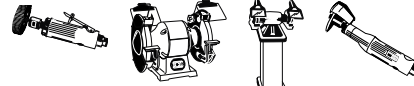
40 - 320

Grit Range:

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide Blend, Aluminum Oxide

Machine Used:



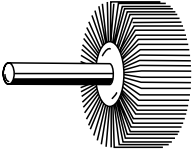

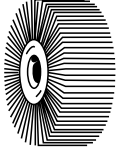
DIE GRINDER

BENCH GRINDER

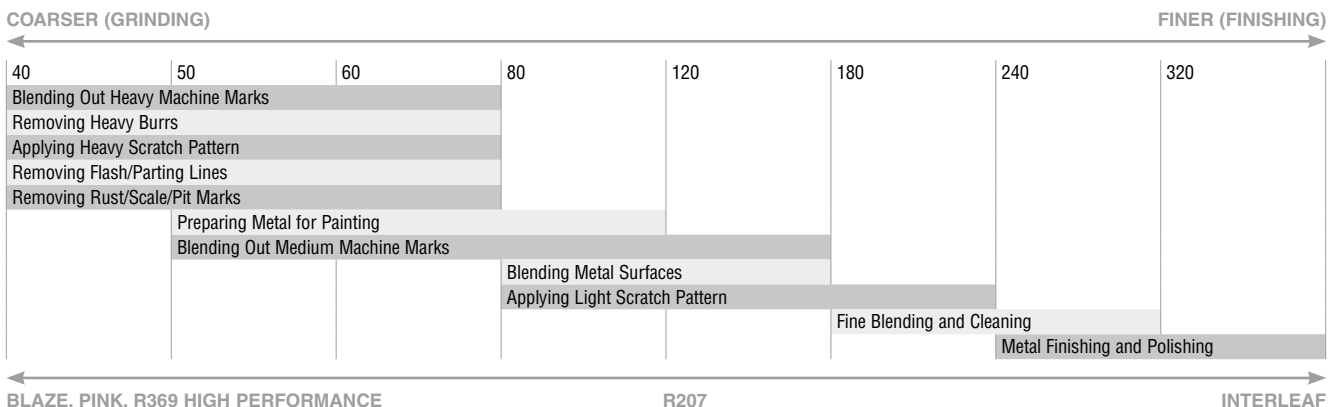
PEDESTAL GRINDER

PORTABLE GRINDER

Shape Recommendation Guide

Shape	Description/Application
	<p>Flap Wheels with Mounted Steel Shanks</p> <p>Wheels are designed with a 1/8" or 1/4" steel shank as an integral part of each wheel. These shanks run through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on air tools when using other abrasive products.</p>
	<p>Flap Wheels with Mounted 1/4"-20 Thread</p> <p>Wheels are designed with a 1/4"-20 thread and flange as an integral part of the wheel. These threads facilitate the quickest changes on air tools using flap wheels exclusively, as there are no special tools needed to change the flap wheel. Also allow extended reach with accessory mandrels.</p>
	<p>Flap Wheels with Arbor Holes</p> <p>For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.</p>

Application/Grit Recommendation Guide



BLAZE, PINK, R369 HIGH PERFORMANCE
See Non-Woven Flap Wheel section for Interleaf Flap Wheels

R207

INTERLEAF

Best choice for hard-to-grind materials, including superalloys (cobalt, inconel, and titanium) and stainless steel!



BLAZE R920 CERAMIC ALUMINA

- See significantly faster, cooler, burn-free results on the toughest jobs from the next-generation of sharp, longest-lasting ceramic abrasive grains and advanced grinding aid lubricant
- X-weight cotton flaps provide conformability and even wear
- Advanced self-lubricating grain treatment reduces heat on hard-to-grind materials

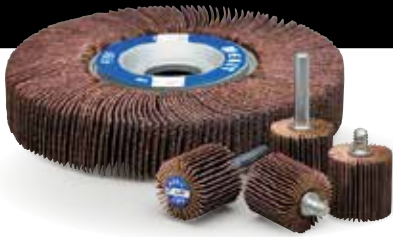
Better choice for blending, deburring and finishing on a wide range of materials



PINK R928 CERAMIC ALUMINA

- Ceramic grain provides better performance than zirconia alternatives
- Improved resin bond system provides longer life
- Versatile X-weight poly cotton backing for flexibility and life

Good choice for more durable flap wheel applications where aggressive cut and superior life are required



MERIT R369 HIGH PERFORMANCE A/O BLEND

- Long-lasting premium aluminum oxide blend with 2 to 3 times longer life
- Delivers an excellent cut rate on finishing operations
- Heavy cotton blended flaps provide extended durability, conformability, and superior wear resistance

Better choice for more flexible flap wheel applications where finish is required



MERIT R207 ALUMINUM OXIDE

- Solid-performing aluminum oxide abrasive delivers uniform stock removal and long life
- Heavy X-weight cotton flaps provide conformability and even wear
- Good general purpose starting specification for small deburring and cleaning jobs

Flap Wheel Test Kits

Mini 1/4"-20 Thread Test Kit "CQ"

- Part # 088341**38001**
- Includes ten, 1" to 3" diameter, 1/4"-20 thread mini flap wheels
- Each kit includes a 1/4"-20 QC-4 quick-change adapter

Mini 1/4" Steel Shank Test Kit "CMM"

- Part # 088341**38004**
- Includes ten wheels, 1" to 3" diameter in various grits
- The flap wheels are mounted on a 1/4" diameter hardened steel shank

Micro Mini 1/8" Steel Shank Test Kit "MMC"

- Part # 088341**31493**
- Includes 5 wheels, 3/8" to 1-3/16" in diameter
- The flap wheels are mounted on a 1/8" diameter hardened steel shank
- Ideal for fast polishing and light deburring of holes or grooves





Micro-Mini Flap Wheels with 1/8" Mounted Steel Shanks

- The smallest flap wheels, ranging from 3/8" to 1-3/16" diameter, mounted on a 1/8" diameter steel shank
- Provide fast polishing and light deburring of internal workpieces with holes or grooves as small as 1/2"



TIER: **GOOD**
 TRADENAME: **MERIT R369**
 ABRASIVE: Premium Aluminum Oxide
 BACKING: Y-Weight Cotton

SIZE (D x W x SK.)	GRIT	MAX. RPM	STD. PKG.	PART #
3/8 x 3/8 x 1/8	60	40,000	10	088341 37470
	80	40,000	10	088341 37471
	120	40,000	10	088341 37472
	180	40,000	10	088341 37473
	240	40,000	10	088341 37474
5/8 x 5/8 x 1/8	60	37,000	10	088341 37480
	80	37,000	10	088341 37481
	120	37,000	10	088341 37482
	180	37,000	10	088341 37483
	240	37,000	10	088341 37484
5/8 x 3/4 x 1/8	80	37,000	10	088341 37541
	120	37,000	10	088341 37542
	180	37,000	10	088341 37543
	240	37,000	10	088341 37544
	320	37,000	10	088341 37545
3/4 x 3/16 x 1/8	60	35,000	10	088341 37550
	80	35,000	10	088341 37551
	120	35,000	10	088341 37552
	180	35,000	10	088341 37553
	240	35,000	10	088341 37554
3/4 x 3/8 x 1/8	60	35,000	10	088341 37560
	80	35,000	10	088341 37561
	120	35,000	10	088341 37562
	180	35,000	10	088341 37563
	240	35,000	10	088341 37564
3/4 x 1/2 x 1/8	60	35,000	10	088341 37570
	80	35,000	10	088341 37571
	120	35,000	10	088341 37572
	180	35,000	10	088341 37573
	240	35,000	10	088341 37574
320	35,000	10	088341 37575	



TIER: **GOOD**
 TRADENAME: **MERIT R369**
 ABRASIVE: Premium Aluminum Oxide
 BACKING: Y-Weight Cotton

SIZE (D x W x SK.)	GRIT	MAX. RPM	STD. PKG.	PART #
3/4 x 5/8 x 1/8	60	35,000	10	088341 37580
	80	35,000	10	088341 37581
	120	35,000	10	088341 37582
	180	35,000	10	088341 37583
	240	35,000	10	088341 37584
3/4 x 3/4 x 1/8	60	35,000	10	088341 37590
	80	35,000	10	088341 37591
	120	35,000	10	088341 37592
	240	35,000	10	088341 37594
	320	35,000	10	088341 37595
1-3/16 x 1/8 x 1/8	80	30,000	10	088341 37491
	120	35,000	10	088341 37492
	180	35,000	10	088341 37493
	320	35,000	10	088341 37495
1-3/16 x 3/16 x 1/8	60	30,000	10	088341 37508
	80	35,000	10	088341 37501
	120	35,000	10	088341 37502
	180	35,000	10	088341 37503
1-3/16 x 3/8 x 1/8	60	30,000	10	088341 37511
	120	35,000	10	088341 37512
	180	35,000	10	088341 37513
	240	35,000	10	088341 37514
	320	35,000	10	088341 37515

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Micro-Mini Test Kit "MMC"

- Part # 088341**31493**
- Includes five wheels, 3/8" to 1-3/16" diameter in various grits, mounted on a 1/8" diameter hardened steel shank
- The "MMC" kit is ideal for fast polishing and light deburring of internal holes or grooves as small as 1/2"





Mini Flap Wheels with 1/4" Mounted Steel Shanks

- Small flap wheels, ranging from 1" to 3" diameter, mounted on a 1/4" diameter steel shank
- Very durable, long-lasting mini flap wheels for demanding, heavy stock removal applications



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	BLAZE R920	PINK R928	MERIT R369	MERIT R207
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Premium Aluminum Oxide	Aluminum Oxide
BACKING:	X-Weight Cotton	X-Weight Poly/Cotton	Y-Weight Cotton	X-Weight Cotton

SIZE (D x W x SK.)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
1 x 1/2 x 1/4	80	30,000	10				
	120	30,000	10				
1 x 5/8 x 1/4	40	30,000	10			088341 37105	
	60	30,000	10			088341 37100	636425 02576
	80	30,000	10			088341 37101	636425 02577
	120	30,000	10			088341 37102	636425 02578
	180	30,000	10			088341 31536	
1 x 1 x 1/4	240	30,000	10			088341 37104	
	40	30,000	10		699573 39701	088341 31259	
	60	30,000	10	662611 51170	699573 39702	088341 37310	636425 02580
	80	30,000	10	662611 51171	699573 39703	088341 37311	636425 02581
	120	30,000	10	662611 51172	699573 39704	088341 37312	636425 02582
	180	30,000	10			088341 37313	
	240	30,000	10			088341 37114	
1-3/8 x 5/8 x 1/4	320	30,000	10			088341 37315	
	60	30,000	10			088341 37320	
	80	30,000	10			088341 37321	
	120	30,000	10			088341 37322	
	180	30,000	10			088341 37323	
1-1/2 x 1/2 x 1/4	240	30,000	10			088341 37324	
	60	25,000	10				
1-1/2 x 1 x 1/4	80	25,000	10				
	40	25,000	10			088341 35140	
1-1/2 x 1 x 1/4	60	25,000	10			088341 37340	636425 02592
	80	25,000	10			088341 37141	636425 02593
	120	25,000	10			088341 37142	636425 02594
	180	25,000	10			088341 37343	
	240	25,000	10			088341 32101	
1-1/2 x 1-1/2 x 1/4	40	25,000	10			088341 30642	
	60	25,000	10			088341 30643	
	80	25,000	10			088341 30644	
	120	25,000	10			088341 30641	
2 x 1/2 x 1/4	180	25,000	10			088341 30695	
	60	25,000	10				
2 x 1/2 x 1/4	80	25,000	10				
	120	25,000	10				
2 x 3/4 x 1/4	40	25,000	10			088341 37158	
	60	25,000	10			088341 37160	
	80	25,000	10			088341 37161	
	120	25,000	10			088341 37162	
	180	25,000	10			088341 37163	

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

Continued

Mini Flap Wheels with 1/4" Mounted Steel Shanks *continued*



		TIER: BEST		TIER: BETTER		TIER: GOOD		TIER: GOOD	
		TRADENAME: BLAZE R920		TRADENAME: PINK R928		TRADENAME: MERIT R369		TRADENAME: MERIT R207	
		ABRASIVE: Ceramic Alumina		ABRASIVE: Ceramic Alumina		ABRASIVE: Aluminum Oxide		ABRASIVE: Aluminum Oxide	
		BACKING: X-Weight Cotton		BACKING: X-Weight Poly/Cotton		BACKING: Y-Weight Cotton		BACKING: X-Weight Cotton	
SIZE (D x W x SK.)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
2 x 1 x 1/4	40	25,000	10		699573 39705	088341 37377			
	60	25,000	10	662611 151173	699573 39706	088341 37370		636425 02600	
	80	25,000	10	662611 151174	699573 39711	088341 37371		636425 02601	
	120	25,000	10		699573 39712	088341 37372		636425 02602	
	180	25,000	10			088341 37373			
	240	25,000	10			088341 37374			
	320	25,000	10			088341 37375			
2 x 1-1/2 x 1/4	40	25,000	10			088341 37183			
	60	25,000	10			088341 37380			
	80	25,000	10			088341 37381			
	120	25,000	10			088341 37382			
	180	25,000	10			088341 37383			
2-1/2 x 1 x 1/4	40	20,000	10			088341 37408			
	60	20,000	10			088341 37410		636425 02608	
	80	20,000	10			088341 37411		636425 02609	
	120	20,000	10			088341 37412		636425 02610	
	180	20,000	10			088341 37413			
	240	20,000	10			088341 37633			
	320	20,000	10			088341 37415			
2-1/2 x 1-1/2 x 1/4	60	20,000	10			088341 37420			
	80	20,000	10			088341 37421			
	120	20,000	10			088341 37422			
3 x 1/2 x 1/4	60	20,000	10					636425 02612	
	120	20,000	10					636425 02614	
3 x 3/4 x 1/4	60	20,000	10			088341 37440			
	80	20,000	10			088341 37441			
3 x 1 x 1/4	40	20,000	10		699573 39713	088341 37456			
	60	20,000	10	662611 151176	699573 39714	088341 37450		636425 02620	
	80	20,000	10	662611 151177	699573 39715	088341 37451		636425 02621	
	120	20,000	10	662611 151178	699573 39716	088341 37252		636425 02622	
	180	20,000	10			088341 37253			
	240	20,000	10			088341 35339			
	320	20,000	10			088341 35341			
	3 x 2 x 1/4	40	20,000	10			088341 37460		
		60	20,000	10			088341 37260		
80		20,000	10			088341 37261			
120		20,000	10			088341 37262			
180		20,000	10			088341 37263			

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.



Mini 1/4" Steel Shank Test Kit "CMM"

- Part # 088341**38004**
- Includes ten wheels, 1" to 3" diameter in various grits mounted on a 1/4" diameter hardened steel shank



Mini Flap Wheels with 1/4"-20 Thread

- Mini flap wheels ranging from 1" to 3" diameter, mounted on a 14-20 thread that allows you to quickly spin the wheels on and off with no tools
- Designed for polishing and finishing intricate surfaces; cost-effective replacement for brushes, rubber points, and felt bobs



TIER:	BETTER	GOOD	GOOD
TRADENAME:	PINK R928	MERIT R369	MERIT R207
ABRASIVE:	Ceramic Alumina	Premium Aluminum Oxide	Aluminum Oxide
BACKING:	X-Weight Poly/Cotton	Y-Weight Cotton	X-Weight Cotton

SIZE (D x W x THD.)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #
1 x 5/8 x 1/4-20	60	30,000	10		088341 31001	636425 02624
	80	30,000	10		088341 31002	636425 02625
	120	30,000	10		088341 31003	636425 02626
1 x 1 x 1/4-20	40	30,000	10	699573 39718	088341 31027	
	60	30,000	10	699573 39719	088341 31008	636425 02628
	80	30,000	10	699573 39720	088341 31009	636425 02629
	120	30,000	10	699573 39721	088341 31010	636425 02630
	240	30,000	10		088341 31012	
	320	30,000	10		088341 31013	
1-3/8 x 5/8 x 1/4-20	60	30,000	10		088341 32001	636425 02632
	80	30,000	10		088341 32002	636425 02633
	120	30,000	10		088341 32003	636425 02634
1-5/8 x 1 x 1/4-20	40	25,000	10		088341 32051	
	60	25,000	10		088341 32015	636425 02638
	80	25,000	10		088341 32016	636425 02639
	120	25,000	10		088341 32017	636425 02640
	180	25,000	10		088341 32018	
2 x 1/2 x 1/4-20	80	25,000	10			636425 02643
	120	25,000	10			636425 02644
2 x 3/4 x 1/4-20	60	25,000	10		088341 33008	
	80	25,000	10		088341 33009	
	120	25,000	10		088341 33010	
	180	25,000	10			
2 x 1 x 1/4-20	40	25,000	10	699573 39722	088341 33044	
	60	25,000	10	699573 39723	088341 33015	636425 02646
	80	25,000	10	699573 39735	088341 33016	636425 02647
	120	25,000	10	699573 39736	088341 33017	636425 02648
	180	25,000	10		088341 33018	
	240	25,000	10		088341 33019	
2 x 1-1/2 x 1/4-20	60	25,000	10		088341 35201	
	80	25,000	10		088341 35202	
	120	25,000	10		088341 35203	
2-1/2 x 1 x 1/4-20	40	20,000	10		088341 34061	
	60	20,000	10		088341 34022	636425 02654
	80	20,000	10		088341 34023	
	120	20,000	10		088341 34024	
3 x 1/2 x 1/4-20	80	20,000	10			636425 02659
	120	20,000	10			
3 x 3/4 x 1/4-20	80	20,000	10		088341 35009	
	120	20,000	10		088341 35010	
3 x 1 x 1/4-20	40	20,000	10	699573 39737	088341 35230	
	60	20,000	10	699573 39738	088341 35015	636425 02664
	80	20,000	10	699573 39739	088341 35016	636425 02665
	120	20,000	10	699573 39740	088341 35017	636425 02666
	180	20,000	10		088341 35018	
240	20,000	10		088341 35019		

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.
For adapters for flap wheels with 1/4"-20 thread, see the end of this section

3" – 8" Flap Wheels with Arbor Holes

- Flap wheels ranging from 3" to 8" diameter with arbor holes
- Heavy cotton backing and premium abrasive grains combine to provide superior life with aggressive cut on a wide range of polishing and finishing applications



TIER: **GOOD** **GOOD**

TRADENAME: **MERIT R369** **MERIT R207**

ABRASIVE: Premium Aluminum Oxide Aluminum Oxide

BACKING: Y-Weight Cotton X-Weight Cotton

SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #
3 x 2 x 3/8	80	20,000	10	088341 35051	
	120	20,000	10	088341 35052	
3-1/2 x 1 x 5/8	40	20,000	10	088341 22001	
	60	20,000	10	088341 22003	
	80	20,000	10	088341 22004	
	120	20,000	10	088341 22006	
	180	20,000	10	088341 22007	
	240	20,000	10	088341 22008	
3-1/2 x 1-1/2 x 5/8	320	20,000	10	088341 22009	
	40	20,000	10	088341 22011	
	60	20,000	10	088341 22013	
	80	20,000	10	088341 22014	
	120	20,000	10	088341 22016	
3-1/2 x 2 x 5/8	180	20,000	10	088341 22018	
	40	20,000	10	088341 22022	
	60	20,000	10	088341 22024	
	80	20,000	10	088341 22025	
4 x 1 x 5/8	120	20,000	10	088341 22027	
	180	20,000	10	088341 22028	
	40	12,000	10	088341 22032	
	60	12,000	10	088341 22034	636425 02673
	80	12,000	10	088341 22035	636425 02674
	120	12,000	10	088341 22037	636425 02675
4 x 1-1/2 x 5/8	180	12,000	10	088341 22038	
	240	12,000	10	088341 22039	
	320	12,000	10	088341 22040	
	40	12,000	10	088341 22042	
	60	12,000	10	088341 22044	
4 x 2 x 5/8	80	12,000	10	088341 22045	
	120	12,000	10	088341 22047	
	240	12,000	10	088341 22050	
	40	12,000	10	088341 22053	
4 x 2 x 5/8	60	12,000	10	088341 22055	
	80	12,000	10	088341 22056	
	120	12,000	10	088341 22058	
	240	12,000	10	088341 22060	
	320	12,000	10	088341 22061	

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.
For flap wheel with arbor hole adapters and bushings, see the end of this section.

Continued

3" – 8" Flap Wheels with Arbor Holes *continued*



		TIER: BEST		GOOD		GOOD	
		TRADENAME: BLAZE R920		MERIT R369		MERIT R207	
		ABRASIVE: Ceramic Alumina		Premium Aluminum Oxide		Aluminum Oxide	
		BACKING: X-Weight Cotton		Y-Weight Cotton		X-Weight Cotton	
SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #	PART #
5 x 1-1/2 x 5/8	40	12,000	10		088341 22063		
	60	12,000	10		088341 22065		
	80	12,000	10		088341 22066		
	120	12,000	10		088341 22068		
	180	12,000	10		088341 22070		
	240	12,000	10		088341 22071		
6 x 1/2 x 1	320	12,000	10		088341 22072		
	40	6,000	10		088341 23001		
	60	6,000	10		088341 23003		
	120	6,000	10		088341 23005		
	150	6,000	10		088341 22198		
	180	6,000	10		088341 23006		
6 x 1 x 1	40	6,000	5		088341 23009		
	60	6,000	5	662611 46104	088341 23011	636425 02680	
	80	6,000	5	662611 46105	088341 23012	636425 02681	
	120	6,000	5	662611 46106	088341 23014	636425 02682	
	150	6,000	5		088341 23015		
	180	6,000	5		088341 23016		
6 x 1-1/2 x 1	240	6,000	5		088341 23017		
	40	6,000	5		088341 23020		
	60	6,000	5		088341 23022	636425 02686	
	80	6,000	5			636425 02687	
	120	6,000	5		088341 23025		
	180	6,000	5		088341 23027		
6 x 2 x 1	240	6,000	5		088341 23028		
	320	6,000	5		088341 23029		
	40	6,000	5		088341 23031		
	60	6,000	5		088341 23033	636425 02691	
	80	6,000	5		088341 23034	636425 02692	
	120	6,000	5		088341 23036	636425 02694	
6 x 3 x 1	180	6,000	5		088341 23038		
	240	6,000	5		088341 23039		
	320	6,000	5		088341 23040		
	80	6,000	3		088341 23056		
	120	6,000	3		088341 23058		
	180	6,000	3		088341 23060		
8 x 1 x 1	240	6,000	3		088341 23061		
	40	4,500	3		088341 23070		
	60	4,500	3		088341 23072		
	80	4,500	3		088341 23073		
8 x 2 x 1	120	4,500	3		088341 23075		
	180	4,500	3		088341 23077		
	40	4,500	3		088341 23092		
	60	4,500	3		088341 23094	636425 02700	
	80	4,500	3		088341 23095	636425 02701	
	120	4,500	3		088341 23097		
	180	4,500	3		088341 23099		
	320	4,500	3		088341 23101		

Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times. For flap wheel with arbor hole adapters and bushings, see the end of this section.



10" – 16" Large Flap Wheels with Arbor Holes

Wide range of applications:

- For polishing/grinding jobs in production work as well as clean-up and maintenance jobs
- Work on metals, plastic, rubber and wood

Easy to operate:

- No adjustments, dressing, or preparation required before or during operation

Fewer rejected parts:

- More forgiving than other abrasive products
- Reduce the possibility of flattening, gouging and surface deformation

TIER: **GOOD**
TRADENAME: **MERIT R369**
ABRASIVE: Premium Aluminum Oxide
BACKING: Y-Weight Cotton

SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #
10 x 1 x 1-3/4	40	4,000	4	088341 2223
	80	4,000	4	088341 24003
	120	4,000	4	088341 24005
	180	4,000	4	088341 24007
	240	4,000	4	088341 22889
10 x 1-1/2 x 1-3/4	320	4,000	4	088341 24009
	60	4,000	4	088341 24022
	80	4,000	4	088341 24023
10 x 2 x 1-3/4	180	4,000	4	088341 24027
	60	4,000	2	088341 24042
	80	4,000	2	088341 24043
10 x 3 x 1-3/4	120	4,000	2	088341 24045
	180	4,000	2	088341 24047
	60	4,000	2	088341 24077
12 x 1 x 1-3/4	80	4,000	2	088341 22316
	180	4,000	2	088341 22312
	60	3,000	4	088341 24085
	80	3,000	4	088341 22349
12 x 2 x 1-3/4	120	3,000	4	088341 22311
	180	3,000	4	088341 22315
	40	3,000	2	088341 22248
	60	3,000	2	088341 22250
12 x 4 x 1-3/4	120	3,000	2	088341 22269
	150	3,000	2	088341 22270
	240	3,000	2	088341 22273
	320	3,000	2	088341 22275
	180	2,400	1	088341 20017

TIER: **GOOD**
TRADENAME: **MERIT R369**
ABRASIVE: Premium Aluminum Oxide
BACKING: Y-Weight Cotton

SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #
14 x 1 x 1-3/4	60	2,400	1	088341 20020
	120	2,400	1	088341 20022
14 x 2 x 1-3/4	60	2,400	1	088341 20028
	80	2,400	1	088341 23215
	120	2,400	1	088341 22907
14 x 3 x 1-3/4	240	2,400	1	088341 20032
	120	2,400	1	088341 20035
	240	2,000	1	088341 20041
16 x 1 x 1-3/4	80	2,400	1	088341 20043
	120	2,400	1	088341 20044
	240	2,400	1	088341 20046
16 x 2 x 1-3/4	60	2,400	1	088341 20047
	120	2,400	1	088341 20050
	180	2,400	1	088341 20051
	240	2,400	1	088341 20052
16 x 3 x 1-3/4	120	2,400	1	088341 20055

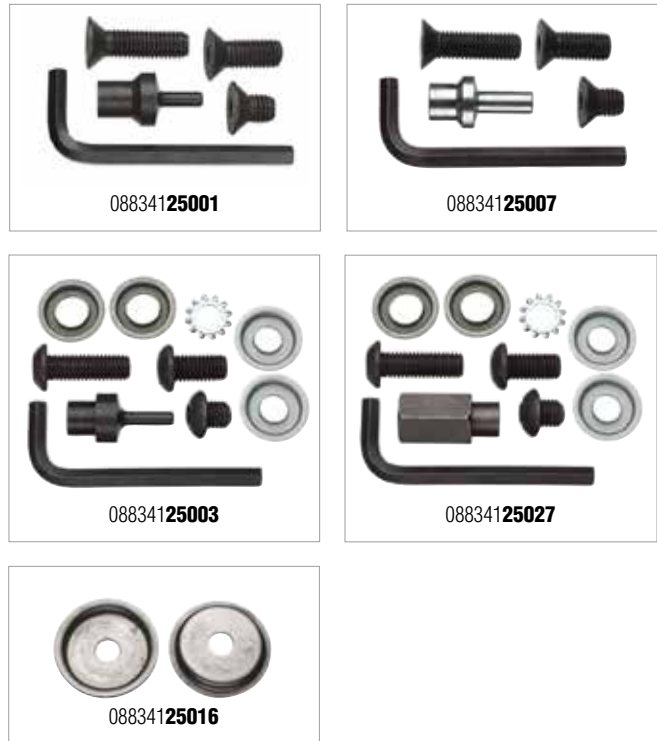
Some part numbers are non-stock; contact your Norton representative for status, order quantities and lead-times.

For flap wheel with arbor hole adapters and bushings, see the end of this section.

Adapter and Bushings for Flap Wheels with Arbor Holes

WHEEL DIAMETER	ADAPTERS	PART #
Shank Adapters		
3-1/2	1/4 Shank	088341 25001
3-1/2	3/8 Shank	088341 25007 NS
4-8	1/4 Shank	088341 25003
Threaded Mounting Adapters		
4-8	5/8-11 Thread	088341 25027
Reducing Bushings		
6-8	1 to 3/8	088341 25016 NS
	1 to 1/2	088341 25017
	1 to 5/8	088341 25018 NS
	1 to 3/4	088341 25019 NS
	1 to 7/8	088341 25020 NS
10-16	1 to 5/8	088341 22069 NS

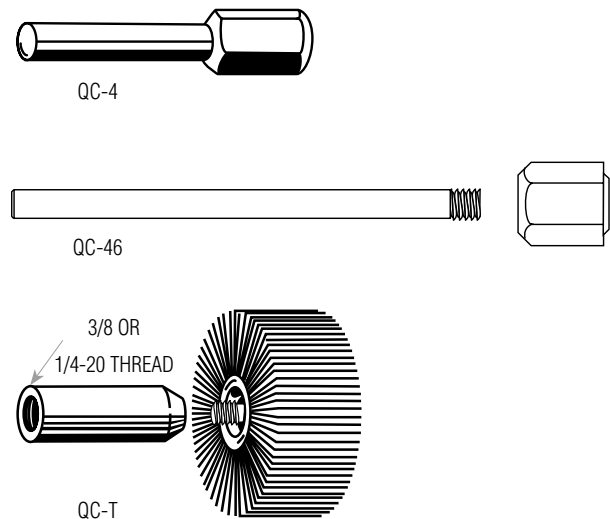
Standard packages = 1 adapter, 1 pair of bushings
 NS Non-stock. Contact your Norton representative for current order quantities and lead-times.
 For additional aluminum reducing bushings see non-woven convolute wheel section



Adapters for 1/4"-20 Thread Mini and Arbor Hole Flap Wheels

MODEL #	DESCRIPTION	PART #
Adapters		
ADAPT C	Fits 3 x 2 x 3/8 arbor flap wheel	088341 37009 NS
MA-100	Fits A.H. Mini Wheel	088341 37007 NS
QC-8	1/8 x 5/8	088341 37002 NS
QC-4	1/4 SK. Dia. x 5/8 SK. L.	088341 37001
QC-44	1/4 x 4	088341 37003
QC-46	1/4 x 6	088341 37004
QC-48	1/4 x 8	088341 37005
QC-T	1/4-20 Thread	088341 37012
QC-T	3/8-24 Thread	088341 37010

Standard package = 1 adapter
 Other thread sizes available for quotation
 NS Non-stock. Contact your Norton representative for current order quantities and lead-times.





Merit Sand-O-Flex Wheels

With their firm cushioning brushes, Sand-O-Flex's abrasive strips are forced into, around and over corners, hollow and fluted surfaces, and small openings. Pressure is distributed evenly over the surface to prevent loss of detail and the flattening of rounded areas; for sanding metals, woods, plastics, rubber and ceramic.

Sand-O-Flex wheels eliminate the need to hand-sand and are designed to fit most standard equipment. They load quickly and easily by turning the index knob as needed, allowing you to change grit size in minutes. Sand-O-Flex refills are available both scored (for finer, less aggressive work) and unscored. And, with the use of adapters, Sand-O-Flex wheels will fit most electric bench grinders.

Sand-O-Flex Wheel – Model 350-RP

- Diameter: 6-1/2" overall, 4" diameter high-impact plastic body
- 1" wide abrasive strips backed by 8 cushioning brushes
- 1/4" diameter steel shank
- Weight: 9-1/2 oz.
- Maximum operating speed: 2,400 RPM
- Special adapter required for bench grinder use
- Some assembly required

TIER: **GOOD**
TRADENAME: **MERIT SAND-O-FLEX**
ABRASIVE: Aluminum Oxide

MODEL #	GRIT	STD. PKG.	PART #
Sand-O-Flex Wheel			
350-RP		1	088341 11051
<i>Comes assembled with 80 grit A/O resin bond scored refill and brushes</i>			
Sand-O-Flex Accessories			
Replacement Brushes for 350-RP; 8 per set		1 set	088341 13003
Resin Bond Refills			
350-RP SCORED	60	10	088341 11052
	80	10	088341 11053
	100	10	088341 12114
	120	10	088341 11054
	180	10	088341 11057
Glue Bond Refills			
350-RP SCORED	80	10	088341 12054
	100	10	088341 12055
	120	10	088341 12056
350-RP UNSCORED	80	10	088341 12044





Non-woven surface finishing flap wheels are an ideal choice for a wide variety of blending and finishing applications common in the metal fabrication, welding and polishing industries. Flap wheels are conformable to intricate shapes and contours. Designed to deliver a consistent finish with a uniform rate of cut, flap wheels wear away continually exposing fresh abrasives.

There are two types of non woven flap wheels: non-woven only abrasive flaps where finishing is the primary application, and interleaf with alternating cloth and non-woven abrasive flaps (less conformable, more aggressive) for stock removal and finishing. Interleaf flap wheels must always be run in the direction indicated by the arrow.

Applications:

Used for a wide range of metal fabrication and welding applications including blending, deburring, cleaning, finishing, and polishing

Size Range:

Flap wheels with mounted steel shanks: 2" – 4" diameter
Flap wheels with arbor holes: 3" – 12" diameter

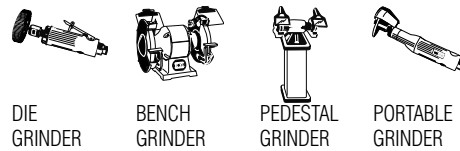
Grit Range:

60 – 320

Abrasive Grain:

Aluminum Oxide

Machine Used:



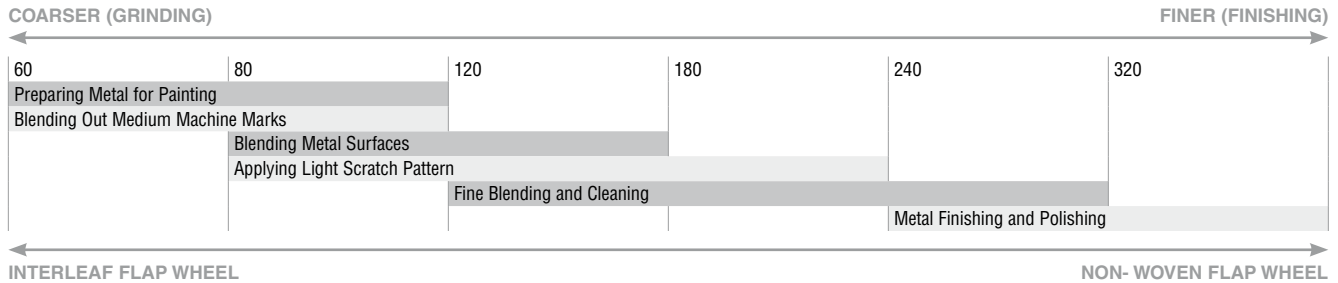
DIE GRINDER

BENCH GRINDER

PEDESTAL GRINDER

PORTABLE GRINDER

Application/Grit Recommendation Guide



Better choice for fine grit light cleaning and finishing

NON-WOVEN FLAP WHEELS

- Premium aluminum oxide grain with durable resin bond and web that wears away continually exposing fresh abrasives
- Tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- Designed with a steel shank as an integral part of the wheel or with an arbor hole

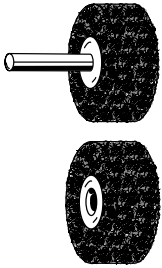


Good choice for fine grit cleaning and blending and finishing applications

MERIT INTERLEAF FLAP WHEELS

- Alternating cloth and non-woven flaps make interleaf wheels less conforming and more aggressive than non-woven flap wheels, but less aggressive than all-cloth flap wheels
- Premium aluminum oxide grain with durable resin bond and web that wears away continually exposing fresh abrasives
- Tough yet conformable to intricate shapes and contours without changing the workpiece dimension





1/4" Mounted Steel Shanks

Wheels are designed with a 1/4" steel shank as an integral part of each wheel. These shanks run through the wheel creating better balance, a reduction of chatter, and reduced operator fatigue. They also permit quick changes on air tools when using other abrasive products.

Arbor Hole Mounts

For use on larger portable and fixed-base tools where the wheel must fit on an existing arbor.



Non-Woven

TIER: **BETTER** **BETTER**
TRADENAME: **BEAR-TEX NON-WOVEN** **BEAR-TEX NON-WOVEN**

SIZE (D x W x SK./AH.)	ABRASIVE	NON-WOVEN GRIT	MAX. RPM	STD. PKG.	PART #	PART #	
2 x 1 x 1/4	A/O	Very Fine	12,000	20	662610 51717		
	A/O	Medium	12,000	20	662610 51716		
	A/O	Very Fine	12,000	20	662610 51719		
	A/O	Medium	12,000	20	662610 51718		
3 x 2 x 1/4	A/O	Medium	8,000	10	662610 58474		
	6 x 1 x 2	S/C	Very Fine	3,000	4		662610 58450
		S/C	Fine	3,000	4		662610 58451
		A/O	Fine	3,000	4		662610 58487
A/O	Medium	3,000	4		662610 58456		
8 x 1 x 3	A/O	Fine	2,500	3		662610 58491	
8 x 2 x 3	A/O	Fine	2,500	2		662610 58493	
	A/O	Medium	2,500	2		662610 00889	
12 x 2 x 5	A/O	Medium	1,900	1		662610 05070	

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.



TIER: **GOOD** **GOOD**
TRADENAME: **MERIT INTERLEAF** **MERIT INTERLEAF**

Interleaf

SIZE (D x W x SK./AH.)	ABRASIVE	COATED GRIT	NON-WOVEN GRIT	MAX. RPM	STD. PKG.	PART #	PART #
2 x 1 x 1/4	A/O	60	Very Fine	12,000	10	088341 38122	
	A/O	80	Very Fine	12,000	10	088341 38123	
	A/O	120	Very Fine	12,000	10	088341 44457	
	A/O	180	Very Fine	12,000	10	088341 44458	
	A/O	320	Very Fine	12,000	10	088341 44459	
2 x 1-1/2 x 1/4	A/O	80	Very Fine	12,000	10	088341 38125	
	A/O	120	Very Fine	12,000	10	088341 38126	
	A/O	320	Very Fine	12,000	10	088341 38128 NS	
3 x 1 x 1/4	A/O	60	Very Fine	12,000	10	088341 38129	
	A/O	80	Very Fine	12,000	10	088341 38130	
	A/O	120	Very Fine	12,000	10	088341 38118	
	A/O	180	Very Fine	12,000	10	088341 38120	
	A/O	320	Very Fine	12,000	10	088341 38119	
3 x 2 x 1/4	A/O	120	Very Fine	8,000	10	088341 44460	
3 x 2 x 3/8	A/O	180	Very Fine	8,000	10	088341 44461	
	A/O	60	Very Fine	12,000	10		088341 39000 NS
	A/O	120	Very Fine	12,000	10		088341 39001 NS
	A/O	240	Very Fine	12,000	10		088341 39028 NS
A/O	320	Very Fine	12,000	10		088341 39024 NS	
4 x 2 x 1/4	A/O	80	Very Fine	12,000	10	088341 21115	
	A/O	120	Very Fine	12,000	10	088341 20458	
4 x 2 x 5/8	A/O	60	Very Fine	12,000	10		088341 26025 NS
	A/O	240	Very Fine	12,000	10		088341 26014 NS
	A/O	320	Very Fine	12,000	10		088341 26027 NS
6 x 1 x 1	A/O	120	Very Fine	6,000	10		088341 26006 NS
	A/O	240	Very Fine	6,000	10		088341 26030 NS
6 x 2 x 1	A/O	80	Very Fine	6,000	10		088341 26009 NS
	A/O	180	Very Fine	6,000	10		088341 26018 NS
6 x 3 x 1	A/O	80	Very Fine	6,000	6		088341 26055 NS

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

Refer to Non-Woven Convolute Wheel section for Flap Wheel Reducing Bushings.



Flaps of abrasive cloth are stacked, inserted into a holder, and then attached to a mandrel. The flaps are designed to break down during use and reveal the next layer of abrasive.

To create an interleaf bore polisher, cloth flaps are mixed with non-woven flaps.

Applications:

For deburring, sizing, cleaning and polishing the interior diameters of cylinders, tubes and hydraulic fittings. Flaps adjust automatically to inside diameter, polishing the entire surface area with each pass.

Bore polishers are self-centering, so they apply equal pressure to full wall of inside diameter. Spring action design gives faster inside diameter cleaning, deburring and polishing to cylinders, deep bores and tubes.

Interleafed bore polishers are designed to polish and finish in one easy application. The abrasive flaps cut, while the non-woven flaps apply a fine finish.

Grit Range:

60 - 240

Abrasive Grain:

Aluminum Oxide

Application-to-Product Shape Recommendation Guide

Shape	Application
Solid Flaps B-3 Series	 <ul style="list-style-type: none"> For 5/8" to 1" interior diameter bores 3 abrasive packs 1-1/2" wide, bonded to hub Use with QC-5 mandrel Part # 08834154182
Solid Flaps B-4 Series	 <ul style="list-style-type: none"> For 1" to 4" interior diameter bores 4 abrasive packs 1-1/2" wide, bonded to hub Use with BPM-4 mandrel Part # 08834154183
Solid Flaps B-8 Series	 <ul style="list-style-type: none"> For 2" to 5-7/8" interior diameter bores 8 abrasive packs 1-1/2" wide, bonded to hub Use with BPM-8 mandrel Part # 08834154184
Scored Flaps	Available upon request as made-to-order products.
Interleaf	 <p>Cloth flaps are mixed with non-woven flaps. Interleaf bore polishers do double duty. Designed to polish and finish in one easy application, they are the ideal choice when close tolerances must be maintained, while giving an interior a polished finish.</p>

Application/Grit Recommendation Guide

COARSER (MATERIAL REMOVAL) ←		→ FINER (FINISHING)		
60	80	120	180	240
Blending Out Medium Machine Marks				
Sizing Cylinders				
	Deburring Cylinders			
	Blending Metal Surfaces			
	Cleaning Cylinders			
	Applying Light Scratch Pattern			
			Fine Blending and Cleaning	
			Metal Finishing and Polishing	
← SOLID FLAP		SCORED		INTERLEAF →

Aluminum Oxide Bore Polishers

TIER: **GOOD**
 TRADENAME: **MERIT R369**
 ABRASIVE: Aluminum Oxide
 BACKING: Y-weight Cotton/Poly

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #
Bore Polishers – Solid Flap B-3 and B-4 Series				
B-305	60	25,000	10	088341 54190
Fits ID 5/8 to 1	80	25,000	10	088341 54191
	120	25,000	10	088341 54193
	180	25,000	10	088341 54195
	240	25,000	10	088341 54197
B-405	60	22,000	10	088341 54091
Fits ID 1 to 1-1/2	80	22,000	10	088341 54092
	120	22,000	10	088341 54093
	180	22,000	10	088341 54094
B-410	60	20,000	10	088341 54100
Fits ID 1-1/2 to 2	80	20,000	10	088341 54101
	120	20,000	10	088341 54102
	180	20,000	10	088341 54103
	240	20,000	10	088341 54104
B-415	60	16,000	10	088341 54109
Fits ID 2-1/8 to 2-1/2	80	16,000	10	088341 54110
	120	16,000	10	088341 54111
	180	16,000	10	088341 54112
B-420	60	15,000	10	088341 54118
Fits ID 2-1/2 to 3	80	15,000	10	088341 54119
	120	15,000	10	088341 54120
	180	15,000	10	088341 54121
B-425	60	10,000	10	088341 54127
Fits ID 3-1/8 to 4	80	10,000	10	088341 54128
	120	10,000	10	088341 54129
	180	10,000	10	088341 54130

NS Non-stock. Contact your Norton representative for current order quantities and lead-times.

TIER: **GOOD**
 TRADENAME: **MERIT R369**
 ABRASIVE: Aluminum Oxide
 BACKING: Y-weight Cotton/Poly

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #
Bore Polishers – Solid Flap B-8 Series				
B-810	60	16,000	10	088341 54136
Fits ID 2 to 2-1/2	80	16,000	10	088341 54137
	120	16,000	10	088341 54138
	180	16,000	10	088341 54139 NS
	240	16,000	10	088341 54140 NS
B-815	60	15,000	10	088341 54145
Fits ID 2-5/8 to 3	80	15,000	10	088341 54146
	120	15,000	10	088341 54147
	180	15,000	10	088341 54148 NS
	240	15,000	10	088341 54149 NS
B-820	60	10,000	10	088341 54154
Fits ID 3-1/8 to 4	80	10,000	10	088341 54155
	120	10,000	10	088341 54156
	180	10,000	10	088341 54157
	240	10,000	10	088341 54158 NS
B-825	60	8,000	10	088341 54163
Fits ID 4-1/4 to 5-1/4	80	8,000	10	088341 54164
	120	8,000	10	088341 54165
	180	8,000	10	088341 54166
	240	8,000	10	088341 54167
B-830	60	8,000	10	088341 54172
Fits ID 5-1/4 to 5-7/8	80	8,000	10	088341 54173
	120	8,000	10	088341 54174
	180	8,000	10	088341 54175
	240	8,000	10	088341 54176

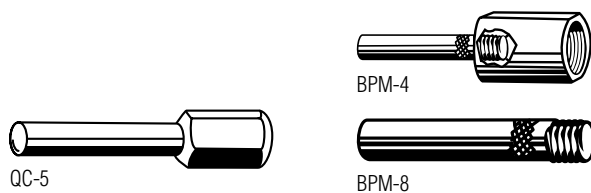
Bore Polishers – Scored Flaps

Available on request as made-to-order products

Bore Polishers – Interleaf

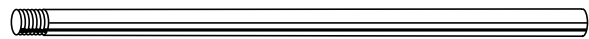
B-405 Interleaf	80	22,000	10	088341 50271
Fits ID 1 to 1-1/2	180	22,000	10	088341 50273

Mandrels for Bore Polishers



DESCRIPTION	MODEL NO.	THREAD	STD. PKG.	PART #
For B-3 Series	QC-5	5/16-18	1	088341 54182
For B-4 Series	BPM-4	1/2-20	1	088341 54183
For B-8 Series	BPM-8	1/4-20	1	088341 54184

Extension Mandrels for Bore Polishers



DIAMETER x LENGTH	MODEL NO.	THREAD	STD. PKG.	PART #
1/4 x 4	EM-144	1/4-20	1	088341 54185
1/4 x 6	EM-146	1/4-20	1	088341 54186
1/4 x 8	EM-148	1/4-20	1	088341 54187

To extend a B-4 series bore polisher, attach the adapter piece of the BPM-4 mandrel to the bore polisher, then attach the desired length extension mandrel above to the BPM-4 adapter piece. To extend a B-8 series bore polisher, attach the desired length extension mandrel above directly to the bore polisher.

Bore Polisher Test Kit “BP”

- Part # 088341**54181**
- Contains ten bore polishers and two mini 1/4"-20 thread flap wheels in assorted sizes and grits for finishing 1" to 5" interior diameters, and mandrel for 1/4" chuck.





FlexDrum abrasive segments sweep away flaws. Their extreme longevity and perfect balance make them well-suited for automatic as well as offhand use. Hubs and abrasive segments can be combined to fit your job perfectly.

Applications:

Blending out parting lines on castings, smoothing out pre-ground welded areas, removing burrs and work flaws, graining stainless, brush-finishing and satin-finishing aluminum, removing rust, deflashing molded plastic and rubber parts, and preparing surfaces for painting or plating.

Size Range:

Diameter of loaded FlexDrum: 8" – 18"
Width of FlexDrum: 1-1/2" – 12"
Custom die-cut segments as well as extra wide segments, in widths up to 144" are also available as made-to-order products.

Grit Range:

50 – 240

Bond:

Resin or glue

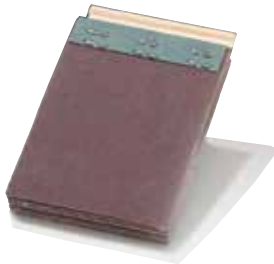
Backing:

Heavyweight cotton

Abrasive Grain:

Premium Aluminum Oxide

Shape/Application Recommendation Guide



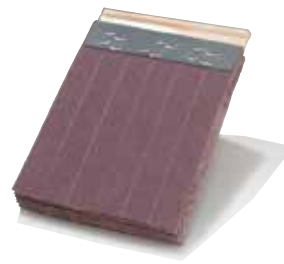
Plain Segment

- For flat or mildly contoured surfaces



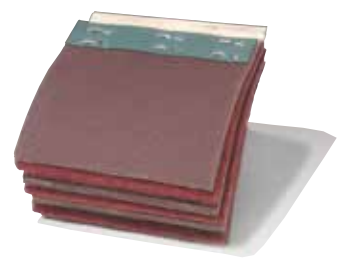
1/4 Scored (SC) Segment

- Great for complex parts
- Provides a fine finish



1/2 Slash (SL) Segment

- Great for mild and moderate contours



Interleaf Segment

- Plain cloth segments are mixed with non-woven segments. Interleaf FlexDrums do double duty. Designed to polish and finish in one easy application,
- Available upon request as made-to-order product

Loading Flex Drum Hubs



FlexDrum hub end plate removes for easy loading of abrasive segments.



Custom profiled segments eliminate break-in resulting in maximum productivity. Contact your sales representative for more information.

Plain Segments – for flat or mildly curved surfaces

TIER: GOOD									
TRADENAME: MERIT R369									
ABRASIVE: A/O									
BACKING: Y-weight Cotton									
GRIT: 50 60 80 100 120 180 240									
WIDTH	TRIM LENGTH*	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	PART #
1-1/2	2-3/4	12	088341 55002	088341 55003	088341 55004		088341 55006	088341 55008	088341 55010
2	2-3/4	12	088341 55013	088341 55014	088341 55015	088341 55016		088341 55019	
2	4	20		088341 55313	088341 55314			088341 55318	
2	5	20		088341 55568					
3	2-3/4	12		088341 55026	088341 55027		088341 55029	088341 55031	
3	4	20			088341 55326			088341 55330	
3	5	20		088341 55579			088341 55582		
4	2-3/4	12	088341 55036				088341 55040		
4	4	20	088341 55336	088341 55337	088341 55338		088341 55340		
4	5	20		088341 55590					

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times.

1/4" Scored Segments – for complex parts and providing a fine finish

TIER: GOOD									
TRADENAME: MERIT R369									
ABRASIVE: A/O									
BACKING: Y-weight Cotton									
GRIT: 50 60 80 100 120 180									
WIDTH	TRIM LTH.*	SCORE	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
1-1/2	2-3/4	1/4	12		088341 55083	088341 55084		088341 55086	088341 55088
2	2-3/4	1/4	12	088341 55094	088341 55095	088341 55096	088341 55097	088341 55098	088341 55100
3	2-3/4	1/4	12		088341 55107	088341 55108	088341 55109		088341 55112
4	2-3/4	1/4	12	088341 55117	088341 55118	088341 55119		088341 55121	088341 55123

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times.

1/2" Slashed Segments – for mild and moderate contours

TIER: GOOD									
TRADENAME: MERIT R369									
ABRASIVE: A/O									
BACKING: Y-weight Cotton									
GRIT: 60 80 120 180 240									
WIDTH	TRIM LTH.*	SLASH	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #
2	4	1/2	20	088341 55420			088341 55425	088341 55427	
2	5	1/2	20			088341 55639			
3	4	1/2	20		088341 55432				
4	4	1/2	20		088341 55445	088341 55447		088341 55451	
4	5	1/2	20		088341 55659				

All FlexDrum segments are non-stock; contact your Norton representative for current order quantities and lead-times.

*Trim Length is the actual usable length of segment when loaded

TECH TIP

FlexDrums can be used for polishing large IDs. Just load half the segments with a wheel diameter 1/2" to 1" larger than the ID of your workpiece.

Hub Units

- FlexDrum hubs are perfectly balanced, last indefinitely and are available in widths from 1-1/2" to 12"
- Extra wide widths are available up to 144" as made-to-order products

MODEL NO.	D x W	ARBOR HOLE/THREAD	SEGMENTS PER HUB	PART #
FlexDrum Hub Units				
81.5-B	2-3/8 x 1-1/2	1 AH	12	088341 40065
82-B	2-3/8 x 2	1 AH	12	088341 41049
		5/8-11 THD	12	088341 40048
83-B	2-3/8 x 3	1 AH	12	088341 41018
		5/8-11 THD	12	088341 40034
84-B	2-3/8 x 4	1 AH	12	088341 40066
		5/8-11 THD	12	088341 40049
122-B	4 x 2	1-1/4 AH	20	088341 40050
123-B	4 x 3	1-1/4 AH	20	088341 40051
124-B	4 x 4	1-1/4 AH	20	088341 40061
142-B	6 x 2	1-1/4 AH	30	088341 40062
143-B	6 x 3	1-1/4 AH	30	69957 99208
144-B	6 x 4	1-1/4 AH	30	088341 41060
840-B2	8 x 2	1-1/4 AH	40	636425 92550
840-B4	8 x 4	1-1/4 AH	40	636425 92548

All FlexDrum hub units are non-stock; contact your Norton representative for current order quantities and lead-times.



**2-3/8" DIAMETER HUB
WITH 1" ARBOR HOLE**

8" WHEEL WHEN LOADED



**2-3/8" DIAMETER HUB ALSO
AVAILABLE WITH 5/8"-11 ARBOR**

8" WHEEL WHEN LOADED



4" DIAMETER HUB

12" WHEEL WHEN LOADED



6" DIAMETER HUB

14" OR 16" WHEEL WHEN LOADED



8" DIAMETER HUB

16" OR 18" WHEEL WHEN LOADED

FlexDrum Reference Charts

FlexDrums can be mounted on any type of arbor.

Weights

DIAMETER	WEIGHT
Weight of Hubs*	
4" Diameter Hub	1.5 lbs./inch of width
6" Diameter Hub	2 lbs./inch of width
8" Diameter Hub	2.5 lbs./inch of width
Weight of Hubs with Segments*	
4" Diameter Hub	3.4 - 4 lbs./inch of width
6" Diameter Hub	5 - 5.5 lbs./inch of width
8" Diameter Hub	6.75 - 7 lbs./inch of width

*Approximate values. Actual weight will depend on abrasive type and overall width of hub.

FlexDrum Maximum RPM

WHEEL DIAMETER	MAXIMUM RPM
8	4,500
12	3,000
14	2,500
16	2,200
18	2,000

Recommended H.P. Required

HUB	H.P.
4" Diameter Hub	1/2 H.P. /inch of width
6" Diameter Hub	3/4 H.P./inch of width
8" Diameter Hub	1 H.P./inch of width

Recommended Surface Feet per Minute for using FlexDrum Wheels on Various Materials

MATERIAL	SFPM
Mild Steel	5,000
Stainless Steel	6,500
Alloy Steel	5,000
Titanium	3,500
Hard Aluminum	5,500
Nonferrous	5,000
Rubber	4,500
Hardwood (edge breaking)	4,000
Softwood	3,500
Thermoplastic	3,000

SPEC CHECK



FlexDrum Hub Specification Chart

MODEL NO.	82-B	121-B	141-B	840-B
Diameter of Finished Wheel	8	12	14 or 16	16 or 18
Diameter of Hub Alone	2-3/8	4	6	8
Arbor Hole	1 or 5/8-11 thd	3/4 to 1-3/4	1 to 3-1/2	1-1/4 to 5
Segments Per Hub	12	20	30	40

How to Determine Diameter of Finished FlexDrums

HUB DIAMETER	TRIM LENGTH (X2)	FINISHED WHEEL
2-3/8	2-3/4	8
4	4	12
4	5	14
6	4	14
6	5	16
8	4	16
8	5	18

TECH TIP

For surface feet per minute, use the following calculation: SFPM=.262 x DIA (in inches) x RPM.



Our double-cut style carbide burrs have stronger tooth formulation and numerous cutting edges to outperform other double-cut carbide burrs with better stock removal, granular chip break, and longer life.

Pair up these long-lasting burrs with our pneumatic die grinder to quickly and comfortably accomplish many portable applications on one machine – including jobs using specialties, small diameter flap wheels, and mounted points.

Applications:

Deburring, medium-to-light surface cleaning and stock removal, weld removal and prep, chamfering

Shapes:

A, B, C, D, F, G, H, L, M

Shank Diameter:

1/4"

Machine Used:

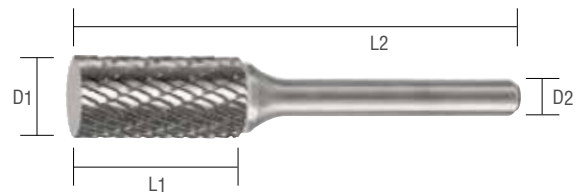


DIE GRINDER

Understanding the Product

Burr Dimensions

D1	L1	D2	L2
HEAD DIAMETER	HEAD LENGTH	SHANK DIAMETER	OVERALL BURR LENGTH (OL)



TECH TIP

Each carbide burr is packed individually in a clear, protective plastic case with Norton-blue end-caps. Each burr is marked with the burr head diameter and length for easy identification.



Double cut burrs are a popular choice because of their universal cutting style

DOUBLE CUT CARBIDE BURRS

- Hard tungsten carbide burrs with strong tooth formulations and numerous cutting edges for extended life and less changeover downtime versus other cutting tools
- Higher stock removal, and smaller, granular chip-break on hard-to-grind workpieces versus other carbide burrs
- Perform well at higher temperatures and can be used longer than high-speed steel tools – even if your operation generates some heat



Designed for use on aluminum and non-ferrous metals

SINGLE CUT CARBIDE BURRS

- Single spiral carbide burrs make deburring aluminum and non-ferrous materials an ease
- Extra sharp edges and fast debris removal keeps you on task for better production
- Perform well at higher temperatures and can be used longer than high-speed steel tools

Carbide Burrs for Standard Metal Removal



SA Cylindrical without End Cut

The ends of these burrs are flat, with no cutting edges and are used for contour finishing and to get into right-angled corners.

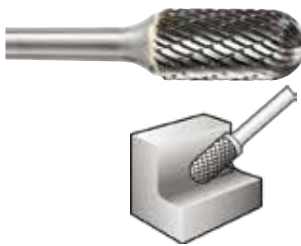
SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SA1	25,000	1/4"	3/4"	2"	1	699573 08002
SA3	25,000	3/8"	3/4"	2-1/2"	1	699573 08004
SA5	25,000	1/2"	1"	2-3/4"	1	699573 08005



SB Cylindrical with End Cut

The cutting edge at the end of the burr makes these burrs a good choice for contour finishing.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SB3	25,000	3/8"	3/4"	2-1/2"	1	699573 08006
SB5	25,000	1/2"	1"	2-3/4"	1	699573 08007
SB6	25,000	5/8"	1"	2-3/4"	1	699573 08008



SC Ball-Nosed Cylindrical

Use these round-nosed burrs for smoother operation and better tool control.

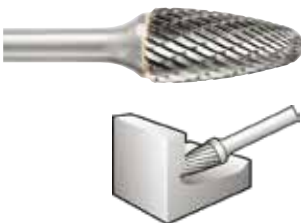
SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SC1	25,000	1/4"	3/4"	2"	1	699573 08009
SC2	25,000	5/16"	3/4"	2-1/2"	1	699573 08010
SC3	25,000	3/8"	3/4"	2-1/2"	1	699573 08011
SC5	25,000	1/2"	1"	2-3/4"	1	699573 08012
SC5	25,000	1/2"	1"	6"	1	699573 60679
SC6	25,000	5/8"	1"	2-3/4"	1	699573 08013



SD Ball Shape

Use these carbide burrs to create a concave and to hollow out a workpiece.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SD1	25,000	1/4"	1/4"	2"	1	699573 08014
SD3	25,000	3/8"	5/16"	2-1/8"	1	699573 08016
SD5	25,000	1/2"	7/16"	2-3/16"	1	699573 08017



SF Ball-Nosed Tree

Designed to round off edges and make concave cuts.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SF1	25,000	1/4"	3/4"	2"	1	699573 08018
SF2	25,000	5/16"	3/4"	2-1/2"	1	699573 08019
SF3	25,000	3/8"	3/4"	2-1/2"	1	699573 08020
SF3	25,000	3/8"	3/4"	6"	1	699573 60689
SF5	25,000	1/2"	1"	2-3/4"	1	699573 08021
SF5	25,000	1/2"	1"	6"	1	699573 60691
SF6	25,000	5/8"	1"	2-3/4"	1	699573 08022

Carbide Burrs for Standard Metal Removal



SG Tree with Taper

The taper allows access to hard-to-reach areas, such as angled contours.

SUB-SHAPE	MAX.-RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SG1	25,000	1/4"	3/4"	2"	1	699573 08023
SG3	25,000	3/8"	3/4"	2-1/2"	1	699573 08025
SG5	25,000	1/2"	1"	2-3/4"	1	699573 08026
SG5	25,000	1/2"	1"	6"	1	699573 60712
SG6	25,000	5/8"	1"	2-3/4"	1	699573 08027



SH Flame Shape

Great for channel working and shaping due to its long fluted sides and rounded head.

SUB-SHAPE	MAX.-RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SH5	25,000	1/2"	1-1/4"	6"	1	699573 66822



SL Ball-Nosed Cone

This cone shape is excellent for imparting fine finishes.

SUB-SHAPE	MAX.-RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SL2	25,000	5/16"	7/8"	2-3/4"	1	699573 08028
SL3	25,000	3/8"	1 3/16"	2-15/16"	1	699573 08029
SL4	25,000	1/2"	1 3/16"	3"	1	699573 08030
SL4	25,000	1/2"	1-3/16"	6"	1	699573 60720



SM Pointed Cone

Ideal for rounded edges or reaching difficult, tight areas.

SUB-SHAPE	MAX.-RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SM5	25,000	1/2"	7/8"	6"	1	699573 60767



Carbide Burr Kit



SUB-SHAPE	MIN/STD PKG QTY	PART #
Carbide Burr Kit*	1	699573 08060

* Kit Includes one each of: SA5 (699573**08005**), SF3 (699573**08020**), SF5 (699573**08021**), SG5 (699573**08026**), and SL4 (699573**08030**)

Carbide Burrs for Aluminum and Non-Ferrous Materials



SA Cylindrical without End Cut

The ends of these burrs are flat, with no cutting edges and are used for contour finishing and to get into right-angled corners.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SA3 NF	25,000	3/8"	3/4"	2-1/2"	1	699573 40148
SA5 NF	25,000	1/2"	1"	2-3/4"	1	699573 40149



SF Ball-Nosed Tree

Designed to round off edges and make concave cuts.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SF3 NF	25,000	3/8"	3/4"	2-1/2"	1	699573 40154
SF5 NF	25,000	1/2"	1"	2-3/4"	1	699573 60647



SL Ball-Nosed Cone

This cone shape is excellent for imparting fine finishes.

SUB-SHAPE	MAX. RPM	D1	L1	L2	MIN/STD PKG QTY	PART #
SL4 NF	25,000	1/2"	1-1/4"	6"	1	699573 60651



we've got you covered
**FROM DIY TO TOOLCRIB
TO PRODUCTION FLOOR**

Available in vitrified bond, resin bond, center lap and cotton fiber, and in a variety of shapes our mounted points offer fast, free cutting grinding and finishing capability. Produce sharp edges with the Norton line of sharpening stones - bringing solutions for craftsmen and hobbyists alike for over 190 years.





Resin bond, vitrified bond, center lap, and cotton fiber mounted points are available in a wide range of shapes.

- Industries:**
- Aerospace
 - Tool and Die
 - Construction
 - Metal Fabrication
 - Automotive
 - Cutlery
 - Mold Shops
 - Stainless Steel Equipment
 - Foundries

Abrasive Grain: Ceramic Alumina, Zirconia Alumina, Zirconia Alumina / Aluminum Oxide Blend, Aluminum Oxide

Shape Availability: A, B, and W

Machine Used:

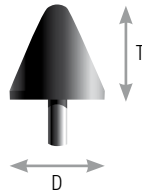
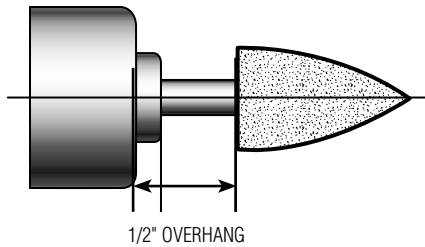


DIE AND
PENCIL
GRINDER



HORIZONTAL/
STRAIGHT SHAFT
PORTABLE GRINDER

Measurement Guide



Description of Overhang

Overhang is the distance between the grinder chuck and the abrasive on the spindle. The larger the overhang, the lower the maximum safe operating speed.

Size

Measured by diameter (D) x thickness (T)

Cotton Fiber



Good for blending and polishing

COTTON FIBER ALUMINUM OXIDE - RESIN BOND

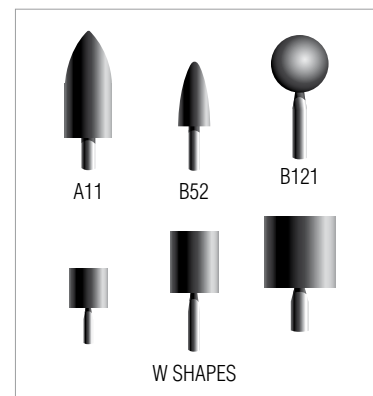
- Aluminum oxide grain provides an excellent blend of cut rate and life
- The cotton fibers ensure smooth, chatter-free grinding
- Designed for blending and polishing in one step; use 80 grit for most materials and 120 for polishing and stainless steel applications

TIER: **GOOD**
TRADENAME: **COTTON FIBER**
ABRASIVE: Aluminum Oxide

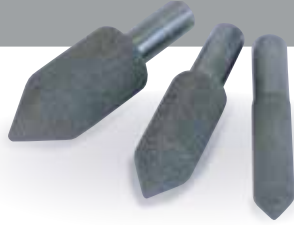
SHAPE	SIZE (D x T)	SPINDLE DIA. †	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #
Cotton Fiber Mounted Points						
A11	7/8 x 2	1/4	19,860	5/25	A80-HBF3	614636 22664
B52	3/8 x 3/4	1/8	45,370	5/25	A120-HBF3	614636 20242
B121	1/2" Ball	1/8	45,370	5/25	A80-HBF3	614636 22657
W163	1/4 x 1/2	1/8	60,000	5/25	A80-HBF3	614636 22655
			60,000	5/25	A120-HBF3	614636 22656
W176	3/8 x 1/2	1/8	45,370	5/25	A80-HBF3	614636 22654
W185	1/2 x 1/2	1/8	34,500	5/25	A80-HBF3	614636 22649
W187	1/2 x 1	1/8	20,620	5/25	A80-HBF3	614636 22651
W220	1 x 1	1/4	25,500	5/25	A80-HBF3	614636 22646

† Spindle length is 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.



Center Lap



Better for Excell-O center lap and similar machines

CENTER LAP ALUMINUM OXIDE - VITRIFIED BOND

- Specially formulated wheel treatment provides added lubricity to the wheel, minimizing risk of metallurgical damage
- The larger diameter spindle ensures minimal deflection and rigid support
- Precise dimensional tolerances ensure accurate location of part centers

TIER: **BETTER**
TRADENAME: **CENTER LAP**
ABRASIVE: Aluminum Oxide

SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #
Center Lap Mounted Points						
–	1/2 x 2**	1/2	65,000	5/25	A80-VVM	614636 21421
–	1 x 2**	1/2	15,900	5/25	A80-VVM	614636 22926

† Spindle length is 1-1/4"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.

** Pointed 60°

TECH TIP

Dress the center lap mounted points frequently to ensure accurate and smooth center holes.



It is the user's responsibility to refer to and comply with ANSI B7.1

Resin Bond



Best choice for fast stock removal

NORZON ZIRCONIA ALUMINA – RESIN BOND

- Zirconia alumina abrasive blend for 2X faster cut rate than standard aluminum oxide
- Strong grain and specially formulated organic bond provide 4X greater life than aluminum oxide points, while reducing vibration and wheel chatter
- Ideal for removing parting lines, fins and small risers from castings, and smoothing and blending of welded areas



Better choice for fast stock removal and long life

CHARGER Z/A & A/O BLEND – RESIN BOND

- Durable zirconia alumina and aluminum oxide abrasive blend delivers 35% faster cut rate than standard aluminum oxide; an aggressive, free cut, and more parts cleaned in less time to substantially increase productivity
- Specially formulated organic bond provides 2X greater life than standard resin bonds while reducing vibration and wheel chatter
- Better choice for removing parting lines, fins and small risers from castings, and smoothing and blending welded areas
- Charger mounted point pre-packed in small packages are ideal for vending machines, pegboards, small jobs, and carrying to job site

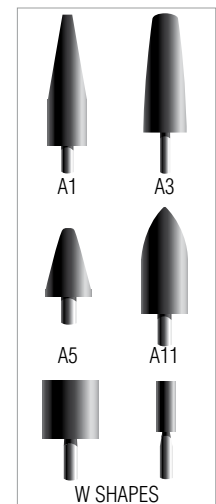
TIER: **BEST** **BETTER**
TRADENAME: **NORZON** **CHARGER**
ABRASIVE: Zirconia Alumina Zirconia Alumina/Aluminum Oxide

SHAPE	SIZE (D x T)	SPINDLE DIA.†	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #
Resin Bond Mounted Points								
A1	3/4 x 2-1/2	1/4	19,800	5/25	NZ24-UBXR1	614636 16457	Charger	614636 16458
A3	1 x 2-3/4	1/4	16,100	5/25	NZ24-UBXR1	614636 16459	Charger	614636 16460
A11	7/8 x 2	1/4	19,860	5/25	NZ24-UBXR1	614636 16463	Charger	614636 16464
W189	1/2 x 2	1/4	24,000	5/25	NZ24-UBXR1	614636 16465	Charger	614636 16466
W197	5/8 x 2	1/4	21,000	5/25	NZ24-UBXR1	614636 16467		
W207	3/4 x 1-1/2	1/4	24,000	5/25			Charger	614636 16470
W208	3/4 x 2	1/4	18,750	5/25	NZ24-UBXR1	614636 16471		
W220	1 x 1	1/4	25,500	5/25	NZ24-UBXR1	614636 17520	Charger	614636 17521
			25,500	5 V				
W221	1 x 1-1/2	1/4	19,120	5/25	NZ24-UBXR1	614636 16473	Charger	614636 16474
W222	1 x 2	1/4	15,900	5/25	NZ24-UBXR1	614636 16475	Charger	614636 16476

† Spindle length is 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.

NS Non-stock; contact your Norton representative for current order quantities and lead times.



Vitrified Bond



Best choice for high volume operations

QUANTUM CERAMIC ALUMINA – VITRIFIED BOND

- Quantum grain with unique, engineered ceramic grain and shape, specifically developed for high-volume, high-speed alloy grinding operations
- Minimal loading and heat build-up; provide up to 33% longer life and 37% better metal removal rates versus other ceramic points
- Versatile; optimized for all low-, medium-, and high-force vitrified applications
- Oil and Gas 36 grit mounted points; specifically engineered to efficiently grind the carbide matrix material of oil field drill heads



Better medium grit option for blending and deburring

PINK ALUMINUM OXIDE – VITRIFIED BOND

- Sharp versatile 86A aluminum oxide grain is free cutting and resists burn
- Excellent form holding compared to more friable white aluminum oxides
- Medium grit for blending and deburring



Good value for general purpose, small job shop applications

GEMINI ALUMINUM OXIDE – VITRIFIED BOND

- 38A abrasive is designed to be cool cutting to minimize burn
- High temperature vitrified bond maximizes form holding and life
- Wide grit range for stock removal, blending/deburring, and finishing/polishing

TECH TIP

- For best mounted point performance, always run the mounted point at the maximum allowable speed according to ANSI B7.1. Refer to the speed chart included in each shipment for proper operating speeds.
- Use "A" shapes for medium- to heavy-duty blending.
- Use "B" shapes for light deburring and finishing/polishing.
- Use "W" shapes for offhand and precision grinding of medium to heavy stock.
- Use 36 grit and coarser for rough grinding.
- Use 60 and 90 grits for imparting fine finishes or when grinding on narrow surfaces.



It is the user's responsibility to refer to and comply with ANSI B7.1



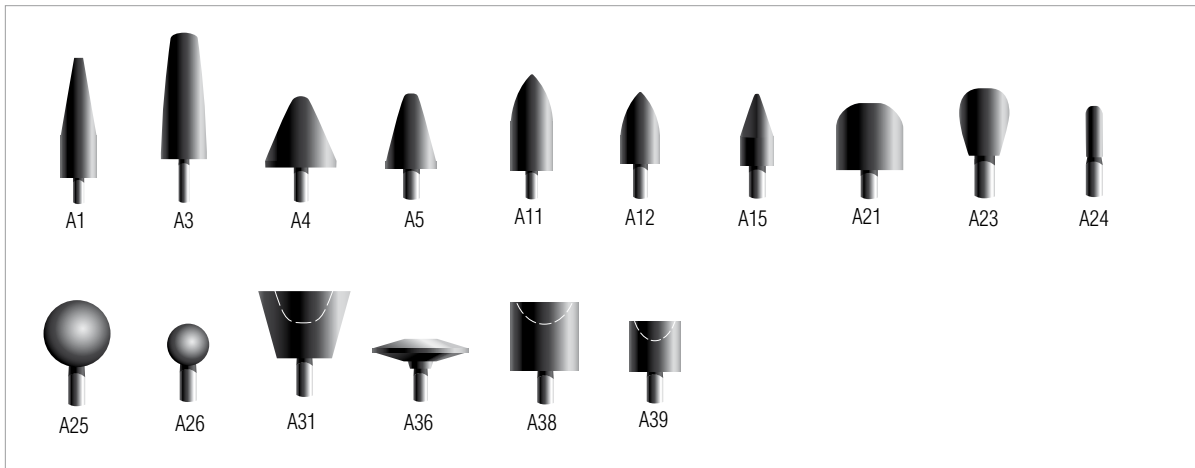
Vitrified Bond

TIER:	BEST	BETTER	GOOD
TRADENAME:	QUANTUM	PINK	GEMINI
ABRASIVE:	Ceramic Alumina	86A Aluminum Oxide	38A Aluminum Oxide

SHAPE	SIZE (D x T)	SPINDLE DIA. †	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
Vitrified Bond Mounted Points – A Shapes										
A1	3/4 x 2-1/2	1/4	19,800	25/250	Oil & Gas 36	614636 86139				
A1	3/4 x 2-1/2	1/4	19,800	5/25	3NQ80	690831 49139	86A80-S	690786 45335	38A36-T	614636 24374
A1	3/4 x 2-1/2	1/4	19,800	5/25					38A60-P	614636 24375
A3	1 x 2-3/4	1/4	16,100	25/250	Oil & Gas 36	614636 86138				
A3	1 x 2-3/4	1/4	16,100	5/25			86A80-S	690786 45333	38A36-T	614636 24377
A3	1 x 2-3/4	1/4	16,100	5/25					38A60-P	614636 24378
A4	1-1/4 x 1-1/4	1/4	30,560	5/25					38A60-P	614636 24380
A5	3/4 x 1-1/8	1/4	45,000	5/25			86A80-S	690786 45339	38A36-T	614636 24381
A5	3/4 x 1-1/8	1/4	45,000	5/25					38A60-P	614636 24382
A11	7/8 x 2	1/4	19,860	5/25	3NQ80	690831 49141			38A36-T	614636 24384
A11	7/8 x 2	1/4	19,860	5/25			86A80-S	690786 45336	38A60-P	614636 24385
A12	11/16 x 1-1/4	1/4	48,000	5/25			86A80-S	690786 45344	38A60-P	614636 24388
A15	1/4 x 1-1/16	1/4	72,750	5/25					38A60-P	614636 24391
A21	1 x 1	1/4	34,500	5/25					38A60-P	614636 24392
A23	3/4 x 1	1/4	39,370	5/25					38A60-P	614636 24394
A24	1/4 x 3/4	1/4	76,500	5/25					38A60-P	614636 24395
A25	1" Ball	1/4	35,620	5/25			86A80-S	690786 45341	38A60-P	614636 24396
A26	5/8" Ball	1/4	61,120	5/25					38A60-P	614636 24397
A36	1-5/8 x 3/8	1/4	23,520	25/250	Oil & Gas 36	662531 45562				
A36	1-5/8 x 3/8	1/4	23,520	5/25					38A60-P	614636 24404
A38	1 x 1	1/4	34,500	5/25			86A80-S	690786 45345	38A60-P	614636 24406
A39	3/4 x 3/4	1/4	47,250	5/25					38A60-P	614636 24407

† Standard spindle size is 1/4" x 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.



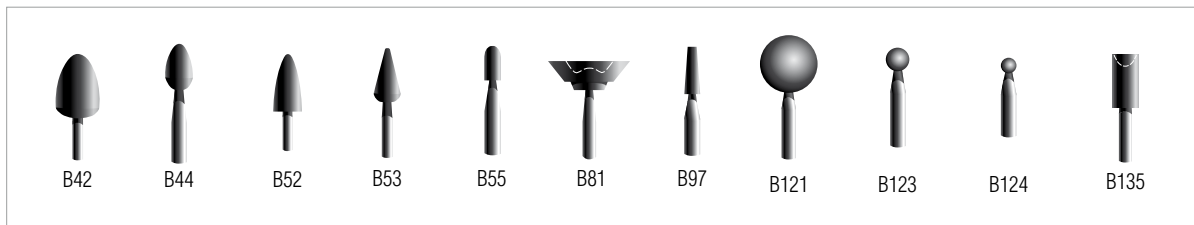
Vitrified Bond

TIER:	BEST	BETTER	GOOD
TRADENAME:	QUANTUM	PINK	GEMINI
ABRASIVE:	Ceramic Alumina	86A Aluminum Oxide	38A Aluminum Oxide

SHAPE	SIZE (D x T)	SPINDLE DIA. †	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
Vitrified Bond Mounted Points – B Shapes										
B42	1/2 X 3/4	1/8	33,570	5/25					38A60-P	614636 24412
B44	7/32 x 3/8	1/8	68,400	5/25					38A60-P	614636 24414
B52	3/8 x 3/4	1/8	45,370	5/25			86A80-S	690786 45334	38A60-P	614636 24420
B52	3/8 x 3/4	1/4	81,000	5/25					38A60-P	614636 24419
B52	3/8 x 3/4	1/8	45,370	5/25					38A90-Q	614636 24422
B53	5/16 x 5/8	1/8	60,000	5/25			86A80-S	690786 45340	38A60-P	614636 24423
B81	3/4 x 3/16	1/8	50,930	5/25			86A80-S	690786 45347		
B97	1/8 x 3/8	1/8	105,000	5/25	3NQ80	690831 49048	86A80-S	690786 45337	38A60-P	614636 24451
B121	1/2" Ball	1/8	45,370	5/25			86A80-S	690786 45338	38A60-P	614636 24466
B122	3/8" Ball	1/8	61,650	5/25	3NQ80	690831 49050	86A80-S	690786 45360	38A60-P	614636 24470
B123	3/16" Ball	1/8	104,250	5/25					38A60-P	614636 24472
B124	1/8" Ball	1/8	105,000	5/25					38A90-Q	614636 24474
B135	1/4 x 1/2	1/8	60,000	5/25			86A80-S	690786 45342	38A60-P	614636 24484

† Spindle size is 1/8" or 1/4" x 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.

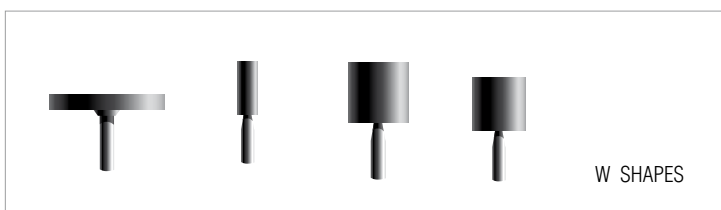


TIER:	BEST	GOOD	GOOD
TRADENAME:	QUANTUM	PINK	GEMINI
ABRASIVE:	Ceramic Alumina	86A Aluminum Oxide	38A Aluminum Oxide

SHAPE	SIZE (D x T)	SPINDLE DIA. †	MAX. RPM*	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
Vitrified Bond Mounted Points – W Shapes										
W154	3/16 x 1/2	1/8	70,500	5/25	3NQ80	690831 49133			38A60-P	614636 24497
W163	1/4 x 1/2	1/8	60,000	5/25			86A80-S	690786 45346	38A60-P	614636 24504
W164	1/4 x 3/4	1/8	45,900	5/25					38A60-P	614636 24505
W176	3/8 x 1/2	1/8	45,370	5/25					38A60-P	614636 24517
W177	3/8 x 3/4	1/8	33,750	5/25			86A80-S	690786 45355	38A60-P	614636 24518
W179	3/8 x 1-1/4	1/4	20,415	25/250	Oil & Gas 36	690831 54055				
W185	1/2 x 1/2	1/8	34,500	5/25					38A60-P	614636 24525
W185	1/2 x 1/2	1/4	61,500	5/25			86A80-S	690786 45354		
W188	1/2 x 1-1/2	1/4	30,370	5/25					38A60-P	614636 24530
W189	1/2 x 2	1/4	24,000	25/250	Oil & Gas 36	614636 86137				
W189	1/2 x 2	1/4	24,000	5/25					38A60-P	614636 24531
W200	3/4 x 1/8	1/8	50,930	5/25			86A80-S	690786 45356	38A60-P	614636 24543
W205	3/4 x 1	1/4	34,500	5/25					38A60-P	614636 24550
W215	1 x 1/8	1/8	38,200	5/25					38A60-P	614636 24560
W218	1 x 1/2	1/4	38,200	5/25					38A60-P	614636 24564
W220	1 x 1	1/4	25,500	5/25			86A80-S	690786 45359	38A60-P	614636 24566
W222	1 x 2	1/4	15,900	5/25					38A60-P	614636 24569
W235	1-1/2 x 1/4	1/4	25,470	5/25			86A80-S	690786 45343	38A60-P	614636 24583
W236	1-1/2 x 1/2	1/4	25,470	5/25					38A60-P	614636 24585
W237	1-1/2 x 1	1/4	22,500	5/25					38A60-P	614636 24587
W238	1-1/2 x 1-1/2	1/4	15,600	5/25					38A60-P	614636 24588
W242	2 x 1	1/4	19,100	5/25					38A60-P	614636 24592

† Spindle size is 1/8" or 1/4" x 1-1/2"

* Maximum RPM valid to 1/2" overhang. See package insert for other overhangs.





Since 1823, Norton stones have lead the marketplace with conventional and diamond benchstones, waterstones, sharpening systems, files, slips and specialty stones for industrial, commercial and DIY sharpening applications. Our comprehensive line of sharpening and finishing products is the industry's broadest line with premier performance and quality.

Applications:

Deburring, dimensioning, sharpening, honing

Grit Range:

Coarse, Medium, Fine, Extra Fine, Ultra Fine

Abrasive Types:

Aluminum Oxide (India), Silicon Carbide (Crystolon), Arkansas (Soft and Hard Translucent), and Diamond

Machine Used:



HAND SHARPENING

Application-to-Product Recommendation Guide Benchstones

	Coarse/Medium Sharpening	Fine Stoning	Finish Honing
Chip Breakers	–	Fine Crystolon Benchstone	–
Draw Knives	Coarse Crystolon Benchstone	Fine India Benchstone	Ascent Benchstone
Scrapers	Coarse Crystolon Benchstone	Fine India Benchstone	Ascent Benchstone
Chisels (Wood)	Coarse Crystolon Benchstone 1000 Waterstone	Fine India Benchstone 4000 Waterstone	Ascent Benchstone 8000 Waterstone
Plane Blades	Coarse Crystolon Benchstone 1000 Waterstone	Fine India Benchstone 4000 Waterstone	Ascent Benchstone 8000 Waterstone

Slips

	Coarse/Medium Sharpening	Fine Stoning
Milling Cutter	Medium India Round Edge Slip	Fine India Round Edge Slip
Carbide Tools		Fine Crystolon Slip for Carbide Tools

Abrasive Files

	Coarse/Medium Sharpening	Fine Stoning	Finish Honing
Form Cutter	Coarse or Medium India Knife Blade	Fine India Knife Blade	–
Keyways	Coarse or Medium India Square File	Fine India Square File	–
Lathe Bits	Medium India Square File	Fine India Square File	–
Radius Tools	Medium India Round File	Fine India Round File	–
Reamers	Medium India Reamer Stone	Fine India Reamer Stone	–
Router Bits	–	Fine India Square File	–
Saws	Coarse India Triangular File	Fine India Tapered Triangular File	–
Center Punches	Medium India Triangular File	Fine India Triangular File	–
Magnetic Chucks	Medium Crystolon Round File	Fine India Round File	–
Molding Cutters*	Coarse or Medium India File	Fine India File	–
Countersinks	Coarse India Triangular File	Fine India Triangular File	Hard Arkansas Triangular File
Tap Threads	–	Fine India Triangular File	–

* Select shape to fit configuration

Instructional Videos



Sharpening Stones
Playlist

nortonsga.us/kb542

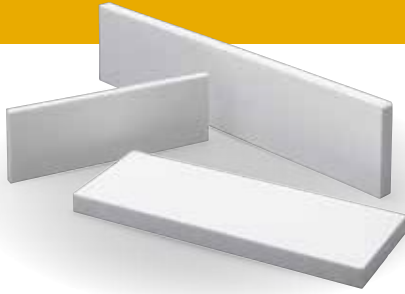
Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life – to make all your sharpening, honing, etc. applications easier.

Relative Sharpening Comparisons for Norton Products

Crystolon (Silicon Carbide); India (Aluminum Oxide)	Arkansas (Soft, Hard Translucent)	Diamond Stones	Waterstones	Coated Abrasives (Waterproof Sandpaper)		Diamond Compound
			JIS (Japan)	CAMI (USA)	FEPA (Europe)	MICRON Size
Coarse Crystolon				120	P100	141
					P120	127
						116
Coarse India				150	P150	97
						93
						78
Medium Crystolon		Extra Coarse Diamond (220)	Norton 220	180	P180	65
					P220	60
					P240	58
Medium India				240	P280	53.5
						52.5
						50
Fine Crystolon		Coarse Diamond (325)		280	P320	46
						45
						43
Fine India				360	P360	40.5
						36
						35
Soft Arkansas		Fine Diamond (600)	600	400	P400	29
						25.8
						23
Hard Translucent Arkansas				800	P600	22
						20
						16
				Norton 1000	P1200	14
						12.6
						11
				1200	P1500	10.3
						9.2
						9
				1500	P2000	8.4
						7.5
						6
			Norton 4000	2000	P2500	5
						3
						1.2
			Norton 8000			1
						0.5
				15000		

Benchstones

Extremely hard and wear resistant



ASCENT BENCHSTONES

- Fine and Ultra-fine Ceramic benchstones produce a keener edge that possible with traditional sharpening stones
- Designed to work on all types of knife and tool steels, Ceramic benchstones are the best choice for honing and polishing an already sharp edge
- These smooth finished stones are best used dry or with a very small amount of water

TIER: **BEST**

SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Ascent Single Grit Benchstones				
4 x 1 x 1/2	1	Fine	690786	43670
	1	Ultra Fine	690786	43671
6 x 2 x 1/2	1	Fine	690786	43672
	1	Ultra Fine	690786	43673
8 x 2 x 1/2	1	Fine	690786	43674
	1	Ultra Fine	690786	43675
8 x 3 x 1/2	1	Fine	690786	43676
	1	Ultra Fine	690786	43677
11-1/2 x 2-1/2 x 1/2	1	Fine	690786	43678
	1	Ultra Fine	690786	43679

Better choice for sharpening tools and knives



PRECISION BENCHSTONES

- Jewelers' Benchstones – These stones are excellent for sharpening the fine, precision cutting tools used by jewelers, engravers and artisans
- Penknife Precision Benchstones – Ideal for sharpening cutting tools, laboratory blades, surgical instruments, engravers' and die makers' tools, and pocket knives to the keenest edge

TIER: **BETTER**

SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Precision Benchstones – Jewelers'				
4 x 2 x 3/8	5	Ultra Fine – Hard Translucent Arkansas	HB24	614636 87525
6 x 2 x 3/8	5	Ultra Fine – Hard Translucent Arkansas	HB26	614636 87530
<i>Jewelers' stones are packed in individual boxes within a case. Order in multiples of stones/case.</i>				
Precision Benchstones – Penknife				
3 x 1 x 3/8	5	Extra Fine – Soft Arkansas	SB13	614636 87560
		Ultra Fine – Hard Translucent Arkansas	HB13	614636 87550
4 x 1 x 3/8	5	Extra Fine – Soft Arkansas	SB14	614636 87565
		Ultra Fine – Hard Translucent Arkansas	HB14	614636 87555

Benchstones

Better choice for edge shaping and honing



SINGLE GRIT ABRASIVE BENCHSTONES

- Crystolon – sharp premium silicon carbide abrasive, delivers fast stock removal for quick edge shaping with minimal loading
- India - smooth cutting aluminum oxide abrasive produces a strong, keen, long-lasting edge and is the choice for the best blend of cut rate and finish
- Arkansas – Natural premium Novaculite quarried in Arkansas and available in Soft or Hard Translucent

TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Single Grit Benchstones – Crystolon (Silicon Carbide)				
4 x 1 x 1/4	5	Coarse	CJB14	614636 85470
	5	Medium	MJB14	614636 85465
	5	Fine	FJB14	614636 85460
4 x 1 x 1/2	5	Coarse	CJB24	614636 85485
	5	Medium	MJB24	614636 85480
	5	Fine	FJB24	614636 85475
5 x 2 x 5/8	5	Medium	MJB35	614636 85495
	5	Fine	FJB35	614636 85490
6 x 2 x 1	5	Coarse	CJB6	614636 85510
	5	Medium	MJB6	614636 85505
	5	Fine	FJB6	614636 85500
8 x 2 x 1	5	Coarse	CJB8	614636 85525
	5	Medium	MJB8	614636 85520
	5	Fine	FJB8	614636 85515
8 x 3 x 1/2	5	Coarse	CJB83	614636 54459*
	5	Medium	MJB83	614636 54458*
	5	Fine	FJB83	614636 54457*
11-1/2 x 2-1/2 x 1/2	1	Coarse	JM3	614636 85980#
	1	Medium	JM6	614636 85975#

TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Single Grit Benchstones – Soft Arkansas				
8 x 2 x 3/4-1	5	Extra Fine	SB8	614636 85680

* May be used as replacement stone for IM-83 Sharpening System.
May be used as replacement stone for IM-313 Sharpening Stone System.
These benchstones (except for 8 x 3 x 1/2 and vendibles) are packed in individual boxes within a case. Order in multiples of stones/case.

TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Single Grit Benchstones – India (Aluminum Oxide)				
4 x 1 x 1/4	5	Coarse	CB14	614636 85580
	5	Medium	MB14	614636 85575
	5	Fine	FB14	614636 85570
4 x 1 x 1/2	5	Coarse	CB24	614636 85595
	5	Medium	MB24	614636 85590
	5	Fine	FB24	614636 85585
5 x 2 x 5/8	5	Medium	MB35	614636 85605
	5	Fine	FB35	614636 85600
6 x 2 x 1	5	Coarse	CB6	614636 85620
	5	Medium	MB6	614636 85615
	5	Fine	FB6	614636 85610
8 x 2 x 1	5	Coarse	CB8	614636 85635
	5	Medium	MB8	614636 85630
	5	Fine	FB8	614636 85625
8 x 3 x 1/2	5	Coarse	CB83	614636 54462*
	5	Medium	MB83	614636 54461*
	5	Fine	FB83	614636 54460*
11-1/2 x 2-1/2 x 1/2	1	Medium	IM6	614636 54214#
	1	Fine	IM9	614636 85970#

TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Single Grit Benchstones – Hard Translucent Arkansas				
4 x 2 x 3/4-1	5	Ultra Fine	HB4	614636 85655
6 x 2 x 3/4-1	5	Ultra Fine	HB6	614636 85660
8 x 2 x 3/4-1	5	Ultra Fine	HB8	614636 85665



Benchstones

Better choice for economical solution for general sharpening and finishing with one stone



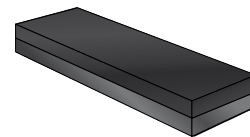
COMBINATION GRIT ABRASIVE BENCHSTONES

- **Crystolon Combination**
Coarse and fine grit sharp-cutting silicon carbide abrasive surfaces for general sharpening (to moderate tolerances) when the speed of sharpening is more important than the fineness of the cutting edges. Gray in color.
- **India Combination**
Coarse and fine grit aluminum oxide abrasive surfaces produce strong, keen, long-lasting edges on quality tools. Orange/brown in color.
- **Crystolon/India Combination**
Fast-sharpening, medium grit silicon carbide (Crystolon) and fine aluminum oxide (India) abrasive surfaces for keen, long-lasting edges on quality tools. Crystolon side is dark gray in color, India side is orange.
- **Giant Combination Stones**
11-1/2" and 12" bench oil stones are used to sharpen large edge tools with long sweeping strokes.

Application-to-Product Recommendation Guide

	FAST CUT STOCK REMOVAL	INITIAL SHARPENING	FINAL SHARPENING	HONING	SHARPEST EDGE
Grit Size	Coarse	Medium	Fine	Extra Fine	Ultra Fine
Abrasive	Crystolon	Crystolon	India	Soft Arkansas	Hard Arkansas
Product/Color	Grey	Grey	Orange	Milky White	Translucent

SIZE (L x W x H)	QTY./CASE	SPEC.	TIER: BETTER	
			PRODUCT #	PART #
Combination Grit Benchstones – Crystolon (Silicon Carbide)				
4 x 1 Round	5	Coarse/Fine	JB64	614636 85435
4 x 1-3/4 x 5/8	5	Coarse/Fine	JB134	614636 85440
5 x 2 x 3/4	5	Coarse/Fine	JB45	614636 85445
6 x 2 x 1	5	Coarse/Fine with Anniversary Box	JB6	614636 85450
8 x 2 x 1	5	Coarse/Fine with Anniversary Box	JB8	614636 85455
11-1/2 x 2-1/2 x 1	2	Coarse/Fine	JUM3	614636 85840
12 x 2-1/2 x 1-1/2	2	Coarse/Fine	JUM4	614636 85855
Combination Grit Benchstones – India (Aluminum Oxide)				
4 x 1 Round	5	Coarse/Fine	IB64	614636 85545
4 x 1-3/4 x 5/8	5	Coarse/Fine	IB134	614636 85550
5 x 2 x 3/4	5	Coarse/Fine	IB45	614636 85555
6 x 2 x 1	5	Coarse/Fine with Anniversary Box	IB6	614636 85560
8 x 2 x 1	5	Coarse/Fine with Anniversary Box	IB8	614636 85565
11-1/2 x 2-1/2 x 1	2	Coarse/Fine	IM2	614636 85851
Combination Grit Benchstones – Crystolon/India				
6 x 2 x 1	5	Medium/Fine	IC6	614636 85643
11-1/2 x 2 x 1	2	Medium/Fine	IC11	614636 87239



These benchstones are packed in individual boxes within a case. Order in multiples of stones/case.

Waterstones

Waterstones are synthetic stones designed to be softer than oil stones. These softer grade stones are used with water as the lubricant (versus oil) to develop a fast cutting slurry. The Norton Waterstone system was designed in a carefully planned sequence to create sharpening efficiency. You get the level of abrasiveness you need at each stage, without wasting time trying to sharpen your tools on a grit that is too fine, too soon.



Better choice for producing superior edges on planes and straight chisels

WATERSTONES

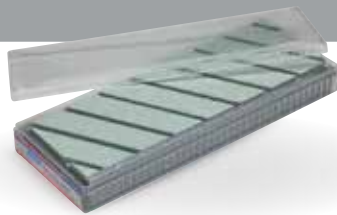
- Synthetic stones designed to work together, with water for fast sharpening, fine finish
- Softer than traditional oilstones - providing lapping action for superb results with low pressure
- Color-coded by grit: 220 grit for repairing badly damaged tools, 1000 grit for initial cut, 4000 grit for excellent finishing, and 8000 grit for polishing



Better choice for raising slurry

PREP STONE

- This synthetic stone enhances the performance of waterstones by speeding up the slurry-making process needed to cut and polish with waterstones
- This prep stone is designed to raise the slurry on waterstones without significantly altering the dimensions of the stone
- Waterstones are great for producing superior edges for planes and straight chisels



Better choice for producing flat surfaces on waterstones

FLATTENING STONE

- Coarse grit silicon carbide stone promotes fast results
- Diagonal grooves increase swarf removal
- Superbly flat with hard bond to produce extremely flat surfaces on all waterstones

SIZE (L x W x H)	QTY./CASE	SPEC.	TIER: BETTER	PART #
Waterstones – Single Grit				
8 x 3 x 1	5	220		614636 89505
	5	1000		614636 89506
	5	4000		614636 89507
	5	8000		614636 89508
Set	1	4 Stones: 220, 1000, 4000, 8000 Grit		614636 24334
Waterstones – Combination Grit				
8 x 3 x 1	5	220 / 1000		614636 24335
	5	1000 / 4000		614636 24450
	5	1000 / 8000		699366 55039
	5	4000 / 8000		614636 24336
Prep Stone				
20mm x 20mm x 3"	5	Aluminum Oxide		662434 39361
Flattening Stone				
9 x 3 x 3/4	5	Silicon Carbide		699366 87444
Waterstone Kit				
N/A	1	Kit includes: 1-220/1000 and 1-4000/8000 waterstone, 1 flattening stone		076607 87943

Waterstones are packed in individual boxes within a case. Order in multiples of stones/case.

TECH TIP

Maximizing Waterstone Performance

- Wet waterstone
- Rub evenly with the prep stone to create slurry
- Evening off the high spots will make for less-frequent flattening of the waterstones
- Waterstones wear concave with use; periodically flatten with flattening stone

Instructional Videos



Sharpening Stones
Playlist

nortonsga.us/kb542

Ideal for sales training and end-user self-study. Learn to efficiently use these sharpening products to maintain tools at peak performance and prolong their life – to make all your sharpening, honing, etc. applications easier.

Diamond Benchstones

Made in the USA, these benchstones have unique stackable non-skid rubber feet designed to keep the diamond plate steady while you sharpen, and efficiently stacked for space-saving storage when not in use. Our simple grit-size color-coding makes them easy to differentiate.

Better choice for producing superior edges on planes and straight chisels



STACKABLE DIAMOND BENCHSTONES

- Flat, diamond surface plated onto a nickel coated steel bar precision ground to a tolerance of .001 in. for fast, even blade and tool edge sharpening
- Continuous diamond sharpening surface for excellent sharpening performance across entire surface of stone
- Choose 220 grit for badly worn tools, 325 for initial sharpening, 600 grit for final sharpening
- Color-coded tabs on stones and packaging for easy identification of grit sizes for use and displaying
- Stackable; the stones firmly stack on top of each other for easy, small-profile storage
- Non-skid rubber base stays in place while sharpening for smoother, efficient sharpening

SIZE WITH RUBBER FEET (L x W x H)	QTY./ CASE	SPEC.	TIER: BETTER	
			PRODUCT #	PART #
Stackable Diamond Benchstones				
6 x 2 x 1/4*	5	D220	662532	68082
6 x 2 x 1/4*	5	D325	662532	68081
6 x 2 x 1/4*	5	D600	662532	68080

Diamond benchstones are packed in individual boxes within a case. Order in multiples of stones/case.



6" stones come retail packaged

Sharpening Stone Oil

Better choice for improving sharpening stone performance



SHARPENING STONE OIL

- Highly refined lubricating oil which is specifically formulated for sharpening stone use
- Will not load or "gum-up" sharpening stones, meets U.S. Pharmacopoeia standards for mineral oil purity; may be used around food preparation operations
- Equally ideal for all lubricating jobs

SIZE	QTY./ CASE	SPEC.	TIER: BETTER	
			PRODUCT #	PART #
Sharpening Stone Oil				
4-1/2 oz.	20	Oil	XB1	614636 87760
1 Pint	20	Oil	XB5	614636 87770
1 Quart	5	Oil	XB2	614636 87775

TECH TIP

- All oil stones are porous in nature; oil is required to keep the pores open and working efficiently
- Use Norton oil to optimize the performance of Crystolon, India and Arkansas stones
- While sharpening knives, blades and tools, be careful to keep fingers away from sharp edges

Sharpening Systems

Tri-Stone Systems

The base of the tri-stone system acts as an oil reservoir permitting continuous submersion of the unused stones, keeping them clean and saturated, ready for immediate use and years of utility. Rotating the handle brings the desired stone into position for sharpening. All offer a range of replacement stones to replace worn or damaged stones, or substitute different specifications to customize the system.



Better choice for large, straight-edged tool sharpening

IM313 MULTI-OILSTONE SHARPENING SYSTEM

- Considered by many to be the ultimate sharpening system, the IM313 contains three oil stones. The 11-1/2" stone length permits long, sweeping strokes for faster and more precise sharpening and honing of all large, wider straight-edged tools. The heavy base has a non-skid bottom.
- Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- Each IM313 system is included with a pint of Norton oil, plastic angle guide, and reservoir unit



Better choice for a versatile, multi-size tool and knife sharpener

IM200 PROFESSIONAL SHARPENING SYSTEM

- The smaller 8" stone IM200 system provides the same quality sharpening features as the IM313 – making it the perfect choice for small restaurants and home DIYers
- Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- Contains 4-1/2 oz. of lubricating oil, plastic angle guide, and the reservoir unit



Better choice for small straight-edged tool sharpening

IM100 3-IN-1 TOOL AND KNIFE SHARPENING SYSTEM

- The smallest system, designed for general sharpening, the IM100 is an affordable choice for small knives, cutlery, and woodworking tools
- Coarse Crystolon stone quickly restores worn edges for general sharpening; medium Crystolon stone produces the average edge needed for most tools; and fine India stone hones for a sharper edge
- 4-1/2 oz. of lubricating oil and a reservoir unit included

Portable Sharpening Systems



Better choice for all sharpening enthusiasts who carry their system with them

IM83 PORTABLE SHARPENING STONE SYSTEM

- Sturdy metal latches secure the cover and storage case – where small tools can be housed. The IM83 system is designed like all our other sharpening systems; the stones can be replaced to customize the unit to individual requirements
- Ideal for industrial toolrooms, restaurants, knife manufacturers, DIYers, and sportsmen
- Both IM83 systems include 3 sharpening stones, and a reservoir carrying case; the oil stone system also includes 4-1/2 oz. oil
- IM83-W Portable Waterstone System – Tool Repair to Fine Finishes
This portable sharpening system is equipped with a carefully engineered sequence of waterstones for clean, efficient sharpening. The waterstones can easily be maintained with the flattening stone provided
- IM83-O Portable Oil Stone System – Straight-Edged Tool Sharpening
The coarse silicon carbide (Crystolon) stone in this system repairs damaged edges quickly; the medium aluminum oxide (India) stone imparts a durable, smooth cutting edge; and the fine aluminum oxide (India) stone provides the final sharpening and polishing stage

Sharpening Systems

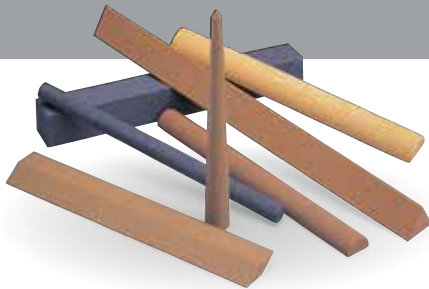
Portable Sharpening Systems

SIZE	QTY./CASE	SPEC.	PRODUCT #	PART #
<i>TIER: BETTER</i>				
IM313 Multi-Oilstone Sharpening System				
11-1/2 x 2-1/2 x 1/2	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 1 Pint Oil, Angle Guide, Reservoir Unit	IM313	614636 85960
IM200 Professional Sharpening System				
8 x 2 x 3/8	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 4-1/2 oz. Oil, Angle Guide, Reservoir Unit	IM200	614636 91260
IM100 3-in-1 Tool and Knife Sharpening System				
6 x 2 x 1/2	1	1 Coarse Crystolon, 1 Medium Crystolon, and 1 Fine India Stone, 4-1/2 oz. Oil, Reservoir Unit	IM100	614636 85356
IM83 Portable Systems				
8 x 3 x 1/2	1	Oilstones: 1 Coarse Crystolon, 1 Medium India, 1 Fine India, 4-1/2 oz. Oil, Reservoir Carrying Case	IM83-O	662435 82823
8 x 3 x 1	1	Waterstones: 1 ea. of 1000, 4000, 8000 Grit, 1 Flattening Stone, Reservoir Carrying Case	IM83-W	662435 82825

For sharpening system replacement stones: see single grit benchstone charts, or your Norton representative for replacement stones and parts which may be used as replacements or to customize your system.

Abrasive Files

Norton abrasive files hold their shape while imparting the finest, most uniform finish on precision machine parts and in tool and die making. They are ideal for any deburring, chamfering or radiusing job, or for filing delicate parts. Select the file shape that matches the contour of the surface being stoned.



Better choice for any deburring, chamfering or radiusing job, or for filing delicate parts

ABRASIVE FILES

- Crystolon Files – Fast-acting silicon carbide products, Crystolon files are designed for use where moderate tolerances are acceptable, and speed of sharpening is more important than fineness
- India Files – India files are ideal when close tolerance, and strong, keen, long-lasting edges are needed
- Hard Translucent Arkansas Files – Hard Arkansas has an ultra fine grit that produces the finest edge possible while maintaining tolerances unequalled by any other abrasive file. It will also produce a highly polished finish

Square Abrasive Files

Square File applications range from dimensioning keyways to maintain fit, stoning faces on router bits, touching-up edges of reamer teeth, and lapping/honing to close tolerances to produce the finest edge on precision instruments, die work and delicate tools.



SIZE (L x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
<i>TIER: BETTER</i>				
Square Abrasive Files – Crystolon (Silicon Carbide)				
4 x 1/2	5	Medium	MJF44	614636 86045
	5	Fine	FJF44	614636 86040
Square Abrasive Files – Hard Translucent Arkansas				
3 x 1/4	5	Ultra Fine	HF13	614636 86590
3 x 3/8	5	Ultra Fine	HF33	614636 86595
3 x 1/2	5	Ultra Fine	HF43	614636 86600

All square files are bulk packed

SIZE (L x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
<i>TIER: BETTER</i>				
Square Abrasive Files – India (Aluminum Oxide)				
4 x 1/4	5	Coarse	CF14	614636 86075
	5	Medium	MF14	614636 86070
	5	Fine	FF14	614636 86065
4 x 3/8	5	Coarse	CF34	614636 86090
	5	Medium	MF34	614636 86085
	5	Fine	FF34	614636 86080
4 x 1/2	5	Coarse	CF44	614636 86105
	5	Medium	MF44	614636 86100
	5 V	Medium	MF44-V	662533 25913
	5	Fine	FF44	614636 86095
6 x 1/2	5	Coarse	CF46	614636 86120
	5	Medium	MF46	614636 86115
	5	Fine	FF46	614636 86110
6 x 5/8	5	Medium	MF56	614636 86130
	5	Fine	FF56	614636 86125
	6 x 3/4	5	Coarse	CF66
5		Medium	MF66	614636 86145
5		Fine	FF66	614636 86140
6 x 1	5	Coarse	CF76	614636 86165
	5	Medium	MF76	614636 86160
	5	Fine	FF76	614636 86155

V = Vendible Package. Ideal for vending machines, small jobs, and carrying to job site. Pre-packed in sturdy boxes of 5 per pack. Order by total number of stones needed in multiples of 5.

Abrasive Files

Triangular Abrasive Files

Triangular Files are used for a variety of deburring, chamfering and radiusing applications including cleaning tap threads, stoning cutting surfaces of milling cutters, lapping honing tools, dies and molds, and putting precision points on center punches.

The India line also offers Tapered Triangles, used by mechanics and tool and die makers to impart the correct edge in the least time.



TIER: **BETTER**

SIZE (L x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Triangular Abrasive Files – Crystolon (Silicon Carbide)				
4 x 1/4	5	Fine	FJF114	614636 86185
4 x 1/2	5	Fine	FJF144	614636 86205
Triangular Abrasive Files – Hard Translucent Arkansas				
3 x 1/4	5	Ultra Fine	HF113	614636 86620
3 x 3/8	5	Ultra Fine	HF133	614636 86625
3 x 1/2	5	Ultra Fine	HF143	614636 86630

All Triangular files are bulk packed

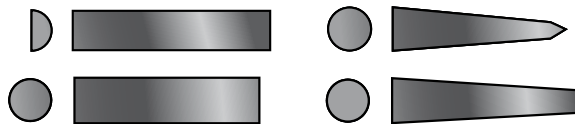
Round Abrasive Files

Half Round Files offer both a round and a flat surface for imparting a fine finish on precision machine parts, tools and dies.

Round Files are ideal for deburring, chamfering, radiusing, lapping, honing, cleaning radius tools to a burr-free edge, and dimensioning compound curves on templates.

Round Pointed Files are ideally suited for engravers and die sinkers for stoning difficult recesses on instruments and die tools.

Round Tapered Files are used by craftsmen, woodworkers, and die makers as their unique shape imparts the correct edge quickly.



TIER: **BETTER**

SIZE (L x D)	QTY./CASE	SPEC.	PRODUCT #	PART #
Half Round Abrasive Files – India (Aluminum Oxide)				
4 x 1/4	5	Medium	MF314	614636 86355
		Fine	FF314	614636 86350
4 x 3/8	5	Medium	MF334	614636 86385
		Fine	FF334	614636 86380
4 x 1/2	5	Coarse	CF344	614636 86405
		Medium	MF344	614636 86400
		Fine	FF344	614636 86395

All Half-Round and Round files are bulk packed

TIER: **BETTER**

SIZE (L x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Triangular Abrasive Files – India (Aluminum Oxide)				
4 x 1/4	5	Coarse	CF114	614636 86240
		Medium	MF114	614636 86235
		Fine	FF114	614636 86230
4 x 3/8	5	Coarse	CF134	614636 86255
		Medium	MF134	614636 86250
		Fine	FF134	614636 86245
4 x 1/2	5	Coarse	CF144	614636 86270
		Medium	MF144	614636 86265
		Fine	FF144	614636 86260
6 x 1/2	5	Coarse	CF146	614636 86285
		Medium	MF146	614636 86280
		Fine	FF146	614636 86275
6 x 5/8	5	Medium	MF156	614636 86295
		Fine	FF156	614636 86290
6 x 3/4	5	Medium	MF166	614636 86310
		Fine	FF166	614636 86305
6 x 1	5	Medium	MF176	614636 86325
		Fine	FF176	614636 86320
Triangular Tapered Abrasive Files – India (Aluminum Oxide)				
4 x 1/2 x 1/4	5	Medium	MF544	614636 86685
		Fine	FF544	614636 86680

TIER: **BETTER**

SIZE (L x D)	QTY./CASE	SPEC.	PRODUCT #	PART #
Round Abrasive Files – Crystolon (Silicon Carbide)				
4 x 1/4	5	Medium	MJF214	614636 86430
		Fine	FJF214	614636 86425
4 x 3/8	5	Medium	MJF234	614636 86440
Round Abrasive Files – India (Aluminum Oxide)				
4 x 1/4	5	Coarse	CF214	614636 86480
		Medium	MF214	614636 86475
		Fine	FF214	614636 86470
4 x 3/8	5	Coarse	CF234	614636 86495
		Medium	MF234	614636 86490
		Fine	FF234	614636 86485
4 x 1/2	5	Coarse	CF244	614636 86510
		Medium	MF244	614636 86505
		Fine	FF244	614636 86500
6 x 1/2	5	Coarse	CF246	614636 86525
		Medium	MF246	614636 86520
		Fine	FF246	614636 86515
6 x 5/8	5	Medium	MF256	614636 86535
6 x 3/4	5	Medium	MF266	614636 86550
6 x 1	5	Medium	MF276	614636 86565
Round Abrasive Files – Hard Translucent Arkansas				
3 x 1/4	5	Ultra Fine	HF813	614636 86800
Round Pointed Abrasive Files – India (Aluminum Oxide)				
3 x 5/16 Base	5	Medium	MF723	614636 86745
		Fine	FF723	614636 86740
Round Pointed Abrasive Files – Hard Translucent Arkansas				
3 x 1/4 Base	5	Ultra Fine	HF863	614636 86825
Round Tapered Abrasive Files – India (Aluminum Oxide)				
4 x 1/2 x 1/4	5	Medium	MF644	614636 86655
		Fine	FF644	614636 86650

Abrasive Files

Diamond-Shaped Abrasive Files

Diamond-shaped Files are precision sharpening favorites for cleaning acute angles in dies and molds, and for stoning geometric chasers and sewing machine feeds.



TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Diamond-Shaped Abrasive Files – India (Aluminum Oxide)				
4 x 9/16 x 3/16	5	Coarse	CT134	614636 86720
	5	Medium	MT134	614636 86715
	5	Fine	FT134	614636 86710
Diamond-Shaped Abrasive File – Hard Translucent Arkansas				
3 x 1/2 x 3/16	5	Ultra Fine	HF843	614636 86815

All Diamond-shaped files are bulk packed

Beveled Abrasive Files

Beveled Files are preferred by exacting artisans, jewelers, mechanics, and watchmakers for honing the finest of finishes. These extremely hard files provide years of service.



TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Beveled Abrasive File – Hard Translucent Arkansas				
3 x 3/8 x 1/8	5	Ultra Fine	HF833	614636 86810

All Beveled files are bulk packed

Flat Abrasive Files

The Flat File is the choice of mechanics, artisans and jewelers. This long lasting file produces the finest finishes.



TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Flat Abrasive File – Hard Translucent Arkansas				
3 x 3/8 x 1/8	5	Ultra Fine	HF823	614636 86805

All Flat files are bulk packed

Oval Abrasive Files

The Oval File's shape makes it ideal for finishing and honing recesses or curved edges of precision instruments.



TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Oval Abrasive File – Hard Translucent Arkansas				
3 x 1/2 x 3/16	5	Ultra Fine	HF853	614636 86820

All Oval files are bulk packed

Knife Blade Abrasive Files

Knife Blade Files are used by clock and watch makers to quickly sharpen, hone, and maintain the edges and points of cutting tools.



TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Knife Blade Abrasive Files – India (Aluminum Oxide)				
4 x 1 x 1/8 Back	5	Coarse	CF724	614636 86780
	5	Medium	MF724	614636 86775
	5	Fine	FF724	614636 86770
Knife Blade Abrasive File – Hard Translucent Arkansas				
3 x 3/4 x 1/8	5	Ultra Fine	HF873	614636 86830

All Knife Blade files are bulk packed

Abrasive File Sets

Hard Translucent Arkansas File Set

This set provides a selection of our most popular square, triangular, round and knife blade files in ultra fine Hard Translucent Arkansas for honing and polishing a wide range of configurations.

Hard Translucent Arkansas-India File Set

This set contains an assortment of files for finishing, honing and polishing applications. It contains a selection of the most popular square, triangular, round and knife blade files in both fine grit India and ultra fine grit Hard Translucent Arkansas.



TIER: BETTER			
SIZE (L x W x H)	QTY./CASE	PRODUCT #	PART #
File Set – Hard Translucent Arkansas			
	1		614636 86839
1 Each of Ultra Fine Hard Arkansas HF13, HF113, HF813, and HF873			
File Set – Hard Translucent Arkansas and India (Aluminum Oxide)			
	1		614636 86840
1 Each of Ultra Fine Hard Arkansas HF13, HF43, HF113, HF813, HF873, and Fine India FF14, FF44, FF114, FF214, FF724			

See the "Norton Professional Sharpening Products and Dressing Sticks Catalog #200" on nortonabrasives.com to view the complete list and descriptions of our many sharpening products.

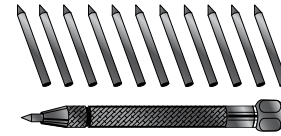
Abrasive Files

Engravers' Chuck & Points

Engravers' Points are the choice of professional die-makers for cleaning tight corners and recesses where close tolerances and accuracy are a must. The Engravers' Chuck is a knurled nickel-plated tool designed to hold the Engravers' Point.

TIER: BETTER				
SIZE (L x POINT)	QTY./CASE	SPEC.	PRODUCT #	PART #
Engravers' Chuck				
Engravers' Chuck	5		XT1	614636 87485
Engravers' Point – India (Aluminum Oxide)				
1 x 1/8 Point	5	Fine	FT11	614636 87495
Engravers' Point – Soft Arkansas				
1 x 1/8 Point	5	Extra Fine	AT11	614636 87490

All Engravers' Chucks and Points are bulk packed.

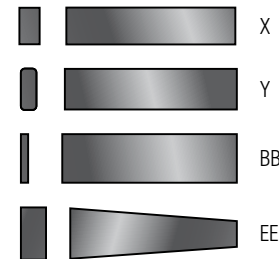


Silversmith Precision Files

These aluminum oxide precision-shaped stones are designed for use by silversmiths and mechanics for close tolerance lapping, touching-up instruments, and for cleaning tools and dies.

TIER: BETTER				
SIZE	QTY./CASE	SPEC.	PRODUCT #	PART #
Silversmith Precision Files – India (Aluminum Oxide)				
4 x 5/16 x 3/16 x 5/16 x 1/16 - X	5	Medium	MF414	614636 86855
	5	Fine	FF414	614636 86850
4 x 1/2 x 1/16 - BB	5	Medium	MF444	614636 86960
	5	Fine	FF444	614636 86955
4 x 1/2 x 1/4 x 5/16 x 1/8 - EE	5	Medium	MF474	614636 87005
	5	Fine	FF474	614636 87000 NS

All Silversmith Precision Files are bulk packed.



Pocket Stones



Better choice for outdoor enthusiasts

POCKET STONES

- Convenient and easily transported
- Ideal for outdoor enthusiasts to sharpen scissors, knives, axes, etc.
- Available in a protective case

TIER: BETTER				
SIZE (L x W x H)	QTY./CASE	SPEC.	PRODUCT #	PART #
Sportsman Pocket Stone – India (Aluminum Oxide)				
3 x 1-1/2 x 1/2	50	Coarse/Fine	IBP4	614636 90705
Pocket Stone – India (Aluminum Oxide)				
4 x 3/4 x 1/4	25	Fine	IBP4	614636 24153
Pocket Stone with Case – India (Aluminum Oxide)				
3 x 7/8 x 3/8 with case	50	Fine	FBP3	614636 91122
Pocket Stone with Case – Crystolon (Silicon Carbide)				
3 x 7/8 x 3/8 with case	50	Fine	JP14	614636 90703
Fish Hook Stone With Pouch – Crystolon Half-Round (Silicon Carbide)				
3 x 1/2 with pouch	50	Fine		614636 24072

All Pocket Stones are bulk packed.

Abrasive Slips



Better choice for imparting fine, uniform finishes

ABRASIVE SLIPS

- Norton abrasive slips impart the finest, most uniform finishes on curved knives and tools, molders' knives, wood gouges, bead planers, and carbide-tipped tools
- The Crystolon and India stones are designed for preliminary sharpening; the Norton Hard Translucent Arkansas stones are the choice for achieving the finest finish possible
- These fast-acting slips hold their shape and are long lasting

Carbide Tool Slips

Crystolon (silicon carbide) Slips are used to maintain the edge of carbide tools – keeping regrinding costs and time to an absolute minimum. Not oil-filled.

Round Edge Slips

Round Edge Slips are ideal for precision sharpening and honing of bead planers, curved knives and tools, molders' knives and wood gouges.



TIER: **BETTER**

SIZE	QTY./CASE	SPEC.	PRODUCT #	PART #
Carbide Tool Slips – Crystolon (Silicon Carbide)				
3-1/2 x 3/4 x 1/2	5	Coarse	CJT63	614636 87295
	5	Medium	MJT63	614636 87290
	5	Fine	FJT63	614636 87285
Set of Three Above	5	Coarse, Medium & Fine	J63	614636 87300
Carbide Tool Slips – India (Aluminum Oxide)				
2-1/4 x 7/8 x 3/16	5	Medium	MS12	614636 87215
Round Edge Slips – Crystolon (Silicon Carbide)				
4-1/2 x 1-3/4 x 1/4 x 3/32	5	Medium	MJS24	614636 87080
	5	Fine	FJS24	614636 87075
4-1/2 x 1-3/4 x 1/2 x 3/16	5	Coarse	CJS44	614636 87100
	5	Medium	MJS44	614636 87095
	5	Fine	FJS44	614636 87090
6 x 2-1/4 x 3/4 x 3/8	5	Medium	MJS66	614636 87110
	5	Fine	FJS66	614636 87105
Round Edge Slips – India (Aluminum Oxide)				
4 x 1 x 7/16 x 3/16	5	Medium	MS14	614636 87140
	5	Fine	FS14	614636 87135
4-1/2 x 1-3/4 x 1/4 x 3/32	5	Coarse	CS24	614636 87155
	5	Medium	MS24	614636 87150
	5	Fine	FS24	614636 87145
4-1/2 x 1-3/4 x 3/8 x 1/8	5	Coarse	CS34	614636 87170
	5	Medium	MS34	614636 87165
	5	Fine	FS34	614636 87160
4-1/2 x 1-3/4 x 1/2 x 3/16	5	Coarse	CS44	614636 87185
	5	Medium	MS44	614636 87180
	5	Fine	FS44	614636 87175
5 x 1 x 5/16 x 3/32	5	Medium	MS15	614636 87195
	5	Fine	FS15	614636 87190
Round Edge Slips – Soft Arkansas				
4 x 1-3/4 x 3/8 x 1/8	5	Extra Fine	SS4	614636 87055
Round Edge Slips – Hard Translucent Arkansas				
3 x 1-3/4 x 1/4 x 1/16	5	Ultra Fine	HS3	614636 87040
4 x 1-1/4 x 1/4 x 1/8	5	Ultra Fine	HS14	614636 87050
4 x 1-3/4 x 3/8 x 1/8	5	Ultra Fine	HS4	614636 87045

All Slips are bulk packed.

Specialty Stones



Better choice for specific sharpening or deburring applications

SPECIALTY STONES

- Norton continues to offer specialty stones with optimum specifications and unique shapes that conform to, and quickly sharpen, specific tools

Specialty Stones for Machine Tools

Gouge Sharpening Stone

This stone has a unique shape for sharpening and lapping inside and outside curved surfaces on gouges and other cutting tools.

Jointer Stones

These stones provide a fast method of restoring and maintaining the cutting edges of mechanical jointing devices on automatic planers.

Machine Knife Stone

Crystolon (silicon carbide) machine knife stones offer both coarse and fine sides for sharpening and honing paper and cloth-cutting knives and planer knives on the machine. The groove around the middle of the stone protects fingers and provides a secure hold.

Reamer Stones

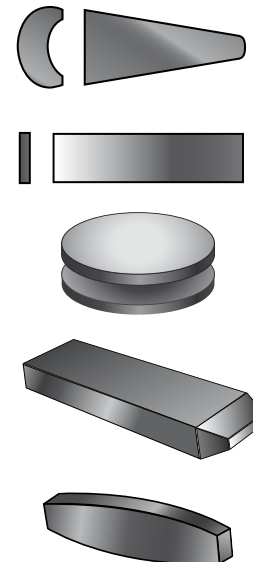
Durable, fast-cutting stones designed for imparting a professional edge on reamers, taps, and rough rounders on shoe machine tools.

Boat Stones

Boat Stones are medium grit, medium grade stones that are easy to hold and use. Excellent for deburring and breaking sharp edges on dies, fixtures and machined parts, and for deburring grinder magnetic chucks.

SIZE	QTY./CASE	SPEC.	PRODUCT #	PART #
<i>TIER: BETTER</i>				
Gouge Sharpening Stone – India (Aluminum Oxide)				
6 x 2 x 1 x 1/2 x 3/8	5	Fine	FS76	614636 87305
Jointer Stones				
4 x 3/4 x 3/8 – Crystolon (Silicon Carbide)	5	Medium	JE74	614636 87335
Machine Knife Stone – Crystolon (Silicon Carbide)				
4" Diam. x 1-1/2" Thick	5	Coarse/Fine	JB74	614636 87570
Reamer Stones – India (Aluminum Oxide)				
4-1/2 x 1 x 5/16	10	Medium	MT124	614636 87420
	10	Fine	FT124	614636 87415
5 x 1 x 3/16	10	Medium	MT125	614636 87430
	10	Fine	FT125	614636 87425
6 x 1 x 1/4	10	Medium	MT126	614636 87440
	10	Fine	FT126	614636 87435
Boat Stone – Crystolon (Silicon Carbide)				
9 x 2-1/2 x 1-1/2	10	37C80-HV		614636 10369
Boat Stone – India (Aluminum Oxide)				
9 x 2-1/2 x 1-1/2	10	38A60-IVBE		614636 10503

Boat and Reamer Stones are bulk packed. All these other Specialty Stones are packed in individual boxes within a case.



Large Specialty Stones

Tradesmen's Utility Stones

Used for sharpening trimming knives and as an abrasive file in many different industries. The JT910 does not have a handle, while the JT920 and JT930 have wooden handles.

Sickle and Scythe Stones

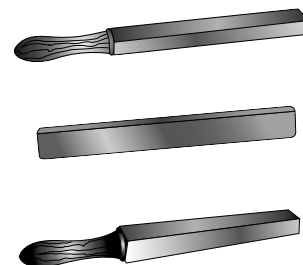
These silicon carbide stones quickly produce a fast-cutting edge on sickles, scythes, and brush hooks. These stones are most frequently chosen where the speed of sharpening is the primary consideration.

Utility File

A long wedge-shaped stone with four flat sides designed for sharpening coarse cutting edges on cutting implements and edged garden tools. Wooden handles make them easy to use. They will outlast and out-sharpen metal files.

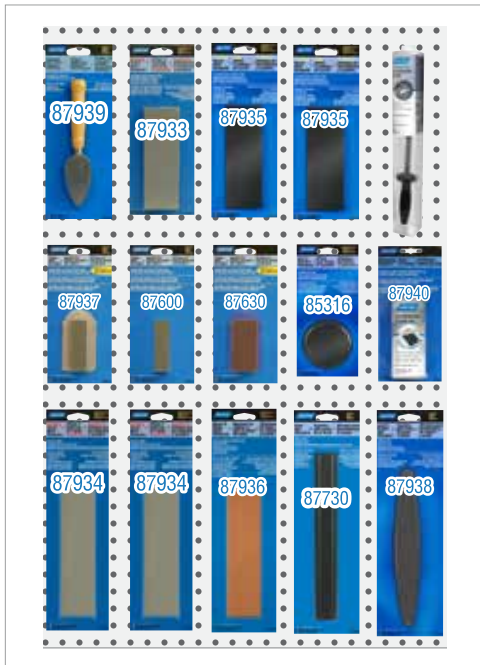
SIZE	QTY./CASE	SPEC.	PRODUCT #	PART #
<i>TIER: BETTER</i>				
Tradesmen's Utility Stones – Crystolon (Silicon Carbide)				
10 x 1-1/4 x 3/4	10	Medium	JT910	614636 87665
14-3/4 Overall (with Handle)	10	Coarse/Fine	JT930	614636 87675
	10	Medium	JT920	614636 87670
Sycle and Scythe Stones				
10 x 1-1/4 x 3/4 Crystolon (Silicon Carbide)	10	Coarse	TJ3	614636 87731
10 x 1-5/16 x 3/4 India (Aluminum Oxide)	10	Coarse	TD1	614636 87715
Utility File – Crystolon (Silicon Carbide)				
14 Overall (w/ Handle)	10	Coarse	JD2	614636 87750

All Large Specialty Stones are bulk packed.



Retail Packaged Sharpening Products

Our retail-packaged line brings Norton quality to your distributor showroom, vending machine, tool crib, and your tool box. Each stone is specifically designed for a popular sharpening application and packaged to sell or carry to the job site.



SIZE (L x W x H)	SPEC.	TIER: BETTER	
		QTY./CASE	PART #
Axe and Hatchet Sharpener			
3 x 5/8 round	Coarse/Fine Crystolon (Silicon Carbide)	10	076607 85316
Pocket Knife Sharpener			
3 x 7/8 x 3/8	Fine Crystolon (Silicon Carbide)	5	076607 87600
3 x 7/8 x 3/8 with case	Medium India (Aluminum Oxide)	5	076607 87937
3 x 1-1/2 x 1/2 with case	Coarse/Fine India (Aluminum Oxide)	5	076607 87630
Economy Tool & Knife Benchstone			
6 x 2 x 3/4	Coarse/Fine Crystolon (Silicon Carbide)	5	076607 87933
	Coarse/Fine India	5	692104 26152
8 x 2 x 3/4	Coarse/Fine Crystolon	10	692104 26633
	Coarse/Fine India (Aluminum Oxide)	10	614636 85755
Chisel & Planer Blade Sharpener			
8 x 2 x 3/4	Coarse/Fine India (Aluminum Oxide)	10	076607 87936
Household Knife & Tool Sharpener			
7-1/2	Fine Crystolon (Silicon Carbide)	5	076607 87939
Farm Tool Sharpener			
10 x 1-1/4 x 3/4	Coarse Crystolon (Silicon Carbide)	10	076607 87730
Lawn & Garden Tool Sharpener			
9-1/2 x 1-3/8 x 1/2	Medium Crystolon (Silicon Carbide)	10	076607 87938
Sharpening Stone Oil			
4-1/2 oz.	Oil	5	076607 87940
Sharpening Steel			
1/2 x 10	Round file with rubber handle	8	662532 40433
Vitrified Dressing Stick			
1 x 1 x 6	Medium Silicon Carbide	5	076607 10466



Knife and Scissor Sharpener

The knife and scissor mechanical sharpener is a quick and portable tool for hundreds of sharpening applications.

SPECIFICATION	QTY./CASE	PART #
Knife and Scissor Sharpener		
Carbide. Case contains 4 each of red, green, and yellow.	12	076607 87520



Non-Slip Silicon Sharpening Stone Mat

This thin and flexible 8" x 14" mat is large enough to handle all conventionally-sized sharpening stones. A textured surface keeps the mat firmly in place during use. Ideal for use with stones sold without a non-skid base. It can also be used in conjunction with stone holders to keep them extra secure.

Can be rolled or folded for compact storage. Easily cleaned with soap and water.

SPECIFICATION	QTY./CASE	PART #
Non-Slip Silicon Sharpening Stone Mat		
8 x 14	25	690786 48467

Norton Professional Sharpening Products and Dressing Sticks

See the "Norton Professional Sharpening Products and Dressing Sticks Catalog #200" on nortonabrasives.com to view the complete list and descriptions of our many sharpening products.



Hard silicon carbide rubbing bricks are used for heavy-duty applications such as rubbing floors, cleaning and scouring castings, rubbing down concrete, and removing mold marks.

Applications:

Floor Rubbing Bricks – are used to rub down concrete and remove mold marks. These are designed to fit the chucks of common concrete floor grinding equipment. Reusable wooden wedges anchor the bricks to the equipment chucks.

Plain Hand Rubbing Bricks – are the choice of mechanics and foundry workers for dressing grinding wheels and cleaning or scouring castings.

Fluted Hand Rubbing Bricks – are used by masons and stone workers for rubbing down concrete and removing mold marks. The diagonal flutes provide sharp edges, a clean shearing action, and carry away debris.

Fluted Hand Rubbing Bricks with Handle – make quick work of removing mold marks and rubbing down concrete. The firmly attached handle reduces fatigue and facilitates overhead, wall, and floor work.

Griddle Bricks – quickly clean away carbon build-up and other residue on your grill without leaving fibers, which grill brushes often do.

Grit Range:

6 – 120

Abrasive Type:

Silicon Carbide

Machine Used:

Hand Sanding



HAND SANDING



ELECTRIC FLOOR STRIPPER



SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PART #
Plain Floor Rubbing Bricks with Wooden Wedges				
4 x 2 x 2	6	C6-R	Silicon Carbide	614636 53292
	6	C10-R	Silicon Carbide	614636 53293
	6	C24-R	Silicon Carbide	614636 53294
	6	C80-R	Silicon Carbide	614636 53295

SIZE (L x W x H)	QTY./ CASE	PART #
Wooden Wedges		
	6	614636 85297

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PRODUCT #	PART #
Plain Hand Rubbing Bricks					
8 x 2 x 2	5	C24	Silicon Carbide	BP28	614636 87830

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PRODUCT #	PART #
Fluted Hand Rubbing Bricks					
6 x 2 x 2	5	C20	Silicon Carbide	BF26	614636 87840
8 x 2 x 2	5	C20	Silicon Carbide	BF28	614636 87845

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PRODUCT #	PART #
Fluted Hand Rubbing Bricks with Handle					
6 x 3 x 1	5	C20	Silicon Carbide	BFH6	614636 87800
8 x 3-1/2 x 1-1/2	5	C20	Silicon Carbide	235	614636 87795

SIZE (L x W x H)	QTY./ CASE	SPEC.	ABRASIVE	PART #
Griddle Brick				
4-1/2 x 3 x 2	5	Medium	Alundum	614636 87870

improve your
**PROCESS, PRODUCTIVITY,
AND COST POSITION**

You know the industry-leading performance of our engineered abrasives. Norton R&D has now created new formulations of these abrasives with our exclusive, proprietary Norton Vitrium³ (VS3) bond. You won't get better productivity from any other grinding wheels and segments.

- Cooler cutting with better chip clearance; improved coolant flow; significantly reduced burn
- Reduced wheel loading
- Improved part quality
- Improved precision profile; ultra-radius accuracy
- Extended wheel life
- Reduced dressing frequency and cost
- Improved cycle and process time
- Able to run at higher operating speed; increased throughput and productivity
- Leverage existing equipment; optimize machine efficiency



iGrind App

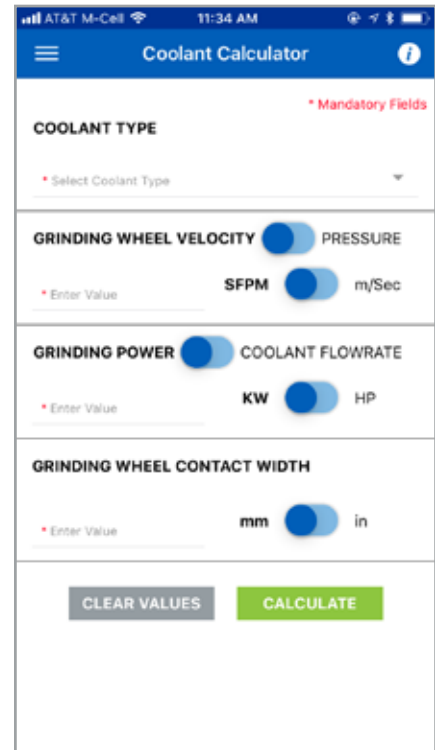
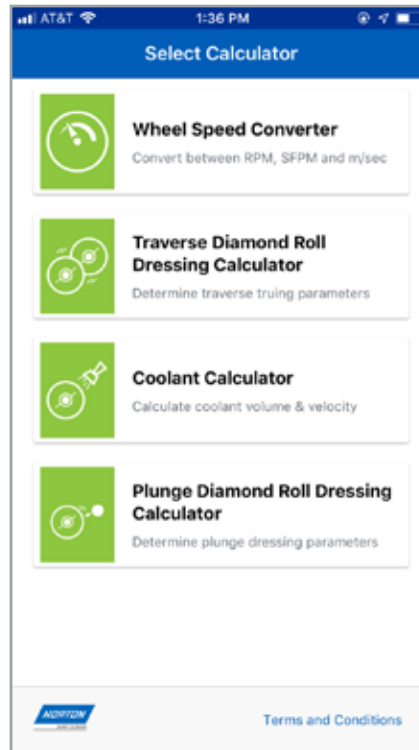
Created by Norton engineers and updated based on feedback from you, the Norton iGrind app features calculators and conversion tools designed to help optimize your grinding processes.

With Norton iGrind, you can calculate the starting parameters for traverse or plunge truing your grinding wheel, determine the ideal setup for delivering coolant to the grinding zone, and convert wheel speeds between RPM, SFPM (Surface Feet Per Minute), and M/Sec to ensure a safe grinding operation.

nortonabrasives.com/en-us/igrind

App Features:

- Wheel Speed Converter
- Traverse Diamond Roll Dressing Calculator
- Coolant Calculator
- Plunge Diamond Roll Dressing Calculator
- Stationary Tool Dressing Calculator



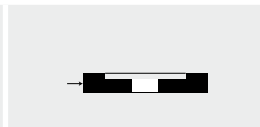
Standard Grinding Wheel and Periphery Shapes



Type 01
Straight Wheels



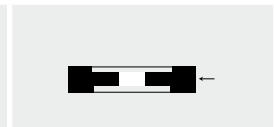
Type 02
Cylinder Wheels



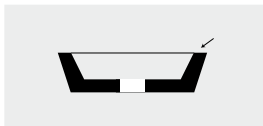
Type 05
Recessed One Side
Wheels



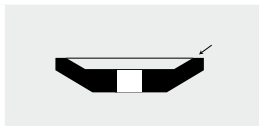
Type 06
Straight Cup Wheels
(rim and back)



Type 07
Double Recessed
Wheels



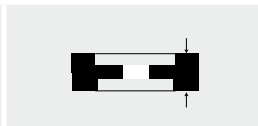
Type 11
Taper Cup Wheels



Type 12
Dish Wheels



Type 31
Segments



Type 35 and 36
Discs

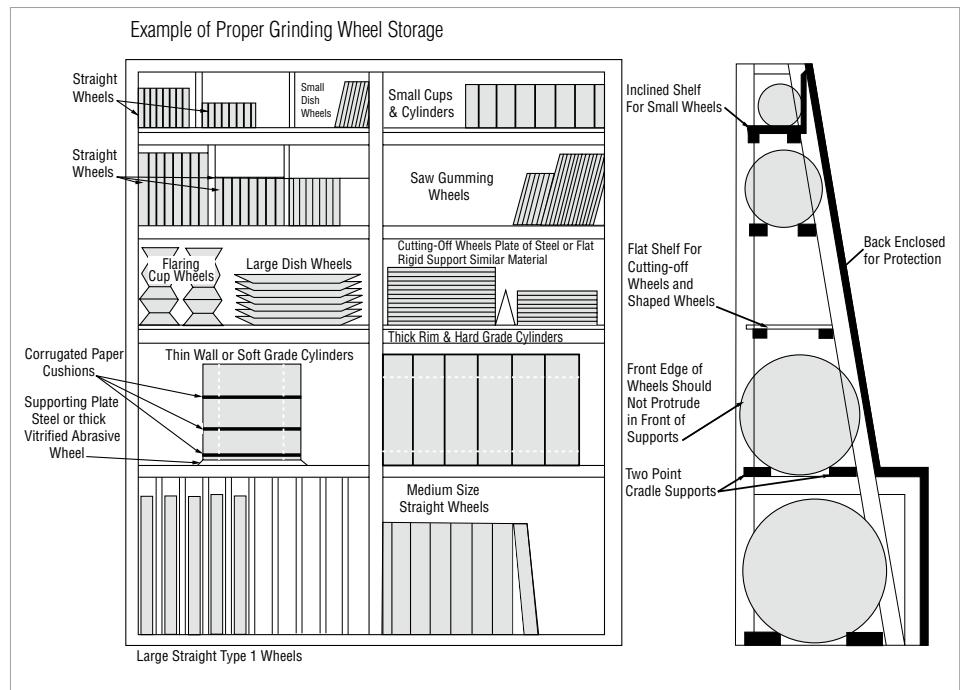
How to Read an Abrasive Product Specification

Conventional Grinding Wheels												
32A 46 I 8 V BE												
Abrasive		Grit Size			Grade			Structure		Bond Type		Norton Symbol
Aluminum Oxide	Ceramic	Silicon Carbide	Zirconia Alumina	Coarse	Medium	Fine	Soft	Medium	Hard	Relative grain spacing	Resin = B	Designates a variation or modification to bond.
23A	Oxide	37C	4NZ	12	30	80	D	I	Q	Dense	Shellac = E	
25A	3SGP	39C	4ZF	14	36	90	E	J	R		Plastic = P	
32A	3SGR	Crystolon	5ZF	16	46	100	F	K	S		Rubber = R	
32AC (blend)	5SG	Masonry	AZ (blend)	20	54	120	G	L	T		Vitrified = V	
38A	BRG	BlueFire		24	60	150	H	M	u			
48A	SG	Charger (blend)			70	220		N	V			
53A	SXG							O	Y			
55A	NorZon Plus (blend)	NZ						P	Z			
57A	NQ (Quantum)	NZC (blend)										
U57A	NQN (Quantum Prime)	NZIII										
64A		NZIV										
86A	Targa	NorZon										
90A		ZI										
Alundum												
FabCut												
India												
Gemini												
Metal												
Vortex												

Shelf Life and Proper Storage of Grinding Wheels

It has always been Saint-Gobain Abrasives recommendation that resinoid bonded grinding wheels be used within 2 years from the date of manufacture. This recommendation assumes that resinoid bonded grinding wheels have been stored under ideal storage conditions. It might be true that under ideal storage conditions resinoid bonded grinding wheels can survive without any degradation in strength for well over two years. However, it is always wise to suspect any wheels over two years old and have them reinspected or re-speed tested to determine if there has been any degradation in strength. If the wheels are stored under less than ideal conditions, they might have a much shorter shelf life depending upon the severity of storage conditions. These same comments also apply to rubber and shellac bonded grinding wheels.

As for vitrified grinding wheels, the shelf life is less influenced by humidity and adverse storage conditions as compared to resinoid, rubber or shellac, but even vitrified grinding wheels do not have an infinite shelf life. The best procedure and the best rule of thumb is to have any wheel that is two years old or older re-speed tested and reinspected to ensure it is fit for use. The procedure for having this done and the charges will be explained by our Customer Service Department, but the cost of shipping as well as the cost of re-inspection is the customer's responsibility. Also, any wheels rejected or otherwise lost in the re-inspection process will also be the responsibility of the customer.



Keep in mind, however, that this procedure is good to verify the reliability of a product but must not be performed until you are ready to consume the wheel. If wheels are sent back after the two year time frame for re-inspection and re-testing and then put back on the shelf, there is no telling how long they will be fit for use after that last inspection. Therefore, these wheels must be consumed as soon as is practical.



The Norton bench and pedestal wheel line consists of numerous wheel diameters and arbor sizes, abrasive types and grit sizes. Our offering answers all metal removal, deburring, shaping and sharpening needs: white aluminum oxide for high-speed tool steels, brown aluminum oxide for carbon steel, and silicon carbide for non-ferrous metals and carbide tooling.

- Applications:** Offhand deburring and sharpening of parts and tools
- Size Range:** 5" – 18"
- Grit Range:** 24 – 150
- Abrasive Types:** Premium Ceramic Alumina, Aluminum Oxide, Silicon Carbide
- Bushings:** Telescopic arbor bushings to fit all popular grinders are packaged with the wheel
- Machine Used:**

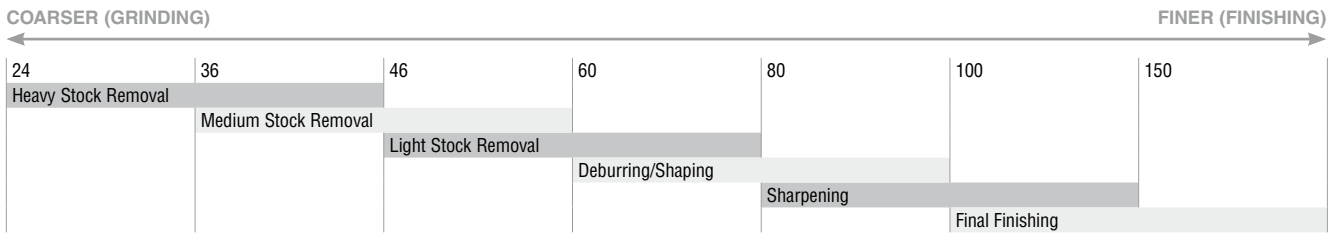


BENCH GRINDER



PEDESTAL GRINDER

Application/Grit Recommendation Guide



TECH TIP

- Unsecured machines can move, causing grinding breakage and injury. Fixed-based bench and pedestal grinders **MUST** be secured.
- Do not grind wood, plastic, or any other non-metallic material on a bench or pedestal grinder.
- All bench and pedestal wheels must be dressed to prevent loading. Loading can cause excessive heat, damage to the workpiece, and wheel breakage. Dressing exposes new cutting edges and provides chip clearance.
- Recommended starting dressing stick: 1" x 1" x 6" 37C24-SVK Part # 614636**10462**



It is the user's responsibility to refer to and comply with ANSI B7.1

Bench and Pedestal Wheel Arbor Bushings

WHEEL DIAMETER	WHEEL CENTER HOLE	1/2"	5/8"	3/4"	7/8"	1"	1-1/4"
5", 6", 7"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•

These size bushings shipped free of charge with your wheel order.



Best choice for deburring and tool sharpening on bench and pedestal grinders

PREMIUM CERAMIC ALUMINA 3SG

- Type 01 straight wheel with ceramic alumina grain has fast cut, minimal burn, and long wheel life
- High performance bond for versatility and exceptional form holding
- Especially great for hollow grinding of plane blades and chisels; telescoping bushings to fit popular arbor hole sizes



Better choice for light metal removal and sharpening of high-speed tool steels (55 Rc and higher)

PREMIUM WHITE ALUMINUM OXIDE

- Type 01 straight wheel with premium white aluminum oxide for maximum cut rate and cool grinding action on hardened or high-speed tool steels
- Vitrified bonded for superb shape holding and resistance to wear
- Better choice for deburring and tool sharpening on bench and pedestal grinders; telescoping bushings to fit popular arbor hole sizes



Better choice for light to medium stock removal

57A ALUMINUM OXIDE

- Type 01 straight wheel, the better choice for the end-user that needs a specific grit size and hardness for engineered applications
- Vitrified bond for superb shape holding and resistance to wear
- Excellent choice for deburring and tool sharpening on bench and pedestal grinders



Better choice for medium grit and grade for light to medium stock removal on carbide tooling and non-ferrous materials

39C SILICON CARBIDE

- Type 01 straight wheel with sharp, green silicon carbide; use for performance applications on carbide tooling and non-ferrous materials
- Vitrified bond for superb shape holding and resistance to wear
- Excellent choice for deburring and tool sharpening on bench and pedestal grinders



Good choice for all general-purpose bench and pedestal applications

GEMINI ALUMINUM OXIDE

- Type 01 straight wheel with quality, aluminum oxide for general purpose bench and pedestal grinder applications on steel
- Vitrified bond for superb shape holding and resistance to wear
- Good choice for deburring and tool sharpening on bench and pedestal grinders; telescoping bushings to fit popular arbor hole sizes



Good choice for all general-purpose bench and pedestal applications on non-ferrous materials and carbide tooling

GEMINI SILICON CARBIDE

- Type 01 straight wheel with sharp, green silicon carbide for general-purpose applications on carbide tooling and non-ferrous materials
- Vitrified bond for superb shape holding and resistance to wear
- Available in many sizes and coarse to fine grits; for sharpening to fine shaping applications



TIER:	BEST	BETTER	BETTER
TRADENAME:	PREMIUM CERAMIC ALUMINA	PREMIUM ALUMINUM OXIDE	57A
ABRASIVE:	3SG Ceramic Alumina	White Aluminum Oxide	Brown Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC	PART #	SPEC	PART #	SPEC	PART #
6 x 3/4 x 1	4,140*	1/5	3SG-46K	076607 05411	Medium 60	076607 88246		
	4,140*	1/5	3SG-60I	076607 04684	Fine 100	076607 88247		
	4,140*	1/5	3SG-80K	076607 05412	Very Fine 150	076607 88248		
	4,140*	1/5	3SG-100I	076607 04682				
6 x 1 x 1	4,140*	1/5	3SG-46K	076607 05413	Medium 60	076607 88261		
	4,140*	1/5	3SG-80K	076607 05414	Fine 100	076607 88262		
	4,140	1/5			Very Fine 150	076607 88263		
8 x 1 x 1	3,600	1/5			Medium 60	076607 88281		
	3,600	1/5	3SG-46K	076607 05421	Fine 100	076607 88282		
	3,600	1/5	3SG-60I	076607 04659	Very Fine 150	076607 88283		
	3,600	1/5	3SG-80K	076607 05422				
	3,600	1/5	3SG-100I	076607 04657				
10 x 1 x 1-1/4	2,485	1/5					57A46-MVBE	662531 16274
	2,485	1/5					57A60-MVBE	662531 16273
12 x 1 x 1-1/4	2,070	1/5					57A46-MVBE	662532 20947
12 x 2 x 1-1/2	2,070	1/4					57A36-OVBE	662532 20952
	2,070	1/4					57A46-MVBE	662532 20953
14 x 2 x 1-1/2	1,800	1/3					57A24-QVBE	662533 19972
	1,800	1/3					57A36-OVBE	662533 19973
	1,800	1/3					57A46-MVBE	662533 19974
14 x 2-1/2 x 1-1/2	1,800	1/2					57A24-QVBE	662533 19976
	1,800	1/2					57A46-MVBE	662533 19975
14 x 3 x 1-1/2	1,800	1/2					57A36-OVBE	662533 19977
18 x 3 x 1-1/2	1,275	1/2					57A24-QVBE	662534 62610

* Max. RPM for Premium Ceramic Alumina Wheels is 5,410

Bench and Pedestal Wheel Arbor Bushings

WHEEL DIAMETER	WHEEL CENTER HOLE	1/2"	5/8"	3/4"	7/8"	1"	1-1/4"
5", 6", 7"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•

These size bushings shipped free of charge with your wheel order.



TIER: **GOOD**
TRADENAME: **GEMINI ALUMINUM OXIDE**
ABRASIVE: Brown Aluminum Oxide



TIER: **GOOD**
TRADENAME: **39C (GREEN) / 37C (GRAY)**
ABRASIVE: Silicon Carbide



TIER: **GOOD**
TRADENAME: **GEMINI SILICON CARBIDE**
ABRASIVE: Green Silicon Carbide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC	PART #	MIN./STD. PKG.	SPEC	PART #	MIN./STD. PKG.	SPEC	PART #
5 x 1/2 x 1	4,965	1/5	Medium 60/80	076607 88202						
	4,965	1/5	Fine 100/120	076607 88201						
5 x 3/4 x 1	4,965	1/5	Medium 60/80	076607 88210						
	4,965	1/5	Fine 100/120	076607 88205						
5 x 1 x 1	4,965	1/5	Medium 60/80	076607 88225						
	4,140	1/5	Coarse 36/46	662528 36132			1/5	Medium 60	662528 36571	
	4,140	1/5	Medium 60/80	662528 36131			1/5	Fine 80	662528 36572	
6 x 1/2 x 1	4,140	1/5	Fine 100/120	662528 36133			1/5	Extra Fine 120	662528 36573	
	4,140	1/5	Coarse 36/46	076607 88245			1/5	Medium 60	662528 37190	
	4,140	1/5	Medium 60/80	076607 88240			1/5	Fine 80	662528 37191	
6 x 3/4 x 1	4,140	1/5	Fine 100/120	076607 88235			1/5	Extra Fine 120	662528 37192	
	4,140	1/5	Coarse 36/46	076607 88260			1/5	Medium 60	662528 37187	
	4,140	1/5	Medium 60/80	076607 88255			1/5	Fine 80	662528 37193	
6 x 1 x 1	4,140	1/5	Fine 100/120	076607 88250			1/5	Extra Fine 120	662528 37194	
	3,600	1/5	Coarse 36/46	076607 88275			1/5	Medium 60	662529 42300	
	3,600	1/5	Medium 60/80	076607 88270			1/5	Fine 80	662529 42301	
8 x 3/4 x 1	3,600	1/5	Fine 100/120	076607 88265			1/5	Extra Fine 120	662529 42302	
	3,600	1/5	Coarse 36/46	076607 88278						
	3,600	1/5	Medium 60/80	076607 88277						
8 x 1 x 1	3,600	1/5	Fine 100/120	662530 42317						
	3,600	1/5	Very Coarse 24	662530 44454			1/5	Medium 60	662530 44087	
	3,600	1/5	Coarse 36/46	076607 88286			1/5	Fine 80	662530 44534	
10 x 1 x 1-1/4	3,600	1/5	Medium 60/80	076607 88285			1/5	Extra Fine 120	662530 44535	
	3,600	1/5	Fine 100/120	076607 88280						
	2,485	1/2	Very Coarse 24	662531 60788			1/2	Medium 60	662531 44536	
10 x 1-1/4 x 1-1/4	2,485	1/2	Coarse 36/46	076607 88295			1/2	Fine 80	662531 60366	
	2,485	1/2	Medium 60/80	076607 88290						
	2,485	1/2	Fine 100/120	662531 60350						
10 x 1-1/2 x 1-1/4	2,485	1/2	Coarse 36/46	662531 61250						
	2,485	1/2	Medium 60/80	662531 61251						
12 x 1-1/2 x 1-1/2	2,485	1/2	Coarse 36/46	662531 61393	1/5	39C60-IVMT	662531 16265			
	2,485	1/2	Medium 60/80	662531 61395						
12 x 2 x 1-1/4	2,070	1/2	Coarse 36/46	662532 63052						
	2,070	1/2	Medium 60/80	662532 63053						
12 x 2 x 1-1/2	2,070	1/2	Very Coarse 24	662532 63054				1/2	Medium 60	662532 63359
	2,070	1/2	Coarse 36/46	662532 63055				1/2	Fine 80	662532 63360
	2,070	1/2	Medium 60/80	662532 63056	1/4	39C60-KVMT	662532 20942			
14 x 2 x 1-1/2	1,800				1/3	37C24-RVK	662533 19967			
	1,800				1/3	39C60-JVMT	662533 19968			

Bench and Pedestal Wheel Arbor Bushings

WHEEL DIAMETER	WHEEL CENTER HOLE	1/2"	5/8"	3/4"	7/8"	1"	1-1/4"
5", 6", 7"	1"	•	•	•	•		
8"	1"		•	•	•		
10"	1-1/4"			•	•	•	
12" x 2"	1-1/4"					•	
12" and 14"	1-1/2"					•	•

These size bushings shipped free of charge with your wheel order.



Keep circular saws, band saws and other cutting tools razor sharp when you use the NorZon NZ ZA Type 01 sawgumming wheel. Featuring a resin bond to provide a smooth performance and deliver exceptional strength, this hardy wheel is specially designed for use in timber industries and for woodworking and saw manufacturing applications. Ideal for frequent use, the wheel has a zirconia alumina abrasive that ensures sharp cuts while it enhances the wheel's durability.

Applications: Tool Sharpening
Size Range: 12"
Abrasive Grain: Zirconia Alumina
Shape: Type 01 Straight
Machine Used:



GUMMING
SAW

Best choice for saw sharpening in the timber, woodworking, and saw manufacturing industries



NORZON NZ ZIRCONIA ALUMINA

- Durable, sharp zirconia alumina abrasive delivering the highest performance under frequent use conditions
- Strong, yet smooth-running resin bond
- Designed to excel at shaping and resharpening various types of saws including large circular and band saw blades used primarily for timber harvesting

TIER: **BEST**
 TRADENAME: **NORZON NZ**
 ABRASIVE: Zirconia Alumina

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC	PART #
Type 01 Straight				
12 x 5/8 x 1-1/4	3,025	5	SG2981	662532 62303
12 x 3/4 x 1-1/4	3,025	5	SG2181	662532 62305
12 x 3/4 x 1-1/4	3,025	5	SG2981	662532 62306 NS
12 x 3/4 x 1-1/4	3,025	5	SG2981	662532 62307
12 x 7/8 x 1-1/4	3,025	5	SG2981	662532 62462
12 x 7/8 x 1-1/4	3,025	5	SG2181	662532 62461 NS
12 x 1 x 1-1/4	3,025	5	SG2981	662532 62487 NS

NS Non-stock, Contact your Norton representative for current order quantities and lead-times.



Used on surface, cylindrical, and tool and cutter grinders, Norton precision, form-holding vitrified toolroom wheels maximize your productivity. Available in latest-generation ceramic alumina, aluminum oxide, and silicon carbide – for every ferrous and non-ferrous MRO, small job shop, and production operation.

- Applications:** Surface grinding, tool and cutter grinding, and sharpening
- Shapes:** Type 01 Straight, Type 02 Cylinder, Type 05 and 07 Recessed 1 and 2 Sides, Type 06 and 11 Straight and Flaring Cups, Type 12 Dish, Type 20 Concaved 1 Side, and Type 35 Plate Mounted Disc
- Size Range:** 3/4" – 18" diameter
- Grit Range:** 46 – 220
- Abrasive Grain:** Ceramic Alumina, Aluminum Oxide, Silicon Carbide

Material-to-Product Recommendation Guide

APPLICATION / MATERIAL	PERFORMANCE/PRODUCTIVITY								
	Narrow Contact Area			Medium Contact Area			Wide Contact Area		
	BEST	BETTER	GOOD	BEST	BETTER	GOOD	BEST	BETTER	GOOD
Tool Resharpener									
Heavy Stock Removal (> .004)									
HSS & Tool Steel RC 50-68	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-GVSP	32A46-GVBEP	38A46-GVBEP
							3SGR46-GVP2	48A46-GVP2	38A46-GVP2
Moderate Stock Removal (.002-.004)									
HSS & Tool Steel RC 50-68	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	5SG60-GVSP	32A60-GVBEP	38A60-GVBEP
							3SGR60-GVP2	48A60-GVP2	
Carbide			39C60-JVMT				39C60-JVMT		
Surface Grinding									
Heavy Stock Removal (> .004)									
HSS & Tool Steel RC 50-68	5NQ46-JVS	32A46-JVBE	38A46-JVBE	5SG46-IVS	32A46-IVBE	38A46-IVBE	5SG46-GVSP	32A46-GVBEP	38A46-GVBEP
400 Series Stainless							3SGR46-GVP2	48A46-GVP2	38A46-GVP2
Soft Steels RC 30-45	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-HVSP	32A46-HVBEP	38A46-HVBEP
300 Series Stainless							3SGR46-HVP2	48A46-HVP2	38A46-HVP2
Cast Iron: Ductile & Gray	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-HVSP	32A46-HVBEP	38A46-HVBEP
							3SGR46-GVP2	48A46-HVP2	38A46-HVP2
Non-ferrous Alloys			39C46-JVMT				39C46-IVMT		
Moderate Stock Removal (.002-.004)									
HSS & Tool Steel RC 50-68	5NQ60-JVS	32A60-JVBE	38A60-JVBE	5SG60-IVS	32A60-IVBE	38A60-IVBE	5SG60-GVSP	32A60-GVBEP	38A60-GVBEP
400 Series Stainless							3SGR60-GVP2	48A60-GVP2	
Soft Steels RC 30-45	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	3SGR60-HVP2	32A60-HVBEP	38A60-HVBEP
300 Series Stainless								48A60-HVP2	38A60-HVP2
Cast Iron: Ductile & Gray	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	3SGR60-HVP2	32A60-HVBEP	38A60-HVBEP
								48A60-HVP2	38A60-HVP2
Non-ferrous Alloys			39C60-JVMT				39C60-IVMT		
Light Stock Removal and Finishing (<.001)									
HSS & Tool Steel RC 50-68		32A80-JVBE	38A80-JVBE		32A80-IVBE	38A80-IVBE		32A80-HVBE	38A80-HVBE
400 Series Stainless									
Soft Steels RC 30-45		32A80-KVBE	38A80-KVBE		32A80-JVBE	38A80-JVBE		32A80-IVBE	38A80-IVBE
300 Series Stainless									
Cast Iron: Ductile & Gray		32A80-KVBE	38A80-KVBE		32A80-JVBE	38A80-JVBE		32A80-IVBE	38A80-IVBE
Nonferrous Alloys			39C80-JVMT						39C80-HVMT

Upgrade to Vitrium³ to improve your process and productivity in 3 ways

Vitrium³ bond (VS3) wheels for enhanced-performance are available with these abrasives: NQN, NQ, SG, 32A, and 48A

<p>1. COOL CUTTING</p> <p>VITRIUM³ BOND BOND-PART INTERACTION</p> <p>Improved holding power (using less bond-to-abrasive ratio) exposes a larger grain surface area, improving freer cut rate.</p>	<p>2. PRECISE PROFILE</p> <p>VITRIUM³ WHEEL AFTER 5 GRINDING CYCLES</p> <p>Superior grain-holding properties significantly improve wheel form and corner holding vs. other bond systems – reducing dressing time and dresser wear.</p>	<p>3. HIGH SPEED</p> <p>High Speed – Norton Vitrium³ bond provides the ultimate wheel strength. This allows for high speed operation on equipment designed and rated for high speed.</p>
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Vitrified Wheel Bonds

Bond	Description
VS3	Quantum (white) and Norton SG (white): Patented technology produces a strong, exceptionally cool-cutting bond with unprecedented form holding; able to run at higher operating speed; increased throughput and productivity; versatile, for all areas of contact
VS3P	Quantum (white) Norton SG (white): Porous bond; use where heat is an issue; patented technology produces a strong, exceptionally cool-cutting bond with unprecedented form holding; versatile, for all areas of contact
VS	Quantum (white) and Norton SG (blue): High stock removal; narrow/medium contact area; roughing/finishing; cool cutting
VSP	Quantum (white) and Norton SG (blue): Porous bond; use where heat is an issue; high stock removal; medium/wide contact area; cool cutting; high chip clearance
VBE	32A (purple), 38A (white) and 57A (brown): General purpose; narrow/medium contact area; versatile; economical.
VBEP	32A (purple) and 38A (white): Porous bond; use where heat is an issue; medium/wide contact area; cool cutting; high chip clearance; high stock removal
V	38A (orange): For fine grit, form/corner holding applications; narrow contact area
VK	37C (black) and 39C (green): Designed specifically for silicon carbide abrasives; medium to narrow area of contact ; for non-steel applications
VMT	Bond specifically formulated for use with silicon carbide abrasives
VCP	32A (purple) and 23A (blue/grey): Induced-pore, wide contact area, surface/creepfeed grinding applications
VP2	3SGR (ruby), 48A (ruby), 25A (pink) and 38A (white): Unique, controlled-porosity (NORPOR) bond for heat-sensitive applications

TECH TIP

SELECTING A WHEEL WITH THE CORRECT BOND TYPE

- Use VBE, V, VS, VS3, VK, and VMT bonds for general purpose applications or medium contact areas.
- Use VBEP, VSP, VS3P, VCP, and VP2 bonds on wide contact areas where heat is an issue.



It is the user's responsibility to refer to and comply with ANSI B7.1

Application/Grit Recommendation Guide

Grit	Requirement	Finish	Minimum Corner Radius
46	General Purpose	32 Ra and rougher	0.020"
60	Commercial Finish	32 Ra and better	0.016"
80 – 100	Fine Finish	20 Ra and better	0.0105"
120	Very Fine Finish	10 Ra and better	0.006"
150	Corner-Form Holding		0.005"
180	Corner-Form Holding		0.0035"
220	Corner-Form Holding		0.0026"

Cross Reference Guide

NORTON	CAMEL	CINCINNATI	RADIAC	TYROLIT	WINTERTHUR
Quantum 5NQ	—	5M5B	—	—	—
3SGR	AS3	3BP	7BP, 8BP	—	—
5SG	SZA	5MSB	7BW, 8BW	—	—
25A	PA	12A	RAA	88A	57A
32A	AZ	4A, 12A, 29A, 32A	32A, WRA	90A	67A, 68A
38A	83A, WA, AZ (Blue)	9A, 10A, 11A, 82A	WA, 9A	88A, 89A	53A, 49A, 42A
48A	—	—	RA	91A	68A
53A	91A, DA	29A, 97A	43A, 45A, 97A, WPA	50A	61A, 64A
57A	94A, CGW, A	A, AK	A	A, 52A	A
37C	—	6C	C	1C	C
39C	—	5C	GC	C	11C



Take Advantage of VMT Technology!

VMT bond technology, along with advanced silicon carbide grain, offers wheels which excel in grinding a wide range of non-ferrous and hard-to-grind materials

Features & Benefits

- Improved form holding
- Higher wheel life
- Reduced power draw
- Shorter grind cycles
- Increased productivity

Starting Recommendations for Truing and Dressing Norton Toolroom Wheels

TRUING & DRESSING: DRESSING STICK STARTING RECOMMENDATIONS

Size/ Spec.	High Performance Stick Part #	Size/ Spec.	Conventional Stick Part #
3 x 1/2 x 1/4" Norbide	614636 10148	6 x 1 x 1" 37C24-SVK	614636 10462
		8 x 1 x 1" 37C24-SVK	614636 10471
Other sizes are available. See the Dressing Stick section.			

DRESSING: SINGLE POINT DRESSING TOOL STARTING RECOMMENDATIONS

		Ceramic (NQ, Norton SG, TG, Etc.), 37C & 39C Wheels		25A, 32A, 38A, 48A, 53A, 57A, 64A, 86A Wheels	
Wheel Sizes	Tool Shank Diameter	Product No.	Part #	Product No.	Part #
Up to 7"	3/8	BCSG2M6	662601 57007	BC2M6	662601 95000
	7/16	BCSG2M7	662601 56905	BC2M7	662601 95001
8" to 10"	3/8	BCSG3M6	662601 57008	BC3M6	662601 95002
	7/16	BCSG3M7	662601 56906	BC3M7	662601 95003
12" to 14"	3/8	BCSG5M6	662601 57009	BC5M6	662601 95004
	7/16	BCSG5M7	662601 56907	BC5M7	662601 95005

These tools are a standard recommendation; see the "Diamond Tool" section for additional tools
See the Fliesen Tool section for Furioso tools, engineered specifically for Quantum vitrified wheel dressing

TECH TIP

Wheel Dressing

Single Point Diamond Tools

- Rigidly mount Single Point tools at a 10°-15° angle to the wheel centerline with a line drawn through the center of the wheel, pointing in the direction of wheel travel
- Point of contact should be slightly below centerline of wheel
- Use coolant whenever possible
- Normal infeed is .001" per pass
- Lead selections range from .002" - .010" per wheel revolution
- Rotate the tool 1/4 turn periodically to maintain a sharp point
- Use VBE, V, VS, VK bonds for general purpose applications or medium contact areas.
- Use VBEP, VSP, VS3P, VCP, VP2 bonds on wide contact areas where heat is an issue.

Multi-Point Diamond Tools

- Most multi-point tools are used for straight face dressing
- Tool should have full face contact with the wheel
- With new tool, 3 to 5 passes at .005" per pass should be taken to expose diamonds
- Infeed per pass .001" - .002"
- Use coolant whenever possible
- Use appropriate lead (and traverse rate)

Contact your Norton representative for proper tool selection for Targa (TG) wheels



It is the user's responsibility to refer to and comply with ANSI B7.1

Dressing Ceramic Wheels

- Use our specially designed Norton SG diamond tools when dressing ceramic wheels
- When first using a Norton SG tool, make 3 to 5 passes at .005" infeed to ensure full face contact between the dressing tool and wheel face
- Reduce normal dressing infeed by half. Do not exceed infeed of .002" per pass.
- The lead selection should be between .006" - .030" per wheel revolution. Faster traverse with Norton SG tools generally provides an open wheel face that can maximize productivity of the ceramic abrasive.
- To optimize applications using ceramic abrasives and/or tools, normal dressing parameters must change. Reduce infeed by 25%. Significant reductions in the amount of infeed and frequency of dress will result in substantially lower cost per part ground.
- See the Fliesen Tool section for Furioso tools, engineered specifically for Quantum vitrified wheel dressing.

Troubleshooting Guide

Check the obvious first. Before changing the grinding wheel specification, investigate the following most common causes for most grinding problems:

1. Diamond dressing tool condition (check if worn or dull, rotate tool or replace if necessary)
2. Coolant direction, volume and filtration
3. Wheel dressing procedures (dress more open to free up cut rate, dress more closed to improve finish)

PROBLEM	POSSIBLE CAUSE	CORRECTION
Workpiece burn	Poor coolant direction	Redirect coolant into grinding zone
	Restricted or low coolant volume	Increase coolant volume
	Wheel too hard	Use one grade softer wheel
	Wheel structure too closed	Use porous bond wheel
	Wheel dressed too fine	Dress wheel coarser, more "open"
	Worn dressing tool	Inspect, rotate or replace dressing tool
	Work speed too slow	Increase work speed
	Infeed too fast	Reduce stock removed per pass or upgrade to 5SG or 5NQ
Wheel loading and glazing	Wheel too fine	Use coarser grit or softer grade wheel
	Wheel too hard	Use one grade softer wheel
	Too durable abrasive	Use a sharper, more friable abrasive
	Poor coolant quality	Change coolant or use high detergent type
	Wheel structure too closed	Use a porous bond wheel
	Wheel too finely dressed	Dress wheel very open
	Diamond dressing tool worn	Replace diamond and dress coarse (open)
Chatter	Depth of cut too small	Increase feed and traverse speed
	Unsupported work	Increase work support
	Machine vibration	Check for worn bearings
	Too heavy cut rate	Reduce cut rate
	Wheel too hard	Use one grade softer wheel
	Wheel structure too closed	Use a porous bond wheel
Chatter marks on workpiece	Wheel out of balance	Check wheel balance or try new wheel
	Worn spindle bearings	Check and correct for truth and end play
	Wheel out of truth	Redress wheel and check mounting
	Poorly clamped wheel	Check tightness of mounting nuts
Poor surface finish	Glazed face of wheel	Redress wheel with sharp dressing tool
	Incorrect wheel dress	Dress wheel finer (slow down dressing tool traverse)
	Worn dressing tool	Inspect, rotate, or replace dressing tool
	Too coarse grit size	Use a finer grit size
	Wheel too hard	Use softer grade
Not holding form	Wheel too soft	Use one grade harder wheel
	Wheel structure too open	Use a more closed wheel structure
Not holding corner	Incorrect wheel dress	Dress wheel finer. Face and side true wheel.
	Too large grit size	Use smaller grit size (maximum grit diameter less than 1.5 times corner radius)
	Wheel too soft	Use harder grade wheel
	Wheel structure too open	Use more closed structure wheel



Best choice for versatility, maximum performance and cost savings

QUANTUM (5NQ) CERAMIC ALUMINA

- Revolutionary, proprietary, engineered ceramic grain shape and chemistry for all low-, medium- and high-force applications ranging from cast iron, to stainless steel, and hard-to-grind Inconel and titanium
- Proven tough vitrified bond stands up to extreme grinding forces; perform well on old and new CNC cutting tool, cylindrical and surface grinding machines
- 33% to 100% longer life, 30% higher MRR (material removal rate), and 15% lower threshold power versus competitive ceramic products



Best choice for high productivity, low total per-part grinding cost

SG CERAMIC ALUMINA

- Exceptionally high-performance ceramic alumina and friable aluminum oxide abrasive blend for fast stock removal, cool, superior cutting; 3 - 5 times more life than aluminum oxide wheels; double rough stock removal rate versus conventional abrasives
- High performance bond for versatility (for grinding high speed tool steels, hardened and soft steels, and aerospace alloys) and exceptional form holding
- Self-sharpening abrasive minimizes burn and dressing to maximize sharp edge on tools and dies for longer life in production



Better choice for medium-to-heavy stock removal

32A ALUMINUM OXIDE

- Strong, sharp monocrystalline aluminum oxide grain, ideal for precision production medium-to-heavy stock removal applications
- The most versatile vitrified bond, especially recommended for CNC cutting tool machines, and cylindrical and surface grinding
- Grinds with an exceptional cool, fast cutting action, requires minimum dressing



Good choice for light grinding of tool steel

38A ALUMINUM OXIDE

- Friable aluminum oxide abrasive for cool and burn-free cutting toolroom applications with light-to-moderate feed rates
- The most versatile vitrified bond, especially recommended for CNC cutting tool machines, and cylindrical and surface grinding applications on hard and very heat-sensitive high-speed tool steels; cool fast cutting
- Consistent quality for excellent balance and dimensional accuracy time after time



Good choice for use on general-purpose applications; economical


GEMINI ALUMINUM OXIDE

- Specially blended aluminum oxide abrasive for many surface and cylindrical grinding applications
- Durable vitrified bond for high stock removal on narrow to medium contact areas
- Good general-purpose choice when a broad range of parts are ground on one machine

Vitrified Wheels For Steel Applications



TIER: BEST	TIER: BETTER	TIER: GOOD
TRADENAME: QUANTUM / NORTON SG	TRADENAME: 32A	TRADENAME: 38A
ABRASIVE: Ceramic Alumina	ABRASIVE: Aluminum Oxide	ABRASIVE: Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type O1 Straight									
2 x 1/2 x 3/8	16,235	10/50			32A60-KVBE	662434 28214			
3 x 1/4 x 1/2	10,825	10/50			32A60-KVBE	662435 28696			
3 x 1/2 x 3/8	10,825	10/50			32A60-KVBE	662435 28825	10/50	38A60-JVBE	662435 29032
3 x 1/2 x 1/2	10,825	10/50			32A60-KVBE	662435 28828			
3 x 1 x 1/2	10,825						10/10	38A60-MVBE	662435 29145
	10,825						10/10	38A80-MVBE	662435 29146
4 x 1/4 x 1/2	8,120	1/10			32A60-KVBE	662435 29532	1/10	38A60-KVBE	662435 29777
	8,120						1/10	38A100-IVBE	662435 29782
4 x 1/4 x 3/4	8,120	1/10			32A60-KVBE	662435 29736			
4 x 1/2 x 1/2	8,120						1/10	38A60-KVBE	662435 29947
	8,120						1/10	38A100-KVBE	662435 29954
4 x 1/2 x 3/4	8,120	1/10			32A60-KVBE	662435 29849	1/10	38A60-KVBE	662435 29961
	8,120	1/10			32A80-KVBE	662435 29850			
4 x 1 x 1/2	8,120						1/10	38A60-MVBE	662435 30126
6 x 1/8 x 1-1/4	4,140	1/10			32A80-KVBE	662528 35361	1/10	38A150-LVBE	662528 35506
6 x 1/4 x 1/2	4,140	1/10			32A60-KVBE	662528 35784			
6 x 1/4 x 1-1/4	4,140	1/10			32A60-KVBE	662528 35786	1/10	38A60-KVBE	662528 35803
	4,140						1/10	38A80-KVBE	662528 35807
	4,140						1/10	38A150-KV	662528 35759
6 x 1/2 x 1/2	4,140	1/10			32A60-KVBE	662528 36394	1/10	38A60-KVBE	662528 36530
	4,140						1/10	38A80-KVBE	662528 36548
6 x 1/2 x 1-1/4	4,140	1/10			32A46-KVBE	662528 36380	1/10	38A46-KVBE	662528 36520
	4,140	1/10	5SG60-KVS	662528 03344	32A60-KVBE	662528 36396 B	1/10	38A60-KVBE	662528 36533
	4,140	1/10			32A80-JVBE	662528 36405	1/10	38A80-KVBE	662528 36550
	4,140						1/10	38A120-KVBE	662528 36664
6 x 3/4 x 1/2	4,140	1/10			32A60-KVBE	662528 37420			
6 x 3/4 x 5/8	4,140						1/10	38A60-KVBE	662528 37444
6 x 3/4 x 1-1/4	4,140	1/10			32A60-KVBE	662528 37421	1/10	38A60-KVBE	662528 37445
6 x 1 x 1-1/4	4,140	1/10			32A60-KVBE	662528 37921 B			
7 x 1/8 x 1-1/4	3,275	1/10			32A60-IVBE	662529 39112	1/10	38A80-IVBE	662529 39219
	3,600						1/10	38A100-KVBE	662529 39223
7 x 1/4 x 1-1/4	3,600	1/10			32A46-HVBE	662529 39543	1/10	38A46-HVBE	662529 39690
	3,600	1/10	5NQ46-IVS3	662434 95257	32A46-IVBE	662529 39544	1/10	38A46-IVBE	662529 39691
	3,600	1/10	5NQ60-JVS3	662532 93579	32A46-JVBE	662529 39545	1/10	38A46-JVBE	662529 09755
	3,600	1/10			32A46-KVBE	662529 39862	1/10	38A60-HVBE	662529 39695
	3,600	1/10	5SG46-IVS	662529 40207 B	32A60-HVBE	662529 39547	1/10	38A60-IVBE	662529 39696
	3,600	1/10			32A60-IVBE	662529 39548 B	1/10	38A60-JVBE	662529 39698
	3,600	1/10	5SG60-IVS	662529 39459 B	32A60-IVBE	662532 88569 S	1/10	38A60-KVBE	662529 39700
	3,600	1/10			32A60-JVBE	662529 39549 B	1/10	38A80-HVBE	662529 39707
	3,600	1/10			32A60-KVBE	662529 39552 B	1/10	38A80-IVBE	662529 39808
	3,600	1/10	5SG60-JVS	662529 39460	32A60-KVBE	662532 88570 S	1/10	38A80-JVBE	662529 39809
	3,600	1/10	5SG60-KVS	662529 39461 B			1/10	38A80-KVBE	662529 39812
	3,600	1/10			32A80-HVBE	662529 39557	1/10	38A100-IVBE	662529 39823
	3,600	1/10	5SG80-IVS	662529 39462	32A80-IVBE	662529 39658 B			
	3,600	1/10	5SG80-JVS	662529 39463	32A80-IVBE	662532 88571 S	1/10	38A100-JVBE	662529 39826
	3,600	1/10	5SG80-KVS	662529 39464	32A80-JVBE	662529 39660 B	1/10	38A100-KVBE	662529 39827
	3,600	1/10	5SG100-JVS	662529 39467	32A80-KVBE	662529 39662 B	1/10	38A100-LVBE	662529 39830
	3,600	1/10	5SG100-KVS	662529 39468 B	32A80-KVBE	662532 88572 S	1/10	38A120-JVBE	662529 39833
	3,600	1/10					1/10	38A120-KVBE	662529 39834
	3,600	1/10			32A100-IVBE	662529 39670 B	1/10	38A150-KVBE	662529 39838
	3,600	1/10			32A100-JVBE	662529 39672	1/10	38A150-LVBE	662529 39839
	3,600	1/10			32A100-IVBE	662532 88573 S	1/10	38A150-MV	662529 39521
	3,600	1/10			32A100-KVBE	662529 39673 B	1/10	38A220-KV	662529 39528
	3,600	1/10					1/10	38A220-LV	662529 39529
	3,600	1/10			32A120-IVBE	662529 39680	1/10	38A220-LVBE	662529 39847
	3,600	1/10			32A120-KVBE	662529 39682	1/10	38A220-MV	662529 39530
	3,600	1/10			32A220-LVBE	662529 39689			
7 x 3/8 x 1-1/4	3,600	1/10			32A60-KVBE	662529 40276	1/10	38A60-KVBE	662529 40294
	3,600	1/10			32A80-KVBE	662529 40284	1/10	38A80-IVBE	662529 40297 NS

B Best Seller; performs well in a variety of applications for many satisfied customers
S Single Pack

Continued

Vitrified Wheels For Steel Applications *continued*



TIER: **BEST**
 TRADENAME: **QUANTUM / NORTON SG**
 ABRASIVE: Ceramic Alumina

TIER: **BETTER**
 TRADENAME: **32A / 48A**
 ABRASIVE: Aluminum Oxide

TIER: **GOOD**
 TRADENAME: **38A / 25A / GEMINI**
 ABRASIVE: Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #	
Type O1 Straight										
7 x 1/2 x 1-1/4	3,600	1/10	5NQ46-HVS3	662533 75053	32A46-FVBEP	662529 41203	1/10	25A46-HVP2	662529 16219	
	3,600	1/10	5NQ46-IVS3	69083 159103	32A46-GVBE	662529 40862	1/10	25A60-HVP2	662529 16221	
	3,600	1/10			32A46-GVBEP	662529 41204 B	1/10	38A46-GVBE	662529 41022	
	3,600	1/10	5NQ46-JVS3	69083 159104	32A46-HVBE	662529 40863 B	1/10	38A46-GVBEP	662529 41323	
	3,600	1/10	5NQ60-GVS3P	69083 159105	32A46-HVBE	662532 88775 S	1/10	38A46-HVBE	662529 41023	
	3,600	1/10	5NQ60-IVS3	662533 75047	32A46-HVBEP	662529 41205 B				
	3,600	1/10	5NQ60-JVS3	69083 159106			1/10	38A46-HVBEP	662529 41324	
	3,600	1/10			32A46-IVBE	662529 40864 B	1/10	38A46-HVP2	662529 16223	
	3,600	1/10	3SGP46-GVSP	662529 11717	32A46-IVBE	662532 88776 S	1/10	38A46-IVBE	662529 41024	
	3,600	1/10	3SGR46-HVP2	662529 16211	32A46-IVBEP	662529 41206	1/10	38A46-JVBE	662529 41026	
	3,600	1/10	3SGR60-HVP2	662529 16213			1	38A46-JVBE	662532 88767 S	
	3,600	1/10	5SG46-GVSP	662529 40522	32A46-JVBE	662529 40865 B	1/10	38A46-KVBE	662529 41028	
	3,600	1/10			32A46-JVBE	662532 88777 S	1/10	38A60-HVBE	662529 41035	
	3,600	1/10	5SG46-HVSP	662529 41130			1/10	38A60-HVBEP	662529 41330	
	3,600	1/10	5SG46-IVS	662529 40193 B	32A46-KVBE	662529 40867 B	1/10	38A60-IVBE	662529 41036	
	3,600	1/10	5SG46-IVS	662532 88788 S			1/10	38A60-JVBE	662529 41038	
	3,600	1/10			32A54-IVBE	662529 40873	1	38A60-JVBE	662532 88766 S	
	3,600	1/10	5SG46-IVSP	662529 40523	32A60-GVBEP	662529 41313	1/10	38A60-KVBE	662529 41041	
	3,600	1/10	5SG46-JVS	662529 40194 B	32A60-HVBE	662529 40879 B	1			
	3,600	1/10	5SG46-JVS	662532 88789 S	32A60-HVBEP	662529 41314	1/10	38A60-LVBE	662529 11677	
	3,600	1/10	5SG46-JVS3	662434 95263	32A60-IVBE	662529 40880 B	1/10	38A80-HVBE	662529 41047	
	3,600	1/10	5SG46-KVS	662529 40195	32A60-IVBE	662532 88779 S	1/10	38A80-IVBE	662529 41048	
	3,600	1/10	5SG60-GVSP	662529 40524			1/10	38A80-JVBE	662529 41049	
	3,600	1/10	5SG60-IVS	662529 40196 B	32A60-JVBE	662529 40882 B	1/10	38A80-KVBE	662529 41054	
	3,600	1/10			32A60-JVBEP	662529 41316	1			
	3,600	1/10					1/10	38A80-LVBE	662529 41056	
	3,600	1/10	5SG60-IVSP	662529 40525	32A60-KVBE	662529 40885 B	1/10	38A100-IVBE	662529 41163	
	3,600	1/10	5SG60-JVS	662529 40197 B	32A60-KVBE	662532 88782 S	1/10	38A100-JVBE	662529 41165	
	3,600	1/10			32A60-LVBE	662529 40888	1/10	38A100-KVBE	662529 41168	
	3,600	1/10			32A80-HVBE	662529 40894	1/10	38A120-JVBE	662529 41174	
	3,600	1/10	5SG60-KVS	662529 40198	32A80-IVBE	662529 40895 B	1/10	38A120-KVBE	662529 41175	
	3,600	1/10	5SG60-LVS	662529 40199	32A80-IVBE	662532 88783 S	1/10	38A150-JVBE	662529 41179	
	3,600	1/10	5SG80-IVS	662529 40200	32A80-JVBE	662529 40897 B	1/10	38A150-MV	662529 40595	
	3,600	1/10	5SG80-IVSP	662529 40527	32A80-KVBE	662529 40899 B	1/10	38A220-QV	662529 40605	
	3,600	1/10	5SG80-JVS	662529 40201 B	32A80-KVBE	662532 88784 S				
	3,600	1/10			32A80-LVBE	662529 40900	10/10	Gemini 46-I	662532 46800	
	3,600	1/10	5SG80-KVS	662529 40202	32A100-IVBE	662529 40907	10/10	Gemini 46-J	662532 46802	
	3,600	1/10	5SG80-LVS	662529 40203	32A100-JVBE	662529 41008				
	3,600	1/10	5SG100-JVS	662529 40204	32A120-LVBE	662529 41018 B				
	3,600	1/10	5SG100-KVS	662529 40205	32A120-LVBE	662532 88786 S				
	3,600	1/10			48A46-HVP2	662529 16215 B	10/10	Gemini 60-K	662532 46821	
	3,600	1/10			48A60-HVP2	662529 16217 B				
	3,600	1/10			32A60-IVBE	662529 41762				
	7 x 5/8 x 1-1/4	3,600	1/10	5SG46-IVS	662529 42304	32A46-GVBEP	662529 42070	1/10	38A46-HVBE	662529 41950
		3,600	1/10	5SG46-KVS	662529 42305	32A46-HVBE	662529 41930	1/10	38A46-KVBE	662529 41954
3,600		1/10	5SG60-JVS	662529 42307	32A46-IVBE	662529 41931	1/10	38A60-IVBE	662529 42207	
3,600		1/10	5SG60-KVS	662529 42308	32A46-KVBE	662529 41935	1/10	38A60-KVBE	662529 42060	
3,600		1/10			32A60-IVBE	662529 41938				
7 x 1 x 1-1/4	3,600	1/10			32A60-KVBE	662529 41943				
	3,600	1/10			32A80-IVBE	662529 41946				
	3,600	1/10	5SG60-JVS	662529 42429	32A46-HVBE	662529 42513	1/10	38A46-HVBE	662529 42534	
	3,600	1/10	5SG60-KVS	662529 42430	32A46-JVBE	662529 42268				
	3,600	1/10			32A60-IVBE	662529 42524				
3,600	1/10			32A60-KVBE	662529 42709					

B Best Seller; performs well in a variety of applications for many satisfied customers
S Single Pack

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.

Vitrified Wheels For Steel Applications *continued*



TIER: **BEST** **QUANTUM / NORTON SG** **BETTER** **32A / 48A**
 TRADENAME: **QUANTUM / NORTON SG** **32A / 48A**
 ABRASIVE: Ceramic Alumina Aluminum Oxide

GOOD **38A / 25A / GEMINI**
 Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type O1 Straight									
8 x 1/4 x 1-1/4	3,105 / 3,600*	1/10	5SG60-KVS	662530 43351 *	32A46-HVBE	662530 43412	1/10	38A60-IVBE	662530 43431 *
	3,105 / 3,600*	1/10	5SG80-KVS	662530 43353 *	32A46-IVBE	662530 43310	1/10	38A60-JVBE	662530 43432 *
	3,600	1/10			32A46-KVBE	662530 43413	1/10	38A60-KVBE	662530 10825
	3,600	1/10			32A60-IVBE	662530 43416 B	1/10	38A80-IVBE	662530 43437
	3,600	1/10			32A60-IVBE	662532 88796 S	1/10	38A80-JVBE	662530 43439
	3,600	1/10			32A60-JVBE	662530 43417	1/10	38A80-KVBE	662530 43461
	3,600	1/10			32A60-KVBE	662530 43399	1/10	38A100-IVBE	662530 43445
	3,600	1/10			32A80-IVBE	662530 43421	1/10	38A100-KVBE	662530 43447
	3,600	1/10			32A80-KVBE	662530 43458 B	1/10	38A120-KVBE	662530 43450
	3,600	1/10			32A80-KVBE	662532 88797 S	1/10	38A150-KVBE	662530 43451
	3,600	1/10			32A80-LVBE	662530 43425			
	3,600	1/10			32A100-IVBE	662530 43426			
	3,600	1/10			32A100-KVBE	662530 43428			
	3,600	1/10			32A60-KVBE	662530 43565			
8 x 3/8 x 1-1/4	3,600	1/10			32A60-KVBE	662530 43565			
8 x 1/2 x 1-1/4	3,105 / 3,600*	1/10	5NQ46-HVS3	662533 87211	32A46-GVBEP	662530 43882 B	1/10	25A46-HVP2	662530 19354 *
	3,105	1/10	5NQ46-IVS3	690831 59107	32A46-HVBE	662530 43712 B	1/10	38A46-HVBE	662530 43746
	3,105	1/10			32A46-HVBE	662532 88800 S			
	3,105 / 3,600*	1/10	5NQ46-JVS3	690831 59108 *	32A46-HVBEP	662530 43883 *† B	1/10	38A46-HVBEP	662530 43891 †
	3,105	1/10					1/10	38A46-IVBE	662530 43749
	3,105 / 3,600*	1/10	5NQ60-GVS3P	690831 59109			1/10	38A46-JVBE	662530 43752 *
	3,105 / 3,600*	1/10			32A46-IVBE	662530 43713 B	1/10	38A46-KVBE	662530 43762 *
	3,600	1/10	5NQ60-JVS3	690831 59110			1/10	38A60-HVBE	662530 43756
	3,600	1/10			32A46-JVBE	662530 43715 B	1/10	38A60-IVBE	662530 43757
	3,105 / 3,600*	1/10	3SGP46-HVSP	662530 11505	32A46-JVBE	662532 88801 * S	1/10	38A60-JVBE	662530 43858 *
	3,600	1/10	3SGP46-JVH	662530 13796			1/10	38A60-KVBE	662530 43861
	3,600	1/10	3SGR46-GVP2	662530 19345	32A46-KVBE	662530 43716 B	1/10	38A80-IVBE	662530 43866
	3,600	1/10	3SGR46-HVP2	662530 19346			1/10	38A80-JVBE	662530 13787
	3,600	1/10	3SGR60-HVP2	662530 19348	32A60-GVBEP	662530 43887 †	1/10	38A80-KVBE	662530 43869
	3,105 / 3,600*	1/10	5SG46-GVSP	662530 43649	32A60-HVBE	662530 43724 *	1/10	38A100-KVBE	662530 43877 *
	3,600	1/10			32A60-HVBEP	662530 43888	10/10	Gemini 46-H	662532 46841 *
	3,105 / 3,600*	1/10	5SG46-HVSP	662530 43915 *†	32A60-IVBE	662530 43725 * B	10/10	Gemini 46-I	662532 46843
	3,105 / 3,600*	1/10	5SG46-IVS	662530 44089 B	32A60-IVBE	662532 88802 * S	10/10	Gemini 46-J	662532 46845 *
	3,105 / 3,600*	1/10	5SG46-IVS	662532 88804 S	32A60-JVBE	662530 43727 * B			
	3,105 / 3,600*	1/10			32A60-KVBE	662530 43729 * B			
	3,105 / 3,600*	1/10	5SG46-IVSP	662530 43650	32A60-KVBE	662532 88803 * S			
	3,600	1/10	5SG46-JVS	662530 44090 B	32A80-HVBE	662530 43733			
	3,600	1/10	5SG46-JVS	662532 88806 S	32A80-IVBE	662530 43734			
	3,600	1/10	5SG46-KVS	662530 44091	32A80-JVBE	662530 43736			
	3,600	1/10	5SG60-GVSP	662530 43651 †	32A80-KVBE	662530 43737			
	3,600	1/10	5SG60-IVS	662530 44092	32A100-IVBE	662530 43740			
	3,600	1/10			32A100-KVBE	662530 43742			
	3,600	1/10	5SG60-IVSP	662530 43652	48A46-HVP2	662530 19350 B			
	3,600	1/10	5SG60-JVS	662530 44093 B					
	3,600	1/10	5SG60-KVS	662530 44094					
	3,600	1/10	5SG80-JVS	662530 44096					
	3,600	1/10	5SG80-KVS	662530 44097					
3,600	1/10	5SG100-KVS	662530 19435						

B Best Seller; performs well in a variety of applications for many satisfied customers
 S Single Pack
 * Indicates wheel max RPM has been tested to 3,600 as explained in the tech tip below

Continued

TECH TIP

* 8" Type O1 and Type O5 Vitrified Toolroom Wheels' Maximum Operating Speeds:

- Stock NorPor VP2 wheels = 3,600 RPMs
- All other 46 grit, J grade and harder = 3,600 RPMs
- All other 54 grit, I grade and harder = 3,600 RPMs
- All other 60 grit and finer, H grade and harder = 3,600 RPMs
- † Exceptions to the rule: speed-tested to 3,600 RPM
- All other specifications = 3,105 RPMs



It is the user's responsibility to refer to and comply with ANSI B7.1

Vitrified Wheels For Steel Applications *continued*



TIER: BEST	TIER: BETTER	TIER: GOOD
TRADENAME: QUANTUM / NORTON SG	TRADENAME: 32A / 48A	TRADENAME: 38A / 57A
ABRASIVE: Ceramic Alumina	ABRASIVE: Aluminum Oxide	ABRASIVE: Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type O1 Straight									
8 x 3/4 x 1-1/4	3,105	1/10	5NQ46-IVS3	690831 59111	32A46-GVBEP	662530 44195	1/10	38A46-HVBE	662530 44175
	3,105	1/10			32A46-HVBE	662530 44159	1/10	38A46-IVBE	662530 44177
	3,600	1/10	5NQ46-JVS3	690831 59112	32A46-HVBEP	662530 44196 †	1/10	38A46-KVBE	662530 44180
	3,105 / 3,600*	1/10			32A46-IVBE	662530 44215	1/10	38A60-IVBE	662530 44184 *
	3,105 / 3,600*	1/10			32A46-JVBE	662530 44161 *			
	3,105 / 3,600*	1/10	5NQ60-GVS3P	690831 59113	32A46-KVBE	662530 44165 *			
	3,600	1/10	5NQ60-JVS3	690831 59114	32A60-GVBEP	662530 44198			
	3,600	1/10			32A60-HVBE	662530 44168			
	3,105 / 3,600*	1/10	5SG46-IVS	662530 44098	32A60-IVBE	662530 44169 *			
	3,600	1/10	3SGP46-JVH	662530 13792	32A60-JVBE	662530 44171			
	3,600	1/10	5SG46-JVS	662530 44099 B	32A60-KVBE	662530 44173			
	3,600	1/10			32A80-KVBE	662530 44064			
	3,600	1/10	5SG60-IVS	662530 44101					
	3,600	1/10	5SG60-JVS	662530 44102					
3,600	1/10	5SG60-KVS	662530 44103						
8 x 1 x 1-1/4	3,105 / 3,600*	1/10	5SG46-KVS	662530 02588 *	32A46-HVBE	662530 44616	1/10	38A46-IVBE	662530 44636
	3,105 / 3,600*	1/10	5SG60-GVSP	662530 03228 †	32A46-IVBE	662530 44617	1/10	38A60-IVBE	662530 44456 *
	3,600	1/10	5SG60-IVS	662530 02639	32A46-KVBE	662530 44622	1/10	57A60-MVBE	662530 44270
	3,600	1/10			32A60-IVBE	662530 44624			
3,600	1/10			32A60-KVBE	662530 44629				
10 x 1/4 x 3	2,485					1	38A80-KVBE	662531 49572	
10 x 1/2 x 3	2,485	1			32A60-JVBE	662531 49729	1	38A60-KVBE	662531 49859
	2,485						1	38A80-KVBE	662531 49865
10 x 3/4 x 3	2,485	1			32A46-IVBE	662531 60024	1	38A46-JVBE	662531 60158
	2,485	1			32A60-IVBE	662531 60137	1	38A60-IVBE	662531 60163
	2,485	1			32A60-KVBE	662531 60143			
10 x 1 x 1-1/4	2,485	1			32A60-KVBE	662531 60774			
10 x 1 x 2	2,485	1			32A46-IVBE	662531 60749			
10 x 1 x 3	2,485	1	5SG46-GVSP	662531 60494	32A46-HVBE	662531 60747	1	38A46-IVBE	662531 60889
	2,485	1	5SG46-IVS	662531 60400	32A46-IVBE	662531 60750	1	38A46-JVBE	662531 60892
	2,485	1	5SG46-JVS	662531 60401	32A46-JVBE	662531 60754	1	38A60-IVBE	662531 60898
	2,485	1			32A46-KVBE	662531 60758	1	38A60-KVBE	662531 60900
	2,485	1	5SG46-KVS	662531 60402	32A60-IVBE	662531 60769			
	2,485	1			32A60-KVBE	662531 60777			
	2,485	1	5SG60-IVS	662531 60403	32A80-KVBE	662531 60782			
	2,485	1	5SG60-JVS	662531 60404					
	2,485	1	5SG60-KVS	662531 60405					
12 x 1/2 x 3	2,070	2			32A60-JVBE	662532 62134			
	2,070	2			32A80-KVBE	662532 62110			
	2,070	2			32A60-KVBE	662532 62107			
12 x 1/2 x 5	2,070	2			32A80-KVBE	662532 62111			
	2,070	2			32A60-KVBE	662532 62107			
12 x 3/4 x 3	2,070	1	5SG46-IVS	662532 62204	32A46-GVBEP	662532 62392	1	38A46-JVBE	662532 62281
	2,070	1			32A46-HVBE	662532 62260			
	2,070	1			32A46-IVBE	662532 62261			
	2,070	1			32A60-IVBE	662532 62270			
	2,070	1			32A60-KVBE	662532 62273			
12 x 1 x 1-1/4	2,070	1			32A46-KVBE	662532 62570			

B Best Seller; performs well in a variety of applications for many satisfied customers
S Single Wheel Pack
* Indicates wheel max RPM has been tested to 3,600 as explained in the tech tip below

TECH TIP

* 8" Type O1 and Type O5 Vitrified Toolroom Wheels' Maximum Operating Speeds:

- Stock NorPor VP2 wheels = 3,600 RPMs
- All other 46 grit, J grade and harder = 3,600 RPMs
- All other 54 grit, I grade and harder = 3,600 RPMs
- All other 60 grit and finer, H grade and harder = 3,600 RPMs
- † Exceptions to the rule: speed-tested to 3,600 RPM
- All other specifications = 3,105 RPMs



It is the user's responsibility to refer to and comply with ANSI B7.1

Vitrified Wheels For Steel Applications *continued*



TIER:	BEST	BETTER	GOOD
TRADENAME:	QUANTUM / NORTON SG	32A / 48A	38A
ABRASIVE:	Ceramic Alumina	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #	
Type 01 Straight										
12 x 1 x 3	2,070 / 2,710*	1	3SGR46-HVP2	662532 20885*	32A46-GVBEP	662532 62840	1	38A46-HVBE	662532 62700	
	2,070	1	5SG46-HVSP	662532 62488	32A46-HVBE	662532 62562	1	38A46-IVBE	662532 62702	
	2,070	1	5SG46-IVS	662532 62500	32A46-HVBEP	662532 62842	1	38A46-JVBE	662532 62704	
	2,070	1	5SG46-JVS	662532 62501	32A46-IVBE	662532 62564	1	38A60-IVBE	662532 62713	
	2,070	1	5SG46-JVS3	662434 495317	32A46-JVBE	662532 62567				
	2,070	1	5SG46-KVS	662532 62502	32A46-KVBE	662532 62572				
	2,070	1			32A60-HVBE	662532 62580				
	2,070	1	5SG60-GVSP	662532 62593	32A60-IVBE	662532 62581				
	2,070	1	5SG60-IVS	662532 62503	32A60-KVBE	662532 62689				
	2,070	1	5SG60-JVS	662532 62504	32A80-KVBE	662532 62532				
	2,070 / 2,710*	1	5SG60-KVS	662532 62505	48A60-HVP2	662532 20891*				
	12 x 1 x 5	2,070	1	5SG46-GVSP	662532 62594	32A46-GVBEP	662532 62841	1	38A46-IVBE	662532 62703
		2,070	1	5SG46-IVS	662532 62508	32A46-HVBE	662532 62563	1	38A60-KVBE	662532 62719
		2,070	1	5SG46-JVS	662532 62509 B	32A46-IVBE	662532 62565			
2,070		1	5SG46-KVS	662532 62510	32A46-KVBE	662532 62573				
2,070		1	5SG60-GVSP	662532 62595						
2,070		1	5SG60-IVS	662532 62511	32A60-IVBE	662532 62582				
2,070		1	5SG60-JVS	662532 62512	32A60-JVBE	662532 62686				
2,070		1	5SG60-KVS	662532 62513	32A60-KVBE	662532 62691 B				
2,070		1	5SG80-JVS	662532 62515	32A80-JVBE	662532 62696				
2,070		1			32A80-KVBE	662532 62697				
12 x 1-1/4 x 3	2,070	1			32A46-IVBE	662532 62301				
12 x 1-1/2 x 1-1/4	2,070	1			32A46-KVBE	662532 63146				
12 x 1-1/2 x 3	2,070	1	5SG46-IVS	662532 02820	32A46-HVBE	662532 63143				
	2,070	1			32A46-IVBE	662532 63144				
	2,070	1			32A60-JVBE	662532 63123				
12 x 1-1/2 x 5	2,070	1	5NQ46-IVS3	690831 159115	32A46-GVBEP	662532 63192	1	38A46-IVBE	662532 14987	
	2,070	1			32A46-HVBE	662532 63128				
	2,070	1	5NQ46-JVS3	690831 159116	32A46-IVBE	662532 63145				
	2,070	1			32A46-JVBE	662532 63120				
	2,070	1	5NQ60-GVS3P	690831 159117	32A60-HVBE	662532 63149				
	2,070	1	5NQ60-JVS3	690831 159118	32A60-KVBE	662532 63034				
	2,070	1	3SGP60-GVSP	662532 15030						
	2,070	1	5SG46-GVSP	662532 03453						
	2,070	1	5SG46-IVS	662532 02842						
	2,070	1	5SG46-JVS	662532 02926						
12 x 2 x 1-1/4	2,070	1			32A46-KVBE	662532 63461				
	2,070	1			32A46-MVBE	662532 63463				
12 x 2 x 3	2,070	1			32A46-IVBE	662532 63459				
12 x 2 x 5	2,070	1			32A46-HVBE	662532 63403				
	2,070	1			32A46-IVBE	662532 62302				
	2,070	1			32A60-KVBE	662532 63465				
14 x 1/2 x 5	1,800	1	5SG80-KVS	662533 63814	32A60-KVBE	662533 63761				
14 x 3/4 x 5	1,800	1			32A60-KVBE	662533 63772				
14 x 1 x 3	1,800	1	5SG46-IVS	662533 63960						
	1,800	1			32A46-IVBE	662533 63914				
	1,800	1			32A60-IVBE	662533 63927				

* 12" Type 01 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,710; all others = 2,070

B Best Seller; performs well in a variety of applications for many satisfied customers


To maximize the performance of these wheels and finished part quality, refer to the beginning of this section and the "Dressing Solutions" section for truing and dressing products.

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.

Vitrified Wheels For Steel Applications *continued*



TIER: BEST	TIER: BETTER	TIER: GOOD
TRADENAME: QUANTUM / NORTON SG	TRADENAME: 32A	TRADENAME: 38A / 57A
ABRASIVE: Ceramic Alumina	ABRASIVE: Aluminum Oxide	ABRASIVE: Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type O1 Straight 									
14 x 1/2 x 5	1,800	1	5SG80-KVS	662533 63814	32A60-KVBE	662533 63761			
14 x 3/4 x 5	1,800	1			32A60-KVBE	662533 63772			
14 x 1 x 3	1,800	1	5SG46-IVS	662533 63960	32A46-IVBE	662533 63914			
	1,800	1			32A60-IVBE	662533 63927			
14 x 1 x 5	1,800	1	5SG46-GVSP	662533 64108	32A46-GVBEP	662533 64074	1	38A46-HVBE	662533 64043
	1,800	1	5SG46-HVSP	662533 13990	32A46-HVBE	662533 63913	1	38A60-IVBE	662533 63947
	1,800	1	5SG46-IVS	662533 63970	32A46-IVBE	662533 63915	1	38A60-JVBE	662533 64051
	1,800	1	5SG46-JVS	662533 63971	32A46-JVBE	662533 63919	1	38A60-KVBE	662533 64053
	1,800	1			32A46-KVBE	662533 63921	1	38A80-KVBE	662533 64058
	1,800	1	5SG60-IVS	662533 63974	32A60-GVBEP	662533 64077	1	57A60-KVBE	662533 64065
	1,800	1	5SG60-IVSP	662533 63871	32A60-HVBE	662533 63926	1	57A60-LVBE	662533 64066
	1,800	1	5SG60-JVS	662533 63975	32A60-JVBE	662533 63930	1	57A80-MVBE	662533 64070
	1,800	1	5SG60-KVS	662533 63976	32A60-KVBE	662533 63932			
	1,800	1	5SG80-JVS	662533 63979	32A60-LVBE	662533 64035			
	1,800	1	5SG80-KVS	662533 64003	32A80-JVBE	662533 64038			
	1,800	1			32A80-KVBE	662533 64039			
14 x 1 x 8	1,800	1			32A60-IVBE	662533 63887			
14 x 1-1/2 x 5	1,800	1	5NQ46-HVS3	662533 87216	32A46-GVBEP	662533 64238	1	38A46-HVBE	662533 13968
	1,800	1			32A46-HVBE	662533 64335 B	1	38A46-HVBEP	662533 13969
	1,800	1	5NQ46-IVS3	690831 159119	32A46-HVBEP	662533 64243	1	38A46-IVBE	662533 64090
	1,800	1	5NQ46-JVS3	690831 159120	32A46-IVBE	662533 64336	1	38A46-JVBE	662533 64240
	1,800	1			32A46-JVBE	662533 64337	1	38A60-IVBE	662533 64247
	1,800	1			32A46-KVBE	662533 64339			
	1,800	1	5NQ60-GVS3P	690831 159122	32A60-HVBE	662533 64340			
	1,800	1	5NQ60-JVS3	690831 159124	32A60-IVBE	662533 64239			
	1,800	1			32A60-JVBE	662533 64341			
	1,800	1	3SGP46-GVSP	662533 06780	32A60-KVBE	662533 64342			
	1,800	1	3SGP46-HVSP	662533 07025	32A80-JVBE	662533 64246			
	1,800	1	3SGP46-JVH	662533 13976					
	1,800	1	5SG46-GVSP	662533 64320					
	1,800	1	5SG46-HVSP	662533 02625					
	1,800	1	5SG46-IVS	662533 64097					
	1,800	1	5SG46-IVSP	662533 02498					
	1,800	1	5SG46-JVS	662533 64098 B					
	1,800	1	5SG60-IVS	662533 64100					
	1,800	1	5SG60-JVS	662533 64101					
	1,800	1	5SG60-KVS	662533 02160					
	1,800	1	5SG80-KVS	662533 63815					
14 x 2 x 5	1,800	1	5SG60-JVS	662533 64414	32A46-IVBE	662533 64323			
	1,800	1			32A46-JVBE	662533 64508			
	1,800	1			32A46-KVBE	662533 64509			
	1,800	1			32A60-KVBE	662533 64510			

B Best Seller; performs well in a variety of applications for many satisfied customers

Dressing: Single Point Dressing Tool Starting Recommendations

WHEEL SIZES	TOOL SHANK DIAMETER	Ceramic (NQ, Norton SG, TG, etc.), 37C & 39C Wheels		25A, 32A, 38A, 48A, 53A, 57A, 64A, 86A Wheels	
		PRODUCT NO.	PART #	PRODUCT NO.	PART #
12" to 14"	3/8"	BCSG5M6	662601 57009	BC5M6	662601 95004
	7/16"	BCSG5M7	662601 56907	BC5M7	662601 95005



These tools are a standard recommendation; see the "Dressing Solutions" section for additional tools. See the Fliesen Tool section for Furioso tools, engineered specifically for Quantum vitrified wheel dressing.



Vitrified Wheels For Steel Applications *continued*



TIER:	BEST	BETTER	GOOD
TRADENAME:	QUANTUM / NORTON SG	32A / 23A / 48A	38A / 53A / 57A
ABRASIVE:	Ceramic Alumina	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 02 Cylinder 									
6 x 1 x 4	3,600	1/10			32A46-KVBE	662528 38308	1/10	38A80-HVBE	662528 38314
Rim 1"	3,600	1/10			32A60-JVBE	662528 38309			
Plate A47466									
8 x 2 x 5-1/2	2,865						1/8	53A46-KVBE	662530 44942
Rim 1-1/4"									
Plate A50831									
10 x 2 x 7-1/2	2,295	1			32A54-JVG	662531 61687	1	53A60-KVG	662531 61701
Rim 1-1/4"									
(ME62845)									
Plate A110170									
11 x 5	1,910	1			32A30-HVBE	662531 61800			
Rim 1" (ME33437)									
Tape Wound									
11 x 5	1,740	1			32A36-EVBEP	662531 61780	1	38A46-GVBE	662531 61807
Rim 1" (ME52726)	1,910	1			32A36-GVBEP	662531 61808			
Tape Wound	1,910	1			32A46-HVBE	662531 61893			
18 x 5 Rim 1-1/2"	1,065	1			32A30-E19VCP	662534 65142			
(ME15536)									
Tape Wound									
18 x 5 Rim 1-1/2"	1,170	1			23A30-F19VCP	662534 65235			
(ME52719)									
Tape Wound									
Includes Strips									
Type 05 Recessed One Side 									
3/4 x 3/4 x 1/4	43,290	5/40			32A60-KVBE	662434 27582			
Recess 1/S 3/8 x 3/8									
1 x 1 x 1/4	32,470	5/40			32A60-KVBE	662434 27769			
Recess 1/S 1/2 x 1/2									
1 x 1 x 3/8	32,470	5/40			32A60-KVBE	662434 27773			
Recess 1/S 1/2 x 1/2									
1-1/4 x 1 x 3/8	25,975	5/40			32A60-KVBE	662434 27799			
Recess 1/S 5/8 x 1/2									
1-1/2 x 1 x 3/8	25,975	5/40			32A60-KVBE	662434 27938			
Recess 1/S 5/8 x 1/2									
1-1/2 x 1 x 3/8	21,645	5/40			32A60-KVBE	662434 27937			
Recess 1/S 3/4 x 1/2									
2 x 1 x 3/8	16,235	5/40			32A60-KVBE	662434 28329			
Recess 1/S 3/4 x 1/2									
2 x 1-1/2 x 5/8	16,235	10/30			32A60-KVBE	662434 28332			
Recess 1/S 1 x 3/4									
7 x 3/4 x 1-1/4	3,600	1/10	5SG46-IVS	662529 41976	32A46-HVBE	662529 42209	1/10	38A46-IVBE	662529 42222
Rec 1/S 2-3/4 x 1/4	3,600	1/10			32A46-IVBE	662529 42211	1/10	38A60-IVBE	662529 42225
	3,600	1/10			32A46-JVBE	662529 42213			
	3,600	1/10			32A60-IVBE	662529 42217			
	3,600	1/10			32A60-JVBE	662529 42218			
	3,600	1/10			32A60-KVBE	662529 42205			
	3,600	1/10			32A46-GVBEP	662529 42826			
7 x 1 x 1-1/4	3,600	1/10			32A46-HVBE	662529 42688			
Rec 1/S 2-3/4 x 1/2	3,600	1/10	3SGR46-HVP2	662529 16228	32A46-HVBE	662529 42828			
	3,600	1/10	5SG46-IVS	662529 42318	32A46-HVBE	662529 42828			
	3,600	1/10			32A46-IVBE	662529 42691			
	3,600	1/10	5SG46-JVS	662529 42427	32A46-KVBE	662529 42708			
	3,600	1/10			32A60-IVBE	662529 42699			
	3,600	1/10	5SG60-JVS	662529 42431	32A60-JVBE	662529 42701			
	3,600	1/10			32A60-KVBE	662529 42703			
	3,600	1/10			48A46-HVP2	662529 16232			

Continued

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.

Vitrified Wheels For Steel Applications *continued*



TIER: **BEST** **BETTER** **GOOD**
 TRADENAME: **QUANTUM / NORTON SG** **32A / 48A** **38A / GEMINI**
 ABRASIVE: Ceramic Alumina Aluminum Oxide Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 05 Recessed One Side									
7 x 1 x 1-1/4	3,600	1/10	5NQ46-IVS3	662533 50691	32A46-HVBE	662529 42689	1/10	38A46-HVBE	662529 42707
Rec 1/S 3 x 1/2	3,600	1/10	5SG46-IVS	662529 01814	32A46-IVBE	662529 42690	1/10	38A46-IVBE	662529 42809
	3,600	1/10			32A60-IVBE	662529 42686	1/10	38A46-KVBE	662529 42793
	3,600	1/10	5SG60-IVS	662529 06907			1/10	38A60-IVBE	662529 42815
	3,600						1/10	38A60-JVBE	662529 42816
	3,600						1/10	38A60-KVBE	662529 42817
	3,600					10/10	Gemini 46-J	662532 46835	
7 x 1-1/4 x 1-1/4	3,600	1/5			32A46-HVBE	662529 42833			
Rec 1/S 2-3/4 x 5/8	3,600	1/5			32A60-IVBE	662529 42859			
	3,600	1/5			32A60-JVBE	662529 42835			
	3,600	1/5			32A46-IVBE	662529 42843			
7 x 1-1/2 x 1-1/4	3,600	1/5			32A60-IVBE	662529 42844			
Rec 1/S 2-3/4 x 3/4	3,600	1/5			32A46-IVBE	662529 42843			
8 x 3/4 x 1-1/4	3,105	1/10			32A60-IVBE	662529 42844			
Rec 1/S 3-1/4 x 1/4									
8 x 1 x 1-1/4	3,600						10/10	Gemini 46-J	662532 46850
Rec 1/S 3 x 1/2									
8 x 1 x 1-1/4	3,105	1/10	5SG46-IVS	662530 13543	32A46-IVBE	662530 44790			
Rec 1/S 3-1/4 x 1/2	3,600	1/10			32A46-JVBE	662530 44382			
	3,600	1/10	5SG46-JVS	662530 03301					
	3,600	1/10			32A60-IVBE	662530 44753			
	3,600	1/10			32A60-KVBE	662530 44810			
	2,485	1			32A60-JVBE	662531 60189			
10 x 3/4 x 2									
Rec Side A									
5 x 3/16 Face Bev									
Side A 75 Deg									
From 1/8" Flat									
12 x 1-1/2 x 3	2,070	1			32A46-IVBE	662532 63186			
Rec 1/S 6 x 1/2									
12 x 1-1/2 x 5	2,070 / 2,710*	1	3SGR46-HVP2	662532 20904*	32A46-HVBEP	662532 63180	1	38A46-IVBE	662532 63175
Rec 1/S 7-1/2 x 1/2	2,070	1	5SG46-GVSP	662532 63127	32A46-IVBE	662532 63166			
	2,070	1			32A46-JVBE	662532 63169			
	2,070	1	5SG46-IVS	662532 02883	32A46-KVBE	662532 63170			
	2,070	1			32A60-KVBE	662532 63172			
				5SG60-IVSP	662532 63050				
14 x 1-1/2 x 5	1,800 / 2,320*	1			32A46-HVBE	662533 64359			
Rec 1/S 8 x 1/2	1,800 / 2,320*	1	3SGR46-HVP2	662533 19954*	32A46-IVBE	662533 64300			
	1,800 / 2,320*	1	3SGR60-HVP2	662533 19956*	32A46-KVBE	662533 64362			
	1,800	1	5SG46-IVS	662533 64102	32A60-JVBE	662533 64364			
	1,800	1	5SG46-IVS3	662434 94106	32A60-KVBE	662533 64365			
	1,800	1	5SG46-JVS	662533 64103					
	1,800	1	5SG60-IVS	662533 64104					
	1,800	1	5SG60-JVS	662533 64105					
14 x 2 x 5	2,320	1			48A46-HVP2	662533 19941	1	25A46-HVP2	662533 19945
Rec 1/S 8 x 1/2	2,320	1	3SGR46-HVP2	662533 19937			1	38A46-HVP2	662533 19949
	2,320						1	38A60-HVP2	662533 19951
	1,800	1			32A60-KVBE	662533 64390			

* 12" Type 05 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,710; all others = 2,070

* 14" Type 05 Wheel Maximum RPM: NORPOR VP2 Wheels = 2,320; all others = 1,800

To maximize the performance of these wheels and finished part quality, refer to the beginning of this section and the "Dressing Solutions" section for truing and dressing products.



If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.

Vitrified Wheels For Steel Applications *continued*



TIER: **BEST** **NORTON SG**
 TRADENAME: **32A / 48A**
 ABRASIVE: Ceramic Alumina Aluminum Oxide

GOOD
38A / 25A / 53A
 Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 06 Straight Cup 									
3-1/2 x 1-1/2 x 1/2 Rim 1/2" Back 1/2"	6,550						1/10	38A60-KVBE	662435 29372
100mm x 50mm x 20mm Rim 10mm, Back 13mm	6,550						1/10	38A80-JVBE	662435 30429
4 x 1-1/2 x 1/2 Rim 1/2" Back 1/2"	5,730	1/10			32A60-KVBE	662435 30218			
4 x 1-1/2 x 1-1/4 Rim 1/2" Back 1/2"	5,730						1/10	38A60-KVBE	662435 30221
4 x 2 x 20mm Rim 3/8" Back 1/2"	5,730						1/10	38A80-JVBE	662435 30523
5 x 1-1/2 x 1-1/4 Rim 3/8" Back 3/8"	4,585	1/10			32A46-KVBE	662528 30832	1/10	38A46-KVBE	662528 30842
Face Y (ME19243)	4,585	1/10			32A60-JVBE	662528 30837	1/10	38A60-KVBE	662528 30846
5 x 2 x 5/8 Rim 1/2" Back 1/2"	4,585	1/10			32A60-KVBE	662528 30838			
5 x 2 x 5/8 Rim 1/2" Back 1/2"	4,585	1/10			32A60-JVBE	662528 30987			
6 x 1-1/2 x 1/2 Rim 1" Back 1/2"	3,820	1/10			32A46-KVBE	662528 38458			
6 x 2 x 1-1/4 Rim 1/2" Back 1/2"	3,820	1/10			32A46-IVBE	662528 38544	1/10	38A60-KVBE	662528 38486
7 x 2 x 1-1/4 Rim 1/2" Back 1/2"	3,275	1/8			32A60-JVBE	662528 38538			
7 x 2 x 1-1/4 Rim 1/2" Back 1/2"	3,275	1/8			32A46-JVBE	662529 42856			
9-1/2 x 1-1/2 x 1-1/2 Rim 1-1/2" Back 5/8"	2,415						1	53A46-LVBE	662531 49136
10 x 4 x 1-1/2 Rim 1-1/4" Back 1"	2,295						1	38A46-IVBE	662531 61797
Tape Wound									
12 x 2-1/2 x 7 Rim 1-1/2" Back 7/8"	1,910	1			32A46-LVBE	662532 63614			
Type 07 Recessed Two Sides 									
12 x 2 x 3 Rec 2/S 5-1/2 x 3/8	2,070	1			32A46-IVBE	662532 63588			
12 x 2 x 3 Rec 2/S 7-1/4 x 1/2	2,070	1			32A46-HVBE	662532 63590			
12 x 2 x 5 Rec 2/S 7-1/4 x 1/2	2,070	1			32A46-JVBE	662532 63348			
12 x 2 x 5 Rec 2/S 7-1/4 x 1/2	2,070	1			32A46-IVBE	662532 63594			
12 x 2 x 5 Rec 2/S 7-1/2 x 1/2	2,070	1	5SG46-JVS	662532 09930	32A46-HVBE	662532 63591	1	38A46-IVBE	662532 63600
	2,070	1			32A46-HVBEP	662532 63603			
	2,070	1			32A46-JVBE	662532 63483			
	2,070	1			32A46-KVBE	662532 63596			
	2,070	1			32A60-IVBE	662532 63597			







Vitrified Wheels For Steel Applications *continued*



TIER: **BEST** **NORTON SG** **BETTER** **32A**
 TRADENAME: **NORTON SG** **32A**
 ABRASIVE: Ceramic Alumina Aluminum Oxide

GOOD **38A**
 Aluminum Oxide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	SPEC.	PART #	MIN./STD. PKG.	SPEC.	PART #
Type 11 Flaring Cup 									
3/2-1/4 x 1-1/4 x 3/4	7,640	1/10			32A60-JVBE	662435 29183	1/10	38A60-JVBE	662435 29197
Rim 1/4" Back 3/8"	7,640	1/10			32A60-KVBE	662435 29187			
Face Z (ME21560)									
3-1/2/2-3/4 x 1-1/2 x 1-1/4	7,640	1/10			32A60-KVBE	662435 29358			
Rim 1/4" Back 3/8"									
Face Z (ME24327)									
4/3 x 1-1/2 x 1-1/4	5,730	1/5	5SG46-IVSP	662435 30127	32A46-IVBE	662435 30240	1/10	38A46-KVBE	662435 30378
Rim 1/4" Back 1/2"	5,730	1/5	5SG46-KVS	662435 03342	32A46-KVBE	662435 30246	1/10	38A60-JVBE	662435 30387
Face Z (ME19237)	5,730	1/5			32A60-JVBE	662435 30256	1/10	38A60-KVBE	662435 30390
	5,730	1/5	5SG60-JVS	662435 30415	32A60-KVBE	662435 30361	1/10	38A80-JVBE	662435 30393
	5,730	1/5					1/10	38A80-KVBE	662435 30395
	5,730	1/5	5SG60-LVS	662435 30417	32A80-KVBE	662435 30368			
	5,730	1/5	5SG80-JVS	662435 30419					
4-1/2/3-3/4 x 2 x 1-1/4	5,730	1/5			32A46-KVBE	662528 30539			
Rim 1/4"									
Back 1/2"(ME20115)									
5/3-3/4 x 1-3/4 x 1-1/4	4,585	1/5	5SG46-KVS	662528 03291	32A46-JVBE	662528 30858	1/5	38A46-KVBE	662528 30971
Rim 1/4" Back 1/2"	4,585	1/5	5SG60-KVS	662528 30737	32A46-KVBE	662528 30859	1/5	38A60-JVBE	662528 30973
Face Z (ME21563)	4,585	1/5					1/5	38A60-KVBE	662528 30975
	4,585	1/5	5SG60-LVS	662528 30736	32A60-JVBE	662528 30962			
	4,585	1/5			32A60-KVBE	662528 30964			
6/4-1/2 x 2 x 1-1/4	3,820	1/5			32A46-JVBE	662528 38491	1/5	38A46-KVBE	662528 38495
Rim 3/8" Back 1/2"	3,820	1/5			32A46-KVBE	662528 38528	1/5	38A60-KVBE	662528 38497
Face Z (ME19241)	3,820	1/5			32A60-JVBE	662528 38492			
7/5 x 2 x 1-1/4	3,275	1/8			32A46-JVBE	662529 42959	1/8	38A46-HVBE	662529 42963
Rim 3/4" Back 1/2"									
(ME19242)									
Type 12 Dish 									
4 x 1/2 x 3/4 (ME19226)	6,207	1/10			32A60-KVBE	662435 30067			
6 x 1/2 x 1-1/4 (ME19229)	4,140	1/10	5SG60-LVS	662528 36574	32A46-JVBE	662528 36860	1/10	38A60-JVBE	662528 36977
	4,140	1/10			32A60-JVBE	662528 36966			
6 x 3/4 x 1-1/4 (ME19230)	4,140	1/10	5SG60-KVS	662528 37771	32A46-KVBE	662528 37732			
	4,140	1/10			32A60-JVBE	662528 37734			
	4,140	1/10			32A60-KVBE	662528 37735			
7 x 1/2 x 1-1/4 (ME13717)	3,600	1/10			32A46-KVBE	662528 41644			
	3,600	1/10			32A60-KVBE	662529 41647			
8 x 3/4 x 1-1/4 (ME19231)	3,600						1/10	38A60-KVBE	662530 44319
10 x 1 x 1 (ME38702)	2,485	1			32A54-JVBE	662531 61196			
10 x 1 x 1-1/4 (ME38702)	2,485	1			32A54-JVBE	662531 61197			
Type 20 Concave One Side 									
14 x 1-1/2 x 5	1,800	1	5SG60-JVS	662533 02265	32A60-JVBE	662533 64250			
Concave from Periphery	1,800	1			32A60-KVBE	662533 64332			
1/2" Deep to 8" Flat Spot									
Type 35 Plate Mounted Disc 									
9 x 2 x 4-15/16	2,550	1			32A46-MVBE	662530 49115			
Rim 2-1/32" (ME31130)	2,550	1			32A60-J25VCF2	662530 06557			
Plate A47248	2,550	1			32A70-JVBEP	662530 49112			

If you don't see the toolroom wheel you need in our stock listing contact your Norton rep for made-to-order availability including wheels made with our revolutionary new premium Quantum Prime ceramic and Vitrium³ bond wheels.



These sharp silicon carbide, vitrified wheels are used for grinding non-ferrous applications.

Applications:

Use 39C (green silicon carbide) for cemented carbides, titanium, metal matrix composites and plasma sprayed materials.
Use 37C (black silicon carbide) on 300 series stainless steels, irons, nonferrous metals (aluminum, brass, bronze and copper) and non-metallic materials (stone, marble, rubber, ceramics and glass).

Shapes:

Type 01 Straight, Type 02 Cylinder, and Type 05 Recessed 1 Side

Size Range:

3" – 14" diameter

Grit Range:


24 – 120

Abrasive Grain:




39C Green Silicon Carbide, 37C Black Silicon Carbide

Vitrified Wheels For Non-Ferrous Applications

TIER: **GOOD**
TRADENAME: **39C / 37C**
ABRASIVE: Silicon Carbide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #
Type 01 Straight 				
3 x 1/2 x 1/2	10,825	10/50	37C60-MVMT	662435 29041
3 x 1 x 1/2	10,825	10/10	37C60-MVMT	662435 29166
	10,825	10/10	37C80-HVMT	662435 29170
	10,825	10/10	37C80-MVMT	662435 29171
	10,825	10/10	37C100-HVMT	662435 29172
	10,825	10/10	37C100-MVMT	662435 29070
3-1/2 x 1-1/2 x 7/8 (ME622)	7,095	1/10	37C24-SVK	662435 29339
	7,095	1/10	37C30-SVK	662435 29338
4 x 1/2 x 1/2	8,120	1/10	37C60-MVMT	662435 29960
	8,120	1/10	39C100-IVMT	662435 30064
6 x 1/2 x 1-1/4	4,140	1/10	39C60-IVMT	662528 36706
	4,140	1/10	39C80-IVMT	662528 36816
	4,140	1/10	39C100-IVMT	662528 36827
	4,140	1/10	39C120-IVMT	662528 36836
6 x 3/4 x 1-1/4	4,140	1/10	39C60-IVMT	662528 37584
	4,140	1/10	39C80-IVMT	662528 37598
	4,140	1/10	39C100-IVMT	662528 37717
	4,140	1/10	39C60-IVMT	662528 38161
6 x 1 x 1-1/4	4,140	1/10	39C80-IVMT	662528 38173
	3,600	1/10	39C80-JVMT	662529 40007
7 x 1/4 x 1-1/4	3,600	1/10	39C100-IVMT	662529 40109
	3,600	1/10	39C120-IVMT	662529 40111
	3,600	1/10	37C46-JVMT	662529 41488
7 x 1/2 x 1-1/4	3,600	1/10	37C60-OVMT	662529 41498
	3,600	1/10	39C60-IVMT	662529 41609
	3,600	1/10	39C60-JVMT	662529 41611
	3,600	1/10	39C60-KVMT	662529 41613
	3,600	1/10	39C80-IVMT	662529 41617
	3,600	1/10	39C80-JVMT	662529 41618
	3,600	1/10	39C100-HVKMT	662529 41622
	3,600	1/10	39C100-IVMT	662529 41624
	3,600	1/10	39C120-IVMT	662529 41632 B
	3,600	1/10	39C80-JVMT	662529 42096
7 x 3/4 x 1-1/4	3,600	1/10	39C100-JVMT	662529 42104
	3,600	1/10	39C60-IVMT	662529 42666
7 x 1 x 1-1/4	3,600	1/10	39C80-IVMT	662529 42413
	3,600	1/10	39C120-IVMT	662529 42416
8 x 1/4 x 1-1/4	3,600	1/10	39C80-IVMT	662530 14526
8 x 3/8 x 1-1/4	3,600	1/10	39C80-IVMT	699366 64144
8 x 1/2 x 1-1/4	3,600	1/10	39C60-IVMT	662530 44013
	3,600	1/10	39C80-IVMT	662530 44015
	3,600	1/10	39C100-IVMT	662530 44017 B

TIER: **GOOD**
TRADENAME: **39C / 37C**
ABRASIVE: Silicon Carbide

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	PART #	
Type 01 Straight 					
8 x 3/4 x 1-1/4	3,600	1/10	39C60-JVMT	662530 44312	
	3,600	1/10	39C80-IVMT	662533 50645	
	3,600	1/10	39C100-IVMT	662530 44314	
8 x 1 x 1-1/4	3,600	1/10	39C60-JVMT	662530 44770	
	3,600	1/10	39C80-IVMT	662530 44425 B	
	3,600	1/10	39C100-IVMT	662530 44379	
	2,485	1	39C60-JVMT	662531 160348	
	2,485	1	39C60-JVMT	662531 161640	
10 x 1 x 3	2,485	1	39C60-IVMT	662532 62985	
10 x 1-1/2 x 2	2,070	1	39C60-IVMT	662532 62884	
	2,070	1	39C80-JVMT	662532 62988	
12 x 1 x 3	2,070	1	39C60-JVMT	662533 64206	
	1,800	1	39C80-JVMT	662533 64208	
	1,800	1	39C60-JVMT	662533 64208	
12 x 1 x 5	2,070	1	39C60-JVMT	662533 64242	
	1,800	1	39C80-JVMT	662533 64322	
Type 02 Cylinder 	6 x 1 x 4	3,600	1/10	39C60-IVMT	662528 38322
	Rim 1"	3,600	1/10	39C60-JVMT	662528 38324
	Plate A47466	3,600	1/10	39C80-IVMT	662528 38327
		3,600	1/10	39C100-IVMT	662528 38330
		3,600	1/10	39C120-IVMT	662528 38193
	6 x 1-1/4 x 4	3,600	1/10	39C60-IVMT	662528 38345
	Rim 1"				
	Plate A47466				
	10 x 2 x 7	2,100	1	39C60-HVMT	662531 161675
	Rim 1-1/2"	2,295	1	39C60-JVMT	662531 161678
Plate A83831					
Type 05 Recessed One Side 					
14 x 1-1/2 x 5	1,800	1	39C60-IVMT	66253364328	
Rec 1/5 8 x 1/2					

B = Best Seller, performs well in a variety of applications for many satisfied customers



VMT Bond Technology

Lower power draw for reduced cycle time and improved wheel life.



Large surface grinding wheels are generally used to grind flat stock or flat surfaces within a workpiece. These wheels are typically used on horizontal spindle machines. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

- Applications:**
- Producing flat stock
 - Grinding large molds and dies
 - Sharpening knives, blades and cutlery
 - Manufacturing broaches
- Shape:** Type 01 Straight, Type 07 Recessed 2 Sides
- Size Range:** Stock: 20" diameter
1" – 6" thickness
- Abrasive Grain:** Aluminum Oxide

Cross Reference Guide

NORTON	GOOD GEMINI
Camel	91A
Cincinnati Milacron	29A, 97A
Radiac	WAA, 97A, 45A



Good choice when a broad range of parts are ground on a few machines

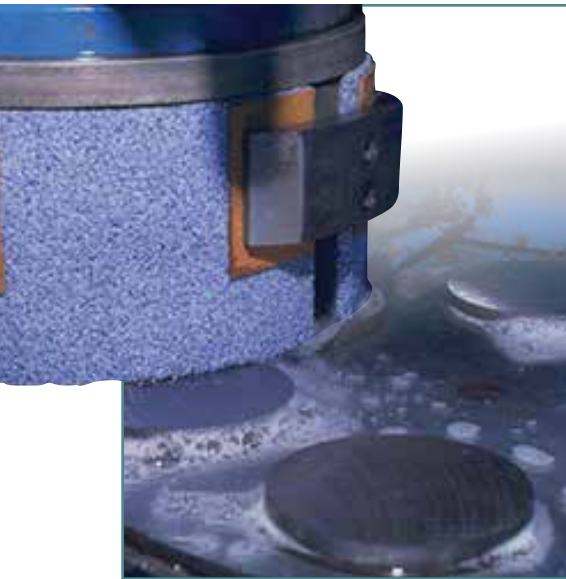
GEMINI ALUMINUM OXIDE BLEND

- Specially blended aluminum oxide abrasive for many surface grinding applications
- Porous bond is cool cutting on medium to wide contact areas; high chip clearance and stock removal
- Faster grinding rates remove stock, lower rates produce finer finishes; ideal when a broad range of tool steel parts are ground on a few machines

TIER: **GOOD**
TRADENAME: **GEMINI**
ABRASIVE: Aluminum Oxide

SIZE (D x T x H)	RECESS	MAX. RPM	STD. PKG.	SPEC.	PART #
Type 01 Straight Wheels					
20 x 1 x 8	–	1,625	1	Norton Gemini A46-H	662532 46937
20 x 2 x 10	–	1,625	1	Norton Gemini A36-J	662532 46956
Type 07 Recessed Two Sides					
20 x 2 x 8	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini 59A46-I	662532 46949
	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-G VSP	662532 46953
20 x 3 x 8	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-G VSP	662532 46972
	Recessed 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-H	662532 46969
	Recess 2 Sides 11-1/2 x 1/2	1,625	1	Norton Gemini A46-I	662532 46960
20 x 3 x 10	Recess 2 Sides 12-1/4 x 3/4	1,625	1	Norton Gemini 59A46-I VSP	662530 58315
	Recess Side A 12-1/2 x 1/2, Side B 12-1/2 x 1	1,625	1	Norton Gemini A36-J VSP	662532 46980
	Recess Side A 12-1/2 x 1/2, Side B 12-1/2 x 1	1,625	1	Norton Gemini A46-D VSP	662532 46988

There are many more sizes and specifications available made-to-your-order. Contact your Norton representative with your custom requirements.



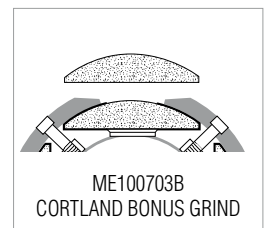
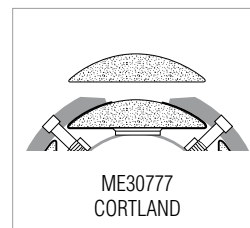
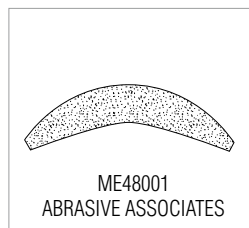
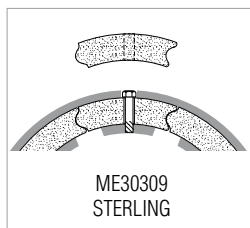
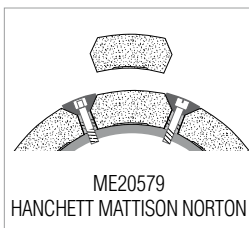
Surface grinding segments are generally used to grind flat stock or flat surfaces within a workpiece. The segment moves over the workpiece in a flat plane or vice versa. Applications can vary from heavy, rapid stock removal to precision tolerance operations.

- Applications:**
- Vertical spindle surface grinding
 - Grinding large molds, dies and plates
 - Producing flat stock
 - Sharpening knives, blades, cutlery
- Abrasive Grain:** Ceramic Alumina, Aluminum Oxide

Material-to-Product Recommendation Guide

MATERIAL	HEAVY-DUTY				GENERAL-DUTY		
	QuantumX 20-G	QuantumX 30-F	86A24-G20VTX2	86A30-E20VTX2	Gemini 30-E	Gemini 30-F	Gemini 30-G
Aluminum				◆	◆		
Bronze (hard)							◆
Cast Iron	◆						◆
Hastalloy			◆		◆		
Inconel		◆			◆		
Hardened Steel	◆				◆		
High Speed Steel	◆				◆		
Soft Steel			◆	◆			◆
Stainless Steel 300				◆	◆		
Stainless Steel 400						◆	

Segment Blueprints



Troubleshooting Guide

PROBLEM	CORRECTION
Segment acting too hard	Increase rate of downfeed Increase table rotation speed (watch amp-meter) Dress more frequently Consider reducing area of table load
Segment acting too soft	Decrease rate of downfeed Decrease table rotation speed Check for abnormal machine vibration
Glazing and/or burning	Choose a softer grade Increase table speed (watch amp-meter)

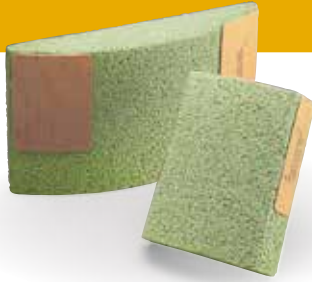
TECH TIP

- Choose as coarse a grit size as possible in order to remove stock as quickly as possible (in big chips).
- To maximize production, choose the hardest grade possible that will not overload the machine.



It is the user's responsibility to refer to and comply with ANSI B7.1

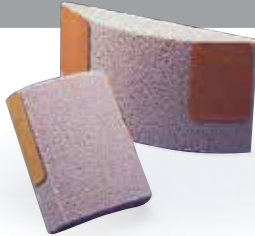
Best choice for all low-, medium-, and high-force applications ranging from cast iron, to stainless steel and hard-to-grind alloys



QUANTUM AND QUANTUM X CERAMIC ALUMINA

- Revolutionary, versatile engineered ceramic grain shape and chemistry produce highest productivity with the lowest total grinding costs
- 33% to 100% longer life versus competitive ceramic products, 30% plus higher metal removal rate, with 15% plus lower threshold power
- Excellent performance on both old and new machines

Better choice for versatile, consistent performance



86A ALUMINUM OXIDE

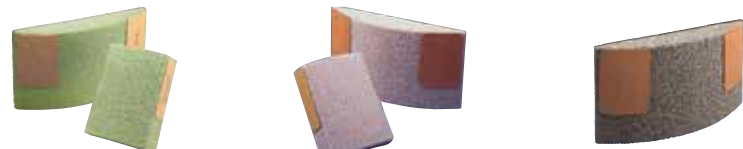
- Sharper aluminum oxide abrasive grain delivers cooler-cutting, consistent performance
- Segments available for Hanchett, Mattison Norton, Sterling, Abrasive Associates, Cortland, and Cortland Bonus Grind machines
- Better choice with porous vitrified bond for increased chip clearance and cool cutting in heat-sensitive applications

Good choice when a broad variety of parts are ground on a few machines



GEMINI ALUMINUM OXIDE BLEND

- Specially blended aluminum oxide abrasive for many surface grinding applications
- The porous vitrified bond increases chip clearance and maximizes coolant flow, reduces loading, and is cool cutting in heat-sensitive applications
- For use in Hanchett, Mattison, and Norton, and Cortland and Cortland Bonus Grind chucks on surface grinding machines



		TIER: BEST		TIER: BETTER		TIER: GOOD				
		TRADENAME: QUANTUM/QUANTUM X		TRADENAME: 86A		TRADENAME: GEMINI				
		ABRASIVE: Ceramic Alumina		ABRASIVE: Aluminum Oxide		ABRASIVE: Aluminum Oxide Blend				
WIDTH	THICK	HEIGHT	BLUEPRINT NO.	STD. PKG.	SPEC.	PART #	SPEC.	PART #		
5	1-1/2	6	ME20579	8	QUANTUMX 20-G	662533 50603				
				8			86A24-H20VTX2	662533 50602	Gemini 30-E	662530 50295
				8			86A30-F12VBEP	614636 50273	Gemini 30-F	662530 50297
6-13/16	1-1/2	6	ME30309	8			86A24-G20VTX2	662533 50595	Gemini 30-G	662530 50299
				5	QUANTUMX 20-G	662533 50607	86A24-E12VBEP	614636 50279	Gemini 30-E	699366 99706
				5	QUANTUMX 20-H	662533 50608	86A24-G20VTX2	662533 50605	Gemini 30-F	699366 99709
11-1/4	2-1/4	6	ME30777	5	3NQP36-G12VSP	662532 51527			Gemini 30-G	699366 99710
				5			86A30-E12VBEP	614636 50285	Gemini 30-H	662434 47588
				5			86A30-F12VBEP	614636 50287		
				5			86A30-G12VBEP	614636 50289		
				5			86A46-D12VBEP	614636 50442		
11-1/4	2-1/4	8	ME30777	5	QUANTUMX 20-G	662533 50612	86A24-G20VTX2	662533 50609	Gemini 30-E	699366 99712
				5	QUANTUMX 20-H	662533 50615			Gemini 30-F	699366 99716
				5	QUANTUMX 30-E	662533 87810	86A30-E20VTX2	662533 87812	Gemini 30-G	699366 99717
				5	QUANTUMX 30-F	662533 87811	86A30-F20VTX2	662533 87813	Gemini 30-H	662434 47591
				5	3NQP30-F12VSP	662532 38276			Gemini 30-I	662434 47592
11-1/4	3	8	ME100703B	4	QUANTUMX 20-G	662533 50623	86A24-G20VTX2	662533 50617	Gemini 30-E	699366 99725
				4	QUANTUMX 20-H	662533 50624			Gemini 30-F	699366 99727
				4	QUANTUMX 30-E	662533 87808			Gemini 30-G	699366 99728
				4	QUANTUMX 30-F	662533 87809			Gemini 30-H	662434 47594
				4	3NQP30-F12VSP	690831 56473			Gemini 30-I	662434 47595
	1-5/8			10	Vitrified Burr Remover	614636 50268*				

*Minimum Quantity = 2



Cylindrical wheels are used most often when the part is held between centers and in chucks. There are three methods of cylindrical grinding: plunge, traverse, and angular.

- Plunge grinding – wheel is thrust or plunged into the part
- Traverse grinding – wheel moves across the part
- Angular grinding – wheel contacts the part at an angle

Typical Industries: Automotive, shipbuilding, engine building, bearing, land- and air-based turbine blades, and toolroom

Shape: Type 01 Straight, Type 05 Recessed One Side, and Type 07 Recessed 2 Sides

Size Range: 16", 18", 20", 24" and 30" diameter

Abrasive Grain: Ceramic Alumina and Aluminum Oxide

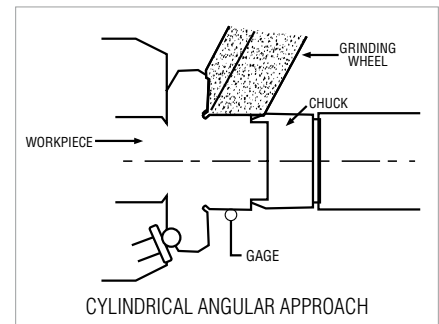
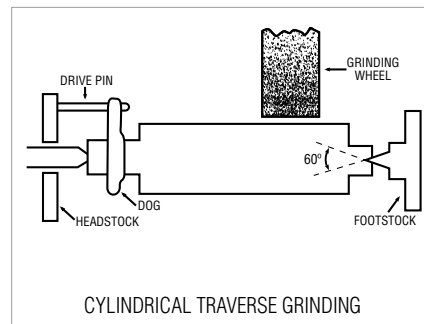
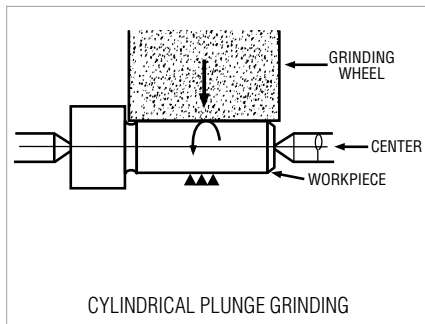
Stationary Dressing Tool Recommendations for Cylindrical Wheels

Grinding Wheel Diameter	Diamond Carat Weight	Single Point		Multi-Point (Grit)			Tool Product/Part #		Shape	
		Tool Product/Part #	0° Angle	Tool Product/Part #	Shape	Tool Product/Part #	15° Angle	Shape		
16" - 20"	3/4	BC7M7	662601 95007	BC62	662601 95012	1/4 x 1/2 Rect.	BC63	662601 95013	1/4 x 1/2 Rect.	
		NS7M7	662601 95132	2A6D7	662601 95046		2A6E7	662601 95049		
21" +	1	BC10M7	662601 95009	BC61	662601 95011	1/4 x 3/4 Rect.	BC60	662601 95010	1/4 x 3/4 Rect.	
		NS10M7	662601 95137	1A6A7	662601 95031		1A6C7	662601 95039		

NS Single Point Diamond Tools are resettable. BC Diamond Tools are not resettable. All tools specified above have 7/16" diameter shanks.

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Burn or cracks on workpiece	Wheel too hard	Try softer wheel or make wheel act softer (see Tech Tip on next page)
	Dress is too fine	Dress faster
	Nozzle not directing coolant properly	Redirect flow
	Work speed too slow or wheel speed too fast	Adjust speeds
	Wheel feed too slow causing excess contact time	Increase feed rate
Chatter marks on workpiece	Loose spindle, end play, bearing failure	Check wheel spindle on assembly
	Work drive faults, out-of-truth plate	Check gear action, truth, drive on pin pressure
	Wheel too hard, poor truing, poor mounting	Use softer grade; dress wheel correctly; secure mounting
Poor quality finish	Poor quality dressing	Reduce final depth of dress on wheel
	Diamond insecurely held	Check and replace diamond and secure properly
	Misalignment of head and tail stocks	Check for properly aligned workpiece
	Dirty coolant	Clean coolant frequently; use efficient filter
	Scored workpiece centers	Check and lap center holes as required



Best choice for highest productivity, lowest total per-part grinding cost

5SG CERAMIC ALUMINA/ALUMINUM OXIDE BLEND

- Exceptionally high-performing seeded gel ceramic alumina and friable aluminum oxide abrasive blend for fast stock removal, cool, superior cutting; 3 - 5 times more life than aluminum oxide wheels; 2 times stock removal rate vs. conventional abrasives
- High-performance versatile bond for cylindrical and surface grinding high-speed tool steels, hardened and soft steels, and aerospace alloys: exceptional form holding
- Self-sharpening abrasive minimizes burn and required dressing, to maximize sharp edge on tools and dies for longer life in production

Better choice for medium to heavy stock removal

32A ALUMINUM OXIDE

- Exceedingly strong, sharp monocrystalline aluminum oxide grain, for precision production medium to heavy stock removal applications
- The most versatile vitrified bond, especially recommended for toolroom, cylindrical, and surface grinding
- Grinds with an exceptional cool; fast cutting action, requires minimum dressing

Better choice for longer wheel life

86A ALUMINUM OXIDE

- Premium abrasive and superior bond system produce high grinding G-Ratios (metal removal/wheel wear) for increased productivity
- Hold form for better part geometry; decreased dress frequency and/or dress compensation
- Engineered for easy use, grind cycles do not need to be altered, no special operator training is needed

Good choice for versatile performance at an economical price

64A ALUMINUM OXIDE BLEND

- Specially blended aluminum oxide abrasive for production cylindrical applications
- A superior vitrified bond that maintains high grinding rates without wheel breakdown
- Good choice for small job shops grinding numerous materials on a few machines

Good choice for smallest volume, lowest initial price applications

GEMINI 2 ALUMINUM OXIDE

- Upgraded aluminum oxide abrasive blend delivers an efficient cut rate and improved grinding wheel life to your precision operations
- Made in the USA, these quality, low initial price wheels are ideal for small- to medium-sized manufacturing facilities that perform a variety of jobs
- Carefully chosen, versatile specifications and sizes meet many cylindrical and surface grinding requirements

TECH TIP

To make a wheel act softer:

- Increase work speed
- Increase traverse speed
- Increase infeed
- Decrease wheel speed
- Increase dresser traverse rate
- Increase depth of dress per traverse
- Dress more often



It is the user's responsibility to refer to and comply with ANSI B7.1

To make a wheel act harder:

- Decrease work speed
- Decrease traverse speed
- Decrease infeed
- Increase wheel speed (do not exceed MAX RPM marked on wheel)
- Dress at slower traverse rate
- Decrease depth of dress per traverse



TIER:	BEST	BETTER	GOOD
TRADENAME:	5SG	32A, 86A	64A, GEMINI, OR GEMINI2
ABRASIVE:	Ceramic Alumina / Aluminum Oxide	Aluminum Oxide	Aluminum Oxide

SIZE (D x T x H)	STD. PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type 01 Straight							
16 x 1 x 5	1	5SG60-JVS	662534 67007	32A60-J8VBE	662534 64836	64A60-K8V127	662534 66722
	1			32A60-K5VBE	662534 64837	Gemini2 60-I	662434 97801
	1					Gemini2 60-K	662434 95077
	1					Gemini2 100-I	662434 97804
	1					Gemini2 100-M	662434 97807
16 x 1 x 8	1			32A60-K5VBE	662534 64826		
16 x 1-1/2 x 5	1	5SG60-KVS	662534 67010	32A46-H8VBE	662534 64925		
16 x 2 x 5	1			32A46-J8VBE	662534 64995	64A60-K8V127	662534 66721
	1			32A60-K5VBE	662534 64960	Gemini2 60-I	662434 97810
	1					Gemini2 100-I	662434 97812
18 x 1 x 5	1					Gemini2 60-I	662434 83777
	1					Gemini2 60-M	662434 97611
	1					Gemini2 100-M	662434 97615
18 x 2 x 5	1					64A60-K8V127	662534 66719
	1					Gemini2 60-I	662434 83779
20 x 1 x 8	1			86A60-J8V127	690786 08982		
	1			86A80-J8V127	690786 08983		
	1					Gemini2 60-M	662434 97841
20 x 1 x 10	1					Gemini2 100-I	662434 97842
	1					Gemini2 60-I	662434 95332
	1					Gemini2 60-K	662434 97789
	1					Gemini2 60-M	662434 97791
	1					Gemini2 100-I	662434 97793
	1					Gemini2 100-K	662434 97796
	1					Gemini2 100-M	662434 97798
20 x 1 x 12	1					Gemini2 60-I	662434 83787
	1					Gemini2 60-K	662434 97827
	1					Gemini2 60-M	662434 97831
	1					Gemini2 100-I	662434 97835
	1					Gemini2 100-M	662434 97838
20 x 1-1/2 x 5	1			32A46-H8VBE	690786 65382		
20 x 2 x 5	1					64A60-J8V127	690786 66713
20 x 2 x 8	1			32A46-I8VBE	690786 65433	64A60-K8V127	690786 66712
	1			32A60-K5VBE	690786 65490	Gemini2 60-I	662434 83785
20 x 2 x 10	1					Gemini2 60-K	662434 97855
	1					Gemini2 100-I	662434 97849
	1					Gemini2 100-K	662434 97850
20 x 2 x 12	1			32A46-I8VBE	690786 65455		
	1					Gemini2 100-K	662434 97854
20 x 3 x 8	1					64A46-I8V127	690786 66447
	1					64A60-J8V127	690786 08140
	1					Gemini2 100-I	662434 97862
20 x 3 x 10	1					Gemini2 60-I	662434 95333
	1					Gemini2 60-I	662434 83789
20 x 3 x 12	1					Gemini2 100-I	662434 97860
	1					Gemini2 60-I	662434 83790
	1					Gemini2 100-I	662434 97866
24 x 1 x 12	1					Gemini2 100-M	662434 97870
	1					64A60-K8V127	690831 66710
	1					64A80-K8V127	690831 66711
24 x 3 x 12	1				Gemini2 60-I	662434 83793	
30 x 2 x 12	1					64A60-J8V127	692104 66704
30 x 3 x 12	1					64A60-J8V127	692104 66697
	1					64A60-K8V127	692104 66698
	1					64A60-J8V127	692104 01774
30 x 4 x 12	1					64A60-J8V127	692104 01774
	1					Gemini2 60-J	662434 97989
Type 07 Recessed Two Sides							
18 x 2 x 8 Rec 2/S 10-1/2 x 1/2	1			32A46-I8VBE	662534 65110		
20 x 2 x 8 Rec 2/S 11-1/2 x 1/2	1			32A46-I8VBE	690786 65537		
20 x 3 x 8 Rec 2/S 11-1/4 x 1/2	1			32A46-I8VBE	690786 65686		
20 x 3 x 8 Rec 2/S 11-1/2 x 1/2	1					Gemini 46-H	662532 46969
20 x 3 x 10 Rec 2/S 12-1/4 x 5/8	1			32A46-I8VBE	690786 65575		
20 x 6 x 10 Rec Side A 12-1/4 x 2 Rec Side B 12-1/4 x 1	1			32A46-I8VBE	690786 65854		

For additional stock cylindrical wheels, see the large surface grinding wheel section of this catalog

Contact your Norton representative with your custom cylindrical wheel requirements. There are many more sizes and specifications available made-to-your-order, including wheels made from Norton 55A and Quantum blank stock. See 55A and Quantum Blank Stock FastTrack Service catalog sections for more details. Ask about wheels made with our revolutionary new premium Quantum Prime ceramic grain and Vitrium3 bond.



Centerless grinding is a production process that produces extremely close tolerances on metal cylindrical forms or parts. Centerless grinding is used on a wide variety of workpieces. The key components in the process are the grinding wheel, the work rest blade (used to support the work) and the regulating or “feed” wheel (the drive mechanism for the workpiece).

Applications:

- High production operations on large volume continuous grinding
- Parts ranging from miniature roller bearings to train axles and bearings
- Fastener and tool manufacturing
- Steel mills
- Automotive related components
- Bearing
- Machine tools
- Aircraft
- Turbine blades – land- and air-based

Shape:

Centerless wheels: Type 01 Straight
 Feed wheels: Type 01 Straight and Type 07 Recessed 2 Sides

Size Range:

Centerless wheels: 16", 20", and 24" diameter
 Feed wheels: 12" and 14" diameter

Abrasive Grain:

Ceramic Alumina, Aluminum Oxide, Aluminum Oxide/Silicon Carbide Blend

Material-to-Product Recommendation Guide

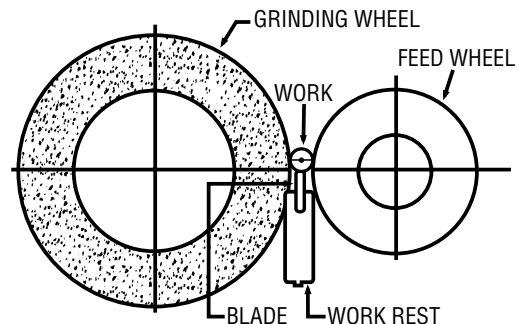
	55A60-KVS3	55A80-LVS3	32AC90-QB	32AC54-QB	2NQMC54-QB45
Alnico	◆			◆	
Cast Iron	◆			◆	
Hastalloy	◆				
Inconel	◆				
Stainless	◆				
Stainless Steel 300	◆				
Stainless Steel 400	◆				
Steel - Hard or Soft					
Less than 1/2" Diameter		◆			
5/8" to 2 1/2" Diameter	◆				
Over 2 1/2" Diameter	◆				◆
High Speed (commercial finish)	◆				◆
High Speed (fine finish)			◆		

Stationary Dressing Tool Recommendations for Centerless Wheels

Grinding Wheel Diameter	Diamond Carat Weight	Single Point		Indexable Single Point		Multi-point (Grit)	
		Tool Product # Part # 0° Angle	Tool Product # Part # 0° Angle	Tool Product # Part # 0° Angle	Shape	Tool Product # Part # 15° Angle	Shape
11" - 14"	1/2	BC5M7 662601 95005	BCUD5 662601 95025	BC65 662601 95015	3/8 Round	BC63 662601 95013	1/4 x 1/2
		NS5M7 662601 95127	NSUD5 662601 95163	2R6K7 662601 95096		2A6E7 662601 95049	
15" - 20"	3/4	BC7M7 662601 95007	N/A	BC62 662601 95012	1/4 x 1/2	BC63 662601 95013	1/4 x 1/2
		NS7M7 662601 95132	NSUD7 662601 95164	2A6D7 662601 95046		Rectangle	
21" +	1	BC10M7 662601 95009	N/A	BC61 662601 95011	1/4 x 3/4	BC60 662601 95010	1/4 x 3/4
		NS10M7 662601 95137	N/A	1A6A7 662601 95031		Rectangle	

Stationary Dressing Tool Recommendations for Feed Wheels

Feed Wheel Diameter	Tool Carat Weight	Tool Shank Diameter	Indexable Single Point	
			Tool Product #	Tool Part #
Up to 14"	1/2	7/16"	NSUD5	662601 95163



TECH TIP

Proper Wheel Mounting

1. Thoroughly clean spindle and flange bearing area of all dirt and foreign material.
2. Inspect for worn, distorted or damaged areas on flanges and spindle.
3. If mounting a wide centerless wheel on a spindle (i.e., twin-grip), do not use grease or other petroleum lubricants. Use a silicone spray lubricant on the spindle to ease mounting the wheel, if necessary.
4. Ensure mount up arrow is at the top of the wheel. In the case of butted sets, assemble so that the arrow is formed across the top of the wheel face.
5. Ensure proper blotters are installed; one on each flange mating surface. Always use new blotters.
6. Install blotter flange and snug up the bolts only finger tight.
7. Using a torque wrench, tighten all bolts in an alternating pattern from side to side to 15 foot pounds.
8. Repeat the same tightening sequence, increasing the torque to 35 foot pounds.
 - » for wide wheels (18"-20"), torque the bolts at 45 to 50 foot pounds
 - » for narrower wheels (2"-12"), a torque of 35 foot pounds is sufficient
9. Retorque the flange bolts to specification after the first eight hours of operation.

TECH TIP

To make a wheel act softer:

- Increase work speed/regulating wheel speed
- Increase throughput speed/regulating wheel speed
- Increase infeed
- Decrease wheel speed
- Dress at a faster traverse rate

To make a wheel act harder:

- Decrease work speed/regulating wheel speed
- Decrease throughput speed/regulating wheel speed
- Decrease infeed
- Increase wheel speed (observe safe limits)

TECH TIP

- Use vitrified bond wheels for form holding and plunge grinding
- Use resinoid bond wheels for stock removal, long irregular parts and faster throughfeed grinding
- Vitrified Centerless Wheel Speeds:
 - » 64A46-KVCE wheels: 6,500 SFPM max. operating speed
 - » All other vitrified centerless stock products: 8,500 SFPM max. operating speed
 - » Always check wheel speed markings on wheels before running wheel



It is the user's responsibility to refer to and comply with ANSI B7.1



Best choice for cast iron to stainless and hard-to-grind materials and alloys (titanium, Inconel...)

QUANTUM (2NQ) CENTURY45 CERAMIC ALUMINA

- Proprietary 2NQ ceramic abrasive and Century45 (B45) resin bond formulation engineered specifically to maximize productivity of centerless applications
- Achieve over 30% improvement of stock removal, and up to 50% reduction in cycle time
- Less grinding noise significantly improves operator safety

Better choice for performance to price ratio

55A-VS3 ALUMINUM OXIDE

- Monocrystalline 55A aluminum oxide offers superior performance on centerless plunge and throughfeed surface grinders with 2 plus times the life of competitive aluminum oxide wheels
- Vitrium 3 VS3 bond allows cool cutting, high-speed, and precise form holding
- Ideal for simple- to complex-shaped components, with increased productivity; more quality parts at low cost per part

Better choice when one wheel is used to grind several different materials

32AC ALUMINUM OXIDE / SILICON CARBIDE BLEND

- Aluminum oxide/silicon carbide abrasive blend in a strong resin bond is ideal when one wheel is used to grind several different materials from high-to-low tensile strength
- Norton resin bond centerless wheels are the choice for stock removal, long irregular paths, and faster through feed grinding
- Ideal for full range of simple- to complex-shaped components

Good choice for hard-to-grind fasteners

57A ALUMINUM OXIDE WITH FINE / HARD SIDE

- Tough, durable aluminum oxide abrasive for heavy duty work
- Superior vitrified bond system for longer wheel life and excellent form holding when toolroom and centerless grinding
- 3/16 inch thick fine/hard side provides good form holding while grinding stainless and Inconel fasteners

Good choice for grinding a variety of materials, economically

64A ALUMINUM OXIDE BLEND

- Good intermediate type aluminum oxide abrasive blend for production centerless applications
- A superior vitrified bond that maintains high grinding rates without wheel breakdown
- Good choice for small job shops grinding numerous materials on a few machines

Good choice for smallest volume, lowest initial price applications

GEMINI 2 ALUMINUM OXIDE

- Upgraded aluminum oxide abrasive blend delivers an efficient cut rate and improved grinding wheel life to your precision operations
- Made in the USA, these quality, low initial price wheels are ideal for small- to medium-sized manufacturing facilities that perform a variety of jobs
- Carefully chosen, versatile specifications and sizes meet many centerless grinding requirements

Centerless Wheels

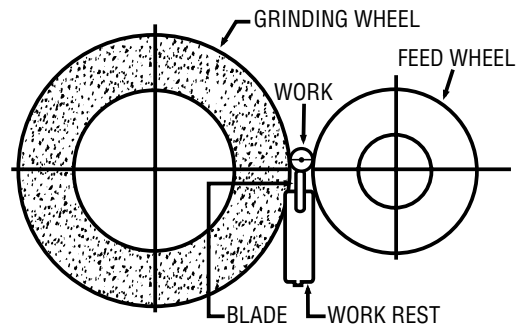
		TIER: BEST		BETTER		BETTER		GOOD	
TRADENAME:		QUANTUM CENTURY45 CENTERLESS RESINOID WHEELS		32AC / 32AC CENTURY 45 CENTERLESS RESINOID WHEELS		55A CENTERLESS VITRIFIED WHEELS		53A, 57A, 64A, GEMINI, GEMIN2 CENTERLESS VITRIFIED WHEELS	
ABRASIVE:		Ceramic Alumina		Aluminum Oxide/Silicon Carbide		Aluminum Oxide		Aluminum Oxide	
SIZE (D x T x H)	STD. PKG.	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #	SPEC.	PART #
Type 01 Straight									
16 x 4 x 10	1							57A80-L8VCN	662534 65001
20 x 2 x 12	1								
20 x 4 x 12	1							64A60-KVCE	690786 66723
	1							64A80-LVCE	690786 66727
20 x 6 x 12	1	2NQMC54-QB45	662434 96406	32AC80-NB45	662434 96398	55A60-KVS3	662533 87817	64A60-KVCE	690786 66729
	1			32AC54-QB	690786 66545			Gemini 60-L	662532 46994
	1					55A80-MVS	662534 90788		
20 x 8 x 12	1	2NQMC54-QB45	662434 96407	32AC80-NB45	662434 96400	55A60-KVS3	662533 87819	64A60-KVCE	690786 66748
	1			32AC54-QB	690786 66546	55A80-LVS	662534 90783	64A60-LVCE	690786 66749
	1							64A80-KVCE	690786 66751
	1							Gemini 54-J	662532 47001
	1							Gemini2 60-K	662534 51857
24 x 2-1/2 x 12	1							57A A80/120 P/R	662534 91223
24 x 2-1/2 x 12 w/ 3/16" fine/hard layer	1								
24 x 3 x 12	1								
24 x 4 x 12	1							64A60-K8V127	690831 66708
	1							Gemini2 100-L	662534 51861
24 x 6 x 12	1	2NQMC54-QB45	662434 96408	32AC80-NB45	662434 96401	55A80-LVS3	662533 87821	Gemini 60-K	662532 47047
	1			32AC54-QB	690831 66547			Gemini2 60-K	662534 51862
24 x 8 x 12	1	2NQMC54-QB45	662434 96409	32AC80-NB45	662434 96403	55A60-KVS	662534 90791		
	1			32AC54-QB	690831 66548	55A60-LVS	662534 90762		
	1					55A80-LVS3	662533 87825		
	1					55A60-MVS	662534 90782		
24 x 10 x 12	1	2NQMC54-QB45	662434 96410	32AC80-NB45	662434 96404	55A60-KVS3	662533 87830		
	1			32AC54-QB	690831 66549	55A80-LVS3	662533 87828		
24 x 20 x 12	1			32AC54-QB	690831 66552				
Composed of 2 Wheels 10" Thick (ME90362)	1			32AC54-SB	690831 66553				

Rubber Bond Feed Wheels

		TIER: BETTER	
ABRASIVE:		Aluminum Oxide	
SIZE (D x T x H)	STD. PKG.	SPEC.	PART #
Type 07 Recessed Two Sides			
12 x 4 x 5	1	57A80-RR51	662532 22844
Rec 2 Sides 7-1/2 x 1/2			
12 x 6 x 5	1	57A80-RR51	662532 22846
Rec Side A 7-1/2 x 1-1/2			
Rec Side B 7-1/2 x 1/2			
12 x 6 x 5	1	57A80-RR51	662532 22847
Rec 2 Sides 7-1/2 x 1-1/2			
12 x 8 x 5	1	57A80-RR51	662532 22850
Rec Side A 7-1/2 x 2-1/2			
Rec Side B 7-1/2 x 1-1/2			
14 x 8 x 5	1	57A80-RR51	662533 22859
Rec Side A 8 x 2			
Rec Side B 8 x 1-1/2			
14 x 20 x 6	1	57A80-RR51	662533 22196
Rec 2 Sides 8-1/2 x 1-1/2			
Butted Feed Wheels Composed of 2 Wheels 10" Thick (ME91512)			

Plastic Bond Feed Wheels

		TIER: BETTER	
ABRASIVE:		Aluminum Oxide	
SIZE (D x T x H)	STD. PKG.	SPEC.	PART #
Type 07 Recessed Two Sides			
12 x 8 x 5	1	57A80-RP4	662532 22199
Rec Side A 7-1/2 x 2-1/2			
Rec Side B 7-1/2 x 1-1/2			



There are many more sizes and specifications available made-to-your-order, including wheels made from our blank stock FastTrack Service for rush orders. Ask about wheels made with our revolutionary new premium Quantum Prime ceramic grain. Contact your Norton representative with your custom centerless requirements.



Norton creepfeed wheels are the best performing creepfeed wheels in the industry. These high-performance blank stock wheels can be altered to your dimensional requirements.

Applications:	Heat-sensitive, porous grinding of difficult-to-grind alloys
Typical Industries:	Aerospace, automotive, toolroom, gear, energy
Size Range:	Blank Stock: 16" – 25" diameter Finished Wheel: 14" – 25" diameter
Grade/Porosity:	C28 – F26
Abrasive Grain:	Ceramic Alumina, Fused Aluminum Oxide

Best choice for versatility, maximum performance, and highest productivity



QUANTUM X CERAMIC ALUMINA AND VORTEX ALUMINUM OXIDE BLEND

- Leading Norton technologies produce the most free-cutting creepfeed wheel: patented pore-induced construction, a blend of Norton Quantum ceramic and Vortex aluminum oxide abrasives, and the newest, strongest Norton bond: Vitrium
- Excel on large area of contact applications with exceptional form and corner-holding and 20+% less power draw; best MRR vs. all other ceramic creepfeed wheels, with reduced cycle times of up to 50%
- Versatile; for all low-, medium- and high-force applications on hard-to-grind Inconel, titanium, and aerospace alloys

Better choice for heat-sensitive, porous grinding of difficult-to-grind alloys




VORTEX ENGINEERED ALUMINUM OXIDE

- High-performance, engineered and optimally spaced fused aluminum oxide abrasive
- High metal removal rates; able to grind large areas of contact with exceptional part integrity and quality and superior surface finish
- Long wheel life: dramatically shorter grinding cycles = less wheel changes and more parts/wheel = high productivity

Key Program Features

- Standard lead-time: 2 weeks
- Alteration Parameters:
 - » Diameter may be altered to 2" smaller than the original blank stock diameter
 - » Thickness may be altered to 1/2 the original blank stock thickness
 - » Bore may be altered to these parameters 5" altered up to 8" max. 8" altered up to 12" max.

TIER: BEST		BETTER		
TRADENAME: QUANTUM X 3NQX, TG		VORTEX		
CERAMIC UNFINISHED BLANK STOCK		A/O UNFINISHED BLANK STOCK		
SIZE (D x T x H)	SPEC.	UF BLANK PART #	SPEC.	UF BLANK PART #
Type 01 Straight				
12 x 1.750 x 3	3NQX60/1-D24VTX2	003105	01586	
12 x 3.500 x 3	3NQX60/1-E24VTX2	003105	01589	
12 x 1 x 3	3NQX60/1-E24VTX2	003105	01590	
12 x 3 x 3	TG2120/1-E24VTX2	003105	01591	
12 x 3.500 x 3	3NQX60/1-C28VTX2	003105	03234	
12 x 1.500 x 3	3NQX60/1-C28VTX2	003105	03235	
16 x 1 x 5	3NQX60-C28VTX2	003104	38575	
	3NQX60-D+28VTX2	003104	79157	
	3NQX60-E24VTX2	003104	25239	
	3NQX80-E+28VTX2	003104	79160	
16 x 3 x 5	3NQX60-C28VTX2	003104	38656	
	3NQX60-D28VTX2	003104	25240	
	3NQX60-E24VTX2	003104	25241	
	3NQX80-E+28VTX2	003104	79161	
16 x 4 x 5			IPA60-D29VTX	003103
			IPA60-E26VTX	12485
16 x 5 x 5	3NQX60-D28VTX2	003104	25242	
	3NQX60-E24VTX2	003104	25243	
16 x 6 x 5	3NQX80-E+28VTX2	003104	79162	
20 x 1 x 8	3NQX60-C28VTX2	003104	38658	
	3NQX60-D28VTX2	003104	25244	
	3NQX60-E24VTX2	003104	25245	
20 x 2-1/2 x 8			IPA60-F17VTX	003103
			IPA80-D29VTX	03131
20 x 3 x 8	3NQX60-C28VTX2	003104	38659	
	3NQX60-D28VTX2	003104	25256	
	3NQX60-E24VTX2	003104	25257	
20 x 4 x 8			IPA60-D29VTX	003103
			IPA60-E26VTX	03133
20 x 5 x 8	3NQX60-D28VTX2	003104	25258	
	3NQX60-E24VTX2	003104	25259	
20 x 6 x 8	3NQX60-C28VTX2	003104	38660	
24 x 4 x 8			IPA60-C29VTX	003103
			IPA60-D29VTX	25091
			IPA60-F26VTX	003104
25 x 2-1/2 x 8			IPA60-E26VTX	06547
25 x 3-1/2 x 8			IPA60-E26VTX	03135
			IPA60-E26VTX	04613
			IPA60-E26VTX	04678





Norton Quantum vitrified wheels deliver the highest productivity of any wheel in the marketplace. They will grind with superior results in many applications. They can be altered to your specific needs within two weeks of receipt of your order.

- Applications:**
- Centerless plunge and throughfeed grinding
 - Surface grinding
 - Cylindrical grinding
- Size Range:**
Blank Stock: 18" – 30" diameter
Finished Wheel: 16" – 30" diameter
- Grit Range:** 60, 80, and 120
- Grade Range:** I – M
- Abrasive Grain:** Ceramic Alumina

Best choice for versatility, maximum performance, and cost savings



QUANTUM CERAMIC ALUMINA

- Revolutionary, sharp, durable engineered ceramic alumina grain shape and chemistry; highly-porous
- Perform well on old and new machines with 30%+ higher metal removal rate and 15%+ lower threshold power; achieve highest productivity with lowest total grinding cost
- Versatile; for all low-, medium- and high-force applications ranging from cast iron, to stainless steel and hard-to-grind Inconel and titanium

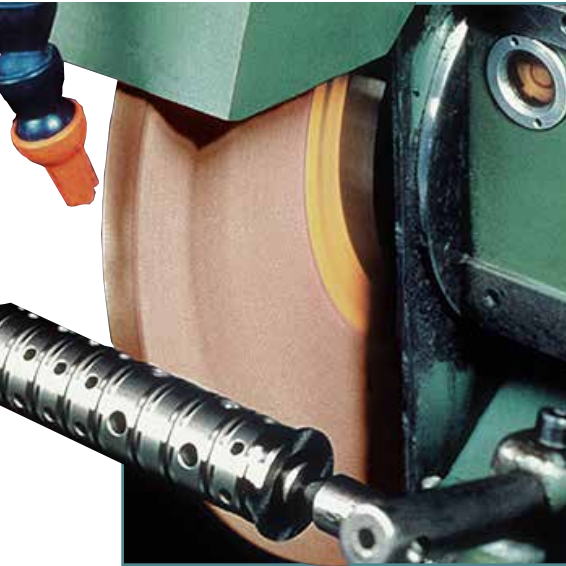
TIER: **BEST**

TRADENAME: **QUANTUM CERAMIC UNFINISHED BLANK STOCK**

SIZE (D x T x H)	SPEC.	UNFINISHED BLANK PART #
Type 01 Straight		
18 x 1 x 5	3NQ80-K10VS	003104 05993
18 x 2 x 5	3NQ80-K10VS	003104 05994
18 x 3 x 5	3NQ80-K10VS	003104 05995
20 x 1 x 8	3NQ80-K10VS	003104 05985
20 x 1 x 12	3NQ80-K10VS	003104 06017
	3NQ120-MVS	003104 05924
20 x 2 x 8	3NQ80-K10VS	003104 06036
20 x 3 x 8	3NQ80-K10VS	003104 06037
20 x 6 x 12	3NQ80-L10VS	003104 06018
20 x 8 x 12	3NQ80-L10VS	003104 06026
24 x 1 x 8	3NQ80-K10VS	003104 06034
24 x 1 x 12	3NQ80-K10VS	003104 06038
24 x 2 x 8	3NQ80-K10VS	003104 06035
24 x 2 x 12	3NQ80-K10VS	003104 06029
24 x 3 x 8	3NQ60-J10VS	003104 25121
	3NQ80-K10VS	003104 06046
24 x 3 x 12	3NQ60-J10VS	003104 25120
	3NQ80-K10VS	003104 06030
24 x 6 x 12	3NQ80-L10VS	003104 06031
24 x 8 x 12	3NQ80-L10VS	003104 06032
24 x 10 x 12	3NQ80-L10VS	003104 06033
30 x 2 x 12	3NQ80-I10VS	003104 27211
	3NQ80-J10VS	003104 06047
	3NQ80-K10VS	003104 06048
30 x 3 x 12	3NQ60-I10VS	003104 27212

There are many finished sizes and specifications available. Contact your local Norton distributor or salesperson with your size and specification requirements for quantity guidelines, quotations and helpful ordering instructions.

Please note "2-week delivery request" if needed, on your order.



55A-VH blank stock wheels are competitively-priced, monocrystalline grain wheels specifically engineered for numerous carbon steel applications requiring moderate to heavy stock removal rates. They can be altered to your specific needs within two weeks of receipt of your order.

- Applications:** Centerless plunge and throughfeed grinding
Surface grinding
Cylindrical grinding
- Size Range:** Blank Stock: 18" – 42" diameter
Finished Wheel: 16" – 42" diameter
- Grit Range:** 60 – 120
- Grade Range:** I – M
- Abrasive Grain:** Aluminum Oxide

Better choice for precision grinding of carbon steel and cast iron



55A-VH ALUMINUM OXIDE

- Advanced combination of monocrystalline 55A aluminum oxide abrasive and superior VH bond
- Superior performance on centerless plunge and throughfeed, surface, and cylindrical grinders with up to 2X the life of competitive aluminum oxide wheels
- Ideal for simple- to complex-shaped components with increased productivity, more quality parts, and lowest cost per part

TIER: **BETTER**
OTHER: **55A-VH ALUMINUM OXIDE UNFINISHED BLANK STOCK**

SIZE (D x T x H)	GRIT	GRADE	UNFINISHED BLANK PART #
Type 01 Straight			
18 x 1 x 5	80	K	003104 04552
18 x 2 x 5	80	K	003104 04554
18 x 3 x 5	80	K	003104 04555
20 x 1 x 8	60	K	003100 20910
20 x 1 x 12	100	K	003103 02177
	120	M	003100 64512
20 x 1-1/2 x 12	80	K	003103 02221
	100	K	003103 02222
20 x 2 x 8	80	K	003100 20918
	100	K	003100 20920
	120	M	003100 64252
20 x 3 x 8	80	K	003104 25116
20 x 3 x 12	80	K	003104 25117
20 x 6 x 12	80	K	003100 20965
24 x 1 x 8	80	K	003100 21884
24 x 1 x 12	60	K	003100 20921
	80	M	003100 20923
24 x 1-1/4 x 12	60	M	003103 02224
24 x 1-1/2 x 8	80	K	003103 02223
24 x 1-1/2 x 12	80	K	003103 02225
	80	M	003103 02226
24 x 2 x 8	80	K	003100 21885
24 x 2 x 12	60	K	003100 20924
	80	I	003100 20926
24 x 3 x 8	80	K	003100 21757
24 x 5 x 12	60	L	003103 02227
24 x 6 x 12	60	K	003100 20968
24 x 10 x 12	80	K	003100 20972
42 x 1-1/2 x 12	60	M	003100 20931

There are many finished sizes and specifications available. Contact your local Norton distributor or salesperson with your size and specification requirements for quantity guidelines, quotations and helpful ordering instructions.

Please note "2-week delivery request" if needed, on your order.



Norton quality non-stock gear wheels are designed to produce high metal removal rates with less power draw. The blank stock wheels below comprise our FastTrack alteration service. All Norton FastTrack wheels are altered on state-of-the-art CNC controlled machines and are finished using Norton dressing wheels. The Norton dressing wheels and machines give these wheels excellent accuracy and repeatability.

Vitrium³ VS3G Bond Wheels

Our revolutionary, exclusive bond platform provides unprecedented wheel performance and finished part accuracy across many precision grinding applications – while lowering process time and cost in three ways:

1. Coolest cutting with maximum chip clearance
2. Optimized precision profile delivers ultra radius accuracy
3. Able to run at higher operating speeds (maximizing your older and newer machines' performances)

Size Range:	Blank Stock: 120mm – 450mm diameter Finished Wheel: 115mm – 450mm diameter
Grit Range:	60 – 120
Abrasive Grain:	Ceramic Alumina and Aluminum Oxide

Key Program Features

- Standard lead time:
 - » 2 weeks
- Alteration Parameters:
 - » Diameter may be altered to 2" smaller than the original blank stock diameter
 - » Thickness may be altered to 1/2 the original blank stock thickness

Best choice for versatility, highest productivity, and lowest total cost

QUANTUM X CERAMIC ALUMINA AND VORTEX ALUMINUM OXIDE BLEND

- Leading Norton technologies produce the most free-cutting gear wheels: patented pore-induced construction, Norton Quantum X ceramic alumina and Vortex aluminum oxide abrasive blend, and strong Norton bond
- Best MRR (metal removal rate) versus all other ceramic gear wheels; reduce grinding cycle times up to 50%, best choice for grinding from solid
- Versatile; for all low-, medium- and high-force applications on hard-to-grind Inconel, titanium, and aerospace alloys; excel on large area of contact applications with exceptional form and corner-holding; 20+% less power draw

Excellent choice for the most demanding operations

TARGA TG, 3TG, 5TG CERAMIC ALUMINA

- The unique elongated shape of our second generation Norton seeded gel ceramic alumina abrasive offers exceptional durability for the most demanding applications and materials
- Consider Targa (TG) when your requirements for SG have been exceeded
- VS3G Vitrium³ bond is the newest, strongest bond in the Norton portfolio: patented pore-induced construction; for all low-, medium- and high-force applications; excels on hard-to-grind aerospace alloys and large areas of contact; exceptional form and corner-holding

Excellent choice for high productivity, low total per-part grinding cost


SG CERAMIC ALUMINA


- High-performance seeded gel ceramic aluminum oxide abrasive provides fast stock removal, cool, superior cutting, and 3X - 5X more life than aluminum oxide wheels, and double rough stock removal rate versus conventional abrasives
- Self-sharpening abrasive for less burn, less dressing; very consistent performing wheel
- 5SG – durable Norton SG and aluminum oxide blend – blue, for high stock removal rates, excellent productivity, long wheel life, low overall grinding cost; versatile, high-performance VS and VSP bonds provide exceptional form holding

Better choice for versatile, consistent performance

86A ALUMINUM OXIDE

- Sharper aluminum oxide abrasive for cooler cutting
- VS3G Vitrium³ bond is the newest, strongest bond in the Norton portfolio: patented pore-induced construction; for all low-, medium- and high-force applications
- Excels on hard-to-grind aerospace alloys and large areas of contact; exceptional form and corner-holding

TIER: BEST		TIER: BEST		TIER: BETTER	
TRADENAME: NORTON QUANTUM X: 5NQX		TRADENAME: NORTON SEEDED GEL: 3TGP, 5G, 5SG		TRADENAME: 86A, 25A, X25A	
TRADENAME: NQN, NQ, 3NQ, 5NQ		TRADENAME: VS3G = VITRIUM³ BOND		TRADENAME: VS3G = VITRIUM³ BOND	
ABRASIVE: Ceramic Alumina Unfinished Blank Stock		ABRASIVE: Ceramic Alumina Unfinished Blank Stock		ABRASIVE: 86A, 25A, X25A – Aluminum Oxide Unfinished Blank Stock	
SIZE (D x T x H)	SPEC.	BLANK PART #	SPEC.	BLANK PART #	SPEC.
Type O1 Straight 					
Worm Profile Wheels					
275mm x 125mm x 160mm				86A100/5-I10VTX2	003104 58402
275mm x 160mm x 160mm				86A90-J10VS3G	003104 86397
300mm x 125mm x 160mm	3NQ90-J10VH	003103 94338		86A100/5-J10VTX2	003104 58405
	3NQ90-J10VS3G	003105 17379		86A100/5-I10VTX2	003104 58404
300mm x 160mm x 160mm				86A120-J10VS3G	003104 86983
	1NQNR90-J10VS3PN	003105 78192			
	1NQNR120-J10VS3PN	003105 78193			
350mm x 125mm x 160mm				86A90-J10VS3PN	003105 78172
				86A120-J10VS3PN	003105 78191
				25A90-H10VS3G	003104 48496
Single Rib Wheels					
120mm x 30mm x 20mm	5NQX100-G20VTX2	003104 90920	3TGP80/3-G12VS3G	003104 48502	
300mm x 30mm x 50.8mm	5NQX60-G20VTX2	003104 90863	3TGP80/3-G12VS3G	003104 48501	
300mm x 60mm x 50.8mm	5NQX60-G20VTX2	003104 90864	3TGP80/3-G12VS3G	003104 48500	
400mm x 60mm x 127mm	5NQX60-G20VTX2	003104 90865			
400mm x 75mm x 127mm			3TGP60-G20VSPF	003104 04597	
400mm x 100mm x 127mm	5NQX60-G20VTX2	003104 90916	3TGP60-G20VSPF	003104 04598	
400mm x 150mm x 127mm	5NQX60-G20VTX2	003104 90917			
450mm x 50mm x 127mm			3TGP80/3-G12VS3G	003104 48499	
450mm x 60mm x 127mm	5NQX60-G20VTX2	003104 90918			
450mm x 100mm x 127mm	5NQX60-G20VTX2	003104 90921	3TGP80/3-G12VS3G	003104 48498	
450mm x 150mm x 127mm	5NQX60-G20VTX2	003104 90919	3TGP80/3-G12VS3G	003104 48497	

TIER: BEST		TIER: BEST	
TRADENAME: NORTON SEEDED GEL: TG, 5TG, 5SG		TRADENAME: NORTON SEEDED GEL: TG, 5TG, 5SG	
ABRASIVE: Ceramic Alumina Unfinished Blank Stock		ABRASIVE: Ceramic Alumina Unfinished Blank Stock	
SIZE (D x T x RIM)	PLATE #	SPEC.	BLANK PART #
Type O2 Plate-Mounted Cylinder 			
4.100 x 3.000 x .700	A311220	5SG80-JVS	003104 85214
8.400 x 3.500 x 1.050	A311384	5SG80-JVS	003104 85228
		TG280-H12V-X575	003104 85229
8.346 x 3.500 x 1.043	A311384	5TG80-3-J8VH	003104 80245

Gear blank stock alteration orders must include complete blueprint information.

Please ask your Norton representative for appropriate blueprint worksheet to fill in:

- Worm wheel blueprint worksheet: ME161508
- Single rib wheel blueprint worksheet: ME161178



ID, Race and Superfinishing Wheels and Sticks



The most extensive line of Pressed-To-Size ID and Race wheels to choose from to maximize performance and cost savings.

In addition to VFL wheels, VS3L-bonded wheels are also available. VS3L is the Vitrium3 high-strength, cool-cutting bond with improved cutting efficiency, productivity, and wheel life. VFL and VS3L wheels are the fastest way to get Make-to-Order Norton ID and Race Grinding wheels. Norton VFL and VS3L wheels are available in both ceramic abrasives and conventional aluminum oxide abrasives in diameters up to 5".

Additional dimensions and grinding faces are available as made-to-order products with 4-week lead-times.

Wheel Types: Type 01 and 05
Abrasive Types: Ceramic Alumina, Aluminum Oxide

ID and Race Wheels

ID and Race Wheel FastTrack Availability

Type 01 Straight		Diameter: 0.172" thru 4.532" Maximum thickness: 3.75"
Type 05 Recessed One Side		Diameter: 0.407" thru 5" Maximum thickness: 3.10"

For more program details, ask your Norton sales representative to review the FirstLine VFL & VS3L ID and Race Wheels Brochure #6981 with you.

VFL Availability

ABRASIVE	25A, 32A, 38A, 48A, 53A, 57A, 86A	5TG*	1SG, 3SG, 5SG	32AA	NQN, 1NQ, 3NQ, 5NQ, 1NQNP, 3NQNP, 5NQNP, 1NQNM, 3NQNM, 5NQNM
GRIT	54 - 120	80/1, 120/1	54-120	54-80	54-150
GRADE	J - P	I - M	I - N	I - M	I - N
STRUCTURE	6 (Not Shown)				
BOND	VFL				
WHEEL TYPES	01, 05				
SHAPES	Special faces not available				
SPEED	8,500 SFPM***				
TREAT 22	Not Available				

* 5TG is available in /1 combination, only
 **Speeds up to 12,500 SFPM by request and Safety approval

VS3L Availability

ABRASIVE	25A, 32A, 38A, 55A, 86A	5TG*	1SG, 3SG, 5SG	NQN, 1NQ, 3NQ, 5NQ, 1NQNP, 3NQNP, 5NQNP, 1NQNM, 3NQNM, 5NQNM
GRIT	54-120	80/1, 120/1	54-120	54-150
GRADE	H - P	I - K	I - N	I - N
STRUCTURE	8, 10	8	8, 10	8, 10
BOND	VS3L			
WHEEL TYPES	01, 05			
SHAPES	Special faces not available			
SPEED	8,500 SFPM***			
TREAT 22	Not Available			

* 5TG is available in /1 combination, only
 **Speeds up to 12,500 SFPM by request and Safety approval

Dimensional Tolerances

IF DIAMETER IS:	DIAMETER	THICKNESS	HOLE
0.532" and less	+/- .003"	+ .004" - .000	+ .001" + .006"
> 0.532" - 2.907"	+/- .005"	+/- .005"	+ .001" + .006"
> 2.907" - 4.407"	+/- .015"	+/- .015"	+ .001" + .006"



ID, Race and Superfinishing Wheels and Sticks

Blank Stock FastTrack Made-to-Order Microabrasive Superfinishing Sticks



Superfinishing blank stock encompasses a wide range of different specifications. These blanks can be finished to your dimensional requirements within two weeks from the date that the order is received at Norton Customer Service. Small lots, for test purposes, can be express shipped.

APPLICATIONS	ABRASIVE TYPE – BOND	GRIT RANGE	TREATMENT TYPE
Superfinishing / Finishing	NLA – V	240 – 1200	Sulfur, Wax
	NMVC – VCA		
	NSA – V		
Honing	SG – VS	54 – 220	
	SGG – VS1		

Rubber Finishing Sticks

These sticks are used for manual or mechanical honing on machines where they are mounted in holders or fixtures. Intended for use where precision dimensional limits and grade controls are required, such as die polishing.



SIZE (T x W x L)	STD. PKG./CASE	SPEC.	PART #
Rubber Finishing Sticks			
1/2 x 1/2 x 6	5/20	57A120-B2RR	614636 10608
1/2 x 1 x 6	5/20	57A120-B2RR	614636 10609

our dressing tools
**MAKE THE
PERFECT POINT**

The Norton Winter full line of expertly-crafted stationary and rotary dressing tools - whether stock or custom-engineered - delivers your every application need. And, our expert resetting and relapping services renew used tools to reduce your "cost per dress."



Our Norton Winter offering is the industry's most comprehensive line of stock and made-to-order products to true (restore the wheel's profile) and dress (opening – to remove stock – or closing to finish) the face of the wheel. In addition to these catalog stock stationary tools, Norton Winter manufactures a full line of custom stationary tools, rotary diamond dressers and truing/dressing devices to meet all your specific application needs.

Applications:

Truing and dressing conventional and superabrasive wheels, straight, step, radius and form dressing

Tool Types:

Stationary: Single Point, Toolroom, Multi-Point, Blade, Form, and Cluster Tools, and Truing Devices

Rotary: Reverse Plated and Infiltrated Form Plunge Diamond Rolls, Diamond CNC Traversing Discs, and Dressing Spindles

Determining the Best Value

Remember that diamonds are a rare commodity—the larger the stone and the better the quality, the higher the initial cost. The key to successful diamond tool productivity and use is based on the "cost per dress." Normally, higher quality diamonds and a proactive resetting program will result in the lowest "cost per dress."

In those situations where a resetting program is not feasible or low initial cost is the primary purchasing consideration, Norton Winter offers a complete line of non-resettable tools.

Resetting Your Used Diamond Tools

Resetting – Minimizing Your Cost

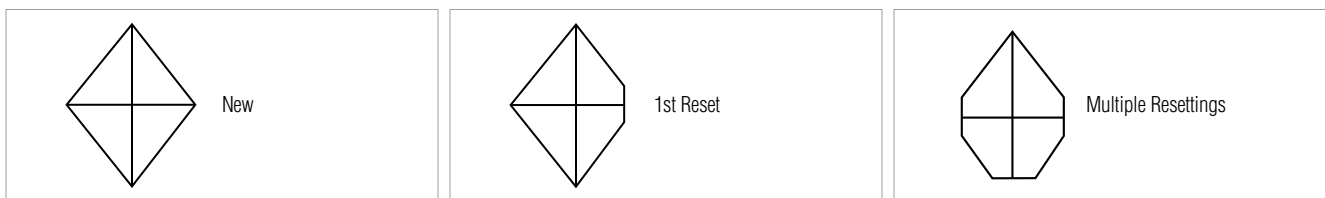
Buying a higher quality diamond is your best value, especially if you participate in a proactive resetting program. Although initial cost may be higher, the payback comes through several factors:

- Diamond durability, providing longer tool life
- Tighter form tolerances
- Consistent finish rates
- Resetting the diamond lowers the overall tooling cost

Used properly, the overall cost of a higher quality, resettable diamond will compare favorably with that of an inexpensive, non-resettable diamond. Initially, the best diamond point is selected for use. When returned, the next best diamond point is selected for resetting, and so on.

To ensure you get the best value for your diamond:

- Rotate the diamond tool ¼ turn periodically to maintain a sharp point
- Use proper flow of coolant to protect the diamond from heat which can create fracturing of the diamond
- Excessive wear on the diamond point may impact the ability to reset the diamond. The widest point of the diamond is referred to as the girth. The diamond girth is buried in a powder metal matrix. Using a diamond into the girth zone might impact the ability to reset other diamond points



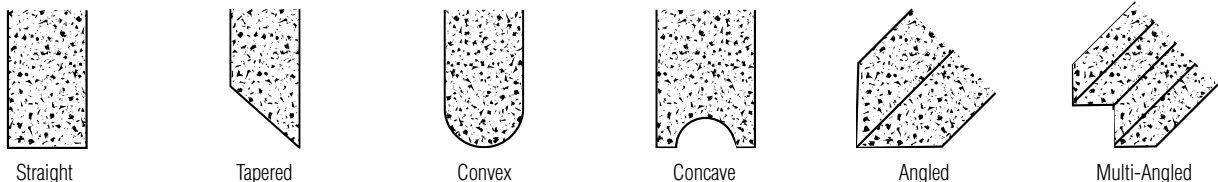
TECH TIP

Selecting the Correct Diamond Tool

To determine the type of dressing tool to use, it is best to think about the desired shape of the wheel face. Finished wheel face shapes are generally categorized into six types, as illustrated below.

Typical Wheel Forms Dressed by Stationary Diamond Tools

Look for the applicable wheel forms beside each product type to help you choose the correct product for your application.





Single Point Tools

Our Norton Winter line of single point tools is used in straight and simple form dressing applications. It includes: resettable and non-resettable products, tools for all abrasive types (conventional and advanced ceramic grains) and the technology-leading "Indexable" tool design.

Wheel Forms Dressed by These Tools



STRAIGHT



TAPERED



CONVEX

SPEC CHECK

Selection Guide

Stock Tools for Ceramic Abrasive Wheels

SG/Ceramic Engineered for use on ceramic (SG, NQ, Targa, etc.) wheels but may also provide significant benefits when used on conventional abrasive products. These tools are furnished with top quality specially selected diamonds.

BCSG/Ceramic Economical alternative to an "SG" tool. Best choice when a disposable tool is preferred.

Stock Tools for Conventional Abrasive Wheels

NS Engineered for use on conventional abrasives. These high quality, value-priced tools can be used for a variety of dressing applications.

BC Economical alternative to an "NS" tool. Best choice when a disposable tool is preferred.

Selecting the Correct Single Point Tool:

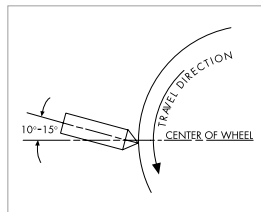
- Identify the wheel abrasive type: aluminum oxide, silicon carbide, or ceramic
- Determine the wheel diameter – to select the optimum carat weight
- Determine the tool holder size – to select appropriate shank diameter

Examples of Single Point Tool Selection

Conventional Wheel Spec:	32A46-IVBE 7" x 1/2" x 1-1/4"
	Machine has a 7/16" tool holder
Tool Selections:	Resettable: NS2M7 or NSUD2 (Indexable)
	Non-Resettable: BC2M7 or BCUD2 (Indexable)
Ceramic Wheel Spec:	5SG60-JVS or 5NQ60-IVS 10" x 1" x 3"
	Machine has a 3/8" tool holder
Tool Selections:	Resettable: SG3M6
	Non-Resettable: BCSG3M6

TECH TIP

- Rigidly mount single point tools at a 10° - 15° angle to the wheel centerline with a line drawn through the center of the wheel, pointing in the direction of wheel travel
- Point of contact should be slightly below centerline of wheel as shown
- Use coolant whenever possible
- Normal infeed is .001" per pass
- Lead selections range from .002" – .010" per wheel revolution
- Rotate the tool 1/4 turn periodically to maintain a sharp point



To optimize applications using ceramic abrasives and/or tools, normal dressing parameters must change. Reduce infeed by 25%. Significant reductions in the amount of infeed and frequency of dress will result in substantially lower cost per part ground.

Single Point Dress Traverse Rate

Select a Lead Value based on desired Surface Finish and run the formula below.

Finish	Lead Value (Per Wheel Revolutions)
For Coarse Finish (approx. 64 RMS)	.008" to .010"
For Medium Finish (approx. 32 RMS)	.005" to .009"
For Fine Finish (approx. 16 RMS)	.002" to .004"

Lead Value x Wheel Speed (RPM) = Traverse Rate in Inches/Minute

- Slower traverse rates result in a closed wheel face and lower surface finish readings on the workpiece.
- Faster traverse rates result in an open wheel face that produces greater stock removal and a rougher workpiece finish.



It is the user's responsibility to refer to and comply with ANSI B7.1

Single Point Tools for Truing/Dressing Ceramic Abrasives



SINGLE POINT TOOLS FOR SG/CERAMIC

- Specially selected broad-shaped, diamond withstands the increased grinding pressures of ceramic abrasives
- Each diamond is hand selected for stone shape, quality and structural integrity for consistent tool performance
- Multi-purpose - can accommodate most straight dressing and simple form dressing applications; stands up to the sharpness of ceramic abrasives (SG, Quantum, Targa, etc.) but can also be used to dress conventional abrasives

Resettable Single Point Tools for SG/Ceramic

- High quality diamond and a proactive resetting program will result in the lowest dressing cost per part for ceramic abrasives

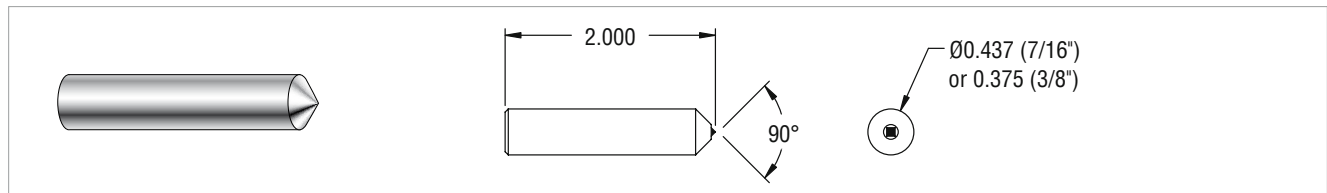
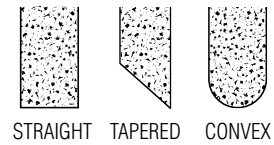
Non-Resettable Single Point Tools for BCSG/Ceramic

- The best selection for ceramic abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration

WHEEL DIAMETER	TOOL CARAT WEIGHT	TOOL DIAMETER	TOOL LENGTH	TIER: BEST		GOOD	
				PRODUCT #	3 SETTABLE PTS (2 RESETS) PART #	PRODUCT #	NON-RESETTABLE PART #
Stock Single Point Tools for Truing/Dressing Ceramic Abrasives							
Up to 7"	1/4 (.25)	3/8"	2"	SG2M6	662601 95365	BCSG2M6	662601 57007
		7/16"	2"	SG2M7	662601 95366	BCSG2M7	662601 56905
8" to 10"	1/3 (.33)	3/8"	2"	SG3M6		BCSG3M6	662601 57008
		7/16"	2"	SG3M7	662601 95368	BCSG3M7	662601 56906
11" to 14"	1/2 (.50)	3/8"	2"	SG5M6	662601 95369	BCSG5M6	662601 57009
		7/16"	2"	SG5M7	662601 95370	CSG5M7	662601 56907
15" to 20"	3/4 (.75)	7/16"	2"	SG7M7	662601 95372	BCSG7M	662601 56908
21"+	1 (1.00)	7/16"	2"			BCSG10M7	662601 57010

Standard Package = 1 tool

Wheel Forms Dressed by These Tools

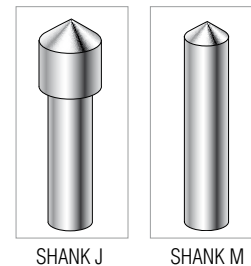


TECH TIP

Stock Single Point Tool Marking System

Diamond Quality	Diamond Size	Shank Design	Shank Diameter
SG/Ceramic	1 = 1/5 (.20) carat	M	6 = 3/8"
BCSG/Ceramic	2 = 1/4 (.25) carat	J	7 = 7/16"
NS	3 = 1/3 (.33) carat		
BC	5 = 1/2 (.50) carat		
	7 = 3/4 (.75) carat		
	10 = 1 carat		

Example: **NS 2 M 6**



Single Point Tools for Truing/Dressing Conventional Abrasives



SINGLE POINT TOOLS FOR CONVENTIONAL ABRASIVES

- Consistent diamond structure and shape for repeatable dressing performance on conventional abrasives
- Well defined, sharp, durable diamond point offers maximum cost effectiveness
- Steeper 60 degree angle head design allows for greater machine and part clearance to produce forms with tighter tolerances

Resettable NS (Norton Standard) Single Point Tools

- Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds

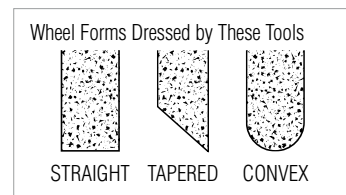
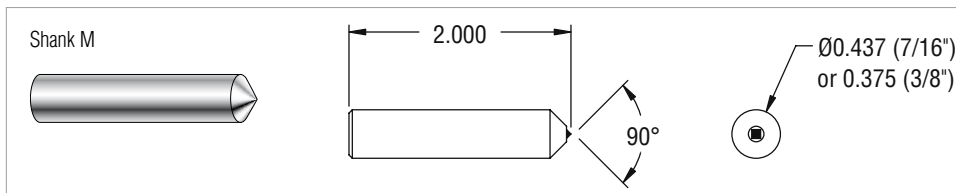
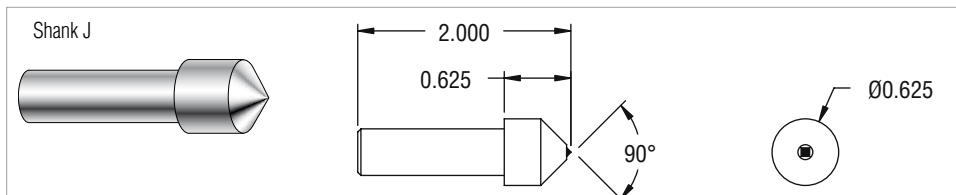
Non-resettable BC Single Point Tools

- The best selection for conventional abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration

		TIER: BETTER			TIER: GOOD		
		TRADENAME: NS (NORTON STANDARD)			TRADENAME: BC		
WHEEL DIAMETER	TOOL CARAT WEIGHT	TOOL DIAMETER	PRODUCT #	2 SETTABLE PTS (1 RESET) PART #	PRODUCT #	NON RESETTABLE PART #	
Stock Single Point Tools for Truing/Dressing Conventional Abrasives							
Internal Wheel	1/5 (.20)	3/8"			BC1M6	662601 95021	
		7/16"			BC1M7	662601 95022	
Up to 7"	1/4 (.25)	3/8"	NS2M6	662601 95116	BC2M6	662601 95000	
		7/16"	NS2M7	662601 95117	BC2M7	662601 95001	
8" to 10"	1/3 (.33)	3/8"	NS3M6	662601 95121	BC3M6	662601 95002	
		7/16"	NS3M7	662601 95122	BC3M7	662601 95003	
11" to 14"	1/2 (.50)	3/8"	NS5M6	662601 95126	BC5M6	662601 95004	
		7/16"	NS5M7	662601 95127	BC5M7	662601 95005	
15" to 20"	3/4 (.75)	3/8"			BC7M6	662601 95006	
		7/16"	NS7M7	662601 95132	BC7M7	662601 95007	
		7/16"	NS7J7*	662601 95130 NS			
21" +	1 (1.00)	3/8"			BC10M6	662601 95008	
		7/16"	NS10M7	662601 95137	BC10M7	662601 95009	
		7/16"	NS10J7*	662601 95135			

* J-shank tools are available in 7/16" diameter with 5/8" head. Standard Package = one tool

NS Non-Stock: Please contact your Norton representative for current lead-times.



Indexable Single Point Tools

Indexable tools are specifically designed to alleviate any misalignment issues and are the tools of choice for CNC grinders. They feature a two-part construction with the head and shank as separate pieces. After the initial installation, operators simply turn the indexable head with a wrench, while the tool shank remains secure (and aligned) in the tool holder.



INDEXABLE SINGLE POINT TOOLS

- These indexable tools are easily turned without having to remove the tool from the holder, making it easier to turn than conventional tools and increasing frequency of beneficial tool turning
- U-Dex-It and Mini-Dex tools have a 60° included angle head design providing additional form versatility through better machine and part clearance
- Offers an excellent choice for regulating wheels

Indexable Single Point Tools for Truing/Dressing Conventional Abrasives

Resettable NS (Norton Standard) Indexable Single Point Tools

- Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard

Resettable NS (Norton Standard) Mini-Dex Indexable Single Point Tools

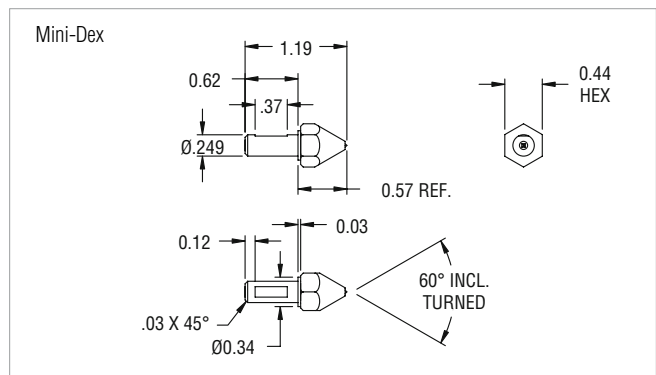
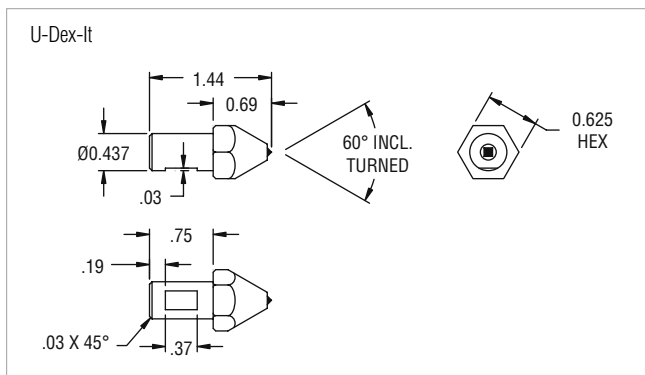
- Selection of the correct tool and a proactive resetting program will usually result in the lowest dressing cost per part on conventional abrasives with these value priced, high quality diamonds
- Use a standard 7/16" wrench to turn; designed for internal, bearing race, and twist drill flute machines

Non-Resettable Indexable Single Point Tools

- The best selection for conventional abrasives when a resetting program is not feasible or low initial cost is the primary purchasing consideration
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard

WHEEL DIAMETER	TOOL CARAT WEIGHT	TOOL SIZE	TIER: BETTER		GOOD	
			PRODUCT #	2 SETTABLE PTS (1 RESET) PART #	PRODUCT #	NON-RESETTABLE PART #
Stock Indexable Single Point Tools for Truing/Dressing Conventional Abrasives						
Up to 7"	1/4 (.25)	7/16" x 1-7/16" with 5/8" head			BCUD2	662601 95023
		1/4" x 1-3/16" with 7/16" head	NSMD2	662601 95171		
8" to 10"	1/3 (.33)	7/16" x 1-7/16" with 5/8" head	NSUD3	662601 95162		
11" to 14"	1/2 (.50)	7/16" x 1-7/16" with 5/8" head	NSUD5	662601 95163	BCUD5	662601 95025
15" to 20"	3/4 (.75)	7/16" x 1-7/16" with 5/8" head	NSUD7	662601 95164		

Standard Package = one tool



Indexable Single Point Tools for Truing / Dressing Ceramic Abrasives

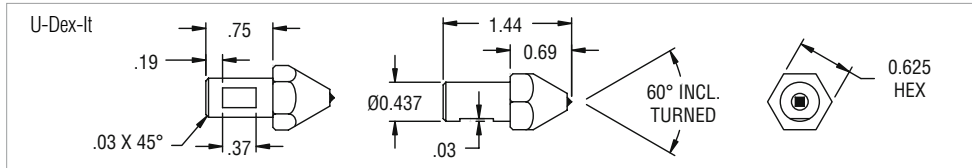
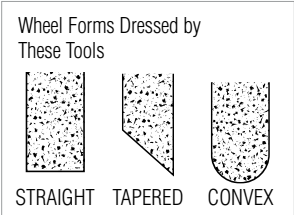
Non-Resettable Ceramic Indexable Single Point Tools

- U-Dex-It BCSG tool contain specially selected diamonds to withstand increased ceramic (SG, Quantum, Targa, etc.) grinding pressures
- Ideal for centerless grinders; using standard 5/8" wrench, the head can be turned through the hole in the side of the wheel guard without removing the guard
- The best selection when a resetting program is not feasible or low initial cost is the primary purchasing consideration

TIER: **GOOD**

WHEEL DIAMETER	TOOL CARAT WEIGHT	TOOL SIZE	PRODUCT #	NON-RESETTABLE PART #
Stock Indexable Single Point Tools for Truing/Dressing Ceramic Abrasives				
11" to 14"	1/2 (.50)	7/16" x 1-7/16" with 5/8" head	BCSGUD5	662601 59894

Standard Package = one tool



Internal Grinding Tools



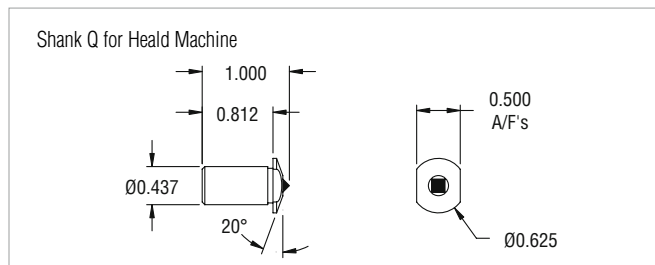
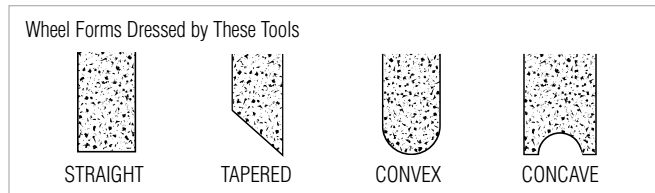
Resettable Tools For Internal Grinding

- Q style shank is used on a Heald internal grinder (resettable)

TIER: **BEST**

MACHINE TYPE	CARAT WEIGHT	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	2 SETTABLE PTS (1 RESET) PART #
Stock Internal Grinding Tools					
Heald	1/5 (.20)	7/16"	1"	NI21Q7	662601 95180

Standard Package = 1 Tool



Thread Grinding Tools



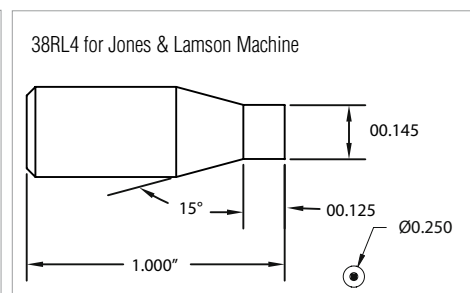
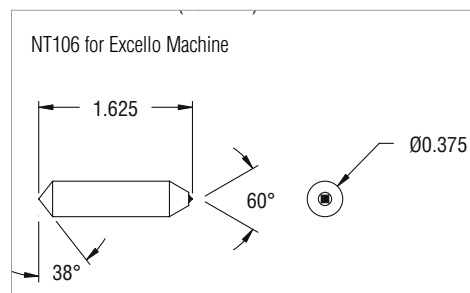
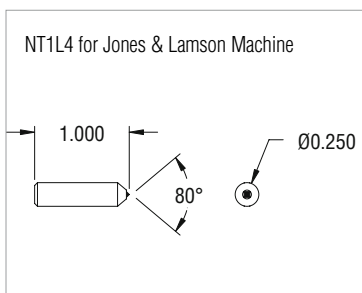
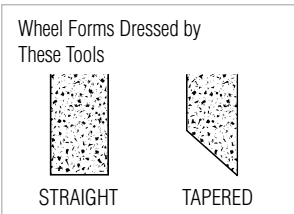
Thread Grinding Tools For SG / Ceramic Abrasives

- These wheels are used on J & L and Excello thread grinding machines to accurately dress the grinding wheels that form the desired thread configuration (non-resettable)

TIER: **BEST**

MACHINE TYPE	SHANK DIAMETER	TOOL LENGTH	INCLUDED ANGLE	MAX. RADIUS ON POINT	PRODUCT #	NON-RESETTABLE PART #
Stock Thread Grinding Tools						
J & L	1/4"	1"			38RL4*	662601 95100
J & L	1/4"	1"	80°	.010"	NT1L4	662601 95187
EXCELLO	3/8"	1-5/8"	60°	.010"	NT106	662601 95190

* 38RL4 is a multi-point (grit) 30 - 40 mesh tool
Standard Package = 1 Tool





Toolroom Tools

Norton Winter Toolroom Dressing Tools are primarily used on surface grinders to form the grinding wheel to an exact concave or convex radius. Although some tools are designed for use on a specific machine, many radius tools can be used on any grinder having the correct set-up.

Used generally on 8" diameter and smaller vitrified toolroom wheels, our Norton Winter offering includes phono-point, conventional radius, and full ball radius tools.

Wheel Forms Dressed by These Tools



STRAIGHT



CONCAVE

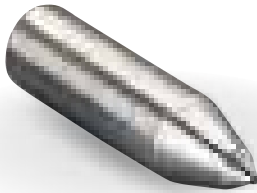


CONVEX



MULTI-ANGLED

Phono-Point Tools

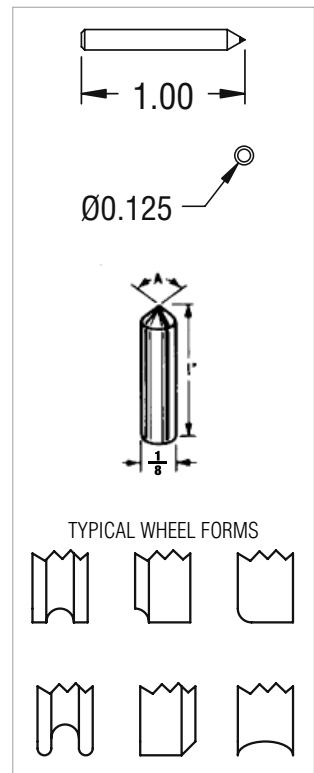


Non-Resettable Phono-Point Tools

- For general toolroom concave and convex dressing on small diameter grinding wheels

INCLUDED ANGLE	SHANK DIAMETER	TOOL LENGTH	TIER: BETTER		GOOD	
			PRODUCT #	NON-RESETTABLE PART #	PRODUCT #	NON-RESETTABLE PART #
Stock Phono-Point Tools						
60°	1/8"	1"	NP1M2	662601 95225	BCPP-60	662601 95017
	3/16"	1"	NP1M3	662601 95226		
	1/4"	1"	NP1M4	662601 95227		
75°	1/8"	1"	NP2M2	662601 95228	BCPP-75	662601 95018
	1/4"	1"	NP2M4	662601 95230		
90°	1/8"	1"	NP3M2	662601 95231	BCPP-90	662601 95019
	3/16"	1"	NP3M3	662601 95232		
	1/4"	1"	NP3M4	662601 95233		

Standard Package = one tool



Wheel Forms Dressed by These Tools



CONVEX



CONCAVE

SPEC CHECK

Phono-Point Tool Marking System

Diamond Type	Included Angle On Diamond	Shank Style	Shank Diameter
NP	1 = 60°	M	2 = 1/8"
BCPP	2 = 75°		3 = 3/16"
	3 = 90°		4 = 1/4"

Example: **NP 1 M 3**

TECH TIP

How to Use Toolroom Tools

- We recommend dressing with coolant. However, if dressing totally dry, allow three to five seconds between passes for diamond to cool.
- Use extremely light cuts from .0002" to .001" maximum.
- Rotate tool if the application and set-up allow.
- Custom Full Ball Radius Tools should be returned for relap after minimum wear.

Radius Tools

Concave Radius Tools

- This line offers a specially-shaped single point diamond, designed for forming concave radii on small diameter grinding wheels; not resettable.

Convex Radius Tools

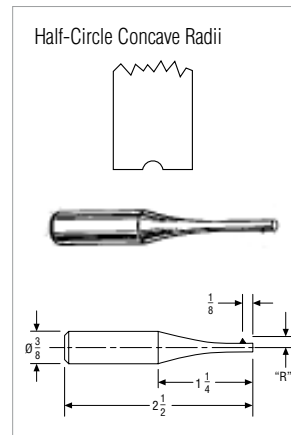
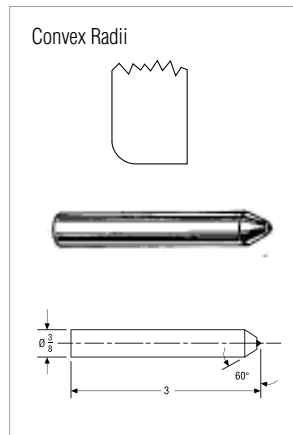
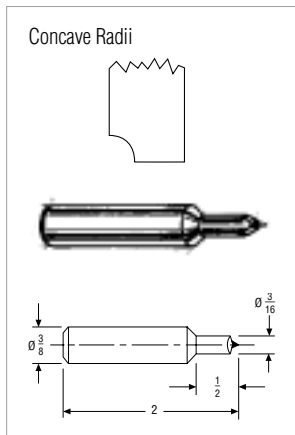
- This line offers a specially-shaped single point diamond, designed for forming convex radii on small diameter grinding wheels; not resettable.

Half-Circle Concave Radius Tools (Available as Non-stock Only)

- This line offers a specially-shaped diamond set in the side of the shank for forming half-circle radii on small diameter grinding wheels.
- The tool is rotated to form the radius. Commonly called a "rat tail dresser"; not resettable.

RADIUS SIZE TO BE DRESSED	SHANK DIAMETER	TOOL LENGTH	TIER: BEST		GOOD	
			PRODUCT #	NON-RESETTABLE PART #	PRODUCT #	NON-RESETTABLE PART #
Stock Concave Radius Tools						
.010" to .015"	3/8"	2"	NR1P6	662601 95210		
.016" to .020"	3/8"	2"	NR2P6	662601 95211		
.021" to .032"	3/8"	2"	NR3P6	662601 95212		
.033" to .062"	3/8"	2"	NR4P6	662601 95213	BCRD	662601 95016
.063" to .125"	3/8"	2"	NR5P6	662601 95214	BCRD	662601 95016
.126" to .250"	3/8"	2"	NR6P6	662601 95215	BCRD	662601 95016
Stock Convex Radius Tools						
.020" to .125"	3/8"	2"	NR2M6	662601 95216		
.126" to .250"	3/8"	2"	NR12M6	662601 95217		

Standard Package = one tool



Full-Ball Radius Tools for precision plunge form dressing of concave radii in the center of a grinding wheel are available made to your custom requirements. Ask your Norton representative for details.



Multi-Point (Grit) Tools

Since Norton Winter conventional and high-performance Multi-Point tools never need turning or resetting, they are the most economical way to accomplish a variety of straight, tapered, and step dressing operations on all sizes of cylindrical, centerless, surface, and toolroom grinding wheel applications.

Wheel Forms Dressed by These Tools



STRAIGHT



TAPERED

SPEC CHECK

Selection Guide

- Identify the wheel abrasive type: ceramic (SG, Quantum, Targa), aluminum oxide, or silicon carbide
- Determine the wheel diameter and grit size
- Determine the tool's approach angle to the centerline of the wheel
- Identify the tool holder diameter
- Use 1E shape for angular wheel slide, cylindrical grinding and for shoulder or step truing

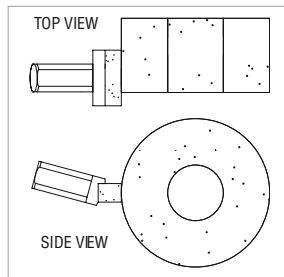
Examples of Multi-Point Tool Selection

Conventional Wheel Spec:	32A46-IVBE 7" x 1/2" x 1-1/4" Machine has a 3/8" tool holder
Tool Selection:	1R6J6
Ceramic Wheel Spec:	5SG60-JVS or 5NQ60-IVS 10" x 1" x 3" Machine has a 7/16" tool holder
Tool Selections:	SG1R6J7

TECH TIP

Multi-Point Tools – Straight Face Dressing and Truing

- Most multi-point tools are used for straight face dressing
- Tool should have full face contact with the wheel
- With new tool, 3–5 passes at .005" per pass should be taken to expose diamonds
- Infeed per pass .001" – .002"
- Use coolant whenever possible
- Use appropriate lead (and traverse rate)
- Contact your Norton representative for proper tool selection for Targa wheels



Multi-Point Dress Traverse Rate

Select a Lead Value based on desired Surface Finish and run the formula below.

FINISH	LEAD VALUE (PER WHEEL REVOLUTIONS)
For Coarse Finish (approx. 64 RMS)	.023" to .030" (.58mm – .76mm)
For Medium Finish (approx. 32 RMS)	.013" to .022" (.33mm – .57mm)
For Fine Finish (approx. 16 RMS)	.006" to .012" (.15mm – .33mm)

Lead Value x Wheel Speed (RPM) = Traverse Rate in Inches/Minute

- Slower traverse rates result in a closed wheel face that produces less stock removal and improved workpiece finish.
- Faster traverse rates result in an open wheel face that produces greater stock removal and a rougher workpiece finish.



It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Optimizing SG Multi-Point Tool Performance

- To optimize applications using ceramic abrasives/tools, normal dressing parameters must change. Significant reductions in the amount of infeed and frequency of dress will result in significantly lower cost per part ground.
- While all SG/Ceramic tools have been designed to improve the efficiency of ceramic grinding applications, they can also offer significant benefits in many applications using conventional abrasives.
- When first using a SG/Ceramic tool, make 3 to 5 passes at .005" infeed to ensure full face contact between the dressing tool and wheel face.
- Reduce normal dressing infeed by half. Do not exceed infeed of .002" per pass.
- The lead selection should be between .006"–.030" per wheel revolution. Faster traverse with a SG/Ceramic tool generally provides an open wheel face that can maximize productivity of the ceramic abrasive.

TECH TIP

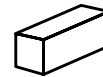
Multi-Point Tool Diamond Section Specifications

SHAPE	WIDTH	LENGTH	DEPTH	TOOL APPROACH ANGLE TO WHEEL	FOR WHEEL DIAMETER
1A	1/4"	3/4"	5/16"	0°	Over 20"
2A	1/4"	1/2"	3/8"	0°	15" – 20"
3A	5/32"	3/8"	1/4"	0°	Over 20"
1E	5/32"	3/8"	5/16"	–	
2E	1/4"	1/2"	1/2"	–	20" x 2" and up
1R	1/4" Round		1/4"	0°	Up to 10"
2R	3/8" Round		3/8"	0°	11" – 14"

Multi-Point Tool Marking System

Diamond Shape	Tool Diamond Size	To Dress Grinding Wheels With Grit Size Of:	Shank Design	Shank Diameter
1A	4	= 46 grit	See the following pages for shank configurations	6 = 3/8"
2A	6	= 54 - 100 grit		7 = 7/16"
3A	8	= 120 - 150 grit		8 = 1/2"
1E	12	= 150+ grit		
2E	14	= Special Applications		
1R				
2R				

Example: **1A 6 A 7**



Shape A is used primarily for straight face dressing.



Shape E (double angle top face) [is used for standard N-Face wheels, angular wheels, face and side truing of cylindrical wheels, and in step dressing.



Shape R is used for straight face dressing where the tool holder is perpendicular to the wheel face (no drag angle), and on thread grinding machines.

Multi-Point Tools for Straight Dressing

SG MULTI-POINT TOOL SHAPE AND SHANK AVAILABILITY

SHAPE SG1A SHANK A	SHAPE SG1A SHANK C	SHAPE SG2A SHANK D
SHAPE SG2A SHANK E	SHAPE SG1R SHANK J	SHAPE SG2R SHANK K

CONVENTIONAL TOOLROOM MULTI-POINT TOOL SHAPE AND SHANK AVAILABILITY

SHAPE 1A BC-60	SHAPE 1A BC-61	SHAPE 2A BC-62
SHAPE 2A BC-63	SHAPE 1R BC-64	SHAPE 1R BC-65

CONVENTIONAL ABRASIVE MULTI-POINT TOOL SHAPE AND SHANK AVAILABILITY

SHAPE 1A SHANK A	SHAPE 1A SHANK B	SHAPE 1A SHANK C	SHAPE 2A SHANK D	SHAPE 2A SHANK E	SHAPE 3A SHANK F
SHAPE 3A SHANK G	SHAPE 1E SHANK F	SHAPE 1R SHANK J	SHAPE 2R SHANK K	SHAPE 3R SHANK L	

Shapes 3A (F and G Shanks) are used for form, shape, and step truing. Shape 1E is used for angle dressing



MULTI-POINT TOOLS

- Uniformly distributed diamonds in a tough, durable matrix for consistent performance throughout tool life
- Fresh, multiple diamond points exposed in truing operation; no turning or resetting required for faster, more consistent straight face dressing and longer tool life than single point tools
- Overall diamond weight exceeds equivalent single point tool making this the most economical way to dress straight and tapered forms

Multi-Point Tools for Truing and Straight Dressing

Multi-Point Tools For SG/Ceramic Abrasives

- Designed specifically for use on ceramic (SG, Quantum, Targa, etc.) abrasives, SG tools contain a higher diamond concentration to withstand the increased grinding pressures generated by the ceramic abrasives
- These tools have improved life and dress quality; they can also offer significant benefits in many applications when used on conventional abrasives

Standard Multi-Point Tools

- The ideal selection for use on conventional abrasives in high-production applications

BC Multi-Point Tools

- General-purpose tools ideal for conventional toolroom applications with a specially selected diamond size for a broad range of dressing applications

		TIER: BEST		TIER: BETTER		TIER: GOOD	
		TRADENAME: SG/CERAMIC		TRADENAME: STANDARD		TRADENAME: BC	
WHEEL DIAMETER	WHEEL GRIT SIZE	TOOL APPROACH ANGLE	TOOL DIAMETER	PRODUCT #	PART #	PRODUCT #	PART #
Multi-Point Tools for Straight Dressing							
Up to 10"	54 to 100	0°	7/16"			1R6J7	662601 95088
		0°	3/8"			1R6J6	662601 95085
11" to 14"	54 to 100	0°	7/16"	SG2R6K7	662601 95378	2R6K7	662601 95096
15" to 20"	54 to 100	0°	7/16"	SG2A6D7	662601 95375	2A6D7	662601 95046
		15°	7/16"	SG2A6E7	662601 95376	2A6E7	662601 95049
21" +	120 to 150	0°	7/16"			2A8D7	662601 95047
		15°	7/16"			2A8E7	662601 95050
	46	15°	7/16"			1A4C7	662601 95038
		0°	7/16"	SG1A6A7	662601 95373	1A6A7	662601 95031
54 to 100	15°	7/16"			1A6B7	662601 95035	
	15°	7/16"	SG1A6C7	662601 95374	1A6C7	662601 95039	
	15°	7/16"			1A8C7	662601 95040	

Wheel Forms Dressed by These Tools



STRAIGHT

Standard Package = one tool

NS Non-Stock: Please contact your Norton representative for current lead-times.

Multi-Point Tools for Form, Shape, or Step Dressing Conventional Abrasives

		TIER: BETTER	
WHEEL DIAMETER	WHEEL GRIT SIZE	TOOL APPROACH ANGLE	TOOL DIAMETER
Stock Multi-Point Tools for Form, Shape, and Step Dressing			
All	54 to 100	0°	7/16"
		15°	7/16"

Standard Package = one tool

Wheel Forms Dressed by These Tools



STRAIGHT



TAPERED

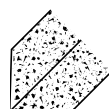
		TIER: BETTER	
WHEEL DIAMETER	WHEEL GRIT SIZE	TOOL APPROACH ANGLE	TOOL DIAMETER
Stock Multi-Point Tools for Angular Dressing Conventional Abrasives			
All	54 to 100	0°	7/16"

Standard Package = one tool

Wheel Forms Dressed by These Tools



TAPERED



ANGLED



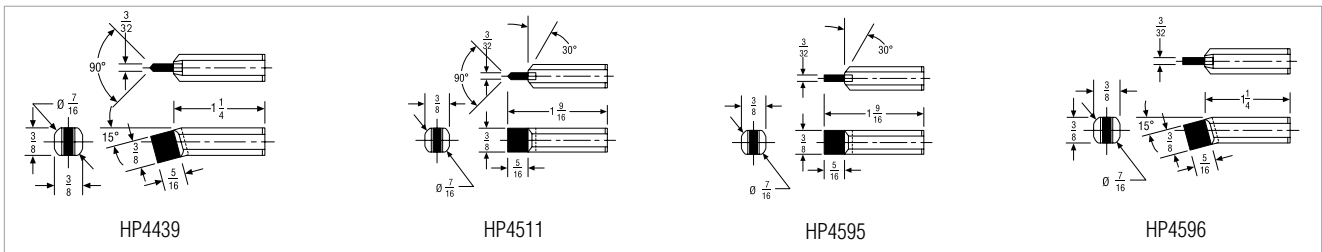
High Performance Grit Tools

Norton Winter High Performance grit tools are used in the same manner as multi-point tools, but are designed to produce a superior finish. They are used on 120 - 150 grit wheels. The traverse rates are equal to or faster than ordinary tools. Mounted on standard shanks, standard High Performance grit tools have a 3/8" wide by .100" thick diamond impregnated blade with a greater number of sharp points than in ordinary multi-point tools.

Since High Performance grit tools contain a higher concentration of diamond than found in standard multi-point tools, they are well suited for ceramic abrasive applications.

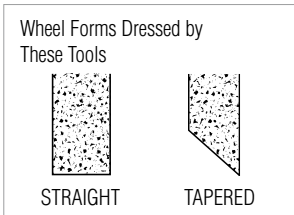
Typical Machines and Applications

- HP4439: cylindrical machines, grinding thrust walls, bearing diameters and multi-diameter shafts with radii
- HP4511: angular machines plunge grinding multi-diameter shafts and plunge grinding on dual-wheel forms
- HP4595: cylindrical machines grinding main bearing and lobes on camshafts
- HP4596: centerless machines step grinding and machines dual-wheel grinding transmission shafts



TIER: BEST					
WHEEL DIAMETER	WHEEL GRIT SIZE	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	PART #
Stock High Performance Grit Tools					
Up to 20"	120 to 150	7/16"	1-9/16"	HP4439	662601 95270
Up to 20"	120 to 150	7/16"	1-9/16"	HP4511	662601 95271
Up to 20"	120 to 150	7/16"	1-9/16"	HP4595	662601 95272
Up to 20"	120 to 150	7/16"	1-9/16"	HP4596	662601 95273

Standard Package = one tool

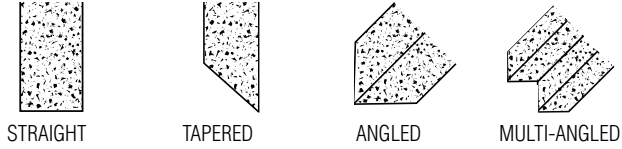




Blade Tools

With the choice of natural and synthetic diamond in three performance/price tiers, blade tools can meet all your angle, step, and radius dressing requirements for cylindrical, surface, and centerless grinding.

Wheel Forms Dressed by These Tools



Synthetic Blade Tools – For USB and Quantum

- Synthetic diamond with a controlled diamond shape provides a constant cross section of diamond to the wheel throughout the life of the tool
- Provides consistent wheel conditioning from the first dress to last; economical, long-lasting alternative to chisel-type tools for centerless form grinding
- USB (made-to-order) - for dressing aluminum oxide wheels; Quantum (made-to-order) - for dressing ceramics and silicon carbide wheels

Multi-Cut Blade Tools (Available in Stock and Made-To-Order)

- Manufactured with top quality natural or processed elongated diamond
- Customizable diamond type depending on wheel specification and application requirements
- Durable performing tools in a medium price range

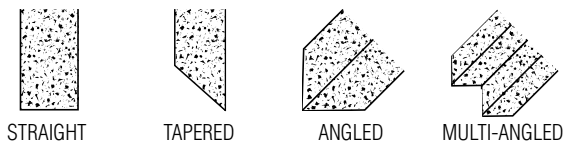
		TIER: BEST			BETTER	
		TRADENAME: SYNTHETIC BLADE TOOLS			MULTI-CUT TOOLS	
WHEEL DIAMETER (WIDTH <= 9")	TOOL APPROACH ANGLE	SHANK DIAMETER	PRODUCT #	PART #	PRODUCT #	PART #
Blade Tools						
12" to 17"	0°	7/16"	NQ20A7	079587 47944 NS		
	15°	7/16"	NQ215A7	079587 47945 NS	MC355	662601 95266
18" to 29"	0°	7/16"	NQ30A7	079587 47946 NS		
	15°	7/16"	NQ315A7	079587 47947 NS		
30" - 36"	0°	7/16"	NQ50A7	079587 47948 NS		
	15°	7/16"	NQ515A7	079587 47950 NS		

These stock tools are composed of 1 layer with 3 diamonds. These tools are not resettable or relappable.

NS Non-Stock: Please contact your Norton representative for current lead-times.

Standard Package = one tool

Wheel Forms Dressed by These Tools



Form Tools

Norton Winter Form Tools have diamond lapped to specific angles and radii required for a particular application, machine, contour dressing system, or CNC operation. Due to the high degree of accuracy necessary, the diamond is of special shape and quality.

Used tools can be relapped - the tip geometry can be restored on worn tools at a reduced cost.

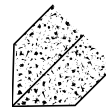
Wheel Forms Dressed by These Tools



CONVEX



CONCAVE



ANGLED



MULTI-ANGLED

TECH TIP

How to Use Form Dressing Tools

- Proper centerline and light infeeds are essential to minimize side pressure. Excessive pressure will cause the diamond to fracture.
- Cone point tools should be rotated approximately 1/4 turn daily.

Ask your Norton representative for information on our made-to-order form tools for the following machines:

- Jones & Lamson
- Moore Pantograph
- Hoglund
- Dia-Form

Cone Point Tools



CONE POINT TOOLS

- Norton Winter vacuum braze technology used in the manufacturing surpasses all traditional diamond retention methods
- Absolute diamond retention, diamond pullout prevention during the dressing cycle, and longer tool life through multiple relaps
- Diamond is accurately coned to the specific included angle and radius making these tools ideal when the most intricate, precise forms and radii are required

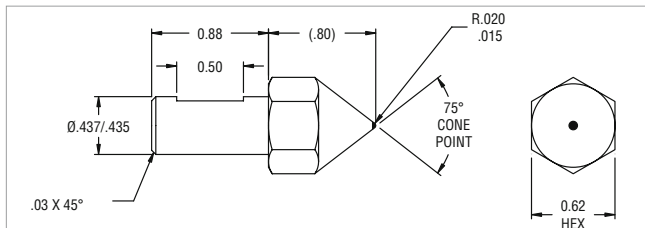
U-Dex-It Cone Point Tool

- Used for precision dressing of intricate forms and radii
- Specially designed with 5/8" indexable head for easy turning during use
- These tools can be relapped

TIER: **BEST**

INCLUDED ANGLE ON DIAMOND	RADIUS ON DIAMOND	TOOL CARAT WEIGHT	SHANK DIAM.	TOOL LENGTH	PRODUCT #	RELAPPABLE PART #
75°	.020"	.50	7/16"	1.678"	CPUD720-7	66260158981

Standard Package = one tool



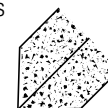
WHEEL FORMS DRESSED BY THESE TOOLS



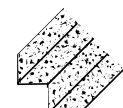
CONVEX



CONCAVE



ANGLED



MULTI-ANGLED

SPEC CHECK

Cone Point Tool Marking System

Tool Type	Included Angle On Diamond	Radius On Diamond	Carat Weight	Shank Diameter
CP	6 = 60°	05 = .005"	L = .10 - .15	6 = 3/8"
	7 = 75°	10 = .010"	M = .20 - .25	7 = 7/16"
	9 = 90°	15 = .015"	H = .33	
		20 = .020"	X = .50	
		25 = .025"		
		30 = .030"		

Example: **CP 6 10 M-6**

Cone Point Tools

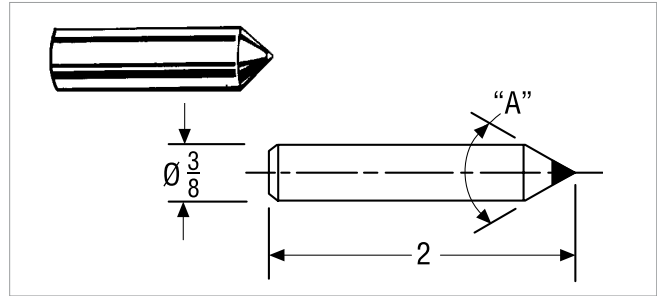
Standard Cone Point Tool

- These tools are used for precision dressing when the most intricate forms and radii are required; can be relapped

TIER: **BEST**

INCLUDED ANGLE ON DIAMOND	RADIUS ON DIAMOND	TOOL CARAT WEIGHT	SHANK DIAM.	TOOL LENGTH	PRODUCT #	RELAPPABLE PART #
60°	.010"	.20 - .25	3/8"	2"	CP610M-6	662601 95240

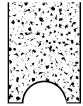
Standard Package = one tool



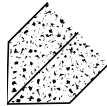
Wheel Forms Dressed by These Tools



CONVEX



CONCAVE



ANGLED



MULTI-ANGLED

Chisel Point Tools

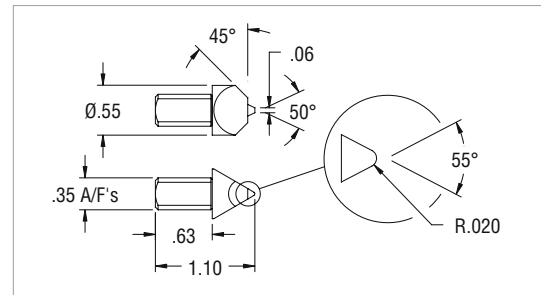
Chisel Point Tool for Toyoda Grinders

- High-precision chisel point tool designed for forming intricate shapes and radii
- Specifically engineered to fit Toyoda machine series GL32 and GL4, it can also be used on various straight and angle-head grinders – for dressing conventional and ceramic abrasive wheels, sizes 12" to 24"
- This tool can be reset/relapped

TIER: **BEST**

INCLUDED ANGLE ON DIAMOND	RADIUS ON DIAMOND	TOOL CARAT WEIGHT	SHANK DIAM.	TOOL LENGTH	PRODUCT #	RELAPPABLE PART #
55°	.020"	.75	7/16"	1.10"	CHT520-7	662601 03741

Standard Package = one tool



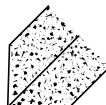
Wheel Forms Dressed by These Tools



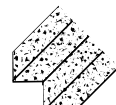
CONVEX



CONCAVE



ANGLED



MULTI-ANGLED

SPEC CHECK

Chisel Point Tool Marking System

Tool Type	Included Angle On Diamond	Radius On Diamond	Carat Weight	Shank Diameter
CH	6 = 60°	05 = .005"	L = .10 - .15	6 = 3/8"
(Natural)	7 = 75°	10 = .010"	M = .20 - .25	7 = 7/16"
Diamond)	9 = 90°	15 = .015"	H = .33	
		20 = .020"	X = .50	
		25 = .025"		
		30 = .030"		

Example: **CH 9 5 M-6**

TECH TIP

Chisel Point Tools

Chisel Point Tools should be rotated 180° when dulling or contour problems occur.



Cluster Tools

Norton Winter Cluster tools are designed specifically for straight face dressing of large diameter, coarse grit grinding wheels on single or double disc, centerless, or surface grinders.

Wheel Forms Dressed by These Tools



STRAIGHT TAPERED

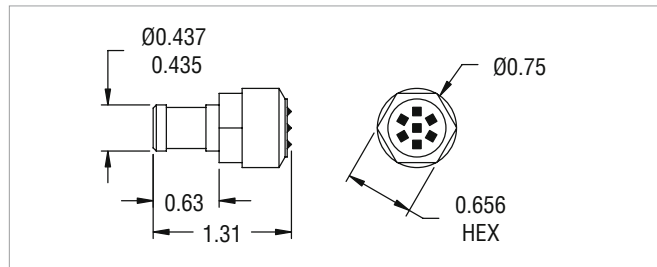
Multi-Point Cluster Tools

- Multi-Point Cluster tools are typically used for straight face dressing on disc and centerless operations
- For greatest efficiency, these tools should be mounted at a 15° angle so that three diamonds are in contact with the wheel face at all times
- The tool should be rotated at frequent intervals; not resettable

TIER: BETTER

DIAMONDS ON FACE	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	NON-RESETTABLE PART #
Stock Multi-Point Cluster Tools				
7	7/16"	1-5/16"	NC7K7	662601 95206

Standard Package = 1 Tool



Wheel Forms Dressed by These Tools



STRAIGHT TAPERED

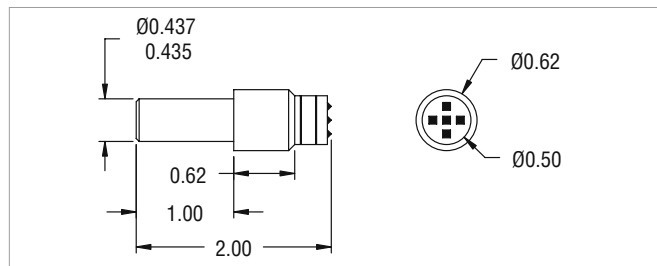
Dia-Pak Tools

- Dia-Pak tools are primarily used in straight face disc grinding, but are extremely versatile and may also be used in centerless and surface operations
- Designed for maximum economy, three layers of diamond are carefully arranged so that a new layer is exposed before the previous layer is completely worn away; not resettable

TIER: BETTER

FOR WHEEL DIAMETERS	DIAMONDS PER LAYER	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	NON-RESETTABLE PART #
Stock Dia-Pak Tools					
Up to 14"	5-4-5	7/16"	2"	DP20	662601 95200
Up to 20"	7-6-7	7/16"	2"	DP30	662601 95201
Any	7-6-7	7/16"	2"	DP35	662601 95202

Standard Package = 1 Tool



Wheel Forms Dressed by These Tools



STRAIGHT TAPERED

TECH TIP

Cluster and Dia-Pak Tools – Straight face dressing of hard / coarse wheels:

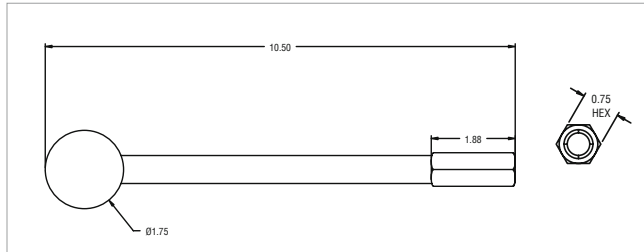
- Tool should approach the wheel at a 15° angle and be rotated periodically to keep three diamonds in contact with the wheel at all times.
- Tools can also be used at a 90° to the wheel face.
- Multi-Point Cluster tools should be rotated at frequent intervals.
- Infeed per pass should not exceed .0015" (.001" with ceramic – Norton SG, Quantum, Targa TG, etc. – wheels).
- Use coolant whenever possible.
- These tools permit a faster traverse rate providing a freer cutting wheel than when dressed by a single-point tool.



Tool Holder/Hand Dresser

- Designed for use when offhand truing and dressing on tool and cutter, or benchstand grinders.
- This stock hand dresser will not rust, and is 10-1/2" long, with a hollow shaft that accepts any tool shank length from 3/4" to 9". The 1-3/4" diameter plastic knob ensures a firm grip. The collet accepts a 7/16" diameter tool shank.

DESCRIPTION	PART NUMBER
Hand Dresser	662601 95020



Open or Closed Dressing... You Can Count on Fliesen Tools

Whether dressing a wheel OPEN or CLOSED you can count on Fliesen tools. Open wheels (sharp, free-cutting abrasive grains are exposed) are created by increasing the speed a Fliesen tool moves across the wheel when dressing. Generally considered the most favorable wheel conditioning, open wheels avoid workpiece burn while maximizing a wheel's ability to remove metal quickly when grinding.

Slowing a Fliesen tool as it moves across the wheel creates a closed wheel condition (abrasive grains are smoother, less sharp); a very helpful condition when trying to lower part surface finish readings.

- Harder, H-bond metal formulation tools have been specifically engineered to efficiently dress durable silicon carbide and ceramic wheels
- Furioso Fliesen tools have a unique bond system developed for optimal performance when dressing Norton Quantum (NQ) ceramic wheels
- W-bond Fliesen tools are designed for conventional aluminum oxide wheels



The Benefits of Fliesen Tools

Spend More Time Grinding

Single point, chisel, and cone point tools require operator attention to ensure proper tool rotation at regular intervals. Fliesen tools require no adjustments. Simply install the tool, dress the wheel to break it in, and the tool will do the rest. Operators spend more time grinding – rather than making non-productive dressing adjustments.

Longer Tool Life

Expect long life when using a Fliesen tool. Other stationary tools, made with a single diamond stone, develop flat spots ("wear flats") over time – which create chatter and burn. Fliesen tools use hand-set, fine diamond grit, eliminating the creation of wear flats.

Fliesen Tool Configurations: Plate and Shank

Fliesen tools are available in two basic tool configurations. The most common is a plate configuration, which is somewhat rectangular-shaped with a mounting hole. Fliesen shank tool configurations are plates mounted in shanks of varying sizes and shapes. Most grinding machines accommodate one or the other tool configuration. To find the correct tool configuration for your machine, check the existing dressing tool, or consult your grinding machine manual.

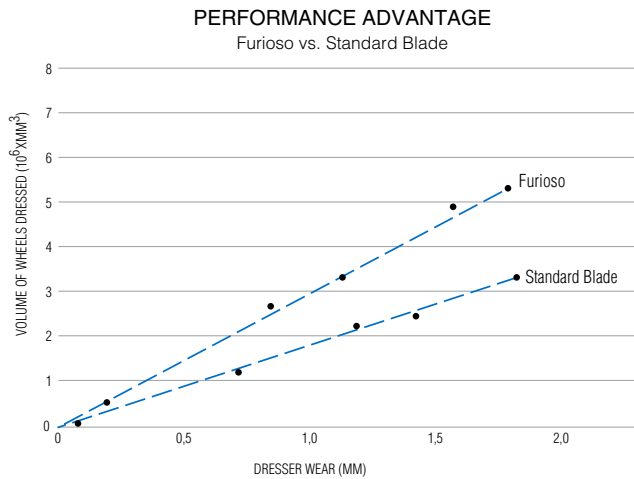
Choosing The Correct Fliesen Tool

Using the chart below, find your desired wheel form – then locate the preferred diamond position. Next, find the correct tool configuration for your machine: plate or shank tool. Follow down that column to find the Fliesen page for your plate or standard shank tool configuration. Go to the appropriate page. Locate the corresponding zone for your wheel diameter and width on the graph. Find that zone number in the part number chart. Next, moving to the right, find your wheel abrasive type and grit size. Locate the part number for your Fliesen tool.

Desired Wheel Form					
Diamond Positions	Blade Only FR	Side-Mounted FRS, FAS, FBS, FCS & FDS	Center-Mounted FAS, FBS, FCS & FDS	Double-Sided FCSD & FDSD	Twin FDST, FSST & 1TFAS
TOOL CONFIGURATION					
Plates	 Consult Customer Service	Page 296 – 297	Consult Customer Service	Consult Customer Service	Page 296– 297
Shank Tools	 Consult Customer Service	Consult Customer Service	Consult Customer Service	Consult Customer Service	Consult Customer Service

Furioso Tools

The new generation of highly wear-resistant stationary diamond dressing tools for dressing modern ceramic abrasives

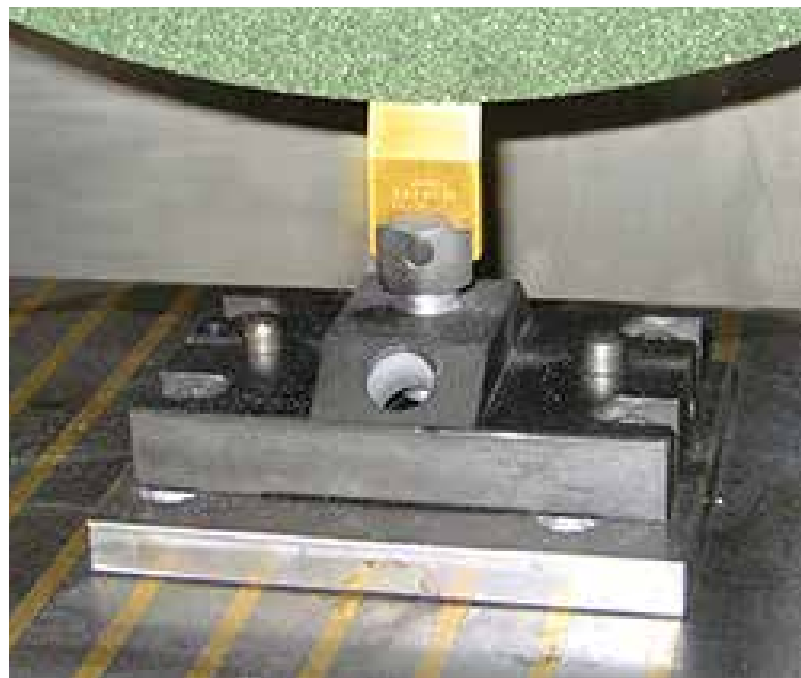
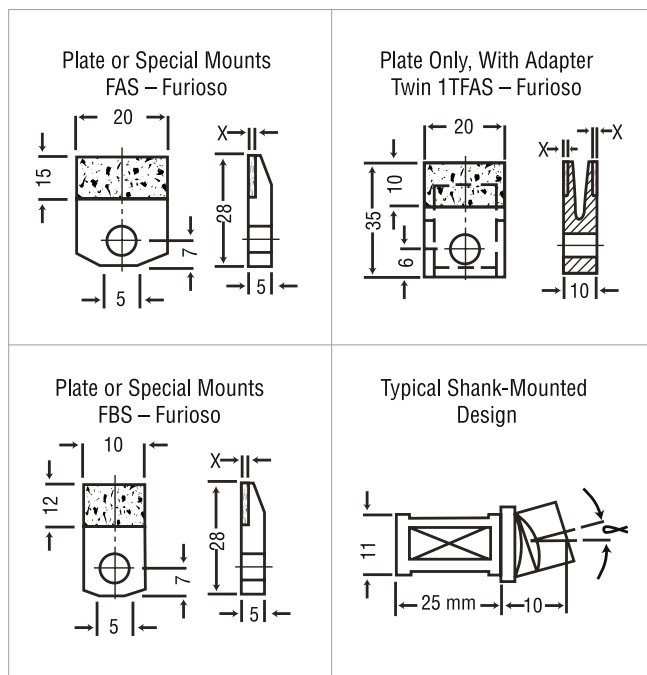


Best choice for optimum performance of Norton Quantum or other ceramic wheels

FLIESEN FURIOSO TOOLS

- The optimized combination of diamond quality, bond and setting pattern when dressing Norton Quantum (NQ) or other ceramic grinding wheels
- Improved wear-resistance and enhanced tool life; excellent dressing behavior with optimum consistency
- Constant surface roughness

Standard Furioso Plate Drawings



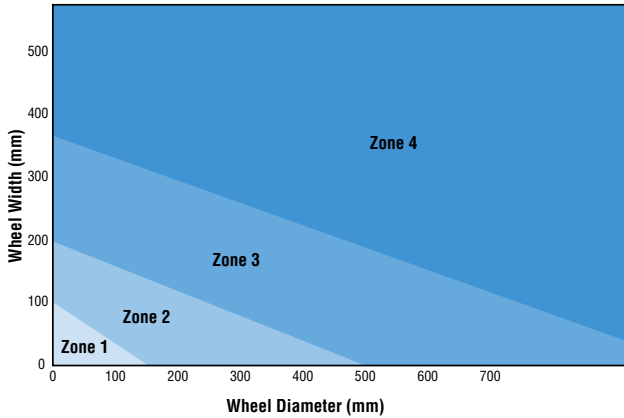
These three pages highlight a small sample of our Fliesen tool offering. Ask your Norton representative for complete product listing and information on these tools.

Furioso Plates; Side-Mounted and Twin




Use the Wheel/Tool Graph to identify your grinding wheel's Zone number, and the chart below to find the Furioso tool for your application.

Wheel / Furioso Tool Graph

Select Zone based on wheel diameter and width



TIER: **BEST**
TO DRESS: **NORTON QUANTUM NQ CERAMIC WHEELS**

ZONE NO. / SERIES	WHEEL GRIT SIZE	TOOL #	PART #	DESCRIPTION
Side-Mounted				
 Zone 2 FBS Series	36 - 54	DT1463	690141 22948 *	FBS 140 Furioso
	54 - 80	DT1462	690141 22947 *	FBS 115 Furioso
	120 - 180	DT1460	690141 22944 *	FBS 75 Furioso
 Zone 3 FAS Series	36 - 54	DT1467	690141 22952 *	FAS 140 Furioso
	54 - 80	DT1466	601576 90579 *	FAS 115 Furioso
	80 - 120	DT1465	601576 93885 *	FAS 90 Furioso
	120 - 180	DT1464	690141 22950 *	FAS 75 Furioso
Twin				
 Zone 4 1TFAS Series	36 - 54	DT1471	690141 22956 *	1TFAS 140 Furioso
	54 - 80	DT1470	690141 22955 *	1TFAS 115 Furioso
	80 - 120	DT1469	690141 22954 *	1TFAS 90 Furioso
	120 - 180	DT1468	690141 22953 *	1TFAS 75 Furioso

* All Furioso Plates shown ship in 10 business days from receipt of order.

SPEC CHECK

Blade Size

DESCRIPTION	DIMENSION
1 FBS	10 mm thick, 15 mm usable length
2 FAS	20 mm thick, 15 mm usable length
3 TFAS	Twin blade with cooling duct

Diamond Grit Size

DESCRIPTION	FEPA
140	D1181
115	D1001
90	D711
75	D501

Furioso Shank Tools

Made-to-order Furioso shank tools are also available. Ask your Norton representative for ordering assistance.

Side-Mounted Diamond Sections

Tools are available in different offset positions and angles.



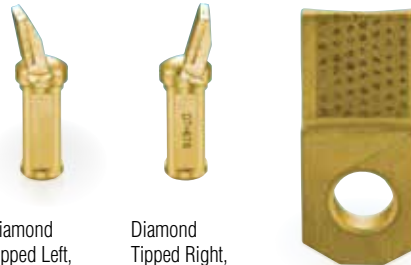
Offset Left,
Specify
angle amount

Zero Offset

Offset Right,
Specify
angle amount

Tipping the Diamond Plates on Shank Tools

Diamond sections can be tipped right or left.



Diamond
Tipped Left,
Specify angle

Diamond
Tipped Right,
Specify angle

There are many different diamonds making up a single plate as this cut-away view shows.



Norton Winter diamond rotary truing and dressing tools provide a very efficient way to modify the shape and topography of your grinding wheels.

Products:

- Form Rolls: Plunge Dressing
 - Infiltrated diamond form rolls
 - Reverse plated diamond form rolls
- Dressing Discs: CNC Traverse Dressing
 - Infiltrated dressing discs
 - BPR dressing discs (for dressing superabrasive wheels)
 - IDW dressing discs (for dressing superabrasive wheels)
- Truing and Dressing Spindles and Devices

Form Roll: Plunge Dressing

- Diamond roll geometry matches geometry of part to be ground
- Roll is fed into grinding wheel to generate the desired form and wheel surface condition
- Used where lowest cycle time and highest accuracy is required

Dressing Disc: CNC Traverse Dressing

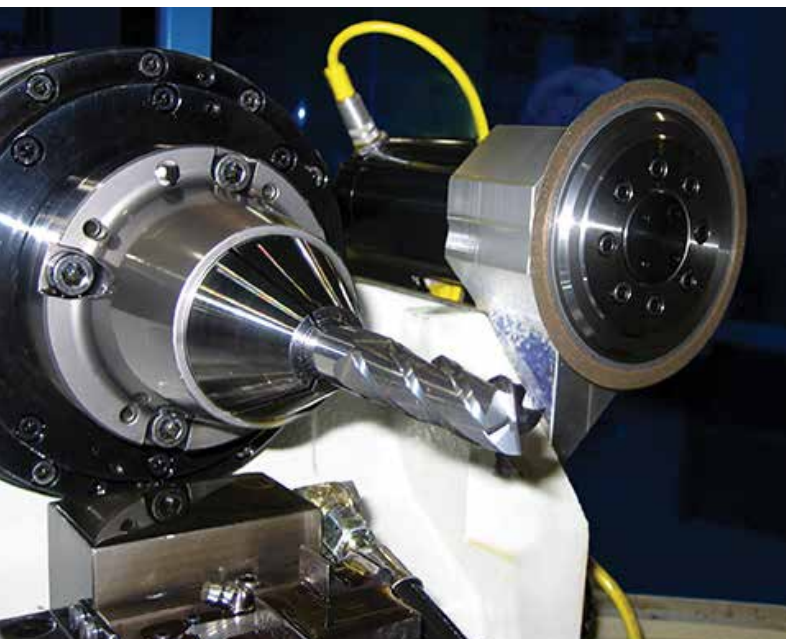
- Diamond dressing disc has a thin diamond section that is traversed across the face of the grinding wheel
- Profile is generated with a CNC program or template
- Used for simple profiles or where flexibility is necessary

How to Order Rotary Dressing Tools

Provide the following information to your local sales representative or customer service representative

Legible blueprint of roll, wheel, or part with the following geometry:

- Overall diameter
- Overall length
- Bore size and tolerances required
- Mounting pattern
- Any feature with tolerances less than 0.0002" (5 um) must be clearly defined for engineering review
- If designing from a part, a fully dimensioned part drawing is required
- Abrasive type (natural diamond, synthetic diamond, CVD stones, etc.)
- Specification of wheel to be dressed (need at least the grit type and size)
- Dressing type (Plunge or CNC Profiling)



Request the "Rotary Truing and Dressing" brochure, form # 8535, and contact your Norton representative for more information and expert assistance with your dressing operation.



Brake Controlled Truing Devices

Designed for truing diamond and cBN wheels rapidly, effectively, and with a minimum of superabrasive loss. Recommended for wheels up to 12" in diameter.

Applications:

- Truing straight, cup and cylinder wheels:
- Straight wheels, used on chip breaker, tool and cutter, surface, and cylindrical grinding machines
 - Cup wheels, used on vertical spindle surface grinders
 - Internal grinding wheels
 - Cut-off wheels



Norton Abrasives:
True to Form, Dress To Cut
nortonsga.us/qnfx2

Non-Stock 4597 Brake Controlled Truing Device

The 4597 is engineered for heavier and more frequent truing applications. The adjustable speeds allow for varying conditions (between 1050 and 1500 SFPM). It comes complete with a reusable case, two 3" 38A60-M8VBE* vitrified wheels, Truing Device Tips book and a dressing stick. It can be rebuilt using the 4597RK Rebuild Kit.

Worn #4597 Brake Controlled Truing Devices (UPC 662601**95350**) in need of reconditioning (beyond new shoes and springs) may be returned to be rebuilt. Contact Customer Service for return instructions and quote.

Stock 3597 Pacesetter Brake Controlled Truing Device

The Pacesetter model is ideal for light-duty use. The pre-set brake speed requires no adjusting. This model includes one 3" 38A60-M8VBE* vitrified wheel and can be rebuilt using the 3597RK Rebuild Kit.

Stock 4597RK and 3597RK Rebuild Kits

The truing devices can be rebuilt with these kits, consisting of 3 brake shoes, 3 springs, and 3 screws.

ITEM	TIER: BETTER		GOOD	
	PRODUCT NO.	PART #	PRODUCT NO.	PART #
Truing Devices				
4597 Brake Controlled Truing Device	4597	662601 95350 NS		
3597 Pacesetter Brake-Controlled Truing Device	3597	662601 35578		
Truing Device Rebuild Kits				
4597 Rebuild Kit	4597RK	662601 95351		
3597 Pacesetter Rebuild Kit	3597RK	662601 35595		
Replacement Wheels				
3 x 1 x 1/2			38A60-MVBE	662435 29145
			38A80-MVBE	662435 29146
			37C60-MVK	662435 29166
			37C80-HVK	662435 29170
			37C80-MVK	662435 29171
			37C100-HVK	662435 29172
			37C100-MVK	662435 29070

NS Non-Stock: Please contact your Norton representative for current lead-times.

SPEC CHECK

Truing Diamond and cBN Wheels

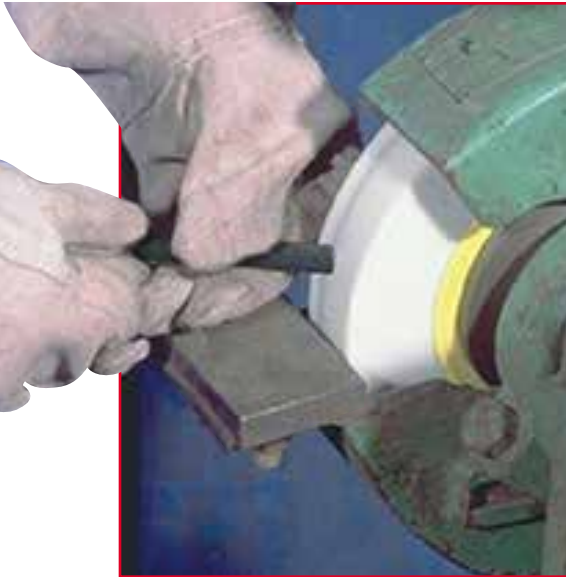
SUPERABRASIVE WHEEL	TRUING WHEEL SPECIFICATION
Resin and Vitrified Bond	
80, 100, and 120 grits	38A60-MVBE 37C60-MVK
150, 180, and 220 grits	38A80-MVBE 37C80-MVK
320 and finer grits	37C100-HVK
Metal Bond	
80, 100, and 120 grits	38A60-MVBE
150, 180, and 220 grits	38A80-MVBE
240 and finer grits	37C80-HVK

TECH TIP

- Prior to truing the wheel, run a wax crayon over the wheel face. Important: do NOT use any liquid-based ink on superabrasive wheels.
- Any crayon left on the wheel face after truing will reveal untrued areas.
- Indicate the superabrasive wheel runout before starting... usually within .001" to .002", to minimize wheel loss.
- Mount the device spindle parallel to the wheel spindle to ensure proper straight face truing.
- For cup-shaped wheels, the device spindle will be mounted perpendicular to the wheel spindle.
- Always use the brake-controlled truing device dry.
- Bring the diamond/cBN wheel and the truing wheel together until they almost touch.
- Start the diamond/cBN wheel to normal speed; spin the truing wheel in the same direction at point of contact.
- Bring the two wheels together until they touch.
- Make sure the truing wheel is spinning at time of contact.
- Traverse the wheel back and forth at 30 to 60 inches/minute.
- Downfeed .0005" to .001" at the end of each traverse.
- At the end of truing, the diamond/cBN wheel should be smooth and in truth.
- Apply a dressing stick to sharpen the wheel.



It is the user's responsibility to refer to and comply with ANSI B7.1



Regular use of properly selected dressing sticks will help you achieve maximum performance from your grinding wheels.

Applications:
Grit Range:
Abrasive Grain:
Shape:
Machine Used:

Truing, cleaning, and dressing diamond, cBN, and conventional abrasive grinding wheels
16 – 1200
Aluminum Oxide, Boron Nitride, Silicon Carbide
Square, rectangular, and round



HAND DRESSING

Grinding Wheel-to-Product Recommendation Guide

Selecting the appropriate dressing stick for each application depends on the wheel size, type, speed, specification, and grit size, as well as the workpiece material. Initial starting specifications are listed below. We recommend testing several sticks to find the best one for your application.



	Product	Specification
Superabrasive Wheels - Resin and Vitrified Bond		
- 80, 100, and 120 grits	Dressing Stick	38A150-HVBE
- 150, 180, and 220 grits	Dressing Stick	38A220-HVBE
- 320 and finer grits	Superfine Stick	NMVC400-J5VCA
Superabrasive Wheels - Metal Bond		
- 80, 100, and 120 grits	Dressing Stick	37C80-NV
- 150, 180, and 220 grits	Dressing Stick	37C150-KV
- 240 and finer grits	Dressing Stick	37C220-KV
Conventional Vitrified Wheels - Vitrified Bond		
- 46 grit and finer and M grade and softer	High Performance Dressing Stick	Norbide
	Conventional Dressing Stick	37C24-SVK

TECH TIP

Dressing Diamond and cBN Wheels

- Resin and Vitrified Bond Diamond, and cBN Wheels: choose a dressing stick one or two grit sizes finer than the abrasive in the wheel – in a soft grade (H or I)
- Metal Bond Diamond, and cBN Wheels: choose a stick the same grit size or one grit size coarser than the abrasive in the wheel – in a medium grade (K–M)



It is the user's responsibility to refer to and comply with ANSI B7.1

Offhand Grinding Wheel Dressing Stick and Holder

This convenient metal holder is widely used by mechanics and foundry-men for truing, dressing and changing the face of the wheel. The JT246 dressing stick – an extra coarse grit silicon carbide for dressing conventional vitrified wheels – is firmly held and adjusted by the knurled control.



SIZE (D x L)	SPEC.	STD. PKG.	TIER: BETTER	
			PRODUCT #	PART #
Offhand Grinding Wheel Dressing Stick and Holder				
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5	JT246	614636 87900
10 Overall	Dressing Stick Holder	5	H6	614636 87895

Norbide High-Performance Sticks

For offhand truing and dressing of medium grit, soft- and medium-grade conventional vitrified grinding wheels. Norton Norbide sticks are the hardest sticks you can buy. Made from boron carbide, they are well suited for dressing tool and cutter wheels 10" and smaller, especially cup and saucer shapes.

SIZE (T x W x L*)	STD. PKG.	TIER: BETTER	
		SPEC.	PART #
High Performance Long Life Stick			
1/4 x 1/2 x 3	5	Norbide	614636 10148

* Thickness x Width x Length

Vitrified Dressing Sticks

Aluminum Oxide (White)

For dressing and cleaning diamond and cBN superabrasive wheels.

Silicon Carbide (Black)

Coarse grit (16 - 46) and hard-grade (R and harder) sticks are used for dressing conventional vitrified wheels. Finer grit and softer grades are used for dressing diamond wheels.

SIZE (T x W x L)	TIER: BETTER		PART #
	STD. PKG.	SPEC.	
Vitrified Dressing Sticks – Aluminum Oxide			
3/8 x 3/4 x 4	5	38A150-IVBE	614636 39635
1/2 x 1/2 x 4	5	38A220-HVBE	614636 10555
1/2 x 1/2 x 6	5	38A150-IVBE	614636 10303
	5	38A220-HVBE	614636 10103
1/2 x 3/4 x 4	5	38A60-LVBE	614636 10415
1/2 x 1 x 4	5	38A180-IVBE	614636 99705
3/4 x 3/4 x 4	5	38A60-LVBE	614636 10440
	5	38A80-MVBE	614636 10362
	5	38A90-LV	614636 39632
	5	38A150-HVBE	614636 10291
	5	38A150-IVBE	614636 10368
	5	38A220-HVBE	614636 10290
3/4 x 3/4 x 8	5	38A220-HVBE	614636 10280
1 x 1 x 6	5	38A150-HVBE	614636 10405
	5	38A150-IVBE	614636 10453
	5	38A220-HVBE	614636 10406
1 x 1 x 8	5	38A120-IVBE	614636 10390
	5	38A150-IVBE	614636 10455

SIZE (T x W x L)	TIER: BETTER		PART #	
	STD. PKG.	SPEC.		
Vitrified Dressing Sticks – Silicon Carbide				
1/2 x 1/2 x 6	5	37C24-SVK	614636 10285	
	5	37C100-LV	614636 10201	
	5	37C150-KV	614636 10205	
	5	37C150-MV	614636 10207	
	5	37C220-KV	614636 10214	
	5	37C150-LV	614636 10375	
3/4 x 3/4 x 6	5	37C150-LV	614636 10375	
1 x 1 x 6	5	37C20-SVK	614636 10459	
	5	37C24-SVK	614636 10462	
	5	37C24-TVK	614636 10354	
	5	37C46-RVK	614636 10466	
	5	37C80-NV	614636 10393	
	5	37C150-KV	614636 10438	
	5	37C220-KV	614636 10398	
	1 x 1 x 8	5	37C24-SVK	614636 10471
	1 x 2 x 8	5	37C16-TVK	614636 10482
	5	37C24-TVK	614636 10485	
	2 x 2 x 8	5	37C24-SVK	614636 10490
	Vitrified Round Dressing Sticks – Silicon Carbide			
1/2 x 6	5	37C24-SVK	614636 10371	
1 x 6	5	S/C Ex-C (JT276)	614636 87905	

Vitrified Superfine Sticks


For dressing diamond and cBN superabrasive wheels.

SIZE (T x W x L)	TIER: BETTER		PART #
	STD. PKG.	SPEC.	
Vitrified Superfine Sticks – Aluminum Oxide			
1 x 1 x 6	5	PCD Coarse - 400 grit	614636 47865
	5	PCD Fine - 800 grit	614636 47867
1 x 1 x 8	5	NSA320-H8V	614636 10597
Vitrified Superfine Sticks – Silicon Carbide			
1/2 x 1/2 x 6	5	NMVC320-J5VCA	614636 10599
5	NMVC400-J5VCA	614636 50324	
1 x 1 x 6	5	NMVC320-J5VCA	614636 10605
	5	NMVC400-J5VCA	614636 50450

Organic Silicon Carbide Micro Dressing Wheel

Type 01 straight dressing wheels with sharp high-purity green silicon carbide abrasive.

For micro-dressing fine grit polyimide superabrasive diamond wheels.

SIZE (D x T x H)	MAX. RPM	MIN./STD. PKG.	SPEC.	TIER: BEST
				ABRASIVE: Silicon Carbide
				PART #
Type 01 Straight 				
200mm x 10mm x 31.75mm	2,870	5	320 Silicon Carbide Organic Micro Dressing Wheels	662532 96349*

* For fine grit diamond Polyimide wheels

TECH TIP

Additional Silicon Carbide Wheels for Dressing

- For additional silicon carbide wheels that can be used for dressing see page 258 in the Precision Grinding Silicon Carbide Toolroom Wheels section



It is the user's responsibility to refer to and comply with ANSI B7.1



Diamond and cBN Wheel Mounting, Truing and Dressing Guide

To achieve the best results using Norton Winter diamond and cBN products, the following steps for mounting, truing and dressing should be practiced:

MOUNTING – Putting Wheel on Machine Spindle

- Examine wheel flanges and spindle carefully.
- Be sure flanges' surfaces are clean and free of damage.
- Ensure that the mounting flanges are flat and of equal diameter, especially on wheels with rigid centers, such as vitrified bond wheels.
- Paper or plastic blotters should only be used when mounting superabrasive wheels with vitrified cores. Using paper or plastic blotters on any other core material might result in the wheel loosening during grinding.
- Inspect machine spindle for excessive runout.
 - » TIR (Total Indicated Runout) should be no greater than 0.0002".
- Mount wheel between hand-tightened flanges.
- Using a dial indicator, tap the wheel lightly with a rubber or wooden block to minimize runout to less than .0010".

TRUING – Making Wheel Round and Concentric with the Spindle Axis

- Prior to truing the wheel, run a wax crayon over the wheel face. Important: do not use any liquid-based ink on superabrasive wheels.
- Any crayon left on the wheel face after truing will reveal untrued areas.
- Indicate the superabrasive wheel runout before starting... usually within .001" to .002", to minimize wheel loss.
- Brake controlled truing devices are most commonly used to true Diamond and cBN straight, cup and cylinder wheels.
 - » Mount the device spindle parallel to the wheel spindle to ensure proper straight face truing.
 - » For cup wheels, the device spindle will be mounted perpendicular to the wheel spindle.
 - » Always use brake controlled truing device dry.

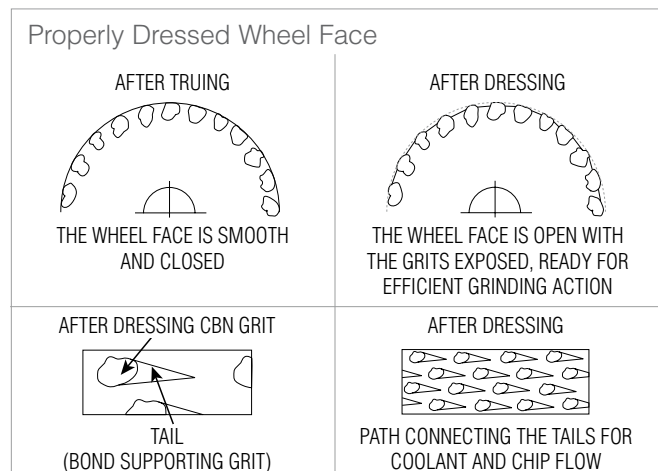
DRESSING – Opening the Face of a Trued Wheel

- Dressing the abrasive – a cleaning/sharpening process to expose sharp, free-cutting grit:
 - » For resinoid and vitrified bond wheels, the dressing stick should be one or two grit sizes finer than the abrasive in the diamond/cBN wheel – in a soft grade such as H or I.
 - » For metal bond wheels, choose a stick with the same grit or one grit coarser than the wheel abrasive – in a medium grade (K – N).
 - » See the "Dressing Stick" section for recommendations.

- Tighten flange securely and recheck with indicator.
- Allow a newly mounted wheel to operate for one full minute before grinding.
- The use of one permanent mounting for the life of the wheel is recommended whenever possible:
 - » If the grinding machine has a tapered spindle, mount each straight, flaring cup or dish wheel on a separate collet or adapter.
 - » When changing wheels the entire unit is removed, keeping the wheel in running truth.
 - » When needed again, the entire unit can be placed directly on the spindle or arbor, thereby eliminating the time and abrasive lost in retruing.

- » Bring the diamond/cBN wheel and the truing wheel together until they almost touch.
- » Start the diamond/cBN wheel to normal speed; start the truing wheel in the same direction.
- » Bring the two wheels together until they touch.
- » Make sure the truing wheel is spinning at time of contact.
- » Traverse the wheel back and forth at 30 to 60 inches per minute.
- » Downfeed .0005" to .001" at the end of each traverse.
- » At the end of truing, the diamond/cBN wheel should be smooth and in truth.
- » Apply a dressing stick to sharpen the truing wheel.

- Dressing the core – The core material (the part of the wheel that holds and supports the abrasive-bearing section) should never contact the work piece during grinding; rubbing will generate excessive heat. As the abrasive section of a cup wheel wears, the core material might become exposed, necessitating dressing.
 - » Use a single-point carbide or steel tool to dress an exposed resalloy core.
 - » Clamp the tool in a vise.
 - » Direct the cutting edge accurately to leave a 1/16" of abrasive section exposed.





setting a new
industry standard
FOR PRODUCTIVITY

From the most comprehensive stock offering to the industry's largest custom-manufactured availability, our Norton Winter superabrasive product portfolio gives you the most options with uncompromising performance.

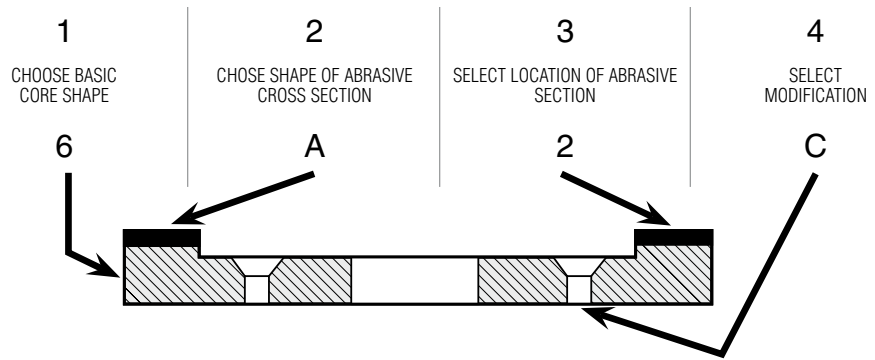
- Diamond / cBN Stock Wheels
- B99 Express Made-to-Order Resin Wheels
- CNC Wheels
- Electroplated Products
- Lapping Compound

The American Standard Code employs a series of numbers and letters to designate the shape of a diamond wheel. Its use involves four simple steps shown at right.

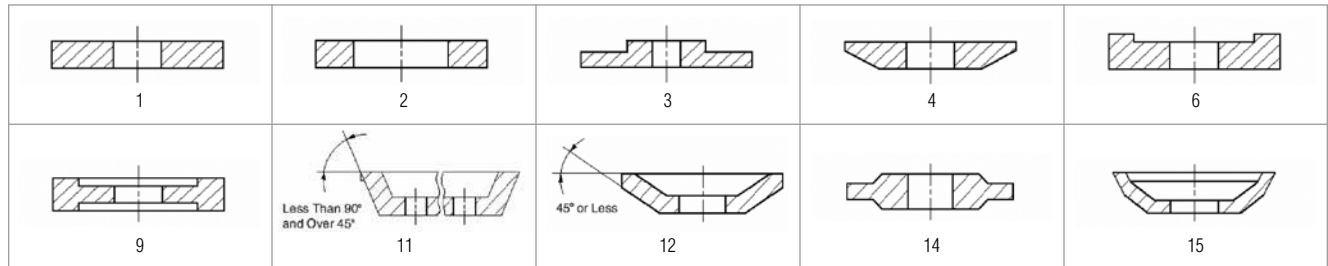
In this example, the complete wheel shape number would read:

6A2C

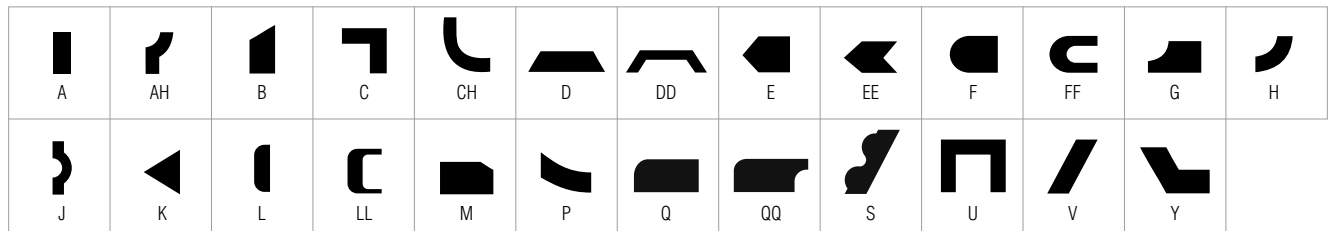
COURTESY OF ANSI



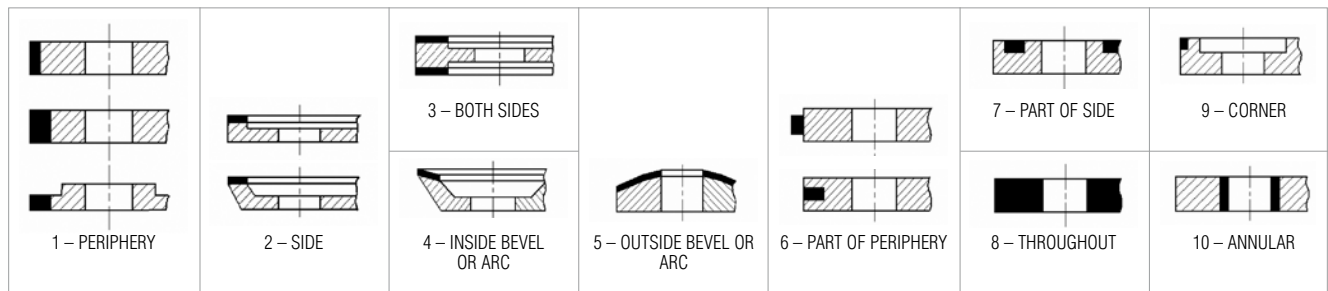
1. Basic Core Shapes and Marks



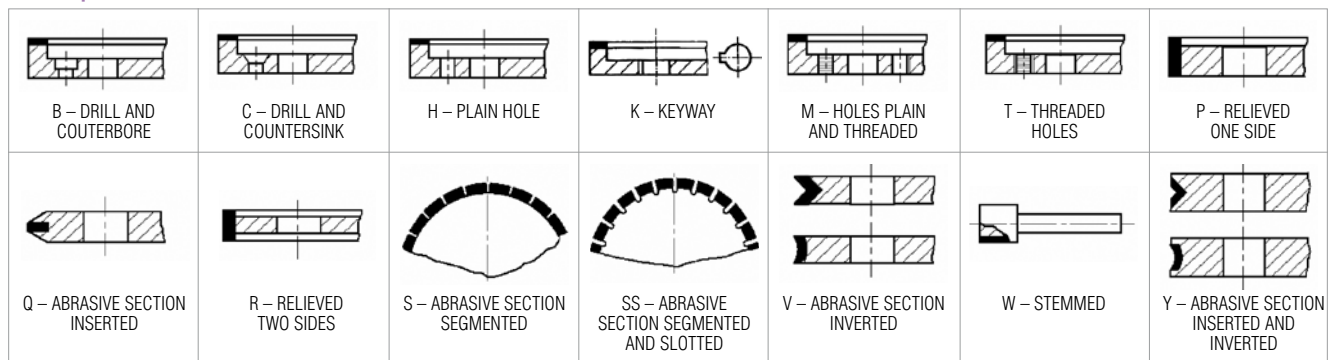
2. Abrasive Cross Sections and Marks



3. Location of Abrasive Section and Marks



4. Popular Modifications and Marks



Norton Winter Diamond Product Identification System / Usage Information

ASD 120 – R 75 B99 1/8

Abrasive Type	Grit Size	Grade	Concentration	Bond	Abrasive Depth
ASD <ul style="list-style-type: none"> Used with B99 and B105 bonds Armored Durable Versatile Use wet or dry Carbide/steel operations 	<ul style="list-style-type: none"> 100S – Roughing 120 – Roughing/cutting-off 150 – Combined roughing and finishing 180 – Improving finish 220, 320 & 400 – Finishing only 10/20 mic 6/12 mic 	Resin Bond R – Norton standard N – Free cutting Metal Bond N – Norton standard Vitrified Bond P – Norton standard R – Most durable	50 <ul style="list-style-type: none"> Most economical For broad area of contact 75 <ul style="list-style-type: none"> Norton standard Freer cutting than 100 Dry grinding with ASD 100 <ul style="list-style-type: none"> Very durable For flood coolants Use with 220 grit or finer Use for cutting-off 115 <ul style="list-style-type: none"> For CNC grinding machines 125 <ul style="list-style-type: none"> Form holding For high volume, high pressure coolant, precision applications on high-speed tool steels 	B99 <ul style="list-style-type: none"> Resin bond Use wet or dry Tool making; resharpening B105 <ul style="list-style-type: none"> Premium resin bond Advanced heat-reducing bond Use dry; reconditioning B610 and B80 <ul style="list-style-type: none"> For CNC grinding machines M99 <ul style="list-style-type: none"> Metal bond 1A1R cut-off Glass and ceramics MSL <ul style="list-style-type: none"> Metal single layer Type 6A2C only Use dry Offhand reconditioning/finishing carbide V99 <ul style="list-style-type: none"> Vitrified bond Offhand finishing of carbide tools Plunge grinding 	1/16" 1/8" 1/4" 9/32" 3/8" 1/2" 3/4" Solid
CD <ul style="list-style-type: none"> Used with B99 bond 					
D <ul style="list-style-type: none"> Used with B99 bond Micron-sized diamond; finishing 					
M3D <ul style="list-style-type: none"> Used with M99 bond 					
M4D <ul style="list-style-type: none"> Used with M99 bond Armored Durable; for non-metallics 					
RMD <ul style="list-style-type: none"> Used with V99 bond 					
SD <ul style="list-style-type: none"> Used with B99 and V99 bonds Norton standard Use wet or dry Free cutting Low horsepower (3/4 hp or less) 					

Norton Winter cBN Product Identification System / Usage Information

CB 120 – T B99 1/8

Abrasive Type	Grit Size	Grade	Bond	Abrasive Depth
CB – cubic Boron Nitride <ul style="list-style-type: none"> Used with B99 bond Armored Use wet or dry 	<ul style="list-style-type: none"> 100 – Roughing 120 – Roughing/cutting-off 150 – Combined roughing and finishing 180 – Improving finish 220, 320, 400 – For finishing only 	Q <ul style="list-style-type: none"> Approx. 50 concentration Type 6A2 Broad area of contact T <ul style="list-style-type: none"> Approx. 75 concentration Norton standard First choice Lower horsepower Broad area of contact Dry grinding Resharpening applications W <ul style="list-style-type: none"> Approx. 100 concentration Most durable High volume coolant Flute polishing Surface grinding Cylindrical grinding 	B99 <ul style="list-style-type: none"> Resin bond Use wet or dry Aztec III <ul style="list-style-type: none"> Premium resin bond Use dry Tool resharpening Aztec .007 <ul style="list-style-type: none"> Premium resin bond Use dry Increased feed rates Heavy stock removal Heavier cuts 	1/16" 1/8" 1/4" 1/2" Solid

Application-to-Product Recommendation Guide – Diamond Wheels

APPLICATION OR COMMON MACHINE TYPE	COMMON WHEEL SIZE, TYPE & BLUEPRINT	APPLICATION VARIABLES	RECOMMENDED SPECIFICATION
Carbide Grinding – Toolroom Production			
Blanchard Grinding Vertical Spindle Surface Grinding	10", 11", 16" & 18" diameters Type 2A2T	Wet – solid carbide	1" or larger pieces – roughing
			Small pieces
		Carbide & steel (combination)	SD100-R75B99E* ASD100-R75B99E* ASDC320B-R125B99
Hand Burr Grinding	6" x 3/32" x 1-1/4" Type 1V1P V – 20° ME89562	Dry	ASD100-R75B99E* ASDC320B-R125B99
Centerless (wet)	Throughfeed Grinding	Roughing	ASD100-R75B99E*
	Unison Dedtru Grinder		
	7" x 1" x 1-1/4" Type 1A1		ASD150-R75B99E*
Cutting Off (wet)	6" x .035" x 1-1/4" Type 1A1R ME43572 10" x .050" x 1-1/4" Type 1A1R ME43565	Most durable	ASD100S-R100B99
		Free cutting	SD100-R75B99
			SD120-R100B99
Cylindrical Grinding (wet)	10", 12", 14", 16" & 20" diameters Type 1A1	Wet, rough grinding of cemented carbides, hard (55 Rc+) plasma and ceramic spray coatings	ASD180-R100B99 ASD180-R75B99E* ASD150-R75B99 ASD120-R75B99
		Wet, finish grinding of all carbides, plasma and ceramic spray coatings	SD220-R100B99E*
Tool Sharpener Bench Grinder (wet)	5" x 1" x 1-1/4" Type 6A2H ME27084 Rim Width (W) = 1-1/16	Tool sharpening	SD320-R50B99
Hand Honing (dry)	Various sizes Type HH1 or HH2		ASD100-R100B99 SD320-100V99
Lamination Dies (wet)	Various sizes Type 1A1	Surface grinding of carbide	ASD120-R75B99
Surface Grinding (wet) Straight Wheels	Various sizes Type 1A1	Roughing	Durable
			Free cutting
		Finishing only	ASD100S-R100B99E* SD100S-R100B99
		General purpose	SD220-R100B99 ASD150-R75B99
Tool & Cutter Grinding	Various sizes Type 11V9, 12V9 or 15V9	Wet or dry	ASD120-R7599
Carbide Grinding – Offhand			
Single-Point Carbide Tools	6" x 3/4" x 1-1/4" Type 6A2C ME27853	Wet roughing	Durable
			Free cutting
		Wet finishing	Durable
			Free cutting
		Wet or dry grinding where free-cutting and self-dressing wheels are required	Roughing
			Finishing
			RMD150-P50V99* SD150-P50V99 RMD220-P50V99* SD220-P50V99 ASD120-R75B99 SD220-R50B99E*

Note: Diamond depths are not indicated in above listings. When ordering, be sure to include Diamond depth (1/16, 1/8, etc.).

*Express Made-To-Order; Refer to the B99E Express Made-to-Order Wheel section.

Application-to-Product Recommendation Guide – cBN Wheels

APPLICATION OR COMMON MACHINE TYPE	COMMON WHEEL SIZE, TYPE & BLUEPRINT	APPLICATION VARIABLES	RECOMMENDED SPECIFICATION
Toolroom Grinding			
Cutter Sharpening Milling Cutters, Broaches, Reamers, etc.	3-3/4" x 1-1/2" x 1-1/4" Type 11V9 ME92192 6" x 1" x 1-1/4" Type 12A2 ME27758 6" x 3/4" x 1-1/4" Type 12V9 ME48666 6" x 3/4" x 1-1/4" Type 15V9 ME40633	Dry	Aztec III 120T
		Wet	CB120-TB99
		Wet or dry	CB120-TB99
		Wet or dry	CB120-TB99
		Wet or dry	CB100-WB99E*
Surface Grinding	10" x 1/2" x 3" Type 1A1	Wet or dry	CB100-TB99E*
Cylindrical Grinding	12" x 1/2" x 3" Type 1A1	Wet or dry	CB150-WB99E*
Internal Grinding Tools	Thinner than 1/2" Type DW	Wet or dry	CB100-WB99
	1/2" or thicker Type 1A1	Wet or dry	CB120-TB99E*
Slotting	7" x .040" x 1-1/4" Type 1A1R	Water-base coolant	CB120-WB99E*

Note: cBN depths are not indicated in above listings. When ordering, be sure to include cBN depth (1/16, 1/8, etc.).

*Express Made-To-Order; Refer to the B99E Express Made-to-Order Wheel section.

Troubleshooting Guide – Dry Grinding

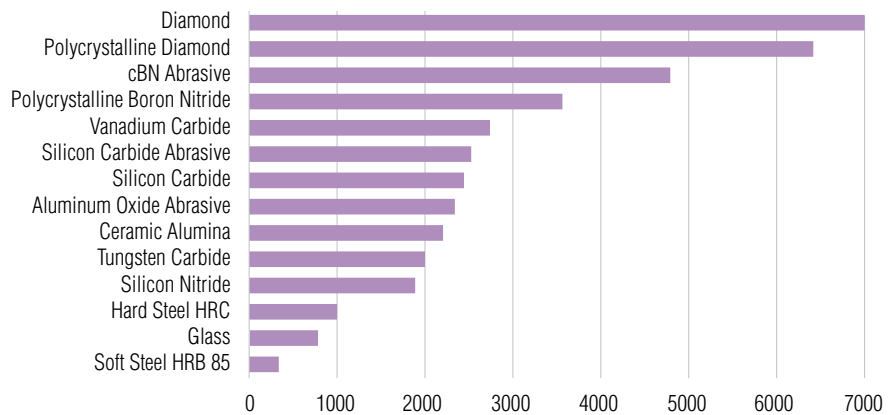
Problem	Possible Causes	Suggested Correction
Burning (excessive heat)	Wheel loaded or glazed	Dress wheel with a dressing stick
	Excessive feed rate	Reduce infeed of wheel or workpiece
	Wheel too durable	Use freer cutting specification or slow down wheel speed
Poor finish	Grit size too coarse	Select a finer grit size
	Excessive feed rate	Reduce infeed of wheel or workpiece
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount (See "Mounting, Truing and Dressing Guide")

Troubleshooting Guide – Wet Grinding

Problem	Possible Causes	Suggested Correction
Burning (excessive heat)	Wheel glazed or loaded	Re-dress wheel
	Poor coolant placement	Apply coolant directly to wheel/workpiece interface
	Excessive material removal rate	Reduce downfeed and/or crossfeed
Poor finish	Excessive dressing	Use lighter dressing pressure Stop dressing as soon as wheel starts to consume stick rapidly
	Grit size too coarse	Select a finer grit size
	Poor coolant flow or location	Apply heavy flood so it reaches wheel/work interface
Chatter	Wheel out of truth	True wheel; ensure it is not slipping on mount
Wheel will not cut	Glazed by truing	Dress lightly until wheel opens up
	Wheel loaded	Dress lightly until wheel opens up Increase coolant flow to keep wheel surface clean Never run wheel with coolant turned off
	Low feeds and speeds	Increase feed rate; increase wheel speed (Do not exceed wheel MOS)
	Incorrect coolant flow	Apply coolant to flood wheel/work surface
Slow cutting	Low wheel speed	Increase wheel speed (observe maximum operating speed)
Short wheel life	Excessive dressing	Use lighter dressing pressure
	Wheel too soft or too hard	Change grit or grade; use higher concentration

Material Hardness Scale

Superabrasives is a term used to describe those abrasives of extreme hardness which produce outstanding results when properly used on specific applications. This graph provides a hardness comparison (Knoop Hardness Scale) between diamond and cBN superabrasives, aluminum oxide and silicon carbide standard abrasives, and some common materials these abrasives are used to grind.



TECH TIP

Avoid Grinding Steel

- Avoid steel when grinding with diamond wheels. Keep the amount of steel ground to an absolute minimum.
- On brazed tools, use aluminum oxide wheel to back off the steel shank.
- A high lubricity grinding fluid should be used.
- For some steels, an armored (AMD) diamond wheel might prove most economical.

Use Rigid Work Support

- All workpieces should be supported firmly during the grinding process. Any amount of vibration will cause wheel wear and produce chatter or wave marks on the ground surface.
- On work ground between centers, centerholds should be properly prepared.
- Minimize work overhang.
- If the ground work is supported by a work finger, ensure the finger is strong enough to provide vibration-free support.

Coolant – Grind Wet

- Diamond wheels should be used with a full flood coolant properly directed toward the grinding zone. Water with a rust inhibitor is recommended.
- Vitrified diamond wheels should be used only with a coolant.
- When flood application can't be used, try mist or spray application.
 - » Use compressed air to "atomize" water or soluble oil.
 - » Direct the spray at the grinding zone to help dissipate heat and prevent heat damage to the work.

Avoid Excessive Feeds

- Excessive feeds will result in premature wheel wear. Excessive feed rates are characterized by:
 - » A hard grinding sound
 - » Chatter
 - » Burn
 - » High wheel wear rate
 - » Vibration

Decimal and Metric Equivalents of Common Fractions

FRACTIONS OF AN INCH	DECIMALS OF AN INCH	MILLIMETERS
1/64	.0156	0.397
1/32	.0313	0.794
3/64	.0469	1.191
1/16	.0625	1.588
5/64	.0781	1.985
3/32	.0938	2.381
7/64	.1094	2.778
1/8	.1250	3.175
9/64	.1406	3.572
5/32	.1563	3.969
11/64	.1719	4.366
3/16	.1875	4.762
13/64	.2031	5.159
7/32	.2188	5.556
15/64	.2344	5.953
1/4	.2500	6.350
17/64	.2656	6.747
9/32	.2813	7.144
19/64	.2969	7.541
5/16	.3135	7.937
21/64	.3281	8.334
11/32	.3438	8.731
23/64	.3594	9.128
3/8	.3750	9.525
25/64	.3906	9.922
13/32	.4063	10.319
27/64	.4219	10.716
7/16	.4375	11.112
29/64	.4531	11.509
15/32	.4688	11.906
31/64	.4844	12.303
1/2	.5000	12.700
33/64	.5156	13.097
17/32	.5313	13.494
35/64	.5469	13.891
9/16	.5625	14.287
37/64	.5781	14.684
19/32	.5938	15.081
39/64	.6094	15.478
5/8	.6250	15.875
41/64	.6406	16.272
21/32	.6563	16.688
43/64	.6719	17.085
11/16	.6875	17.462
45/64	.7031	17.859
23/32	.7188	18.256
47/64	.7344	18.653
3/4	.7500	19.050
49/64	.7645	19.447
25/32	.7813	19.843
51/64	.7969	20.240
13/16	.8125	20.637
53/64	.8281	21.034
27/32	.8438	21.430
55/64	.8594	21.827
7/8	.8750	22.224
57/64	.8906	22.621
29/32	.9063	23.018
59/64	.9219	23.415
15/16	.9375	23.812
61/64	.9531	24.209
31/32	.9688	24.606
63/64	.9844	25.003
1	1.0000	25.400

Expected Surface Finish by Grit Size

Use these charts as guides only. Surface finish is affected by several variables: machine type and condition, type of material ground, coolant, wheel speed, bond system, etc.

DIAMOND		
Grit Size	Expected Finish Micro Inch AA	Maximum Depth of Cut per Pass for Grit Size
100	24 to 32	0.001" to 0.002"
120	16 to 18	0.001" to 0.002"
150	14 to 16	0.001" to 0.002"
180	12 to 14	0.0007" to 0.001"
220	10 to 12	0.0007" to 0.001"
320	8	0.0004" to 0.0006"
400	7 to 8	0.0003" to 0.0005"

cBN		
Grit Size	Expected Finish With Oscillation	Expected Finish Plunge
100	35 – 40	40 – 45
120	30 – 35	35 – 40
150	25 – 30	30 – 35
180	20 – 25	25 – 30
220	15 – 20	20 – 25
320	10 – 15	15 – 20
400	4 – 8	5 – 10

Recommended Wheel Speeds for Diamond and cBN Wheels

WET GRINDING	Cup Wheels	Peripheral Wheels
	11V9, 12V9, 15V9, etc.	1A1, 1V1, 1A1R, etc.
Diamond Grinding Wheels		
Resin Bond Wheels	4921 to 7874 SFPM 25 to 40 m/s	4921 to 7874 SFPM 25 to 40 m/s
Metal Bond Wheels		3937 to 5906 SFPM 20 to 30 m/s
Vitrified Bond Wheels	2953 to 5906 SFPM 15 to 30 m/s	2953 to 5906 SFPM 15 to 30 m/s
cBN Grinding Wheels		
Resin Bond Wheels	5906 to 9843 SFPM 30 to 50 m/s	5906 to 9843 SFPM 30 to 50 m/s
DRY GRINDING		
Diamond Grinding Wheels		
Resin Bond Wheels	2756 to 3543 SFPM 14 to 18 m/s	2756 to 3543 SFPM 14 to 18 m/s
cBN Grinding Wheels		
Resin Bond Wheels	2953 to 5906 SFPM 15 to 30 m/s	2953 to 5906 SFPM 15 to 30 m/s

Note: These are not the maximum operating speeds (MOS). Consult ANSI B7.1 or contact your Norton representative for MOS.

Wheel Speed Calculation

To convert M/S to SFPM:	Multiply M/S x 196.85 = SFPM
To convert SFPM to M/S:	Divide SFPM by 196.85 = M/S
To convert RPM to SFPM:	Multiply wheel diameter in inches x RPM x 0.262
M/S = meters/second RPM = Revolutions Per Minute SFPM = Surface Feet Per Minute	



Norton Winter offers an extensive line of stock Diamond and cBN (cubic Boron Nitride) grinding products, including resin, vitrified, metal and MSL (metal single layer) bond offerings, under the "99" quality line. Premium, high-performance stock resin bond options are also available.

Applications:

- B99 Diamond Wheels**
- Sharpening cemented carbide cutting tools
 - Cutting off carbide rod
 - Grinding or cutting off non-ferrous materials such as ceramics or glass
 - Surface grinding dies
 - O.D. grinding spray coatings

B99 cBN Wheels

- Sharpening high-speed (M2, D2, T15, etc.) steel cutting tools
- Surface and ID grinding hardened steel die components
- Precision grinding steel parts Rc 50 or harder

Stock Shapes:

DW Mounted Points, HH1 and HH2 Hand Hones, and 1A1, 1A1R, 1V1P, 4A2P, 6A2C, 6A2H, 11V9, 12A2, 12V9, and 15V9 Wheels

Abrasive Grain:

Diamond and cBN (cubic Boron Nitride)

Abrasive Bonds:

Resin, Metal, Metal Single Layer, and Vitrified

Superior performance for grinding non-ferrous materials



DIAMOND WHEELS

- High quality synthetic diamond
- High material removal rates with longer wheel life vs. conventional green silicon carbide wheels
- Wide variety of stock wheel shapes and bond options available

Diamond Bond Types

BONDS	DESCRIPTION
Diamond Wheel Bonds	
Pre-engineered resin bond – B99	Free cutting; superior form holding; efficient wet or dry
Premium, heavy-duty resin bond – B105	Ideal for dry toolroom reconditioning applications
Metal bond – M99	Ideal for 1A1R cut-off applications and grinding glass or ceramic materials
MSL (metal single layer) diamond tools; no wheel dressing required	Fast stock removal, cool cutting; excellent for dry offhand finishing of carbide
Vitrified bond – V99	Most durable under high grinding forces; excellent for wet, offhand finishing of carbide tools

Superior performance for grinding ferrous materials



cBN WHEELS

- cBN (cubic Boron Nitride) abrasive material is second in hardness to diamond
- Easily cuts difficult-to-grind steel parts Rc 50 or harder
- Highly wear resistant and thermally stable

cBN Bond Types

BONDS	DESCRIPTION
cBN Wheel Bonds	
Pre-engineered resin bond – B99	Free cutting, superior form holding
Premium Aztec III resin bond	Most efficient for dry tool resharpening
Premium Aztec .007 resin bond	Most efficient for dry tool resharpening where heavy stock removal is desired

How to Select Diamond Wheels

SELECT:		
WHEEL SHAPE	Select desired wheel shape	
WHEEL DIMENSIONS	D x T x H Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.	
ABRASIVE	Select the abrasive based on horsepower, grinding wet or dry, and contact with steel.	Resin Bond Wheels:
		ASD Armored diamond, durable. Versatile: can be used wet or dry. Also should be used when carbide and steel are ground in the same operation.
		D Micron-sized diamond. Used for finishing and polishing operations.
		SD Free cutting standard. Used wet or dry; should be used on low horsepower (3/4 hp or less) machines.
		Metal Bond Wheels:
		M4D Armored, durable standard. A strong, blocky crystal designed for high performance on glass, ceramics, refractories and other non-metallics.
		Vitrified Bond Wheels:
		RMD Medium strength. Specifically designed for use with vitrified bonds.
		SD Free cutting standard.
		100 Roughing. The most common grit size for roughing operations.
		120 For roughing where 100 is too coarse. Also for cut-off applications.
		150 Medium stock removal plus good finish. For combined roughing and finishing applications.
180 Medium stock removal plus good finish. To improve finish.		
220 Finishing		
320 Finishing		
400 Fine Finishing		
10/20 Mic Super Fine Finishing		
6/12Mic Super Fine Finishing		
GRIT SIZE	Select the abrasive grit size based on finish and material removal rate required.	Resin Bond Wheels:
		R Norton standard
		N Free cutting
		Metal Bond Wheels:
		N Norton standard
		Vitrified Bond Wheels:
		P Norton standard
		R Most durable
		50 Most economical. For broad area of contact grinding.
		75 Norton standard. Freer cutting than 100 and the most economical for dry grinding with ASD diamond.
		100 Very durable. Recommended under flood coolant conditions; for use with 220 grit or finer, when durability is required, and for cut-off applications.
		125 Form holding. Used in high volume, high pressure coolant, precision applications on high-speed tool steels.
GRADE	The hardness of the wheel	Resin Bond Wheels:
		R Norton standard
		N Free cutting
		Metal Bond Wheels:
		N Norton standard
		Vitrified Bond Wheels:
		P Norton standard
		R Most durable
		50 Most economical. For broad area of contact grinding.
		75 Norton standard. Freer cutting than 100 and the most economical for dry grinding with ASD diamond.
		100 Very durable. Recommended under flood coolant conditions; for use with 220 grit or finer, when durability is required, and for cut-off applications.
		125 Form holding. Used in high volume, high pressure coolant, precision applications on high-speed tool steels.
CONCENTRATION	Select the abrasive concentration based on grinding wet or dry, material removal rates and form-holding requirements.	Resin Bond:
		B99 Norton standard. Versatile enough to be used wet or dry on most tool making or sharpening applications.
		B105 Premium, heat-reducing bond. For dry toolroom reconditioning applications.
		Metal Bond:
		M99 Best suited for 1A1R cut-off applications as well as grinding glass or ceramic materials.
		MSL Metal Single Layer. Available in shape 6A2C for dry, offhand reconditioning of carbide tools.
		Vitrified Bond:
		V99 Best for wet offhand finishing of carbide tools as well as plunge grinding of carbide tools.
		1/16
		1/8
		1/4
		9/32
Solid		
BOND	Select the bond based on the material being ground and grinding application.	Resin Bond:
		B99 Norton standard. Versatile enough to be used wet or dry on most tool making or sharpening applications.
		B105 Premium, heat-reducing bond. For dry toolroom reconditioning applications.
		Metal Bond:
		M99 Best suited for 1A1R cut-off applications as well as grinding glass or ceramic materials.
		MSL Metal Single Layer. Available in shape 6A2C for dry, offhand reconditioning of carbide tools.
ABRASIVE DEPTH	Usable abrasive	Vitrified Bond:
		V99 Best for wet offhand finishing of carbide tools as well as plunge grinding of carbide tools.
		1/16
		1/8
		1/4
		9/32
Solid		

How to Select Stock cBN Wheels

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS		D x T x H	Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.
ABRASIVE	Select cBN abrasive to grind hard tool steels such as A2, D2, T15, etc., and tough alloy steels.	Resin Bond Wheels: CB	Norton standard coated cBN (cubic Boron Nitride). Optimized for high performance in resin bond systems.
GRIT SIZE	Select the grit size based on finish and material removal rate required.	100 120 150	Roughing. The most common grit size for roughing operations. For roughing where 100 is too coarse. Also for cut-off applications. Medium stock removal plus good finish. For combined roughing and finishing applications.
GRADE	The hardness of the wheel	Q T W	Approximately 50 concentration. Used on wide area of contact applications. Norton standard. Approximately 75 concentration. T is the first choice for lower horsepower equipment or large area of contact between the wheel and the work piece. Ideal for resharpening applications with 11V9, 12A2, 4A2P, and 15V9 wheel shapes when dry grinding. Most durable. Approximately 100 concentration, W is recommended for high volume coolant operations: flute grinding from solid, flute polishing, surface, and cylindrical grinding.
BOND	Select the bond depending on the type of grinding application.	B99 Aztec III Aztec .007	Norton standard. Pre-engineered for optimal performance with cBN abrasive. Available in all shapes. The advanced heat-reducing, lubricating resin bond. Used for dry grinding tool steels. The premium resin bond for increased feed rates, high stock removal and heavier cuts – when dry grinding tool steels.
ABRASIVE DEPTH	Usable abrasive	1/16 1/8 1/4 Solid	

Competitive Cross Reference Guides

	Abrasives				Bonds						
	Resin Diamond	Resin Diamond	Metal Diamond	Resin/Vitrified cBN	Resin Diamond	Resin Diamond	Metal Diamond	Vitrified Diamond	Resin cBN	Resin cBN	Resin cBN
NORTON WINTER	ASD	SD	M4D	CB	B99/B99E	B105	M99	V99	B99/B99E	B99EF	AZTEC
3M / General Industrial Diamond / Diamond Productions, Inc	CGD, ND	GD, D, MD		CB	PS			V		BC	
Abrasive Technology	SN	S		cBN	B		M		B		
Accurate Diamond Tool	NCD	D, MD		BN	B		M				
Citco	5SD, 6SD	SD	MD	CB	B43, B52		M		B26	C3	
Engis	NMD	D, MD		cBN, CB							
Noritake				CBC		BX4			BD/B38		BX4
Radiac / US Diamond	NCD, WD, 1WD, MDC	D, MD	MD4C	B, CB, BZ	B7Z, BB, B5, B56, BN		M, MF	V	BZ, BN		
Regal Diamond				B, BB	BJ						
Superabrasives, Inc.	MDN	D, MD		B					B82	B5	
Tyrolit / Wickman / Bay State / Cincinnati	SDM, XDL, XDN, D, 7D, CMD	SD, D, 6D, MD	1D	5B, 1BN, BN, BM	BD, BC, BX33, B52, B6	Amigo	MI, MSS, MB		B72, B56, BG, B7	BXU8	Amigo
Wendt / Slip Naxos / Winterthur	SDK			B, BXW					RN	RR	

	ABRASIVES		BONDS	
	UNIVEL/G-FORCE		DIAMOND AND cBN	
NORTON WINTER POLYIMIDE	DIAMOND AD	cBN BX	UNIVEL	G-FORCE
3M / General Industrial Diamond / Diamond Productions, Inc	D	CB	BP	BPP
Citco	SD	CB	P	C5

TECH TIP

- Truing makes the wheel concentric with the spindle
- Dressing opens the wheel's cutting face
- Always true and dress diamond and cBN wheels prior to use
- Diamond and cBN wheels with grit sizes 100 – 180 can be trued with a Brake Controlled Truing Device
- Refer to the "Mounting, Truing and Dressing Guide" for more information



It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Diamond Grinds:

In general, diamond is used to grind non-ferrous materials, because of an adverse reaction between diamond and iron.

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials



It is the user's responsibility to refer to and comply with ANSI B7.1

cBN Grinds:

cBN is used to grind ferrous materials.

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hardened stainless steel
- Abrasion-resistant ferrous materials



B99 Express Service

The B99 Express service is designed to offer you up to 65,000 made-to-order choices of resin bond Diamond and cBN wheels. Almost all popular sizes are offered.

12" and less diameter B99 Express wheels will ship in two weeks or less from the date the order is received. 14" and larger wheels are available at standard lead-times.

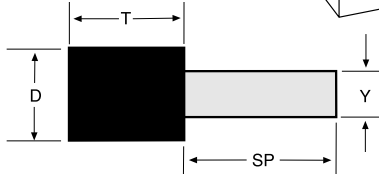
Our Norton Winter line offers a comprehensive stock product selection to service most of your needs – with the fastest delivery and lowest total costs.

Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- For more in-depth B99 Express product availability contact your Norton representative for a complete listing of made-to-order superabrasive products.

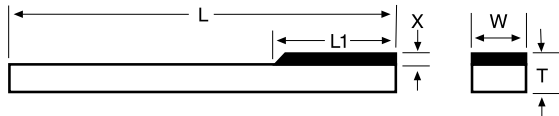
Type DW

- D - Diameter
- T - Thickness
- Y - Spindle Diameter
- SP - Spindle Length



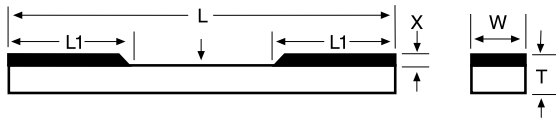
Type HH1

- L - Length
- L1 - Length of Abrasive
- X - Abrasive Depth
- W - Width
- T - Thickness (Back)



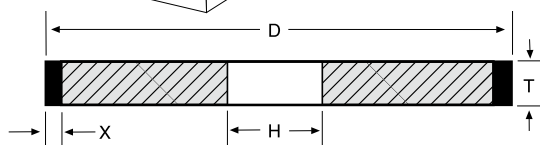
Type HH2

- L - Length
- L1 - Length of Abrasive
- X - Abrasive Depth
- W - Width
- T - Thickness (Back)



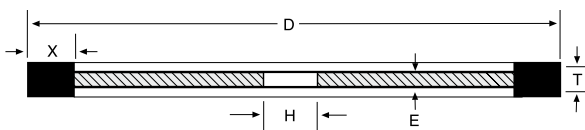
Type 1A1

- D - Diameter
- X - Abrasive Depth
- H - Hole
- T - Thickness



Type 1A1R

- D - Diameter
- X - Abrasive Depth
- H - Hole
- E - Back Thickness
- T - Thickness



SIZE (D x T)	SPECIFICATION	PART #
Type DW Mounted Points - Diamond		
3/16 x 1/4	SD100-R100B99-SOLID	690141 92238
Steel Spindle 1/8 x 1-1/2		
1/2 x 1/2	SD220-R100B99-SOLID	690141 92249
Steel Spindle 1/4 x 1-1/2		
3/4 x 3/8	SD150-R100B99-SOLID	690141 92251
Steel Spindle 1/4 x 1-1/2		
1 x 1/2	SD100-R100B99-SOLID	690141 92428
Steel Spindle 1/4 x 1-1/2		
Type DW Mounted Points - cBN		
3/16 x 1/4	CB150-WB99-SOLID	690141 92258
Carbide Spindle .125 x 1-3/4		
SIZE (T x W x L)	SPECIFICATION	PART #
Type HH1 Hand Hones - Diamond		
1/4 x 1/4 x 6	ASD220-R100B99-1/16	690141 92139
One 1/16 deep 1" long insert in one 1/4 surface		
1/4 x 3/8 x 4	ASD100-R100B99-1/16	690141 92141
One 1/16 deep 1" long insert in one 3/8 surface	ASD180-R100B99-1/16	690141 92142
	ASD220-R100B99-1/16	690141 91670
	ASD320-R100B99-1/16	690141 91672
	ASD400-R100B99-1/16	690141 92143
	D10/20MIC-R100B99-1/16	690141 92144
	SD320-100V99-1/16	690141 92140
Type HH2 Hand Hones - Diamond		
1/4 x 3/8 x 4	ASD120/220-R100B99-1/16	690141 92150
Two 1/16 deep 1" long inserts in one 3/8 surface	ASD220/320-R100B99-1/16	690141 92178
	ASD220/400-R100B99-1/16	690141 92179
	ASD320/400-R100B99-1/16	690141 92180
SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1 Straight - Diamond		
1-1/2 x 1/2 x 1/2	D6/12MIC-N100B99-1/8	690141 92176
2 x 1/8 x 1/4	SD100-R100B99-1/8	690141 92184
3 x 1/4 x 3/4	SD180-N100B99-1/8	690141 92187
4 x .020 x 1-1/4	SD320-R100B99-1/8	690141 92188
4 x 1/32 x 1-1/4	SD100S-R100B99-1/4	690141 92192
4 x 1/16 x 1-1/4	SD100S-R100B99-1/4	662602 73583
	SD150-R100B99-1/4	662602 73584
	SD220-R100B99-1/4	662602 73586
4 x 1/8 x 3/4	SD150-R100B99-1/4	690141 92024
4 x 1/8 x 1-1/4	SD150-R100B99-1/4	690141 91677
4 x 1/4 x 1/2	SD150-R100B99-1/4	662602 73590
4 x 1/4 x 3/4	SD150-R100B99-1/4	662602 73592
4 x 1/4 x 1-1/4	SD100S-R100B99-1/4	662602 73587
	SD120-R100B99-1/4	662602 73588
	SD150-R100B99-1/4	662602 73589
4 x 1/2 x 1-1/4	SD150-R100B99-1/4	662602 73594
6 x 1/32 x 1-1/4	SD220-R100B99-1/8	690141 92197
6 x 1/16 x 1-1/4	SD100-R100B99-1/4	662602 73596
	SD150-R100B99-1/4	662602 73597
	SD180-R100B99-1/4	662602 73598
	SD220-R100B99-1/4	662602 73599
6 x 1/8 x 1-1/4	ASD150-R75B99-1/4	662602 73617
	SD100-R100B99-1/4	662602 73611
	SD150-R100B99-1/4	662602 73613
	SD180-R100B99-1/4	662602 73614
	SD220-R100B99-1/4	662602 73615
6 x 1/4 x 1-1/4	ASD100S-R75B99-1/4	690141 92205
	ASD120-R75B99-1/4	690141 92769
	ASD150-R75B99-1/4	662602 73609
	ASD180-R75B99-1/4	690141 92770
	ASD220-R75B99-1/4	690141 92771
	ASD320-R75B99-1/4	690141 92772
	RMD180-P100V99-1/8	690141 92203
	SD120-R100B99-1/4	690141 91691
	SD150-R100B99-1/4	690141 91692
	SD180-R100B99-1/4	690141 91693
	SD220-R100B99-1/4	690141 92764

Standard Package = 1 mounted point, hand hone, or wheel

Continued

SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1 Straight – Diamond <i>continued</i>		
6 x 3/8 x 1-1/4	ASD120-R75B99-1/4	690141 92773
	ASD150-R75B99-1/4	690141 91695
	SD150-R100B99-1/4	690141 91696
6 x 1/2 x 1-1/4	ASD120-R75B99-1/4	690141 92777
	ASD150-R75B99-1/4	690141 91698
	ASD220-R75B99-1/4	690141 92779
	ASD320-R75B99-1/4	690141 92780
	SD120-R100B99-1/4	662602 73557
	SD150-R100B99-1/4	662602 73561
7 x 1/4 x 1-1/4	SD180-R100B99-1/4	690141 91700
	ASD150-R75B99-1/4	690141 91701
	SD120-R100B99-1/4	662602 73566
	SD150-R100B99-1/4	690141 91703
	SD180-R100B99-1/4	690141 91704
7 x 3/8 x 1-1/4	SD220-R100B99-1/4	690141 91705
	SD120-R100B99-1/4	690141 91849
	SD220-R100B99-1/4	690141 91852
7 x 1/2 x 1-1/4	ASD100-R75B99-1/4	690141 92211
	ASD150-R75B99-1/4	690141 91853
	ASD180-R75B99-1/4	690141 92212
	SD120-R100B99-1/4	690141 91854
	SD180-R100B99-1/4	690141 91856
	SD220-R100B99-1/4	690141 91857
	SD150-R100B99-1/4	662602 73574
8 x 1/2 x 1-1/4	ASD120-R75B99-1/4	690141 92305
10 x 1/2 x 3	ASD120-R75B99-1/4	690141 92313
12 x 1 x 5	ASD150-R75B99-1/4	690141 92314
14 x 1/2 x 5	ASD120-R75B99-1/4	690141 92316
14 x 1 x 5	ASD120-R75B99-1/4	690141 92325
20 x 1 x 12	ASD120-R75B99-1/4	690141 92325

Standard Package = 1 wheel

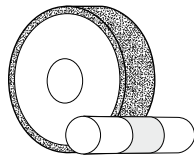
SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1 Straight – cBN		
6 x 1/8 x 1-1/4	CB120-TB99-1/4	662602 73601
6 x 1/4 x 1-1/4	CB120-TB99-1/4	662602 73605
6 x 1/2 x 1-1/4	CB120-TB99-1/4	662602 73607
7 x 1/4 x 1-1/4	CB120-TB99-1/4	690141 92021
7 x 1/2 x 1-1/4	CB120-TB99-1/4	662602 73567
12 x 1/2 x 5	CB150-TB99-1/4	662602 73560
Type 1A1R Cut-Off – Diamond		
3 x .020 x 1/2 (ME104177)	M4D150-N50M99-1/8	690141 92060
4 x .012 x 1/2 (ME104180)	M4D180-N75M99-1/8	690141 92063
4 x .020 x 1/2 (ME104180)	M4D220-N75M99-1/8	690141 92064
4 x .030 x 1/2 (ME104180)	M4D220-N100M99-1/8	690141 92067
4 x 1/32 x 3/4 (ME43570)	M4D150-N75M99-1/8	690141 92068
4 x 1/32 x 1-1/4 (ME43570)	SD100S-R100B99-1/4	690141 92151
5 x .015 x 1/2 (ME104180)	SD120-R100B99-1/4	690141 91706
6 x .017 x 1-1/4 (ME104180)	SD100S-R100B99-1/4	690141 92152
6 x .025 x 1-1/4 (ME104180)	M4D220-N100M99-1/8	690141 92070
6 x .035 x 5/8 (ME104177)	M4D150-N100M99-1/8	690141 92082
6 x .035 x 1-1/4 (ME43572)	M4D220-N100M99-1/8	690141 92083
	M4D150-N100M99-1/8	690141 92086
	M4D100-N75M99-1/8	690141 92088
	SD100-R75B99-1/4	690141 92155
	ASD100S-R100B99-1/4	690141 92158
	ASD120-R100B99-1/4	690141 92159
	SD100-R100B99-1/4	690141 91858
	SD100S-R100B99-1/4	690141 92156
	SD220-R100B99-1/4	690141 92157

Continued

TECH TIP

Cylindrical Grinding Applications – 1A1 wheels:

- Includes all outside grinding of round parts, even though the finished product is not always a true cylinder
- Infeed at both ends of the traverse to keep wheel face flat
- Use work supports to prevent deflection
- Rough grinding traverse speed should be 1/2 to 2/3 of the thickness of the wheel per work revolution
- Finishing grinding traverse speed should be 1/2" or less per work revolution

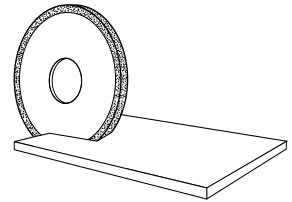


It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Cut-off Applications – 1A1R wheels:

- Use the largest diameter flanges possible
- Use flanges of equal diameter
- Use the thickest wheel possible for increased stiffness and straightness of cut



cBN wheels are used on hardened steels.

Diamond wheels are used to cut or slot carbide, glass or ceramic parts.



It is the user's responsibility to refer to and comply with ANSI B7.1

TECH TIP

Diamond Grinds:

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

cBN Grinds:

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hard stainless steel
- Abrasion-resistant ferrous materials

Can't Find Your Specification Here?

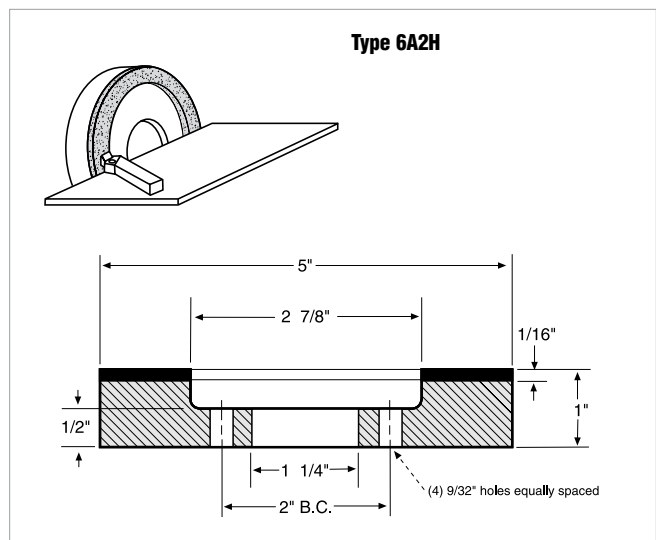
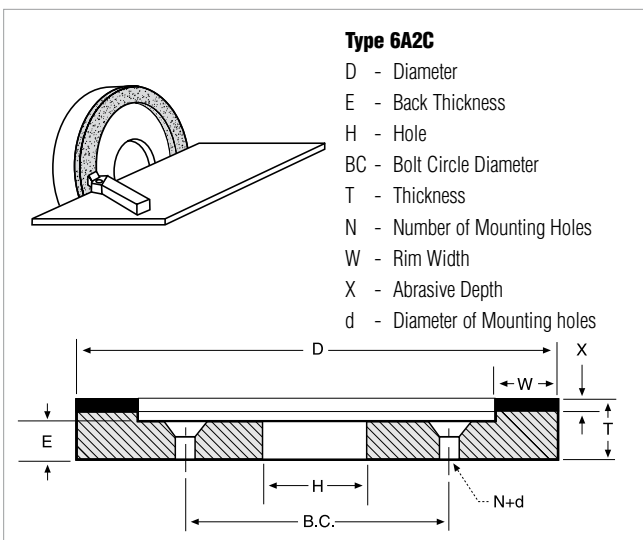
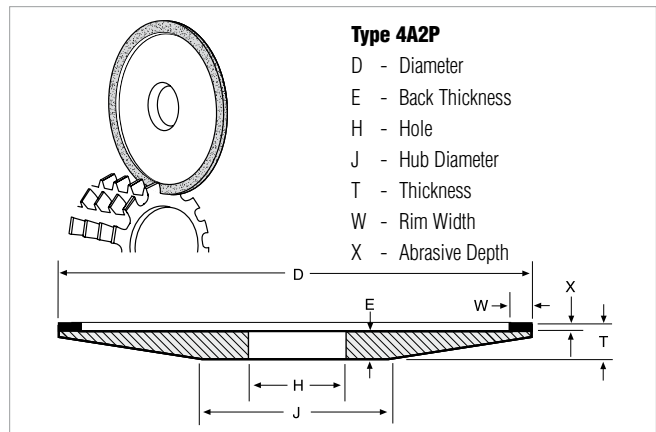
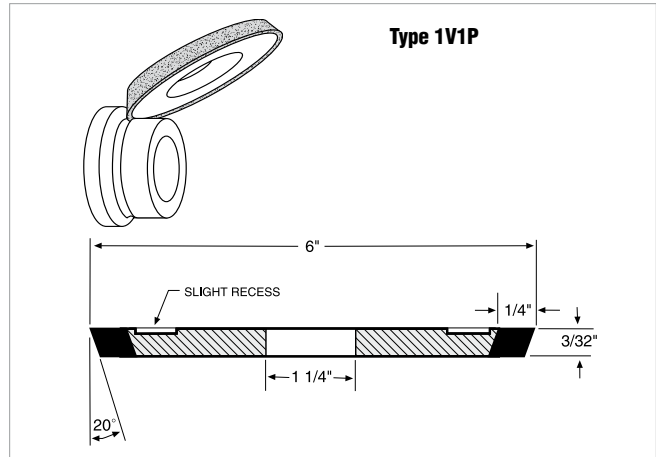
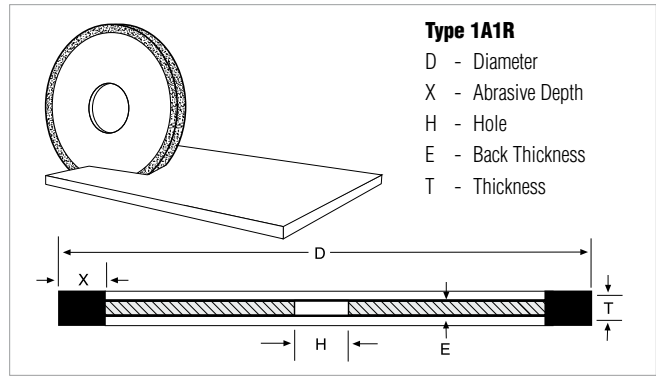
Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- See the more in-depth B99 Express product availability in our "Diamond and cBN Superabrasives Standard Catalog" #8068 on nortonabrasives.com or contact your Norton representative for a complete listing of made-to-order superabrasive products.

SIZE (D x T x H)	SPECIFICATION	PART #
Type 1A1R Cut-off – Diamond		
6 x .035 x 1-1/4 (ME73316)	ASD100S-R100B99-9/32	690141 92164
	ASD120-R100B99-9/32	690141 92165
	SD100-R100B99-9/32	690141 92161
	SD120-R100B99-9/32	690141 92162
	SD150-R100B99-9/32	690141 92163
	SD100-R50B99-1/8	690141 92166
6 x .045 x 1-1/4 (ME83991)		
6 x .055 x 1-1/4 (ME104177)	M4D100-N75M99-1/8	690141 92099
7 x .035 x 1-1/4 (ME82347)	ASD100-R100B99-1/4	662602 38686
7 x .055 x 1-1/4 (ME104177)	M4D120-N100M99-1/8	690141 92108
8 x .030 x 1-1/4 (ME104180)	M4D180-N75M99-1/8	690141 92110
8 x .045 x 5/8 (ME43569)	SD120-R100B99-1/4	690141 92167
8 x .045 x 1-1/4 (ME43569)	SD120-R100B99-1/4	690141 92169
8 x .050 x 1-1/4 (ME104180)	M4D180-N75M99-1/8	690141 92114
10 x .050 x 1-1/4 (ME 43565)	CD100-R100B99-1/4	690141 92815
	SD120-R100B99-1/4	690141 92170
12 x .070 x 3/4 (ME 43567)	SD150-R100B99-1/4	690141 92173
Type 1A1R Cut-off – cBN		
6 x .035 x 1-1/4 (ME43572)	CB100-WB99-1/4	690141 92160
Type 1V1P Fluting – Diamond		
6 x 3/32 x 1-1/4	ASDC320C-R100B99-1/4	690141 92761
Face Bevel 1 Side 20 Deg Copper Core (ME89562)	ASD320B-R125B99-1/4	690141 92302

Standard Package = 1 wheel

Refer to “Brake Controlled Truing Devices” and “Dressing Sticks” in the Dressing Solutions section for truing and dressing products.



SIZE (D x T x H)	SPECIFICATION	PART #
Type 6A2C Straight cup – Diamond		
6 x 7/16 x 1-1/4 Rim Width 1" (0640185M)	D120/140-H-MSL	662602 69172
6 x 3/4 x 1-1/4 Rim Width 3/4" (ME27853)	SD220-R50B99-1/16	690141 91665
	ASD120-R75B99-1/16	690141 91860
	ASD120-R75B99-1/8	690141 92786
	SD150-P50V99-1/16	690141 92217
	SD220-P50V99-1/8	690141 91623

Standard Package = 1 wheel

SIZE (D x T x H)	SPECIFICATION	PART #
Type 6A2H Straight Cup – Diamond		
5 x 1 x 1-1/4 Rim Width 1-1/16" (ME27084)	SD320-R50B99-1/16	690141 92221

Standard Package = 1 wheel

Best choice for dry grinding carbide tools

ASD DIAMOND / B105 RESIN BOND WHEELS

- Premium quality diamond produces keen cutting tools that hold their shape, are easier to sharpen, and require fewer reconditionings
- Advanced, self lubricating bond minimizes heat generation and thermal damage to tool for increases tool life and productivity; lasts more than 2X as long as standard diamond wheels for lowest total wheel costs and highest productivity
- Unique self-dressing core eliminates wheel core damage and downtime to dress core

TIER: **BEST**
BOND: **B105**

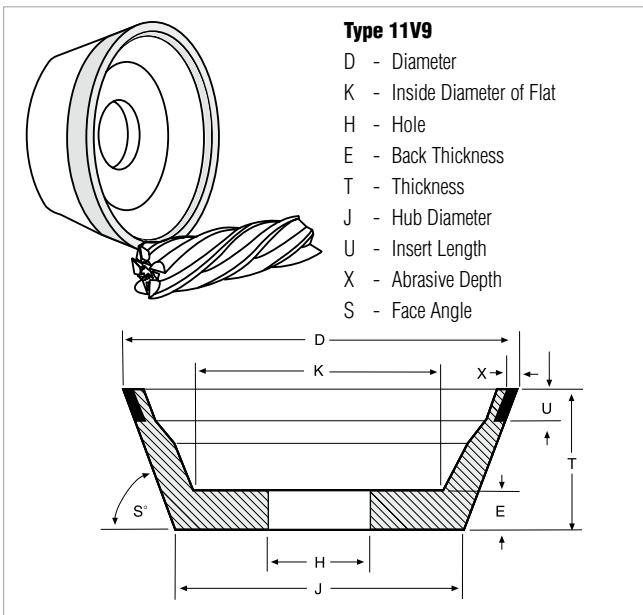
SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup – Diamond		
3-3/4 x 1-1/2 x 1-1/4 Insert Length 3/8" (ME92192)	ASD120-R75B105-1/16	690141 91905
	ASD150-R75B105-1/16	690141 91906
	ASD100S-R75B105-1/8	690141 91908
	ASD120-R75B105-1/8	690141 91909
	ASD150-R75B105-1/8	690141 91910
5 x 1-3/4 x 1-1/4 Insert Length 7/16" (ME98298)	ASD120-R75B105-1/16	690141 91913
	ASD150-R75B105-1/16	690141 91914
	ASD100S-R75B105-1/8	690141 91916
	ASD150-R75B105-1/8	690141 91918

TIER: **BETTER**
BOND: **B99**

SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup – Diamond		
3 x 1-1/4 x 3/4 Insert Length 3/8" (ME93912)	ASD120-R75B99-1/16	690141 92291
	ASD150-R75B99-1/16	690141 92292
	SD150-R100B99-1/16	690141 92293
3-3/4 x 1-1/2 x 1-1/4 Insert Length 3/8" (ME92192)	ASD120-R75B99-1/16	690141 91660
	ASD150-R75B99-1/16	690141 91725
	ASD100S-R75B99-1/8	690141 91653
	ASD120-R75B99-1/8	690141 91652
	ASD150-R75B99-1/8	690141 91651
	ASD180-R75B99-1/8	690141 91650
	SD120-R100B99-1/16	690141 91657
	SD150-R100B99-1/16	690141 91656
	SD220-R100B99-1/16	690141 91654
	SD320-R100B99-1/16	690141 92814
	SD100S-R100B99-1/8	690141 92427
	SD120-R100B99-1/8	690141 91649
	SD150-R100B99-1/8	690141 91648
	SD180-R100B99-1/8	690141 91647
	SD220-R100B99-1/8	690141 91646
5 x 1-3/4 x 1-1/4 Insert Length 7/16" (ME98298)	ASD120-R75B99-1/16	690141 91644
	ASD150-R75B99-1/16	690141 91643
	ASD100S-R75B99-1/8	690141 91637
	ASD120-R75B99-1/8	690141 91636
	ASD150-R75B99-1/8	690141 91635
	ASD180-R75B99-1/8	690141 91634
	SD150-R100B99-1/16	690141 91640
	SD220-R100B99-1/16	690141 91638
	SD150-R100B99-1/8	690141 91632 NS

NS Non-stock. Contact your Norton representative for order quantity and lead time.

Standard Package = 1 Wheel



Best choice for dry tool sharpening

AZTEC cBN WHEELS

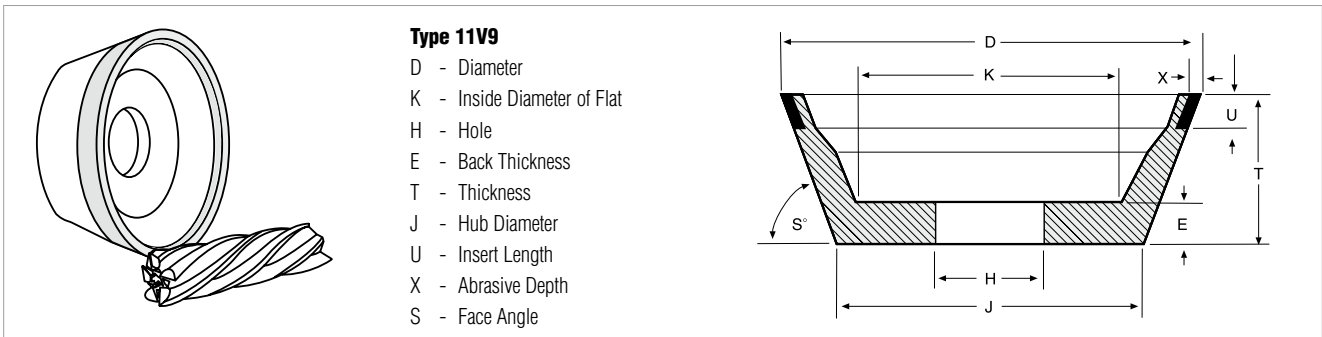
- Consistent, high quality cBN (cubic Boron Nitride) abrasive which offers 85% longer life than standard cBN wheels
- Advanced heat-reducing bond conducts heat away from the workpiece for freer cutting action and extended wheel life; helps maintains cutting tool steel integrity and extends tool life
- AZTEC III lubricating bond eliminates steel braze and loading; AZTEC .007 allows increased infeed (start at .007) for high stock removal

TIER: BEST		
BOND: AZTEC		
SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup – cBN		
3-3/4 x 1-1/2 x 1-1/4 Insert Length 3/8" (ME92192)	AZTEC .007-100-1/16	690141 95683
	AZTEC .007-150-1/16	690141 95679
	AZTEC III 100T-1/16	690141 91832
	AZTEC III 120T-1/16	690141 91833
	AZTEC III 150T-1/16	690141 91834
	AZTEC III 100T-1/8	690141 91838
5 x 1-3/4 x 1-1/4 Insert Length 7/16" (ME98298)	AZTEC III 120T-1/8	690141 91839
	AZTEC III 150T-1/8	690141 91840
	AZTEC .007-100-1/16	690141 95685
	AZTEC III 100T-1/16	690141 91841
	AZTEC III 120T-1/16	690141 91842
	AZTEC III 150T-1/16	690141 91843
	AZTEC .007-100-1/8	690141 95686
	AZTEC .007-150-1/8	690141 95682
	AZTEC III 100T-1/8	690141 91844

Standard Package = 1 Wheel

TIER: BETTER		
BOND: B99		
SIZE (D x T x H)	SPECIFICATION	PART #
Type 11V9 Flaring Cup – cBN		
3-3/4 x 1-1/2 x 1-1/4 Insert Length 3/8" (ME92192)	CB100-TB99-1/16	690141 91719
	CB120-TB99-1/8	690141 91723
	CB150-TB99-1/8	690141 91724
	CB120-WB99-1/16	690141 91720
5 x 1-3/4 x 1-1/4 Insert Length 7/16" (ME98298)	CB120-TB99-1/8	690141 91715
	CB150-TB99-1/8	690141 91716

Standard Package – 1 Wheel



Refer to “Brake Controlled Truing Devices” and “Dressing Sticks” in the Dressing Solutions section for truing and dressing products.

TIER: **BETTER**
BOND: **B99**

SIZE (D x T x H)	SPECIFICATION	PART #
Type 12A2 Dish – Diamond		
4 x 1/2 x 1-1/4 Rim Width 1/4" (ME40745)	SD180-R75B99-1/8	690141 92223
6 x 1 x 1-1/4 Rim Width 3/16" (ME27758)	ASD120-R75B99-1/8 ASD180-R75B99-1/8	690141 91630 690141 92226
Type 12A2 Dish – cBN		
6 x 1 x 1-1/4 Rim Width 3/16" (ME27758)	CB120-TB99-1/16	690141 92227
Type 12V9 Dish – Diamond		
3 x 7/16 x 3/4 Insert Length 7/16" (ME41755)	SD150-R100B99-1/16	690141 92228
4 x 1/2 x 1-1/4 Insert Length 1/4" (ME58734)	SD180-R100B99-1/8	690141 91629
6 x 3/4 x 1-1/4 Insert Length 3/8" (ME48666)	ASD150-R75B99-1/16	690141 91628
Type 12V9 Dish – cBN		
4 x 1/2 x 1-1/4 Insert Length 1/4" (ME58734)	CB120-TB99-1/8	690141 92229
6 x 3/4 x 1-1/4 Insert Length 3/8" (ME48666)	CB120-TB99-1/8 CB150-TB99-1/8	690141 92020 690141 92784
Type 15V9 Dish – Diamond		
6 x 3/4 x 1-1/4 Insert Length 3/8"	SD150-R100B99-1/16	690141 92230

Standard Package = 1 wheel

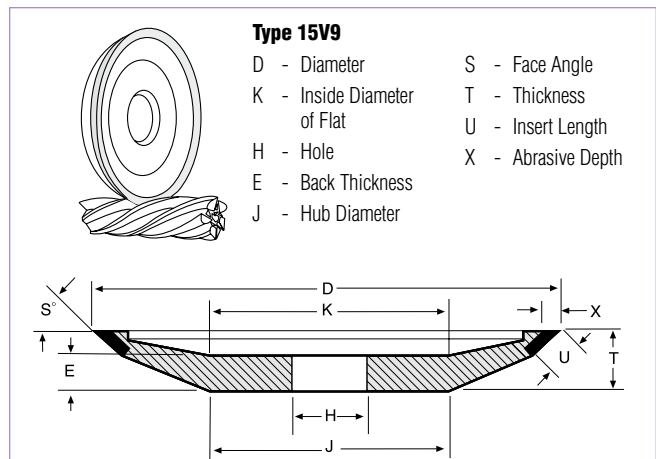
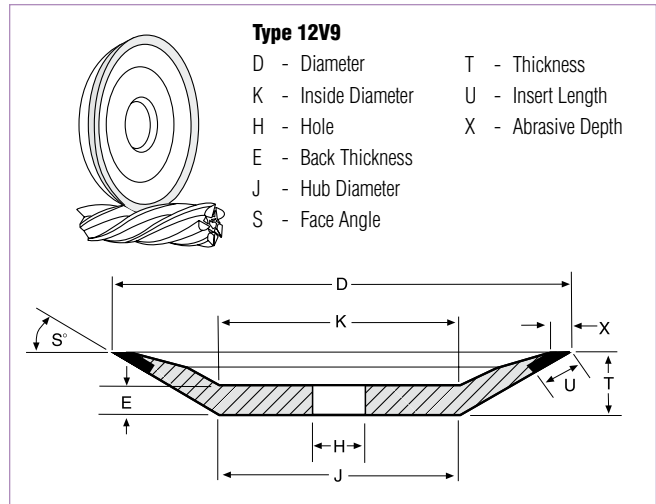
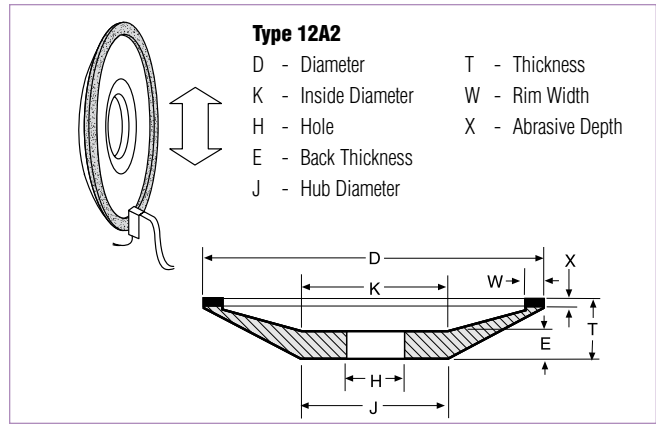
Can't Find Your Specification Here?

We offer a comprehensive stock product selection to service most of your needs

– with the fastest delivery and lowest total cost.

Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- For more in-depth B99 Express product availability contact your Norton representative for a complete listing of made-to-order superabrasive products.





65,000+ made-to-order resin products; 25 wheel shapes, with one- and two-week lead-times for 12" and less diameter wheels. 14" and larger wheels and 80 grit and coarser wheels are available with standard made-to-order lead-times. If you do not find the resin specification and/or shape you need in our stock offering, you will most likely find it in our B99 Express made-to-order offering.

Applications:

- B99E Diamond Wheels
 - Sharpening cemented carbide cutting tools
 - Cutting-off carbide rod
 - Grinding or cutting-off non-metallic materials such as ceramics or glass
 - Surface grinding dies
 - O.D. grinding spray coatings
- B99E cBN Wheels
 - Sharpening high-speed (M2, D2, T15, etc.) steel cutting tools
 - Surface and ID grinding hardened steel die components
 - Precision grinding steel parts Rc 50 or harder

Superior performing diamond and cBN wheels custom made to your requirements

B99 EXPRESS MADE-TO-ORDER DIAMOND AND cBN RESIN BOND WHEELS

- Superior diamond or cBN abrasives with durable resin bond systems
- With thousands of abrasive, grit, grade, concentration, and bond combinations there is a B99 Express wheel for almost every resin bond application
- Offering exceptional quality and performance, these wheels are made in our state-of the art, USA, ISO-certified facilities; excellent performance/price ratio with convenient two-week (or less) lead-times

How to Select B99 Express Made-to-Order Diamond Wheels

SELECT:

WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS		D x T x H	Select Diameter x Thickness x Hole from the availability tables in Catalog #8068. Use blueprint numbers where available.
ABRASIVE	Select the abrasive based on horsepower, grinding wet or dry, and contact with steel.	ASD	Armored diamond; most durable. Versatile: can be used wet or dry. ASD should be used when carbide and steel are ground in the same operation.
		SD	Free cutting standard. Can be used wet or dry; should be used on low horsepower (3/4 hp or less) machines.
GRIT SIZE	Select the grit size based on finish and material removal rate required. Note: Standard made-to-order lead-times apply to 80 grit and coarser wheels.	80	Roughing
		100	Roughing. The most common grit size for roughing operations.
		120	For roughing where 100 is too coarse. Also for cut-off applications.
		150	Medium stock removal plus good finish. For combined roughing and finishing applications.
		180	Medium stock removal plus good finish. To improve finish.
		220	Finishing
		320	Finishing
GRADE	The hardness of the wheel	R	Resin bond standard
		CONCENTRATION	Select the concentration based on grinding wet or dry, material removal rates, and form holding requirements.
		50	Shape 2A2T only. For broad area of contact grinding.
		75	Norton standard. Freer cutting than 100 grit and the most economical for dry grinding with ASD diamond.
BOND	Select the bond based on the material being ground and grinding application.	100	Very durable. Recommended under flood coolant conditions. For use with 220 grit or finer, when durability is required. Also for cut-off applications.
		125	Improved form holding. Used with B99EF bond only for form holding in high-volume, high-pressure coolant applications. Used with ASD abrasive.
		B99E	Norton standard pre-engineered resin bond. Versatile enough to be used wet or dry on most tool making or resharpening applications as well as for grinding non-metallic materials such as ceramics or glass. Available in all shapes.
ABRASIVE DEPTH	Usable abrasive	B99EF	Improved form holding. More durable than B99E. Improved heat dissipation in wet or dry applications. Available in wheel shapes 1V1, 1B1, 1E1, 1EE1, 1F1 and 1FF1.
		1/16	
		1/8	
		1/4	
		1/2	

How to Select B99 Express Made-to-Order cBN Wheels

SELECT:			
WHEEL SHAPE	Select desired wheel shape		
WHEEL DIMENSIONS	Note: Standard made-to-order lead-times apply to 14" and larger wheels.	D x T x H	Select Diameter x Thickness x Hole from the availability tables. Use blueprint numbers where available.
ABRASIVE	Select cBN abrasive to grind hard tool steels such as A2, D2, T15, etc., and tough alloy steels.	CB	Norton standard coated cBN (cubic Boron Nitride). Optimized for high performance in resin bond systems.
GRIT SIZE	Select the grit size based on finish and material removal rate required. Note: Standard made-to-order lead-times apply to 80 grit and coarser wheels.	100	Roughing. The most common grit size for roughing operations.
		120	For roughing where 100 is too coarse. Also for cut-off applications.
		150	Medium stock removal plus good finish. For combined roughing and finishing applications.
		180	Medium stock removal plus good finish. To improve finish.
		220	Finishing
		320	Finishing
GRADE	The hardness of the wheel	T	Norton standard. Approximately 75 concentration, T is the first choice for lower horsepower equipment or wide area of contact between the wheel and the workpiece. Ideal for resharpening applications with 11V9, 12A2, 4A2P, and 15V9 wheel shapes when dry grinding.
		W	Very durable. Approximately 100 concentration, W is recommended for high volume coolant operations: flute grinding from solid, flute polishing, surface, and cylindrical grinding.
		Z	Form holding. Approximately 125 concentration, Z grade is extremely durable and is recommended where long life or form holding is required in high-volume, high-pressure coolant applications. Used with B99EF bond only.
BOND	Select the bond depending on the type of grinding application.	B99E	Norton standard resin bond. Pre-engineered for optimal performance with cBN abrasive. Available in all shapes.
		B99EF	Improved form holding. More durable than B99E. Improved heat dissipation in wet or dry applications. Available in wheel shapes 1V1, 1B1, 1E1, 1EE1, 1F1 and 1FF1.
ABRASIVE DEPTH	Usable abrasive	1/16	
		1/8	
		1/4	
		1/2	

Contact your Norton representative for a complete listing of made-to-order superabrasive products.

TECH TIP

Diamond Grinds:

In general, diamond is used to grind non-ferrous materials, because of an adverse reaction between diamond and iron.

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

cBN Grinds:

cBN is used to grind ferrous materials.

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hardened stainless steel
- Abrasion-resistant ferrous materials



It is the user's responsibility to refer to and comply with ANSI B7.1



These superior, pre-engineered wheels have been specifically developed to meet the demanding needs of precision cutting tool manufacturers as well as re-sharpeners. The use of the highest quality diamond and cBN abrasives matched to superior high temperature bond systems, guarantees high performing wheels. These wheels are manufactured under the strictest quality control protocols ensuring the same, consistent, high-performing product. Cutting tool manufacturers who use these wheels report much improved dimensional accuracy and superior cutting edges.

This product offering provides wheel sizes for most CNC machines and wheels shapes to produce the required cutting tool geometries. If you do not find a wheel in this offering to suit your specific needs, a custom-made wheel can be provided.

Applications: CNC cutting tool manufacturing and resharpening: fluting, end fluting, gashing, and OD relief

Diamond CNC Wheels



Best choice for CNC tungsten carbide round tool manufacturing

PARADIGM DIAMOND WHEELS

- Truable online and offline for maximum productivity
- Wear and load resistance deliver superior grinding performance on tough-to-grind carbides with 6-12% cobalt content
- High grain retention and uniform structure generate high G-ratio; up to 2.5 times longer life and 30% higher MRR than existing superabrasive wheels



Better choice for CNC tungsten carbide round tool manufacturing

G-FORCE AND UNIVEL POLYIMIDE DIAMOND WHEELS

- Polyimide bond systems provide superior form-holding and lower-power requirements compared to premium competitive wheels, reducing frequency of dresses, and decreasing chances of burn and heat damage to the part
- Unique bond technology excels on round, carbide and steel tools; excellent depth of cut, traverse rates, and form holding; reduces total grinding costs by 30% or more
- Self-dressing; maintains a consistently sharp grinding edge which allows for lights-out manufacturing



Better choice for CNC grinding of round tools

V-PRIME DIAMOND WHEELS

- Remarkable edge stability with reduced grinding forces and excellent performance, offering higher feed rates and lowering process times and costs
- New innovative bond system combines extreme wear resistance with the dressing ability of a standard resin bond
- Optimized grinding wheel preparation: off-line dressing is simpler and faster, saving time and money



Good choice for short runs and frequent geometry changes

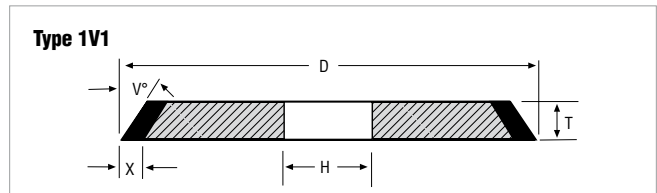
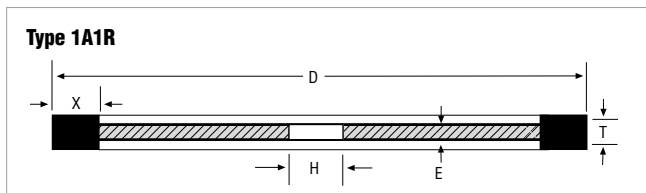
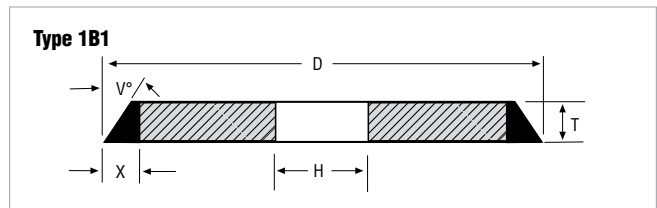
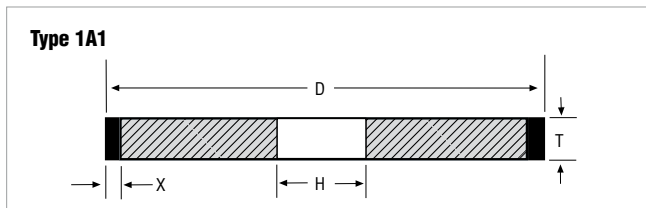
DIAMOND CNC WHEELS

- A price competitive alternative to premium wheels; ideal for short-run manufacturing jobs where frequent wheel profile changes are required
- Consistent wheel-to-wheel performance for reduced cycle times, less dressing = longer wheel life
- Ideal for resharpening and short-run manufacturing operations; competitively-priced while providing good performance

Diamond CNC Wheels

TIER: BEST				BETTER				GOOD			
TRADENAME: PARADIGM				G-FORCE/UNIVEL				NORTON WINTER			
SIZE (D x T x H) U, W	ANGLE V	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #	
TYPE 1A1 – Diamond Flute											
4 x 1/2 x 1-1/4		SD320-D168-P100C	3/8	079587 83055 NS	AD320-UP061 G-Force	1/4	601576 63909				
5 x 3/8 x 1-1/4		SD320-D168-P100C	1/2	079587 83058 NS	AD320-UP061 G-Force	1/2	601576 68409	A4D220-R115B610	1/2	690141 18255	
5 x 1/2 x 1-1/4		SD320-C176-P100C	1/2	079587 83061	AD320-UP061 G-Force	1/2	601576 62240	A4D180-R115B610	1/2	690141 18202	
5 x 5/8 x 1-1/4		SD320-C176-P100C	1/2	079587 83063 NS	AD320-UP061 G-Force	1/2	601576 63486 NS	A4D180-R115B610	1/2	690141 18203 NS	
6 x 1/2 x 1-1/4		SD320-C176-P100C	1/2	079587 83064	AD320-UP061 G-Force	1/4	601576 82133 NS	A4D180-R115B610	1/4	690141 18216 NS	
TYPE 1A1 – Diamond Polish											
5 x 1/2 x 1-1/4					80D1000-100UP731 Univel	1/2	079587 84316 NS				
TYPE 1A1 – Diamond Relief											
6 x 1/2 x 1-1/4		SD320-E168-P100C	1/2	079587 83073 NS	AD320-UP892 G-Force	1/2	690141 17684 NS	A4D180-R115B610	1/2	690141 18217 NS	
TYPE 1A1RN – Diamond Flute											
5 x 3/8 x 1-1/4		SD320-D168-P100C	1/2	079587 83067 NS	AD320-UP061 G-Force	1/2	601576 63501				
5 x 1/2 x 1-1/4					AD220-UP061 G-Force	1/2	662603 22280				
5 x 5/8 x 1-1/4					AD220-UP061 G-Force	1/2	601576 64141				
TYPE 1B1 – Diamond Flute											
4 x 3/8 x 1-1/4	V=20°	SD320-D168-P100C	3/8	079587 83054							
TYPE 1B1 – Diamond Flute/Gash											
5 x 3/8 x 1-1/4	V=45°	SD320-E168-P100C	1/2	079587 83065							
TYPE 1B1 – Diamond Gash											
5 x 1/2 x 1-1/4	V= 45°	SD320-E168-P100C	1/4	079587 83062 NS							
5 x 1/2 x 1-1/4	V=60°	SD320-E168-P100C	1/4	079587 83060 NS							
5 x 1/2 x 1-1/4	V=30°	SD320-E168-P100C	3/4	079587 83070 NS				A4D320-R115B610	3/4	690141 18207	
								D220-C100-K+925	6mm	601576 13112	
5 x 1/2 x 1-1/4	V=45°	SD320-E168-P100C	3/4	079587 83068 NS	AD320-UP531 G-Force	3/4	662603 29603	D220-C100-K+925	6mm	601576 23673	
TYPE 1V1 – Diamond Flute											
4 x 3/8 x 1-1/4	V=20°				AD320-UP061 G-Force	1/4	662603 16591	A4D180-R115B610	1/4	690141 18263	
5 x 1/2 x 1-1/4	V=10°	SD320-C176-P100C	1/2	079587 83071 NS	AD320-UP061 G-Force	1/2	662601 16723				
5 x 1/2 x 1-1/4	V=20°	SD320-C176-P100C	1/2	079587 83074	AD320-UP061 G-Force	1/2	601576 93843				
								D220-C100-K+925	6mm	601576 23953	
5 x 1/2 x 1-1/4	V=30°	SD320-C176-P100C	1/2	079587 83085 NS	AD320-UP671 G-Force	1/2	601576 93841				
TYPE 1V1 – Diamond Flute/Gash											
5 x 3/8 x 1-1/4	V=45°				AD320-UP531 G-Force	1/2	601576 96562	A4D320-R115B610	1/2	690141 18257	
TYPE 1V1 – Diamond Gash											
5 x 1/2 x 1-1/4	V= 45°				AD320-UP531 G-Force	1/4	662603 29604	A4D320-R115B610	1/4	690141 18209	
5 x 1/2 x 1-1/4	V=60°				AD320-UR331 Univel	1/4	662603 29469				

NS Non-stock, contact your Norton representative for current lead-times.
All holes (bores) are machined to (H7) class fit.



TECH TIP

Diamond Grinds:

In general, diamond is used to grind non-ferrous materials, because it reacts with iron.

- Cemented carbide
- Ceramics
- Plastics
- Abrasives
- Glass
- Fiberglass
- Stone
- Electronic components and materials

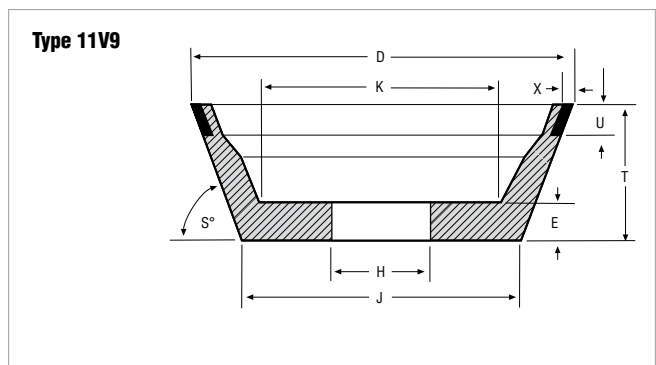
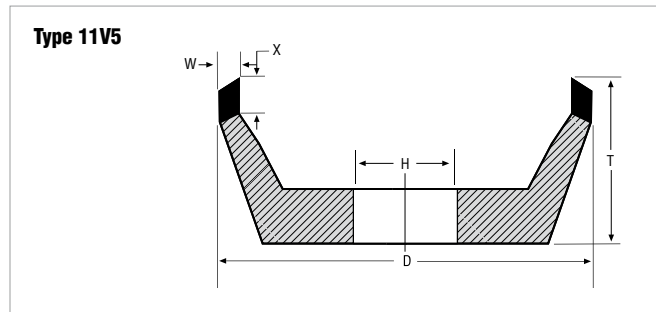
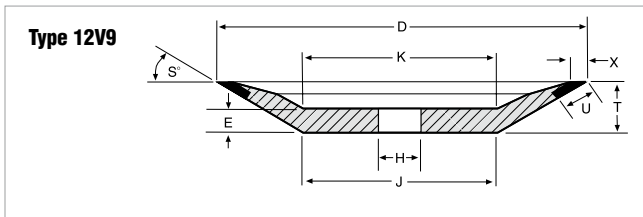
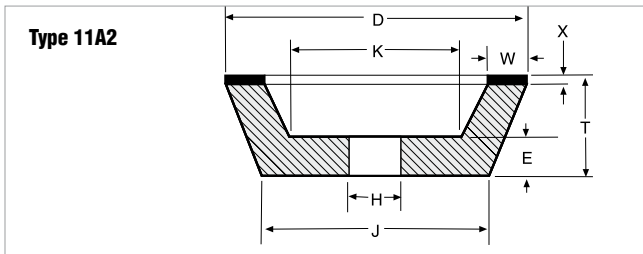
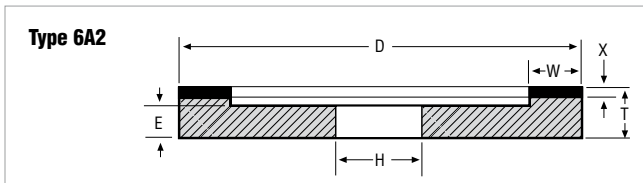


It is the user's responsibility to refer to and comply with ANSI B7.1

Diamond CNC Wheels

TIER: BEST		BETTER				GOOD				
TRADENAME: PARADIGM		G-FORCE/UNIVEL				NORTON WINTER				
SIZE (D x T x H) U, W	ANGLE V	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #
TYPE 6A2 – Diamond Point										
4 x 1-1/4 x 1-1/4 W=1/4		SD320-E168-P100C	1/4	079587 83057NS	AD320-UP251 G-Force	1/4	690141 18644NS	ASD320C-R100B56	1/4	690141 18219NS
TYPE 11A2 – Diamond Relief										
3 x 1-1/4 x 1-1/4 W=1/4					10D320-NB100U Univiel	1/4	601576 92199			
4 x 1-1/4 x 1-1/4 W=1/4		SD320-E168-P100C	1/4	079587 83059NS	AD320-UP701 G-Force	1/4	601576 96315	ASDC320-R100B80	1/4	690141 18213
4 x 1-1/4 x 1-1/4 W=1/4					AD320-UP561 G-Force	1/4	690141 18479NS	ASDC320-R100B80	1/4	690141 18265NS
TYPE 11V5 – Diamond Relief										
4 x 1-1/4 x 1-1/4 V=30° W=1/4					AD320-UP561 G-Force	1/4	690141 17838	ASDC320-R100B80	1/4	690141 18211
4 x 1-1/4 x 1-1/4 V=10° W=3/8					AD320-UP561 G-Force	1/4	690141 17812	ASDC320-R100B80	1/4	690141 18212
TYPE 11V9 – Diamond Relief										
3-3/4 x 1-1/2 x 1-1/4 U=3/8					10D240-PB125-U Univiel	1/8	662603 22134	ASDC320-R100B80	1/8	690141 18259
5 x 1-3/4 x 1-1/4 U=5/8					10D240-PB125-U Univiel	1/8	662601 18300	ASDC320-R100B80	1/8	690141 18215
TYPE 12V9 – Diamond Relief										
4 x 3/4 x 1-1/4 U=3/8					AD320-UP531 G-Force	1/8	662601 27950NS	ASDC320-R100B80	1/8	690141 18221NS
5 x 3/4 x 1-1/4 U=1/2					AD320-UP531 G-Force	1/8	662601 27911NS	ASDC320-R100B80	1/8	690141 18222NS

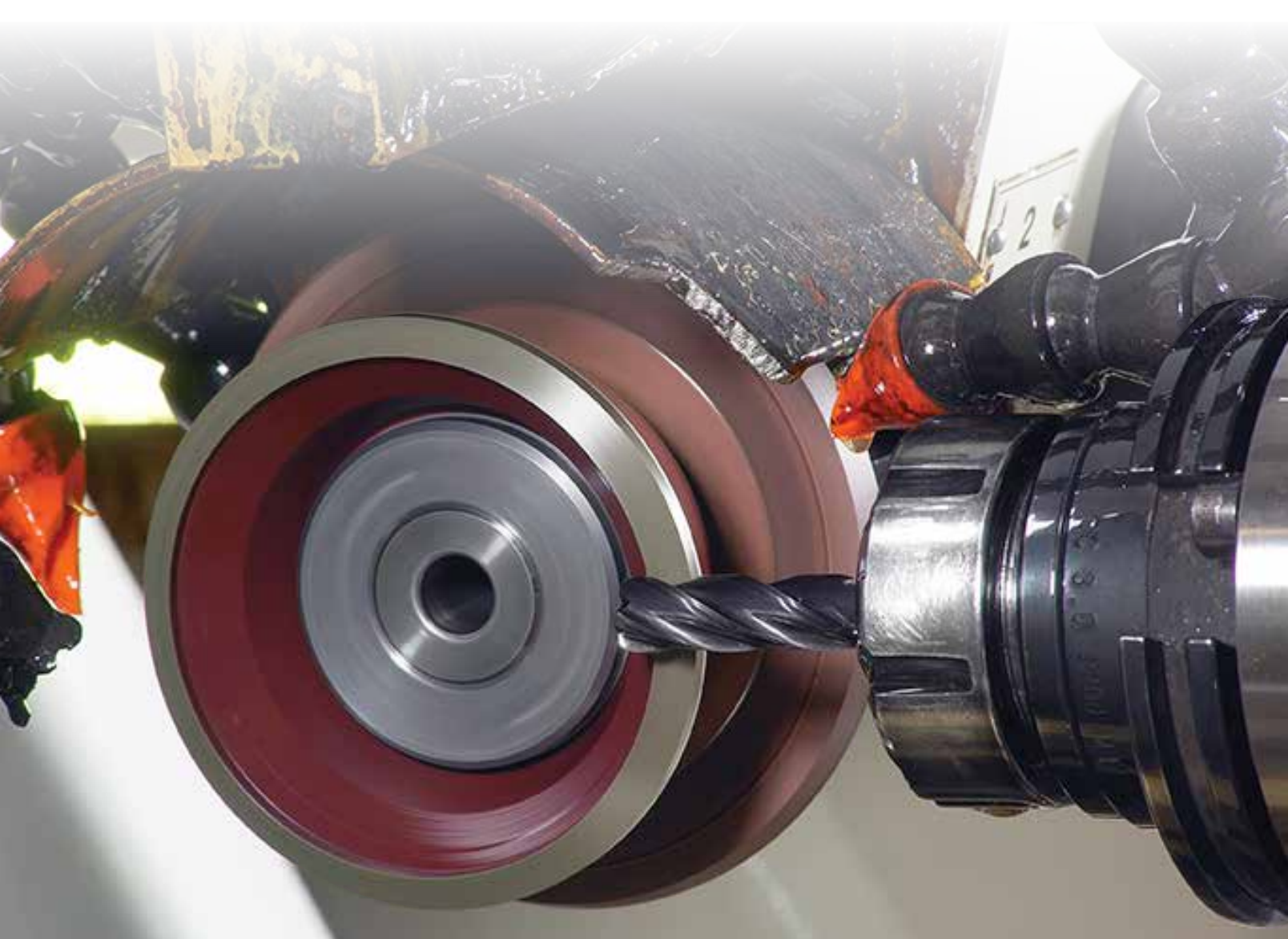
NS Non-stock, contact your Norton representative for current lead-times.
All holes (bores) are machined to (H7) class fit.



Diamond CNC Wheels – V-Prime

TIER: BETTER						
TRADENAME: V-PRIME						
SIZE (D x T x H)	U, W	ANGLE V	SPECIFICATION	GRIT	ABR. DEPTH X	PART #
TYPE 1V1 – Diamond Flute/Gash						
100mm x 10mm x 1-1/4"		V=45°	D54V-Prime 5406 A	320	6 mm	662602 07878
125mm x 10mm x 1-1/4"		V=45°	D54V-Prime 5406 A	320	12mm	662602 07786
TYPE 11V5 – Diamond Relief						
100mm x 1-1/4" x 1-1/4"	W=6mm	V=30°	D46V-Prime 5406 A	400	10mm	662602 04642
TYPE 11V9 – Diamond Relief						
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D64V-Prime 5406 H	240	1/8	662602 13487
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 12321
3-3/4" x 35mm x 1-1/4"	U=9.3mm	V=70°	D46V-Prime 5406 H	400	1/8	662602 13282
100mm x 35mm x 1-1/4"	U=10mm	V=70°	D64V-Prime 5406 H	240	3mm	662602 12804
5" x 40mm x 1-1/4"	U=9.3mm	V=70°	D64V-Prime 5406 H	240	1/8	662602 13286
5" x 40mm x 1-1/4"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 13284
5" x 40mm x 2"	U=9.3mm	V=70°	D54V-Prime 5406 H	320	1/8	662602 13287
TYPE 12V9 – Diamond Relief						
100mm x 20mm x 1-1/4"	U=10mm	V=45°	D46V-Prime 5406 H	400	3mm	662601 98315
125mm x 25mm x 1-1/4"	U=10mm	V=45°	D46V-Prime 5406 H	400	3mm	662601 98316
150mm x 25mm x 1-1/4"	U=10mm	V=45°	D64V-Prime 5406 H	240	3mm	662601 98317

V-Prime wheels are available in cBN upon request. Please contact your Norton representative for more details.



cBN CNC Wheels



Best choice for CNC HSS round tool manufacturing

G-FORCE / UNIVEL cBN WHEELS

- Truable online and offline for lights-out manufacturing and maximum productivity
- Wear and load resistance deliver superior grinding performance on tough-to-grind carbides with 6-12% cobalt content
- Low specific cutting energy for faster grinding with lower power draw and less burn



Good choice for short runs and frequent geometry changes

cBN CNC WHEELS

- A price competitive alternative to premium wheels; ideal for short-run manufacturing jobs where frequent wheel profile changes are required
- Consistent wheel-to-wheel performance for reduced cycle times, less dressing = longer wheel life
- Ideal for resharpening and short-run manufacturing operations; competitively-priced while providing good performance

TIER: BEST				GOOD			
TRADENAME: G-FORCE/UNIVEL				NORTON WINTER			
SIZE (D x T x H) U, W	ANGLE V	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #
TYPE 1A1 – cBN Flute							
4 x 1/2 x 1-1/4		BX220-UP241 G-Force	1/4	601576 69935 NS	BAM180-WBXD3037 B220-V240-KSS920	1/4 6mm	690141 18223 NS 601576 23498
5 x 3/8 x 1-1/4		BX220-UP241 G-Force	1/2	690141 18436 NS	BAM320C-WBXD3037	1/2	690141 18256 NS
5 x 1/2 x 1-1/4		BX220-UP241 G-Force	1/2	601576 70869 NS	BAM180-WBXD3037 B220-V240-KSS920	1/2 6mm	690141 18224 NS 601576 02944
5 x 5/8 x 1-1/4		BX220-UP241 G-Force	1/2	662603 29385 NS	BAM180-WBXD3037	1/2	690141 18225 NS
6 x 1/4 x 1-1/4		BX240-UP241 G-Force	1/4	690141 18435 NS	BAM180-WBXD3037	1/4	690141 18240 NS
TYPE 1A1 – cBN Relief							
6 x 1/2 x 1-1/4		BX320-UP892 G-Force	1/2	690141 17679 NS	BAM180-WBXD3037	1/2	690141 18237 NS
TYPE 1A1RN – cBN Flute							
5 x 1/4 x 1-1/4		BX150-UP241 G-Force	1/2	079587 73216 NS			
5 x 3/8 x 1-1/4		BX150-UP241 G-Force	1/2	079587 73217 NS			
5 x 1/2 x 1-1/4		BX150-UP241 G-Force	1/2	690141 41373 NS			
TYPE 1B1 – cBN Gash							
5 x 1/2 x 1-1/4	V=30°	BX320-UP701 G-Force	3/4	662603 29388 NS	BAM320C-WBXD3037	3/4	690141 18229 NS
5 x 1/2 x 1-1/4	V=45°	BX320-UP531 G-Force	3/4	662603 29391 NS	BAM320C-WBXD3037 B220-V240-KSS920	3/4 6mm	690141 18230 NS 601576 23542
TYPE 1V1 – cBN Flute							
4 x 3/8 x 1-1/4	V=20°	BX220-UP241 G-Force	1/4	690141 18342 NS	BAM180C-WBXD3037	1/4	690141 18264 NS
5 x 1/2 x 1-1/4	V=20°	BX220-UP241 G-Force	1/2	601576 80042 NS	BAM180-WBXD3037 B220-V240-KSS920	1/2 6mm	690141 18227 NS 601576 23944 NS
5 x 1/2 x 1-1/4	V=30°	BX220-UP241 G-Force	1/2	601576 91380 NS	BAM180-WBXD3037	1/2	690141 18228 NS
5 x 1/2 x 1-1/4	V=10°	BX220-UP241 G-Force	1/2	662601 19876 NS	BAM180-WBXD3037	1/2	690141 18226 NS
TYPE 1V1 – cBN Flute/Gash							
5 x 3/8 x 1-1/4	V=45°	BX220-UP531 G-Force	1/2	601576 97699 NS	BAM320C-WBXD3037 B220-V240-KSS920	1/4 6mm	690141 18262 NS 601576 23524
TYPE 1V1 – cBN Gash							
5 x 1/2 x 1-1/4	V=60°	BX320-UR331 Univel	1/4	662603 29461 NS	BAM320C-WBXD3037	1/4	690141 18232 NS
5 x 1/2 x 1-1/4	V=45°	BX320-UP531 G-Force	1/4	662603 29275 NS	BAM320C-WBXD3037 B220-V240-KSS920	1/4 6mm	690141 18231 NS 601576 23776

TECH TIP

cBN Grinds:

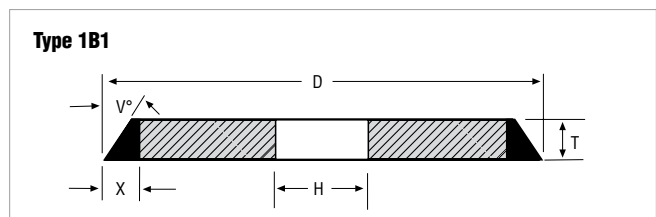
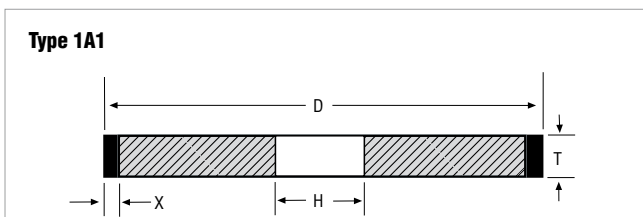
cBN is used to grind ferrous materials.

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hardened stainless steel
- Abrasion-resistant ferrous materials



It is the user's responsibility to refer to and comply with ANSI B7.1

NS Non-stock, contact your Norton representative for current lead-times.
All holes (bores) are machined to (H7) class fit.

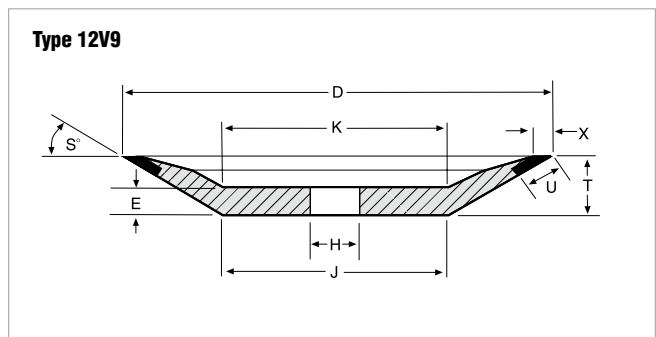
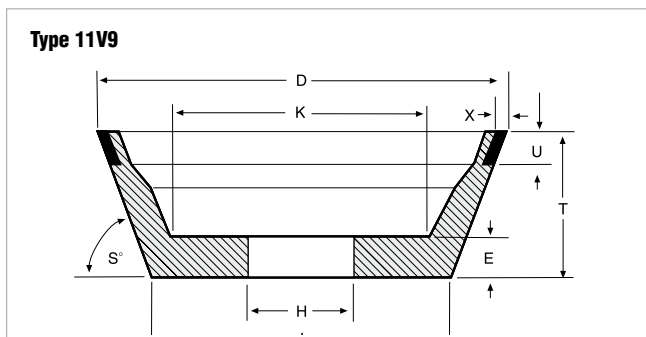
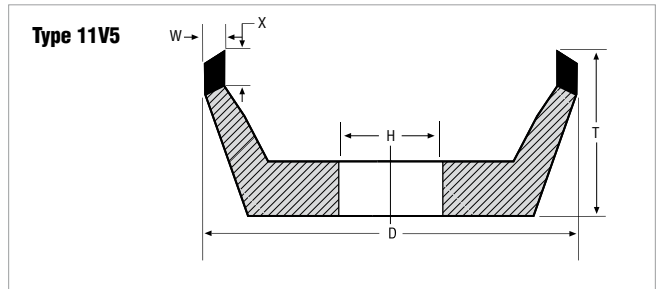
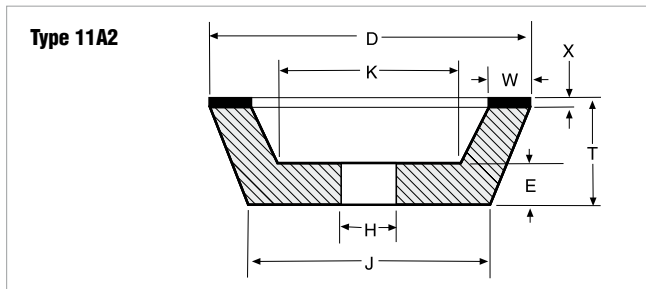
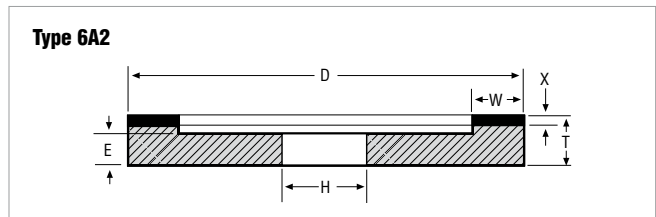
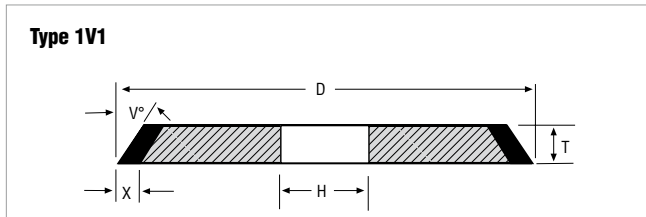


cBN CNC Wheels

TIER: **BEST** **GOOD**
TRADENAME: **G-FORCE/UNIVEL** **NORTON WINTER**

SIZE (D x T x H) U, W	ANGLE V	SPECIFICATION	ABR. DEPTH X	PART #	SPECIFICATION	ABR. DEPTH X	PART #
TYPE 6A2 – cBN Point							
4 x 1-1/4 x 1-1/4 W=1/4		BX320-UP241 G-Force	1/4	690141 18543 NS	CB320C-WBB	1/4	690141 18239 NS
5 x 1-1/4 x 1-1/4 W=1/2		BX320-UP241 G-Force	1/4	690141 18447 NS	CB320C-WBB	1/4	690141 18238 NS
TYPE 11A2 – cBN Relief							
5 x 1-1/2 x 2 W=1/4		BX320-UP531 G-Force	1/4	690141 18406 NS	BAM220-WBE	1/4	690141 18254 NS
TYPE 11A2 – cBN Relief							
4 x 1-1/4 x 1-1/4 W=1/4		BX320-UP531 G-Force	1/4	690141 18445 NS	BAM220-WBE	1/4	690141 18266 NS
TYPE 11V5 – cBN Relief							
4 x 1-1/4 x 1-1/4 W=1/4	V=30°	BX320-UP701 G-Force	1/4	690141 17833 NS	BAM220-WBE	1/4	690141 18233 NS
					B220-J240-KSS63Y	6mm	601576 23563
4 x 1-1/4 x 1-1/4 W=3/8	V=10°	BX320-UP701 G-Force	1/4	690141 17820 NS	BAM220-WBE	1/4	690141 18234 NS
TYPE 11V9 – cBN Relief							
3-3/4 x 1-1/2 x 1-1/4 U=3/8		90B240-PB125-U Univel	1/8	690141 18345 NS	BAM220-WBE	1/8	690141 18260 NS
TYPE 11V9 – cBN Relief							
3-3/4 x 1-1/2 x 1-1/4 U=3/8		90B240-PB125-U Univel	1/8	690141 18029 NS	BAM220-WBE	1/8	690141 18235 NS
5 x 1-3/4 x 2 U=3/8		90B240-PB125-U Univel	1/8	690141 18043 NS	BAM220-WBE	1/8	690141 18248 NS
TYPE 12V9 – cBN Relief							
4 x 3/4 x 1-1/4 U=3/8		BX320-UP531 G-Force	1/8	690141 18470 NS	BAM220-WBE	1/8	690141 18241 NS
5 x 3/4 x 1-1/4 U=1/2		BX320-UP531 G-Force	1/8	690141 18441 NS	BAM220-WBE	1/8	690141 18242 NS

NS Non-stock, contact your Norton representative for current lead-times.
All holes (bores) are machined to (H7) class fit.





Our extensive offering of stock diamond and cBN electroplated products has been engineered to meet the diverse demands of traditional and emerging tool and die, ceramic, and composite applications.

Applications: Small hole/ID grinding, deburring, cleaning, honing, precision drilling, forming dies and molds, routing, reaming, blending radii, notching and cutting-off with saw blades in ceramic, tool and die, and composite applications

Product Types:

- Mounted points
- Mandrels
- Drills
- Routers
- Contour tools
- Wheels
- Files
- Saw blades

Abrasive Grain: Diamond or cBN (cubic Boron Nitride)

Maintain tight tolerances and provide superior form holding; can be used wet or dry



ELECTROPLATED PRODUCTS

- Nickel alloy matrix creates a tough, durable bond
- Single layer of abrasive offers an economical choice
- Exposed particles for aggressive cutting action

Identifying Target Markets

An industry is provided beside each product. This key identifies markets that typically use the product.

TARGET MARKET SYMBOLS

● = Ceramics ▲ = Tool & Die ■ = Composites

TECH TIP

Abrasive Applications

Although diamond and cBN (cubic Boron Nitride) are both superabrasives, the use of diamond and cBN varies, depending upon the materials to be ground.

Diamond Grinds:

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Composites
- Cast Iron
- Abrasives
- Stone
- Electronic components and materials

cBN Grinds:

- High-speed tool steels
- Die steel
- Hardened carbon steels
- Hardened stainless steels
- Alloy steels
- Aerospace alloys
- Abrasion-resistant ferrous materials

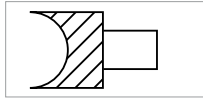
In general, cBN is used to grind ferrous materials. Diamond is used to grind non-ferrous materials, because of an adverse reaction between diamond and iron.

Made-to-Order Electroplated Product Guide

The stock electroplated products offered on the following pages have been engineered to meet the diversity of demands typical in today's manufacturing environment. When special forms, shapes, and configurations are required, Norton Winter electroplated diamond and cBN products can be fabricated in almost any geometry.

Customer-Supplied Preforms and Blanks

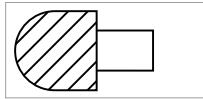
Customers may prefer to manufacture their own preforms/blanks for custom products and in many cases this can reduce cost and lead-times. The instructions below detail the necessary allowances for each grit size. Please refer to these whenever manufacturing blanks.



Area to be plated (female radius)

Female radius must be larger than the finished size required.

Example – If a .500 female radius is required with 60/80 grit, then the blank should be manufactured .011 larger = .511



Area to be plated (male radius)

A male radius must be smaller than the finished size required.

Example – If a .500 male radius is required with 60/80 grit, then the blank should be manufactured .011 smaller = .489

Grit Size Allowance for Plated Products

ALLOWANCE/GRIT SIZE	PARTICLE SIZE
20/30	.035
30/40	.025
40/50	.018
60/80	.011
80/100	.008
100/120	.007
120/140	.006
140/170	.005
170/200	.004
200/230	.0035
270/325	.003
4.5 Micron – 400	.0025
30 Micron – 600	.0016
15 Micron – 1200	.001

This should be used as a guide when manufacturing blanks to be plated with diamond or cBN.

Surface Finish

Use this chart only as a guide. Surface finish is affected by a number of variables: machine type and condition, type of material, coolant, wheel speed, bond system, etc.

Expected RMS Finish

GRIT SIZE	ELECTROPLATED
80	90-125
100	64-90
120	48-64
150	32-48
180	24-32
220	20-24
240	16-20
320	16-20
400	14-20
500	12-13
600	12

Strip and Replate Services

Ask Customer Service for information and quotations on our complete strip and replate services on many electroplated products.

TECH TIP

Coolants

Although coolants may not be necessary, using a coolant produces superior surface finishes, a longer tool life, higher performance, and reduces tool loading.

Feeds

Suggested feeds for jig or internal grinding are from .0002" – .0004" per pass.

Speeds

Maximum Operating Speeds (MOS)

Never exceed the maximum operating speed marked on the superabrasive product being used.

- Electroplated Products: 25,000 SFPMO SFPM

Maximum speeds of mounted points are a function of the length of overhang and size of the product. Refer to "Safe Operating Speeds" in form #2872, provided with your product.

Recommended Operating Speeds

The preceding speed is the maximum safe speed and not necessarily the most efficient. Superabrasive products operate most effectively at speeds lower than the maximum. The following are general recommendations. cBN products, in many cases, are used effectively at higher speeds.

- Electroplated Diamond Products: 5,000 to 10,000 SFPM
- Electroplated cBN Products: 8,000 to 10,000 SFPM

Calculating Operating Speed

The following formula may be used to quickly calculate wheel speed:

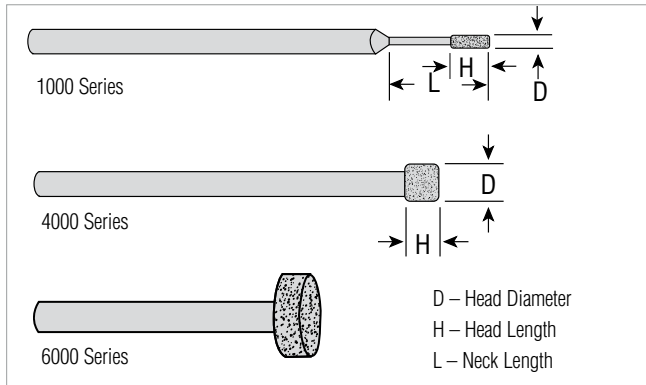
- RPM = Revolutions Per Minute
- SFPM = Surface Feet Per Minute

To convert SFPM to RPM: (Multiply SFPM x 3.82) divided by wheel diameter in inches

Electroplated Mounted Points

Diamond and cBN Mounted Points ● ▲

- Use diamond mounted points for precise, small hole, jig and internal grinding of carbide, ceramics, sapphire, glass, and a variety of tough, super alloys
- For grinding tough, high carbon, high chrome steel, use cBN mounted points
- Mandrels are made of high-speed tool steel to withstand operating pressure



PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	NECK LENGTH	GRIT SIZE
1000 Series – Diamond					
1/8" Shank x 2-1/4" Overall Length					
66260392429	1016FD	.016	.079	1/8	200
66260392432	1020MD	.020	.079	1/8	150
66260392431	1020FD	.020	.079	1/8	200
66260392436	1025MD	.025	.079	1/8	150
66260392435	1025FD	.025	.079	1/8	200
66260392440	1030MD	.030	.079	1/4	150
66260392439	1030FD	.030	.079	1/4	200
66260392445	1035CD	.035	.118	1/4	100
66260392444	1035MD	.035	.118	1/4	150
66260392443	1035FD	.035	.118	1/4	200
66260392451	1040CD	.040	.118	1/4	100
66260392450	1040MD	.040	.118	1/4	150
66260392449	1040FD	.040	.118	1/4	200
66260392457	1045CD	.045	.118	1/4	100
66260392456	1045MD	.045	.118	1/4	150
66260392455	1045FD	.045	.118	1/4	200
66260392463	1050CD	.050	.118	1/2	100
66260392462	1050MD	.050	.118	1/2	150
66260392461	1050FD	.050	.118	1/2	200
66260392469	1050LCD	.050	.118	1	100
66260392468	1050LMD	.050	.118	1	150
66260392467	1050LFD	.050	.118	1	200
66260392475	1055CD	.055	.118	1/2	100
66260392474	1055MD	.055	.118	1/2	150
66260392473	1055FD	.055	.118	1/2	200
66260392481	1060CD	.060	.157	1/2	100
66260392480	1060MD	.060	.157	1/2	150
66260392479	1060FD	.060	.157	1/2	200
66260392487	1060LCD	.060	.157	1	100
66260392492	1065MD	.065	.157	1/2	150
66260392491	1065FD	.065	.157	1/2	200
66260392499	1070CD	.070	.157	1/2	100
66260392498	1070MD	.070	.157	1/2	150
66260392497	1070FD	.070	.157	1/2	200
66260392505 NS	1070LCD	.070	.157	1	100
66260392511	1075CD	.075	.157	1/2	100
66260392510	1075MD	.075	.157	1/2	150
66260392509	1075FD	.075	.157	1/2	200

Continued

PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	NECK LENGTH	GRIT SIZE
1000 Series – Diamond (continued)					
1/8" Shank x 2-1/4" Overall Length					
66260392517	1080CD	.080	.157	1/2	100
66260392516	1080MD	.080	.157	1/2	150
66260392515	1080FD	.080	.157	1/2	200
66260392523	1080LCD	.080	.157	1	100
66260392521	1080LFD	.080	.157	1	200
66260392529	1085CD	.085	.157	1/2	100
66260392528	1085MD	.085	.157	1/2	150
66260392535	1090CD	.090	.157	1/2	100
66260392534	1090MD	.090	.157	1/2	150
66260392533	1090FD	.090	.157	1/2	200
66260392541	1090LCD	.090	.157	1	100
66260392540 NS	1090LMD	.090	.157	1	150
66260392547	1095CD	.095	.157	1/2	100
66260392546	1095MD	.095	.157	1/2	150
66260392553	1100CD	.100	.157	1/2	100
66260392552	1100MD	.100	.157	1/2	150
66260392551	1100FD	.100	.157	1/2	200
66260392565	1105CD	.105	.157	1/2	100
66260392577	1110CD	.110	.157	1/2	100
66260392576	1110MD	.110	.157	1/2	150
66260392589	1115CD	.115	.157	1/2	100
66260392595	1120CD	.120	.157	1/2	100
66260392594	1120MD	.120	.157	1/2	150
66260392593	1120FD	.120	.157	1/2	200
66260392601	1125CD	.125	.157	1/2	100
66260392600	1125MD	.125	.157	1/2	150
66260392599	1125FD	.125	.157	1/2	200
66260392607	1130CD	.130	.197	1	100
66260392606	1130MD	.130	.197	1	150
66260392613	1135CD	.135	.236	N/A	100
66260392612	1135MD	.135	.236	N/A	150
66260392611	1135FD	.135	.236	N/A	200
66260392619	1140CD	.140	.236	N/A	100
66260392625	1156CD	.156	.236	N/A	100
66260392624	1156MD	.156	.236	N/A	150
66260392623	1156FD	.156	.236	N/A	200
66260392730	1171MD	.171	.236	N/A	150
66260392737	1187CD	.187	.312	N/A	100
66260392735	1187FD	.187	.312	N/A	200
66260392742	1203MD	.203	.312	N/A	150
66260392741	1203FD	.203	.312	N/A	200
66260392748	1218MD	.218	.312	N/A	150
66260392747	1218FD	.218	.312	N/A	200
66260392755	1250CD	.250	.312	N/A	100
66260392754	1250MD	.250	.312	N/A	150
66260392753	1250FD	.250	.312	N/A	200
66260363450	1750MD	.750	.035	N/A	150

Additional sizes are available made-to-order.
Contact your Norton representative for availability and quotation.

TARGET MARKET SYMBOLS

- = Ceramics
- ▲ = Tool & Die
- = Composites

Electroplated Mounted Points

Diamond and cBN Mounted Points ● ▲

PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	NECK LENGTH	GRIT SIZE
1000 Series – cBN					
1/8" Shank x 2-1/4" Overall Length					
66260392434	1020MC	.020	.079	1/8	150
66260392442	1030MC	.030	.079	1/4	150
66260392453	1040MC	.040	.118	1/4	150
66260392460	1045CC	.045	.118	1/4	100
66260392466	1050CC	.050	.118	1/2	100
66260392465	1050MC	.050	.118	1/2	150
66260392464	1050FC	.050	.118	1/2	200
66260392484	1060CC	.060	.157	1/2	100
66260392483	1060MC	.060	.157	1/2	150
66260392482	1060FC	.060	.157	1/2	200
66260392496	1065CC	.065	.157	1/2	100
66260392502	1070CC	.070	.157	1/2	100
66260392501	1070MC	.070	.157	1/2	150
66260392500	1070FC	.070	.157	1/2	200
66260392514	1075CC	.075	.157	1/2	100
66260392520	1080CC	.080	.157	1/2	100
66260392532	1085CC	.085	.157	1/2	100
66260392538	1090CC	.090	.157	1/2	100
66260392537 NS	1090MC	.090	.157	1/2	150
66260392536	1090FC	.090	.157	1/2	200
66260392543	1090LMC	.090	.157	1	150
66260392556	1100CC	.100	.157	1/2	100
66260392554	1100FC	.100	.157	1/2	200
66260392561	1100LMC	.100	.157	1	150
66260392568	1105CC	.105	.157	1/2	100
66260392567	1105MC	.105	.157	1/2	150
66260392580	1110CC	.110	.157	1/2	100
66260392578	1110FC	.110	.157	1/2	200
66260392598	1120CC	.120	.157	1/2	100
66260392604	1125CC	.125	.157	1/2	100
66260392603	1125MC	.125	.157	1/2	150
66260392602	1125FC	.125	.157	1/2	200
66260392610	1130CC	.130	.197	1	100
66260392608	1130FC	.130	.197	1	200
66260392616	1135CC	.135	.236	N/A	100
66260392615	1135MC	.135	.236	N/A	150
66260392622	1140CC	.140	.236	N/A	100
66260392628	1156CC	.156	.236	N/A	100
66260392627	1156MC	.156	.236	N/A	150
66260392626	1156FC	.156	.236	N/A	200
66260392734	1171CC	.171	.236	N/A	100
66260392733	1171MC	.171	.236	N/A	150
66260392740	1187CC	.187	.312	N/A	100
66260392739	1187MC	.187	.312	N/A	150
66260392738	1187FC	.187	.312	N/A	200
66260392745	1203MC	.203	.312	N/A	150
66260392751	1218MC	.218	.312	N/A	150
66260392758	1250CC	.250	.312	N/A	100
66260392757	1250MC	.250	.312	N/A	150

Additional sizes are available made-to-order.
Contact your Norton representative for availability and quotation.

PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	NECK LENGTH	GRIT SIZE
4000 Series – Diamond					
1/4" Shank x 3" Overall Length					
66260392630	4156CD	.156	.250	1	100
66260392629	4156FD	.156	.250	1	200
66260392634	4187CD	.187	.250	1	100
66260392633	4187FD	.187	.250	1	200
66260392638	4203CD	.203	.250	1	100
66260392642	4218CD	.218	.250	1	100
66260392641	4218FD	.218	.250	1	200
66260392646	4236CD	.236	.250	1	100
66260392645	4236FD	.236	.250	1	200
66260392650	4250CD	.250	.250	1	100
66260392649	4250FD	.250	.250	1	200
66260392654	4282CD	.282	.250	N/A	100
66260392653	4282FD	.282	.250	N/A	200
66260392658	4312CD	.312	.375	N/A	100
66260392657	4312FD	.312	.375	N/A	200
66260392662	4375CD	.375	.375	N/A	100
66260392661	4375FD	.375	.375	N/A	200
66260392666	4390CD	.390	.375	N/A	100
66260392670	4406CD	.406	.375	N/A	100
66260392674	4437CD	.437	.375	N/A	100
66260392678	4500CD	.500	.375	N/A	100
66260392677	4500FD	.500	.375	N/A	200
66260392682	4730CD	.730	.375	N/A	100
66260392690	41000CD	1.000	.375	N/A	100
66260392689	41000FD	1.000	.375	N/A	200
4000 Series – cBN					
1/4" Shank x 3" Overall Length					
66260392632	4156CC	.156	.250	1	100
66260392631	4156FC	.156	.250	1	200
66260392636	4187CC	.187	.250	1	100
66260392635	4187FC	.187	.250	1	200
66260392640	4203CC	.203	.250	1	100
66260392639	4203FC	.203	.250	1	200
66260392644	4218CC	.218	.250	1	100
66260392643	4218FC	.218	.250	1	200
66260392648	4236CC	.236	.250	1	100
66260392647	4236FC	.236	.250	1	200
66260392652	4250CC	.250	.250	1	100
66260392651	4250FC	.250	.250	1	200
66260392656	4282CC	.282	.250	N/A	100
66260392655	4282FC	.282	.250	N/A	200
66260392660	4312CC	.312	.375	N/A	100
66260392659	4312FC	.312	.375	N/A	200
66260392664	4375CC	.375	.375	N/A	100
66260392663	4375FC	.375	.375	N/A	200
66260392668	4390CC	.390	.375	N/A	100
66260392672	4406CC	.406	.375	N/A	100
66260392676	4437CC	.437	.375	N/A	100
66260392675	4437FC	.437	.375	N/A	200
66260392680	4500CC	.500	.375	N/A	100
66260392679	4500FC	.500	.375	N/A	200
66260392684	4730CC	.730	.375	N/A	100
66260392692	41000CC	1.000	.375	N/A	100

TARGET MARKET SYMBOLS

● = Ceramics ▲ = Tool & Die ■ = Composites

Electroplated Mounted Points, Mandrels, Tapered Honers and Micro Drills

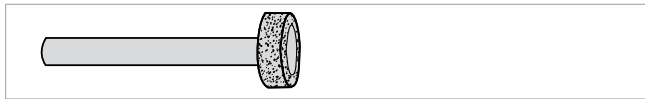
Diamond and cBN Mounted Points ● ▲

PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	GRIT SIZE
6000 Series – Diamond				
3/8" Shank x 3-3/4" Overall Length				
66260392694	6406CD	.406	.375	80
66260392693	6406MD	.406	.375	150
66260392698	6437CD	.437	.375	80
66260392697	6437MD	.437	.375	150
66260392702	6500CD	.500	.375	80
66260392701	6500MD	.500	.375	150
66260392706	6562CD	.562	.375	80
66260392710	6625CD	.625	.375	80
66260392709	6625MD	.625	.375	150
66260392718	6750CD	.750	.375	80
66260392717	6750MD	.750	.375	150
66260392721	6875MD	.875	.400	150
66260392726	61000CD	1.000	.500	80

PART #	PRODUCT #	HEAD DIAMETER INCHES	HEAD LENGTH	GRIT SIZE
6000 Series – cBN				
3/8" Shank x 3-3/4" Overall Length				
66260392696	6406CC	.406	.375	80
66260392695	6406MC	.406	.375	150
66260392700	6437CC	.437	.375	80
66260392699	6437MC	.437	.375	150
66260392704	6500CC	.500	.375	80
66260392703	6500MC	.500	.375	150
66260392708	6562CC	.562	.375	80
66260392712	6625CC	.625	.375	80
66260392716	6687CC	.687	.375	80
66260392715	6687MC	.687	.375	150
66260392720	6750CC	.750	.375	80
66260392719	6750MC	.750	.375	150
66260392724	6875CC	.875	.400	80
66260392728	61000CC	1.000	.500	80
66260392727	61000MC	1.000	.500	150

cBN Heavy Stock Removal Mandrels ▲

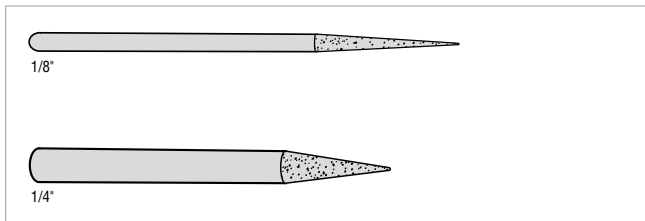
- For heavy stock removal on jig, internal, and offhand operations on tool steels and hardened aerospace alloys. Made with super coarse abrasive grit for long tool life



PART #	PRODUCT #	HEAD DIAMETER	HEAD LENGTH	SHANK DIAMETER	OVERALL LENGTH	GRIT SIZE
HSR Series – cBN						
66260395426	HSR-1/4	1/4	1/4	3/8	3	60
66260395428	HSR-3/8	3/8	3/8	3/8	3	60
66260395429	HSR-1/2	1/2	3/8	3/8	3-1/2	60
66260395431	HSR-3/4	3/4	3/8	3/8	3-1/2	60
66260395432	HSR-1	1	3/8	3/8	3-1/2	60

Diamond Tapered Honers for Drawing Dies ● ▲ ■

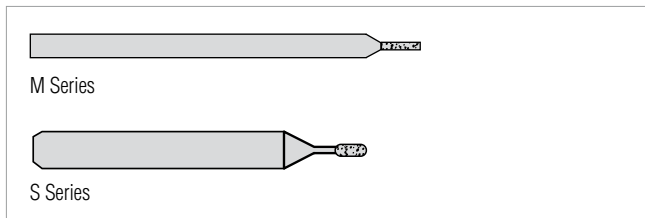
- Used primarily for forming carbide drawing dies, but also can be used for small hole honing in ceramics, fiberglass, plastics, and composite materials



PART #	PRODUCT #	INCLUDED ANGLE	SHANK DIAMETER	GRIT SIZE
Tapered Honers for Drawing Dies – Diamond				
3" Overall Length				
66260395540	TH12-6MD	6°	1/8	150
66260395541	TH12-8MD	8°	1/8	150
66260393371	TH25-12CD	12°	1/4	100
66260395542	TH12-12MD	12°	1/8	150
66260395543	TH25-12MD	12°	1/4	150
66260395544	TH25-14MD	14°	1/4	150
66260395545	TH25-16MD	16°	1/4	150

Diamond Micro Drills ● ▲ ■

- A modification of mounted points, these tools are specifically designed for drilling holes in the .007" to .065" diameter range
- Perfect for drilling sapphire and high density alumina ceramics for hybrid micro-circuit substrates
- M-Series - Carefully-sized, uniformly-shaped diamond particles are used on all M-Series drills
- S-Series - Recommended for adapting to ultrasonic drill heads



PART #	PRODUCT #	DIAMETER INCHES	HEAD LENGTH	OVERALL LENGTH	GRIT SIZE
M-Series Micro Drills – Diamond					
Shank Diameter .040" (1mm)					
66260395516	M7	.007	.028	11/16	600
66260395517	M10	.010	.049	11/16	400
66260395518	M12	.012	.056	13/16	325
66260395519	M15	.015	.077	13/16	325

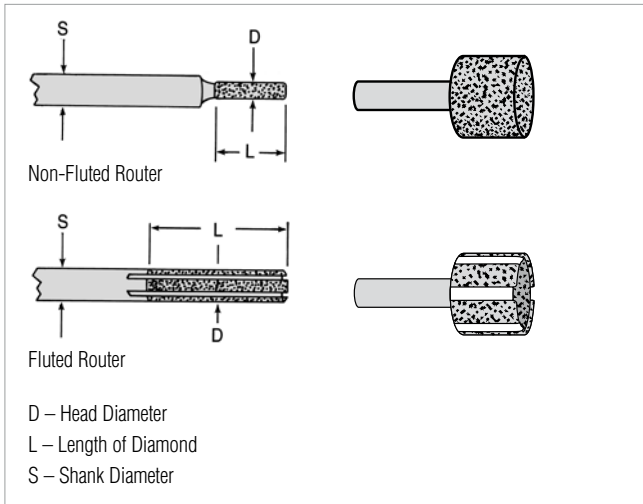
PART #	PRODUCT #	DIAMETER INCHES	HEAD LENGTH	OVERALL LENGTH	GRIT SIZE
S-Series Micro Drills – Diamond					
1/8" Shank x 1" Overall Length					
66260395520	S16FD	.016	.062	.093	200
66260392841	S18FD	.018	.062	.125	200
66260395521	S20FD	.020	.062	.125	200
66260395522	S25FD	.025	.093	.156	200
66260395523	S30MD	.030	.093	.156	150
66260395524	S35MD	.035	.093	.187	150
66260395525	S40MD	.040	.125	.218	150
66260395526	S45CD	.045	.125	.218	100
66260395527	S50CD	.050	.125	.250	100
66260395528	S60CD	.060	.125	.312	100
66260395529	S65CD	.065	.125	.312	100

TARGET MARKET SYMBOLS
● = Ceramics ▲ = Tool & Die ■ = Composites

Electroplated Routers and Mounted Contour Tools

Diamond Routers ● ■

- Used with hand operated tools, drill presses, and milling machines
- Ideal for routing and reaming the highly-abrasive materials of alumina, fiberglass, plastics, and other nonmetallic composite materials.

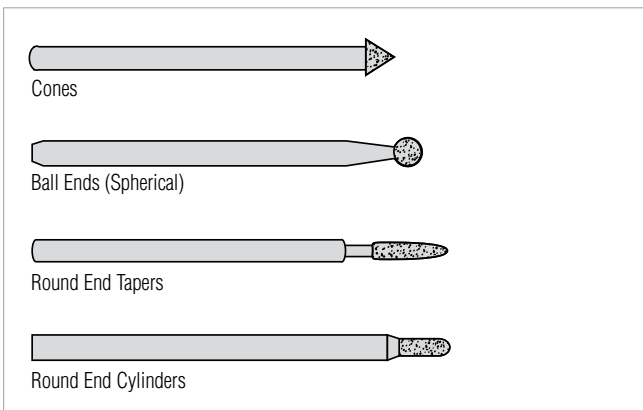


PART #	PRODUCT #	HEAD DIAMETER	LENGTH OF DIAMOND	SHANK DIAMETER	OVERALL LENGTH	GRIT SIZE
Non-Fluted Routers – Diamond						
662603 64302	RNF1410CD	1/4	1	1/4	2-1/2	40
Fluted Routers – Diamond						
662603 64310	RSF1812CD	1/8	1/2	1/4	2-1/2	60
662603 64309	RSF1810CD	1/8	1	1/4	2-1/2	60
662603 64308	RSF1412CD	1/4	1/2	1/4	2-1/2	40
662603 64307	RSF1410CD	1/4	1	1/4	2-1/2	40
662603 02715	RSF3412CD	3/4	1/2	1/2	2-1/2	40

Type 6A2C cup and Type O1 straight bench and pedestal electroplated wheels are available as made-to order products. Contact your Norton representative for availability and quotation.

Diamond and cBN Mounted Contour Tools ● ▲ ■

- For contour grinding applications on carbide, ceramics, glass, ferrites, and many tough alloys and cements. Best suited for blending radii and deburring operations
- Operating speeds: 15,000-20,000 RPM range
- Variety of tool shapes available as stock to satisfy most tool and die and deburring requirements



PART #	PRODUCT #	CONE BASE DIAMETER	INCLUDED ANGLE	CONE LENGTH	GRIT SIZE
Cones – Diamond					
1/8" Shank x 2" Overall Length					
662603 95484	C14CD	1/8	14°	1/2	100
662603 95488	C35CD	5/32	35°	1/4	100
662603 95490	C60CD	11/64	60°	5/32	100
662603 95492	C90CD	3/16	90°	3/32	100
Cones – cBN					
1/8" Shank x 2" Overall Length					
662603 95483	C14CC	1/8	14°	1/2	100
662603 95485	C26CC	3/16	26°	13/32	100
662603 95487	C35CC	5/32	35°	1/4	100
662603 95489	C60CC	11/64	60°	5/32	100
662603 95491	C90CC	3/16	90°	3/32	100

TARGET MARKET SYMBOLS

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PART #	PRODUCT #	BALL DIAMETER	GRIT SIZE
Ball Ends (Spherical) – Diamond			
1/8" Shank x 2" Overall Length			
662603 95434	BE1CD	3/64	100
662603 95436	BE2CD	1/16	100
662603 95438	BE3CD	5/64	100
662603 95440	BE4CD	3/32	100
662603 95442	BE5CD	1/8	100
662603 95444	BE6CD	3/16	100
662603 95448	BE8CD	3/8	100
662603 95450	BE9CD	1/2	100
Ball Ends (Spherical) – cBN			
1/8" Shank x 2" Overall Length			
662603 95437	BE3CC	5/64	100
662603 95439	BE4CC	3/32	100
662603 95441	BE5CC	1/8	100
662603 95443	BE6CC	3/16	100
662603 95445	BE7CC	1/4	100

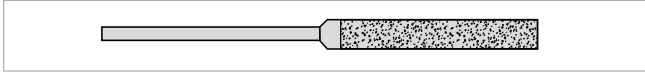
PART #	PRODUCT #	SMALL HEAD DIAMETER	LARGE HEAD DIAMETER	HEAD LENGTH	INC. ANGLE	GRIT SIZE
Round End Tapers – Diamond						
1/8" Shank x 2" Overall Length						
662603 95506	RT44CD	.044	.066	5/16	4°	100
662603 95510	RT78CD	.078	.110	5/16	6°	100
Round End Tapers – cBN						
1/8" Shank x 2" Overall Length						
662603 95509	RT78CC	.078	.110	5/16	6°	100

PART #	PRODUCT #	HEAD DIAMETER	HEAD LENGTH	GRIT SIZE
Round End Cylinders – Diamond				
1/8" Shank x 2" Overall Length				
662603 95494	RE1CD	1/16	1/4	100
662603 95496	RE2CD	5/64	1/4	100
662603 95498	RE3CD	3/32	1/4	100
662603 95500	RE4CD	1/8	1/4	100
662603 95502	RE5CD	3/16	5/16	100
662603 95504	RE6CD	1/4	5/16	100

Electroplated Files

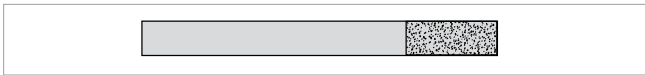
Diamond Machine Files ● ▲

- For use in reciprocating hand profiling machines
- Ideal for reworking and finishing carbide dies and molds, blending radii, and deburring and cleaning slots and grooves



Diamond Hand Files ● ▲

- Indispensable aid for the toolroom
- All purpose hand-held tool useful for deburring, notching, dressing, and honing hard, brittle materials



PART #	PRODUCT #	DIMENSIONS	ABRASIVE LOCATION	GRIT SIZE
Machine Files – Diamond				
5/8" Diamond Length, 1/8" Shank, 2" Overall Length				
662603 95585	1ECD	.020 x .125		100
662603 95586	2ECD	.030 x .125		100
662603 95587	3ECD	.040 x .125		100
662603 95589	3FCD	.120 x .040		100
662603 95590	4FCD	.157 x .040		100
662603 95591	5FCD	.203 x .078		100
662603 95592	6FCD	.120 x .040		100
662603 95593	1CCD	.098 x .196		100
662603 95594	2CCD	.120 x .250		100
662603 95596	3TCD	.127 side		100
662603 95599	2RCD	.080 diam.		100
662603 95600	3RCD	.127 diam.		100

PART #	PRODUCT #	DIMENSIONS	ABRASIVE LOCATION	GRIT SIZE
Hand Files – Diamond				
6" Overall Length, 1-1/2" Diamond Length				
662603 95605 NS	DF1CD	1/8 x 1/8		100
662603 95606	DF2CD	1/8 x 1/4		100
662603 95607	DF2WCD	1/8 x 1/4		100
662603 95608	DF3CD	1/8 x 3/8		100
662603 92844	DF3FD	1/8 x 3/8		200
662603 95609	DF3WCD	1/8 x 3/8		100
662603 64241	DF3SCD	1/8 x 1/2		100
662603 95611	DF4CD	1/8		100
662603 00134	DF4WCD	1/4		100
662603 95613	DF5CD	1/8		100
662603 92846	DF5FD	1/8		200
662603 95614	DF5WCD	1/4		100
662603 95615	DF6CD	1/8		100

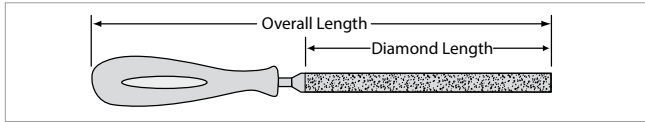
TARGET MARKET SYMBOLS

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Electroplated Files and Drills

Diamond Needle Files ● ▲

- Indispensable aid for the toolroom
- An all-purpose hand-held tool, useful for deburring, notching, dressing, and honing hard, brittle materials



PART #	PRODUCT #	GRIT SIZE
NFK-6 Needle File Kit – Diamond		
662603 64008	NFK-6	
Contains one each of the following:		
	NF1FD	200
	NF2FD	200
	NF3FD	200
	NF4FD	200
	NF5FD	200
	NF6FD	200
DFS-6 Die File Kit – Diamond		
662603 91830	DFS-6	
Contains one each of the following:		
	1571	100
	1572	100
	1573	100
	1574	100
	1575	100
	1576	100

PART #	PRODUCT #	DIMENSIONS	ABRASIVE LOCATION	SHAPE	GRIT SIZE
Needle Files – Diamond					
4-1/4" Diamond Length, 8-1/2" Overall Length					
662603 02432	LNF2CD	.400 x .100		Equaling	100
662603 05611	LNF2FD	.400 x .100		Equaling	200
662603 02898	LNF3CD	.450 x .150		Half Round	100
662603 05612	LNF3FD	.485 x .150		Half Round	200
2-3/4" Diamond Length, 5-3/4" Overall Length, With Handle					
662603 91729	1571	.055 x .190		Flat	100
662603 91730	1572	.075 x .210		Half Round	100
662603 91731	1573	.145 x .145		Triangle	100
662603 91732	1574	.100 x .100		Square	100
662603 91733	1575	.120		Round	100
662603 91734	1576	.055 x .190		Pointed Flat	100
3" Diamond Length, 5-1/2" Overall Length, With Handle					
662603 95575	NF1FD	.150 x .105		Oval	200
662603 95576	NF2FD	.218 x .072		Half Round	200
662603 95577	NF3FD	.205 x .058		Equaling	200
662603 95578	NF4FD	.096 x .096		Square	200
662603 95579	NF5FD	.138 x .138		Triangle	200
662603 95580	NF6FD	.118		Round	200

Needle File Shape and Application Key:

Barrette:	A triangle with diamond on the bottom side only
Crossing:	Elongated oval, with more pointed ends than an oval file; has diamonds all around
Equaling:	A rectangle with diamond on all four sides; ideal for filing both sides of an ID simultaneously
Pointed Flat:	A cone with a flat top with diamond on the sides of the cone

Diamond Core Drills ● ■

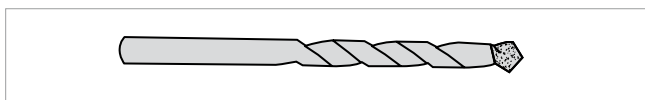
- High performance on glass and ceramic applications while providing fast, reliable cutting
- Submersed drilling is highly recommended for optimum operating performance



PART #	PRODUCT #	OUTER DIAMETER	INNER DIAMETER	GRIT SIZE
Core Drills – Diamond				
Straight Tube Type, 2" Overall Length				
662603 95530	A1MD	1/16	.023	150
662603 95531	A2MD	3/32	.048	150
662603 95532	A3MD	1/8	.075	150
662603 95533	A4MD	5/32	.110	150
662603 95534	A5CD	3/16	.140	100
662603 95535	A6CD	1/4	.195	100
662603 95536	A7CD	5/16	.255	100

Diamond Twist Drills ● ■

- Recommended for precision drilling on circuit boards containing fiberglass, nylon, and similar tough, abrasive materials
- Diamond twist drills are also useful for drilling plastics and resin composites and have been successful in drilling soft ductile materials as well as "green" carbide
- Operating procedures are similar to those of standard twist drills



PART #	PRODUCT #	DRILL DIAMETER	DRILL LENGTH	GRIT SIZE
Twist Drills – Diamond				
662603 95549	TW-1/16	1/16	1-3/4	100
662603 95550	TW-1/8	1/8	2-3/4	100
662603 95551	TW-1/4	1/4	4	100

Diameter tolerance equals + or - 1/64.

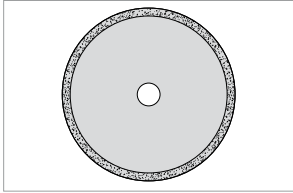
TARGET MARKET SYMBOLS

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Electroplated Saw Blades

Diamond Continuous Rim Cut-off Saw Blades ■

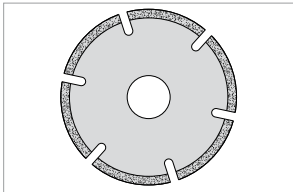
- Ideal for cutting-off highly-abrasive materials such as alumina, fiberglass, plastics, and other nonmetallic composite materials



Additional diamond continuous rim and slotted cut-off saw blades, with extended wraps to avoid binding, are available as made-to-order products. Please contact your Norton representative.

Diamond Slotted Cut-off Saw Blades ■

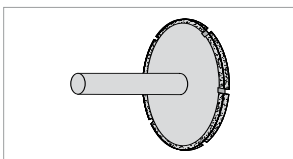
- 3/4" wrap: additional 3/4" of electroplated diamond on the blade core increases life of blade on deep cuts, and reduces binding and grinding on the core



Additional diamond continuous rim and slotted cut-off saw blades, with extended wraps to avoid binding, are available as made-to-order products. Please contact your Norton representative.

Diamond Mounted Saw Blades ■

- Ideal for cutting-off highly-abrasive materials such as alumina, fiberglass, plastics, and other nonmetallic composite materials
- 3/4" wrap - additional 3/4" of electroplated diamond on the blade core increases life of blade on deep cuts, and reduces binding and grinding on the core



PART #	PRODUCT #	DIAM.	OVERALL THICKNESS	HOLE SIZE	GRIT SIZE
Continuous Rim Cut-off Saw Blades – Diamond					
662603 01990	DS2062-250	2	1/16	1/4	40
662603 91474	DS2094-250	2	3/32	1/4	40
662603 91473	DS3094-250	3	3/32	1/4	40
662603 63036	DS3094-375	3	3/32	3/8	40
662603 95554	DS4094-500	4	3/32	1/2	40
662603 00197	DS4094-750	4	3/32	3/4	40
662603 95557	DS8094-625	8	3/32	5/8	40

PART #	PRODUCT #	DIAM.	OVERALL THICKNESS	HOLE SIZE	GRIT SIZE
Slotted Cut-off Saw Blades – Diamond					
662603 01989	DSS2062-250	2	1/16	1/4	40
662603 64258	DSS3094-250	3	3/32	1/4	40
662603 95559	DSS4094-500	4	3/32	1/2	40
662603 95560	DSS6094-500	6	3/32	1/2	40
662603 62981	DSS10125-625	10	1/8	5/8	40
662603 64253	DSS14156-500	14	5/32	1/2	40
662603 62989	DSS14156-1	14	5/32	1	40
662603 95565	DSS16156-1	16	5/32	1	40
662603 95566	DSS18156-1	18	5/32	1	40
Slotted Cut-off Saw Blades with 3/4" Wrap – Diamond					
662603 13423	DSSW4094-750	4	3/32	3/4	40

PART #	PRODUCT #	DIAM.	OVERALL THICKNESS	HOLE SIZE	GRIT SIZE
Mounted Saw Blades – Diamond					
2" Overall Length					
662603 95422	MDS1CD	1	3/32	1/4	40
662603 95423	MDS1-1/2CD	1-1/2	3/32	1/4	40
662603 95424	MDS2CD	2	3/32	3/8	40

TARGET MARKET SYMBOLS

- = Ceramics
- ▲ = Tool & Die
- = Composites

Diamond Lapping Compound



Norton Winter diamond lapping compound polishes all materials – hard and soft. Diamond powders are uniformly distributed in a liquid vehicle for aggressive polishing and consistent part quality. Easy-to-use plastic syringe for quick clean-up.

Applications:

For mold, die, and tool polishing, polishing to final tolerance of ceramic parts, initial charging of lapping plates and discs, and other processes that require mirror finish and close tolerance performance.

Syringe Size:
Type:

5 and 18 gram syringes
Water soluble – when soap/water is used for clean-up

Machine Used:

Oil soluble – when solvent is used for clean-up

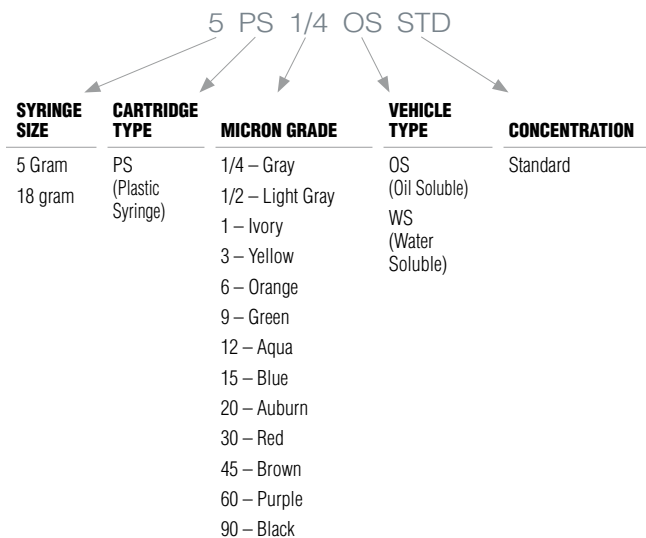


PRODUCT #	MICRON GRADE	COLOR	PART #
Diamond Compound – Water Soluble			
5 Gram Syringes			
5PS1/4WSSTD	1/4	Ultra Fine	Gray 662603 00362
5PS1/2WSSTD	1/2	Ultra Fine	Lt. Gray 662603 00417
5PS1WSSTD	1	Ultra Fine	Ivory 662603 00368
5PS3WSSTD	3	Super Fine	Yellow 662603 00667
5PS6WSSTD	6	Super Fine	Orange 662603 00372
5PS9WSSTD	9	Super Fine	Green 662603 00375
5PS12WSSTD	12	Super Fine	Aqua 662603 00376
5PS15WSSTD	15	Fine	Blue 662603 00379
5PS30WSSTD	30	Fine	Red 662603 00383
5PS45WSSTD	45	Fine	Brown 662603 00384
5PS60WSSTD	60	Fine	Purple 662603 00388
5PS90WSSTD	90	Fine	Black 662603 00389 NS
18 Gram Syringes			
18PS1/4WSSTD	1/4	Ultra Fine	Gray 662603 00392
18PS1/2WSSTD	1/2	Ultra Fine	Lt. Gray 662603 00394
18PS1WSSTD	1	Ultra Fine	Ivory 662603 00396
18PS3WSSTD	3	Super Fine	Yellow 662603 00398
18PS6WSSTD	6	Super Fine	Orange 662603 00400
18PS9WSSTD	9	Super Fine	Green 662603 00402
18PS15WSSTD	15	Fine	Blue 662603 00406
18PS20WSSTD	20	Fine	Auburn 662603 00408

PRODUCT #	MICRON GRADE	COLOR	PART #
Diamond Compound – Oil Soluble			
5 Gram Syringes			
5PS1/4OSSTD	1/4	UltraFine	Gray 614636 91123 NS
5PS1/2OSSTD	1/2	UltraFine	Lt. Gray 662603 00363
5PS1OSSTD	1	UltraFine	Ivory 614636 91133
5PS3OSSTD	3	Super Fine	Yellow 614636 91138
5PS6OSSTD	6	Super Fine	Orange 614636 91143
5PS9OSSTD	9	Super Fine	Green 614636 91148
5PS15OSSTD	15	Fine	Blue 614636 91153
5PS30OSSTD	30	Fine	Red 614636 91158
5PS45OSSTD	45	Fine	Brown 614636 91163
5PS60OSSTD	60	Fine	Purple 662603 00386
5PS90OSSTD	90	Fine	Black 662603 00390
18 Gram Syringes			
18PS1/4OSSTD	1/4	UltraFine	Gray 662603 00391
18PS1OSSTD	1	UltraFine	Ivory 614636 91134 NS
18PS3OSSTD	3	Super Fine	Yellow 614636 91139
18PS6OSSTD	6	Super Fine	Orange 662603 00399
18PS9OSSTD	9	Super Fine	Green 614636 91149 NS
18PS15OSSTD	15	Fine	Blue 614636 91154
18PS20OSSTD	20	Fine	Auburn 662603 00407
18PS30OSSTD	30	Fine	Red 662603 00409
18PS45OSSTD	45	Fine	Brown 614636 91164 NS
18PS60OSSTD	60	Fine	Purple 662603 00413
18PS90OSSTD	90	Fine	Black 662603 00415

NS Non-stock; contact your Norton representative for current lead-times.

Marking System



TECH TIP

Diamond Compound Application Guide

APPLICATION	MICRON GRADE	MICRON RANGE	MESH SIZE EQUIV.	COLOR	CONC.
ULTRA FINE Applying finest finishes on metals and ceramics	1/4	(0-1/2)	100,000	Gray	Std.
	1/2	(0-1)	60,000	Lt. Gray	Std.
	1	(0-2)	14,000	Ivory	Std.
SUPER FINE Final finishing of dies, molds, seals, most applications (RMS 4-12)	3	(2-4)	8,000	Yellow	Std.
	6	(4-8)	3,000	Orange	Std.
	9	(8-12)	1,800	Green	Std.
	12	(9-15)	1,500	Aqua	Std.
FINE FINISH Preparatory lapping (RMS 12-20)	15	(12-22)	1,200	Blue	Std.
	20	(15-25)	800	Auburn	Std.
	30	(22-36)	600	Red	Std.
	45	(36-45)	325	Brown	Std.
	60	(54-80)	230	Purple	Std.
	90	(80-100)	170	Black	Std.

the Norton Clipper brand **HITS THE PAVEMENT**

The leader for diamond blades, tools, and light machines for construction and cutting materials is “Redefining Jobsite Muscle – Rugged. Reliable. Affordable.”





With faster cut rates, constant depth of cut, and less downtime, Norton Clipper diamond blades are the choice of professionals versus conventional abrasive blades. Norton Clipper diamond blades are available for high-speed saws, portable hand-held saws, and walk-behind saws. For the full offering of diamond blades, see the Norton Clipper Construction Products Catalog #7719.

- Applications:** Cutting concrete, stone, tile, and other building materials
- Size Range:** 4" – 18"
- Thickness Range:** .080" – .375"
- Segment Height Range:** .210" – .550"
- Abrasive Grain:** Diamond
- Mounting Options:** 1"/20mm universal arbor, 7/8"-5/8"-20mm, DM-7/8"-5/8", 5/8"-11
- Shape:** Type 01
- Machines Used:**



HIGH-SPEED GAS OR ELECTRIC SAW



CIRCULAR SAW



RIGHT-ANGLE GRINDER



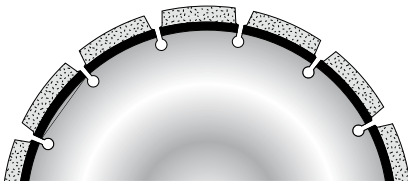
WALK-BEHIND SAW



MASONRY SAW

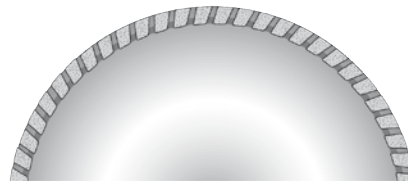
Diamond Blade Rim Types

There are three main diamond blade rim types: segmented, turbo, and continuous rim.



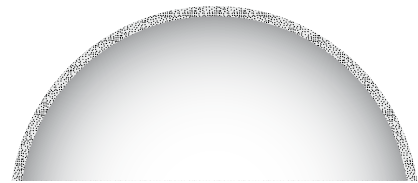
Segmented

- Most aggressive cutting action for general-purpose and masonry applications
- Use when cutting speed and productivity are more important than finish
- Best life, best cut rate, good finish



Turbo

- Aggressive cutting action with a smoother quality of cut than segmented rim blades
- For use on harder materials, such as granite, marble, and stone to reduce chipping
- Better life and cut rate, better finish



Continuous

- Provides the smoothest of cuts
- Best performance when used wet
- Use on porcelain, tile, marble, and other hard materials requiring a high-quality cut
- Good life, good cut rate, best finish

Material / Application-to-Product Recommendation Guide

Icon	Description	Application
	Multi-Purpose, All Materials	Concrete, reinforced concrete, granite, building materials, thin steel sections, angle iron up to 1/2" material thickness, rebar up to no. 5.
	Natural Stone and Tiles	Ceramic and stone tiles, granite, marble, very hard bricks and other very hard and dense materials.
	Reinforced Concrete and Harder Building Materials	Reinforced concrete, hard bricks, limestone, terrazzo, and other hard materials.
	General Purpose and Masonry Building Materials	Blocks, medium-hard building bricks, paving slabs, concrete roof tiles and other medium-hard materials.
	Asphalt	Asphalt, green concrete, asphalt over concrete, abrasive blocks, mortar and other abrasive materials.

Diamond Performance Tiers

- 5 **Best**
Best Performance
- 4 **Better**
High Performance
- 3 **Good**
Good Performance
- 2 **Value**
Consistent Performance

TECH TIP

- Never twist or turn a segmented blade in the cut because it may result in segment breakage
- Never use wet blades dry
- Remove dry blades from cut for 10 seconds of each minute of cut to air cool
- Never operate any saw, wet or dry, without the blade guard



It is the user's responsibility to refer to and comply with ANSI B7.1

For Reinforced Concrete and Harder Building Materials

DRY – Segmented Rim 

DUO EVO 

The unique shape of the DUO EVO segments optimizes the angle of attack while enhancing the evacuation of the debris. With a new manufacturing process, the DUO EVO segments provide an exceptional cutting speed for optimum performance and increased life up to 20% over the original DUO EVO design.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .110 x 1"/20mm	.590"	6,300	DUOEVO12110	701846 84217
14 x .118 x 1"/20mm	.590"	5,460	DUOEVO14118	701846 84218
16 x .130 x 1"/20mm	.590"	4,500	DUOEVO16130	701846 93356



DUO 

Our exclusive design has become a dominant name in the market. The unique dual segment per land technology provides excellent cutting speed with low vibration and high comfort of cut. The exclusive arrow shape gullets not only indicate blade direction, but also assist in fast removal of cutting debris. Maximum general purpose performance when cutting medium to low reinforcement, hard materials.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .110 x 1"/20mm	.393"	6,300	DUO12110	701846 83611
14 x .110 x 1"/20mm	.393"	5,460	DUO14110	701846 83612
14 x .125 x 1"/20mm	.393"	5,460	DUO14125	701846 83613
16 x .125 x 1"/20mm	.393"	4,500	DUO16125	701846 83798



For Asphalt and Abrasive Materials

DRY – Segmented Rim 

DUO ASPHALT 

Dry cutting laser-welded blade for asphalt and green concrete. The laser-welded, wear-retardant drop segments extend blade life. Scoop gullets for faster swarf removal increases cut speed. Stroboscopic indicators to control cut depth and show rotation direction.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
14 x .125 x 1"/20mm	.590"	5,460	DUOASP14125	701846 84315
16 x .125 x 1"/20mm	.590"	4,500	DUOASP16125	701846 84544



DUO ABRASIVE 

Utilizes the basic characteristics of the original DUO blade and adds a unique segment shape that optimizes the angle of attack while enhancing the evacuation of the particles. The result is an exceptional cutting speed allied with very good performance and life in abrasive materials and concrete block. The bond specification lends additional life when high-speed cutting.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
14 x .110 x 1"/20mm	.327"	5,460	DUOAB14110	701846 84291
14 x .125 x 1"/20mm	.327"	5,460	DUOAB14125	701846 84292



For General-Purpose and Masonry Building Materials

DRY – Segmented Rim 

CLASSIC 

The improved bond provides longer life at an economical price in medium-hard materials such as concrete with light to medium reinforcement.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .110 x 1"/20mm	.256"	6,300	COHSGP1220	701846 81383
14 x .110 x 1"/20mm	.256"	5,460	COHSGP1420	701846 81309
14 x .125 x 1"/20mm	.256"	5,460	COHSGP1420P	701846 84268
16 x .125 x 1"/20mm	.256"	4,500	COHSGP1620	701846 40356



VALUPLUS 

For value and performance on small- to medium-size jobs. The sintered blade cuts unreinforced soft-to-medium concrete fast on saws up to 13 HP.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .110 x 1"/20mm	.393"	6,300	VPHSGP1220	701846 84180
14 x .110 x 1"/20mm	.393"	5,460	VPHSGP1420	701846 84181
14 x .110 x 1"/20mm	.393"	5,460	VPHSGP1420 20PK	701846 84428



Multi-Purpose, For All Materials

Dry – Segmented Rim  + 



4X4 MAX CUT

Taking high-speed cutting versatility to an all new level. The same standard features as the 4X4 with its anti-crack gullets and patented depth indicators that not only cool the blade, but also allow the operator to know how deep they are cutting. An all-new bond and diamond specification improves blade life in a wide range of materials while excelling in steel. New segment wear indicators give the operator an idea of remaining blade life.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .118 x 1"/20mm	.472"	6,300	4X4MC12118	701846 45927
14 x .125 x 1"/20mm	.472"	5,460	4X4MC14125	701846 45926



4X4

Multi-purpose laser welded blade for dry cutting a range of construction materials without sacrificing performance or price. Depth of cut is easily controlled with the patented depth-of-cut indicators cut into the steel core. Anti-crack gullets for enhanced safety cutting steel and metal (up to 5mm thick).

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
12 x .110 x 1"/20mm	.393"	6,300	4X412110	701846 84548
14 x .118 x 1"/20mm	.393"	5,460	4X414118	701846 84547
16 x .125 x 1"/20mm	.393"	4,500	4X416125	701846 45306



MULTI-CUT

The perfect combination of performance and price on high-speed, masonry, and floor saws. The laser welded segments are designed for cutting speed and long life, while a precise 1"/20mm laser cut dual arbor hole provides consistently secure mounting on the saw. Premium features combined with low pricing make for a reliable, fast cutting, long life blade for a variety of common construction materials.

SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
14 x .125 x 1"/20mm	.472"	5,460	MULTICUT14125	701846 09680
16 x .125 x 1"/20mm	.472"	4,500	MULTICUT16125	701846 31788



TECH TIP

High-Speed Hand Saw Blades –
Maximum Blade Cutting Depths and
Recommended Operating Speeds

Note: Diamond blade cutting depths listed are approximate. Actual cutting depth will vary with the exact blade diameter or saw type, or the exact diameter of the blade flanges. Cutting depth will also be reduced if saw components extend below the blade flanges.


BLADE DIAMETER	CUTTING DEPTH	MAXIMUM SPEED (RPM)
12"	4"	6,300
14"	5"	5,460
16"	6"	4,500



It is the user's responsibility to refer to and comply with ANSI B7.1

For Reinforced Concrete and Harder Building Materials


DRY – Crack Chasing 

CHARGER 				
A heavy V-shaped segment designed with a special bond and diamond content for maximum removal of grout, mortar jointing, crack chasing and crack widening. Fast cutting and long life in abrasive materials using portable tools. Highly competitive to others of its kind in the market.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .375 x 7/8-5/8-20mm	.550"	15,000	CGCC0400	701846 83856
7 x .375 x 7/8-5/8-20mm	.550"	8,730	CGCC0700	701846 83859



For Asphalt and Abrasive Materials


Dry – Tuck Pointing 

CLASSIC 				
An economical solution for small to medium tuck pointing jobs. High-quality performance for heavy grout removal or mortar jointing. The heavy-duty wide segment reduces wear in abrasive materials.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .250 x 7/8-5/8	.275"	15,000	CHTUCK0400	701846 81776
4-1/2 x .250 x 7/8-5/8	.275"	13,300	CHTUCK0450	701846 81777
5 x .250 x 7/8-5/8	.275"	12,000	CHTUCK0500	701846 81778
7 x .250 x 7/8-5/8	.275"	8,730	CHTUCK0700	701846 81779




For General-Purpose and Masonry Building Materials

Dry – Segmented Rim 


CHARGER 				
High-performance dry cutting of a variety of materials. The segment specification allows extended life and fast cut for medium to large jobs.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.393"	15,000	CGDSEG0400	701846 81505
4-1/2 x .080 x 7/8-5/8-20mm	.393"	13,300	CGDSEG0450	076607 04021
5 x .080 x 7/8-5/8-20mm	.393"	12,000	CGDSEG0500	701846 82851
6 x .080 x 7/8-5/8-20mm	.393"	10,185	CGDSEG0600	701846 83820
7 x .090 x DM-7/8-5/8	.393"	8,730	CGDSEG0700	076607 04020



VALUPLUS 				
For value and performance on small- to medium-size jobs cutting soft abrasive materials like brick and tile. The sintered rim delivers a quality cut and good life.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.315"	15,000	VPSEG0400	701846 84098
4-1/2 x .080 x 7/8-5/8-20mm	.315"	13,300	VPSEG0450	701846 84099
7 x .090 x DM-7/8-5/8	.315"	8,730	VPSEG0700	701846 84100




Dry – Turbo Rim 

CHARGER 				
Combines the characteristics of a standard Charger blade with a turbo rim configuration for cutting hard, dense materials with minimal effort. A better bond and diamond concentration for maximum cutting speed, life and quality of cut.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.393"	15,000	CGTURB0400	076607 05475
4-1/2 x .080 x 7/8-5/8-20mm	.393"	13,300	CGTURB0450	076607 04023
5 x .080 x 7/8-5/8-20mm	.393"	12,000	CGTURB0500	701846 82853
7 x .090 x DM-7/8-5/8	.393"	8,730	CGTURB0700	076607 04022



For Natural Stone and Tiles


Dry – Continuous Rim 


CLASSIC 				
An economical solution for small- to medium-size jobs cutting softer ceramic tile and stone materials with efficient cutting ability.				
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x .080 x 7/8-5/8-20mm	.275"	15,000	CON4DT	076607 02793
4-1/2 x .080 x 7/8-5/8-20mm	.275"	13,300	CON45DT	076607 01194
7 x .090 x DM-7/8-5/8	.275"	8,730	CON7DT	076607 02788



For Reinforced Concrete and Harder Building Materials

WET – Medium Aggregates 


CHARGER 					
The steel core is designed to keep the cut straight while the .410" segment height prolongs cutting wear. Suitable for cutting medium aggregates with up to 35 HP walk-behind saws.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.413"	4,365	35hp	CGWCMD1412	70184681366
18 x .125 x 1	.413"	3,395	35hp	CGWCMD1812	70184681368

CLASSIC 					
Laser welded blade at an economical price for general purpose cutting of cured concrete, medium-hard aggregate and no steel reinforcement. The bond and diamond combination allow fast cutting action on limited horse powered walk-behind saws.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
16 x .125 x 1	.315"	3,820	35hp	CHWCGP1612	70184681360
18 x .125 x 1	.327"	3,395	35hp	CHWCGP1812	70184681361




For Asphalt and Abrasive Materials


DRY – Green Concrete  + 

GMAX – MULTI-PURPOSE 					
Designed specifically for our GC55 down-cut green concrete push saw, the GMAX Multi-Purpose blade is excellent in green concrete. The unique segment specification and anchor slot gullet allows this blade to be used in green concrete applications with outstanding results.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
8 x .095 x 1-5/8	.393"	7,640	6hp	NXDGRN0895	70184683758
9 x .110 x 1-5/8	.275"	6,600	6hp	EE9110	70184675125
10 x .110 x 1-5/8	.275"	6,115	6hp	EE10110	70184684508



WET – Asphalt 

CHARGER 					
For large road and construction jobs with saws up to 35 HP. Higher diamond content increases productivity and offers faster cutting and longer life in asphalt and green concrete applications.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.327"	4,365	35hp	CGWASP1412	70184681478
18 x .125 x 1	.307"	3,395	35hp	CGWASP1812	70184681479

CLASSIC 					
An economical choice for fast cutting and good life when performing jobs in a variety of abrasive materials such as green concrete and asphalt on saws up to 35 HP.					
SIZE (D x T x H)	SEGMENT HEIGHT	MAX RPM	POWER	PART #	UPC #
14 x .125 x 1	.326"	4,365	35hp	CHWASP1412	70184681375
18 x .125 x 1	.326"	3,395	35hp	CHWASP1812	70184681376



TECH TIP

Walk-Behind Saw Blades – Maximum Blade Cutting Depths and Recommended Operating Speeds

Note: Diamond blade cutting depths listed are approximate. Actual cutting depth will vary with the exact blade diameter or saw type, or the exact diameter of the blade flanges. Cutting depth will also be reduced if saw components extend below the blade flanges.


BLADE DIAMETER	CUTTING DEPTH	IDEAL SPEED (RPM)	MAXIMUM SPEED (RPM)
8"	2"	4,536	7,640
9"	2-1/2"	2,640	6,600
10"	3"	2,446	6,115
14"	4-5/8"	2,592	4,365
18"	6-5/8"	2,016	3,395



It is the user's responsibility to refer to and comply with ANSI B7.1




Norton Clipper cup grinders are available in a range of specifications and diameters providing a solution for a number of applications in the building and construction industry. There are many benefits to diamond grinding. It's very fast, low-cost and creates little noise compared to other concrete cutting options. It has become a very popular choice in the commercial construction and DIY home improvement industries.

- Applications:** Used on right angle grinders to grind concrete, stone and masonry materials.
- Size Range:** 4" – 7"
- Segment Height:** .177", .210"
- Range:**
- Abrasive Grain:** Diamond
- Mounting Options:** 5/8"-11 attachment optimized for all popular angle grinders, 7/8-5/8"-20mm
- Options:** Standard – single row or double row available
iHD (Infiltrated High-Density) has thicker body, larger ventilation holes for better cooling
- Machines Used:**  RIGHT-ANGLE GRINDER

General-Purpose and Masonry Building Materials


Dry – Cup Grinder 

3X3 WITH iHD TECHNOLOGY 
The 3X3 cup grinder ensures very high material removal rate, extreme comfort while working without vibrations and a self-sharpening feature. These new iHD cups offer the best finishing and longest life even on softer, more abrasive materials.


SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x 5/8"-11	.177"	15,000	3X3CG0400	701846 01763
5 x 5/8"-11	.177"	12,000	3X3CG0500	701846 01766
7 x 5/8"-11	.177"	8,730	3X3CG0700	701846 01769

CHARGER WITH iHD TECHNOLOGY 
The Charger cup grinder ensures a high material removal rate and more comfortable work. These new iHD cups provide a better finish and long life on a wide range of materials.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x 5/8"-11	.177"	15,000	CGCG0400	701846 01762
5 x 5/8"-11	.177"	12,000	CGCG0500	701846 01765
7 x 5/8"-11	.177"	8,730	CGCG0700	701846 01768

CLASSIC WITH iHD TECHNOLOGY 
The Classic cup grinder provides efficient material removal rate thanks to the small contact surfaces of the segments. The cups also have flat sides to avoid damaging walls or ceilings during flush grinding.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
4 x 5/8"-11	.177"	15,000	CCCG0400	701846 01761
5 x 5/8"-11	.177"	12,000	CCCG0500	701846 01764
7 x 5/8"-11	.177"	8,730	CCCG0700	701846 01767

CLASSIC 
Available in a range of sizes and segment designs for optimum performance by life or by speed. Ideal for leveling all types of masonry materials, brick, block, concrete and stone. Strategically placed hole designs help ventilate dust from the surface to extend the life of the cups.

SIZE (D x H)	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
Single Row for Fast Stock Removal				
4 x 7/8-5/8-20mm	.210"	15,000	CHSCPH0400	701846 82585
5 x 7/8-5/8-20mm	.210"	12,225	CHSCPH0500	701846 84035
7 x 7/8-5/8-20mm	.210"	8,730	CHSCPH0700	701846 82594
4 x 5/8"-11	.210"	15,000	CHSCPT0400	701846 82555
5 x 5/8"-11	.210"	12,000	CHSCPT0500	701846 84036
7 x 5/8"-11	.210"	8,730	CHSCPT0700	701846 82593
Double Row for Long Life, Smooth Finish				
4 x 7/8-5/8-20mm	.210"	15,000	CHDCPH0400	701846 82588
5 x 7/8-5/8-20mm	.210"	12,225	CHDCPH0500	701846 84037
7 x 7/8-5/8-20mm	.210"	8,730	CHDCPH0700	701846 82596
4 x 5/8"-11	.210"	15,000	CHDCPT0400	701846 82586
5 x 5/8"-11	.210"	12,000	CHDCPT0500	701846 84038
7 x 5/8"-11	.210"	8,730	CHDCPT0700	701846 82595

Accessories

VACUUM SHROUD KIT
The Vacuum Shroud's design creates a cyclonic affect extracting dust and debris from the work surface into the support vacuum. This prolongs the life of the grinding cup and grinder and provides a smoother surface while decreasing the chance of dust particle inhalation.

DESCRIPTION	UPC #
5" vacuum shroud kit – includes one shroud, five different adapter rings to fit most popular right angle grinders, and one 5" x 5/8-11 Norton Clipper cup wheel.	701846 94059





Core bits are cutting tools used to remove a cylindrically shaped piece of material. A core drill is designed to cut a hole and remove a core sample or to drill a hole without leaving material behind. Diamond core bits have diamond cutting tips and are frequently used for drilling in materials such as concrete, stone, and asphalt.

- Applications:** Used on core drills in materials such as concrete, stone and other hard materials
- Size Range:** 2" – 10"
- Segment Height Range:** .254", .393"
- Abrasive Grain:** Diamond
- Mounting Options:** 1-1/4"-7 threads
- Machines Used:**



Reinforced Concrete and Harder Building Materials

WET – Hard Aggregates



PARADIGM					
Premium diamond in the turbo segment permits the core to penetrate quickly and efficiently into the toughest cured concrete, for significantly increased performance. The 14" tube length with 1-1/4"-7 threads fits a wide range of core drill mounting arbors.					
SIZE IN INCHES	SIZE IN MM	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
2	51mm	.490"	2,000	PDBIT0200	701846 01410
2-1/2	64mm	.490"	1,300	PDBIT0250	701846 01411
3	76mm	.490"	1,300	PDBIT 0300	701846 01412
3-1/2	89mm	.490"	1,300	PDBIT0350	701846 01413
4	102mm	.490"	1,000	PDBIT0400	701846 01414
4-1/2	114mm	.490"	800	PDBIT0450	701846 01415
5	127mm	.490"	800	PDBIT0500	701846 01416
6	152mm	.490"	665	PDBIT0600	701846 01417
7	178mm	.490"	600	PDBIT0700	701846 01418
8	203mm	.490"	500	PDBIT0800	701846 01419
10	254mm	.490"	400	PDBIT1000	701846 01706

CLASSIC					
Economical choice for use in harder concrete with heavy reinforcement and masonry materials with good performance.					
SIZE IN INCHES	SIZE IN MM	SEGMENT HEIGHT	MAX RPM	PART #	UPC #
2	51mm	.350"	2,000	CHBIT0200	701846 82762
3	76mm	.350"	1,300	CHBIT0300	701846 82765
4	102mm	.350"	1,000	CHBIT0400	701846 82767
6	152mm	.350"	665	CHBIT0600	701846 82771
8	203mm	.350"	500	CHBIT0800	701846 82773
10	254mm	.350"	400	CHBIT1000	701846 82774



TECH TIP

Core Bits – Minimum and Maximum Recommended Operating Speeds

BIT DIAMETER	MINIMUM RPM	IDEAL SPEED (RPM)	MAXIMUM RPM
1	2,400	3,200	4,000
2	1,200	1,600	2,000
3	800	1,050	1,300
4	600	800	1,000
5	475	640	800
6	400	530	665
7	340	450	600
8	300	400	500
10	240	320	400

Note: For half inch increments, go to the next larger bit diameter.



It is the user's responsibility to refer to and comply with ANSI B7.1



High-Speed Gas Saws

No more pre-mixing oil and fuel – the patented iLube option automatically controls mixing for maximum efficiency, and the saw drops to idle speed when the oil is low – eliminating possible machine damage

Walk-Behind Saws

Proven, robust and functional for ideal user comfort. The professionals' choice for outstanding walk-behind cutting performance, wet or dry.

Masonry Saws

Norton introduced the first masonry saw over 85 years ago and they have become the industry standard for masons worldwide.

For the full line of quality Norton Clipper equipment, please contact your local Norton sales representative

High-Speed Gas Saws

CP500 SERIES HIGH-SPEED SAWS

The Norton Clipper CP500 high-speed cut-off saw might be new to the market, but it's destined to be an asset on any crew. It's fully designed with the user in mind to not only cut a smooth, fast track, but it's also fully equipped to handle the everyday performance of any jobsite with unrelenting durability and reliability. Select a standard model or upgrade to the world's first patented automatic lubrication system, Norton Clipper iLube.

The patented iLube option automatically controls mixing of oil and fuel for maximum efficiency. An electronic sensor will indicate a low oil level and adjust the engine to idle to prevent engine damage.

DESCRIPTION	SHAFT RPM	PART #	UPC #
14" Standard High-Speed Cut-Off Saw	4,500	CP514-350	701846 47563
14" iLube High-Speed Cut-Off Saw	4,500	CP514-350i iLube	701846 47565

ACCESSORIES

High-Speed Saw Wheel Kit	005101 09845
High-Speed Saw Tool Kit	005101 09846



Walk-Behind Push Saws



GC55 EARLY ENTRY/GREEN SAW

With a compact, light-weight design backed by the reliable Honda 5HP gasoline engine, the GC55 early entry saw is intended for a variety of applications. From green, cured or decorative concrete cutting to expansion joints, the features of this small push saw are hard to beat in a single saw. The low, wide profile of the frame, along with the front mount blade, contribute to producing a more disciplined cut.

UPC #	MOTOR	WEIGHT	GUARD
701846 30005	Honda GX160	115 lbs	10"



C1318P GASOLINE SAW

The next generation of 13HP saws. The C1318P features shock-absorbing handle bars. The new sleek design of the water tank, with increased capacity and improved securing, adds an additional 1.5 gallons of water over the cut. And, a newly-designed belt tensioning system helps keep the saw cutting true and true. All these features, coupled with the Honda 13HP engine, make the C1318P the premiere choice for rental and service work.

UPC #	MOTOR	WEIGHT	GUARD
701846 42453	Honda GX390	220 lbs	18"



C13PE GASOLINE SAW

Rental equipment has to withstand any and all conditions by user and application. For that reason, the Norton Clipper C13PE suits any rental fleet that both the novice and expert will appreciate to hold-up through tough situations. The 18" blade guard, ride-on water system and quick-release blade guard lock all keep safety in mind while the rugged frame, powerful engine and easy-to-use console makes cutting a breeze.

UPC #	MOTOR	WEIGHT	GUARD
701846 47524	Honda GX390	220 lbs	18"



Large Masonry Saws

BBL BLOCKBUSTER LARGE MASONRY SAWS

Having introduced the first masonry saw over 70 years ago, the Norton Clipper BBL heavy-duty block saws have become the industry standard for masons worldwide. These models are equipped with single-phase electric motors and come with a blade capacity of 14" or 20". Extended water pan and open back frame allow cutting of larger materials. The balanced cutting head makes for effortless cutting depth positioning. Having a rugged all-steel frame design with forklift brackets allows these saws to resist twisting and damage during transport around a job site. For other sizes and horsepower machines, or for gasoline-powered versions, contact your Norton sales representative.

DESCRIPTION	HP	PART #	UPC #
BBL547 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	5	BBL547	701846 83211
BBL527 Blockbuster Saw with Baldor electric motor; 20" blade guard capacity	5	BBL527	701846 83150

ACCESSORIES	UPC #
Electric Water Pump – PE-1	701846 68392
Conveyor Cart Replacement for BBL	003100 07390



Electric Water Pump



Conveyor Cart Replacement



Compact Masonry Saws

BBC BLOCKBUSTER COMPACT MASONRY SAWS

Combines the performance of a full size masonry saw with the convenience of portability. Also available in gas or electric versions, the BBC saws have a rugged jig-welded frame, durable enough for even the heaviest work load. Standard rear wheel dolly design and removable legs make transport and set-up easy. For other sizes and horsepower machines, or for gasoline-powered versions, contact your Norton sales representative.

DESCRIPTION	HP	PART #	UPC #
BBC157 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	1.5	BBC157	701846 82488
BBC207 Blockbuster Saw with Baldor electric motor; 14" blade guard capacity	2	BBC207	701846 82501
BBC307 Blockbuster Saw with Baldor electric motor; 20" blade guard capacity	3	BBC307	701846 30011
BBC547 Blockbuster Saw with Honda gasoline motor; 14" blade guard capacity	5.5	BBC547	701846 82175
BBC507 Blockbuster Saw with Honda gasoline motor; 20" blade guard capacity	5.5	BBC507	701846 30012

ACCESSORIES	UPC #
Electric Water Pump – PE-1	701846 68392
Conveyor Cart Replacement for BBC	003100 07367
Mechanical Water Pump Assembly (water pump not included)	003100 04237
Water Pump Pulley	003100 04669



Mechanical Water Pump Assembly



BBC 9' Mechanical Water Pump Kit



BBC Water Pump Pulley



BBC Conveyor Cart Replacement



Mini Masonry Saws

BBM BLOCKBUSTER MINI MASONRY SAWS

The innovative design of these small masonry saws has been copied many times due to its compact, all-steel unibody construction, giving the best weight-to-strength distribution. A 14" blade capacity and ergonomically-designed, three-position locking, cutting head provides a safe, clear view of the work area. Whether your choice is the 3HP brush motor or the 1.5HP induction motor for heavier commercial use, both come with features such as overload protection, garden hose connection and a channeled-flow water pan to direct dust and slurry away from the operator.

DESCRIPTION	HP	PART #	UPC #
Blockbuster Mini Masonry Saw with AC universal motor; gear drive	3	BBM307	701846 00684
Blockbuster Mini Masonry Saw with Induction motor; belt drive	2	BBM158	701846 26327
ACCESSORIES			
Conveyor Cart with Vacuum Attachment			701846 02862
Wet Kit			701846 00704
Stand			701846 00691



Wet Kit



Stand

shine on
EVERY STEP OF THE WAY

Finishing and masking products to help you finish the job right. Our polishing compounds and surface finishing products along with application accessories are designed to provide the highest level of shine.





The Farécla system of compounds and waxes is designed to achieve a perfect finish on painted and gel coat surfaces. A full line of cutting and polishing compounds, along with application accessories, will enhance the highest-level shine. Farécla compounds contain a unique abrasive technology that removes sanding marks permanently, avoiding costly reworks.

Farécla polishing compounds and surface finishing products are used on a wide variety of substrates and have been used by automotive bodyshops, detailers, boat builders, woodworkers, composite manufacturers and other industrial applications since 1952.

Products:

Liquid Compound, Paste Compound, Wax, Applicator Pads, Microfiber Cloths

Markets:

Marine, Prime Automotive, General Transportation, Solid Surfaces, Instruments and more

Surface Types:

Paint/Laquer, Gel Coat, Composite

Machine Used:



HAND
APPLICATION



PNEUMATIC OR
VARIABLE SPEED BUFFER



DUAL ACTION
POLISHER

Step One – Compounding



For use on all wood lacquers, clear coats and paints

PROFILE ADVANCED PLUS 400 LIQUID COMPOUND

- Offers the highest level of cut and gloss on painted surfaces and wood lacquers
- Unique abrasive technology which contains no fillers or silicones allow operators to see sanding marks from up to P1500 grit permanently removed
- Provides a high shine finish with good depth and clarity

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored liquid	Medium	152 g/L	0.95	8 - 9	All wood lacquers, clear coats and paints



For use on any gel coat surfaces

PROFILE SELECT 200 LIQUID COMPOUND

- A great value, swirl-free, versatile, cutting compound aimed at OEM applications removes P800 grit or finer sanding marks from tooling or production gel coats in a single step
- Used with a wool pad, quickly removes sanding marks up to P1500 on painted surfaces, performs best on a twisted wool compounding pad at high speeds of 2,000-3,500 rpm
- Clean in use, and loads application pads evenly for a fine shine

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored liquid	Medium	152 g/L	0.95	8 - 9	Any painted or industrial surface



For use on marine gel coats, wood, aerospace, caravans, and motorhomes etc.

PROFILE PREMIUM PASTE

- Ideal for removing sanding marks of P1200 and finer or restoring oxidized and weathered gel coat surfaces
- Works great as a single step on dark colors delivering a high gloss finish
- Use as the first stage of a two-part process where higher gloss and lower swirl is desired

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White thick liquid	High	266g/L	1.15	7 - 8	Marine gel coats, wood, aerospace, caravans, and motorhomes etc.

Step One – Compounding *continued*



For use on marine gel coats, wood, aerospace, caravans, and motorhomes etc.

PROFILE 100 EXTRA HEAVY CUT PASTE COMPOUND

- Removes up to P600 sanding marks; leaves a low level shine in comparison to other compounds
- Easy to apply; with added lubrication it resists drying out in hot conditions or on large working surfaces
- Often used as the sole compound on white gel coats

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White thick liquid	High	KG	1.65	10	Marine gel coats, wood, aerospace, caravans, and motorhomes etc.



For use on hard tooling and production gel coats, and solid surfaces

PROFILE PREMIUM COARSE CUT PASTE COMPOUND

- Coarse, water-based cutting compound designed for aggressive compounding on tough resins and gel coats
- Removes sanding marks up to P800 while leaving you with a high gloss finish
- Suitable for stone, granite and other surfaces

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored paste	High	0g/L	1.57	9.6	Hard tooling and production gel coats, and solid surfaces



For use on polyester, acrylic and epoxy resins and gel coats, industrial paint finishes, wood lacquers and solid surfaces

PROFILE 300 RAPID CUT PASTE COMPOUND

- Versatile, mid-range, high gloss, water-based compound capable of removing P1000 or P1200 dry abrasive marks
- Restores gloss and color to virtually any gel coated or painted surface
- Can be used by itself or with other compounds either as a first stage or as a finishing compound

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored paste	High	119g/L	1.45	9.8	Polyester, acrylic and epoxy resins and gel coats, industrial paint finishes, wood lacquers and solid surfaces

Liquid



TRADENAME:

**PROFILE 400
ADVANCED PLUS**

**PROFILE 200
SELECT**

**PROFILE 350 PREMIUM
LIQUID GRP FAST MEDIUM CUT**

SIZE	ORD. QTY.	PRODUCT #	PART #	PRODUCT #	PART #	PRODUCT #	PART #
1 Litre	6	PRA101	780727 15147	PRS101	780727 00168	PRL112	780727 63911
1 Gallon	2	PRA118	780727 15148	PRS106	780727 00169	PRL118	780727 64005
5 Gallon	1	PRA518	780727 29474	PRS506	780727 29473		

Paste



TRADENAME:

**PROFILE 100
EXTRA HEAVY CUT**

**PROFILE PREMIUM
COARSE CUT PASTE**

**PROFILE 300
RAPID CUT COMPOUND**

SIZE	ORD. QTY.	PRODUCT #	PART #	PRODUCT #	PART #	PRODUCT #	PART #
3 kg	24	PRE306	780727 63866	PRP306	780727 64019	PRO300-3000	780727 64012

Step Two – Finishing



For use on all paint types

PROFILE FINISH LIQUID COMPOUND

- Fine abrasive formulation quickly and permanently removes swirls and holograms
- Restores dull surfaces and enhances color for a high shine finish with good depth clarity
- Ideal economical solution to compounding with low viscosity

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
White colored liquid	Medium	152 g/L	0.95	8 - 9	All paint types



TRADENAME: **PROFILE FINISH**

SIZE	ORD. QTY.	PRODUCT #	PART #
1 Litre	6	PRF101	780727 00164



Step Three – Protecting



For use on any painted or industrial surface

PROFILE POLYMER WAX

- Quick and easy to use making short work of large surfaces, perfect for use on boats, vans, trucks and planes
- Creates a durable, highly water resistant protective coating which repels many common contaminants; high-gloss finish has excellent evenness and real transparency on dark colors
- Sprayable formulation is perfect for ultra-fast applications due to its low viscosity and drying resistance

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
Pink colored liquid	Low / Medium	131 g/L	0.960	7	Any painted or industrial surface



For use on all paint types

PROFILE UV WAX

- Carnauba based wax incorporating special UV absorbers to give up to 3 month's protection to gel coats and paints exposed to external weathering
- High Carnauba content ensures long-lasting protection against rain and salt water while the UV absorbers protect against exposure to sunlight
- Gives a high-gloss, long-lasting finish on most surfaces; well suited for use on boats, caravans, trains, planes, lacquered wood and UPVC surfaces

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
Pale purple liquid	Medium viscosity	167g/L	0.970	7 (approx.)	All paint types



For use on all paint types and surfaces

PROFILE RAPID DETAILER CLEANER & WAX

- Fast liquid spray wax for that "just waxed" look or a quick clean leaving a high-gloss finish
- Perfect for paintwork, rubber, vinyl, plastic, glass, and chrome
- Won't remove previously applied polishes or waxes aiding continuous protection

Technical Information

APPEARANCE	VISCOSITY	VOC CONTENT	RELATIVE DENSITY	PH	PAINT TYPE COMPLIANCE
Colorless thin liquid	Low viscosity	27g/L	0.990	8 - 9	All paint and surface types



TRADENAME:		PROFILE POLYMER WAX		PROFILE UV WAX		PROFILE RAPID DETAILER CLEANER & WAX	
SIZE	ORD. QTY.	PRODUCT #	PART #	PRODUCT #	PART #	PRODUCT #	PART #
1 Litre	6	PRW101	780727 00171	PRU101	780727 00170		
1 Gallon	2					PRD106	780727 17216



Having the right applicator pad, whether it's a wool, waffle or dimple configuration will help others see the perfection in your work. Multiple choices in size and face to evenly distribute the Farécla compounds and create a reflection others will envy.

Products:

Foam Pads, Waffle Pads, Wool Pads, Buffing Pads, Spot Repair Pads, Micro-Fiber Cloths

Application:

Even distribution of compounds and waxes; polishing

Machine Used:



HAND
APPLICATION



PNEUMATIC OR
VARIABLE SPEED BUFFER

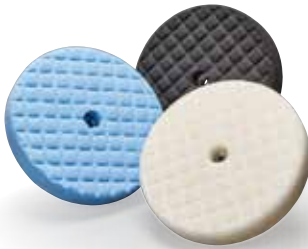
Single-Sided Pads



Single-Sided Pads have a beveled edge design to allow access under trim and improve user control. The recessed back provides accurate alignment for balance and protects against backing plate contact.

SIZE/DESCRIPTION	STD. PKG.	PART #
CCS Dimple Foam Pad – Single-Sided		
3.25" Cutting and Polishing - Orange	6	662610 85302
3.5" Cutting - White	6	666233 91319
3.5" Polishing - Black	6	666233 91320
3.5" Finishing - Blue	6	666233 91321
Cutting Wool Pads – Single-Sided		
3.5" Cutting Wool	6	666233 91318
CCS Waffle Foam Pads – Single-Sided		
8" Cutting - White	6	666233 91306
8" Polishing - Black	6	666233 91307
8" Finishing - Blue	6	666233 91308
Finishing Wool Pads		
8" Single-Sided Wool Pad	6	666233 91315
8" Single-Sided Blended Yellow Wool Pad	6	780727 59561
8" Double-Sided Blended Yellow Wool Pad	6	780727 59563

Double-Sided Pads



Double-Sided Pads have a highly engineered center plate designed to minimize pad hop or chatter with the perfect amount of flexibility when buffing contours.

SIZE/DESCRIPTION	STD. PKG.	PART #
CCS Waffle Foam Pads – Double-Sided		
8" Cutting - White	6	666233 91310
8" Polishing - Black	6	666233 91311
8" Finishing - Blue	6	666233 91312

Spot Repair Pads for Buffing/Polishing



Hook and loop polishing pads for small spot repair

SIZE/DESCRIPTION	STD. PKG.	PART #
Spot Repair Foam Pads		
3" Super Cut Wool Pad	40	636425 43832
3" Blue Cutting Foam Pad	40	636425 05459
3" White Finishing Foam Pad	40	636425 05460
Back-up Pad		
3" Back-up Pad	40	636425 06128

Buffing Pads and Accessories



Wool pads give a high cut and great finish. Our polish applicator pads are available in sizes to suit a range of rotary polishers, including 3" and 8" with backing plates also available.

SIZE/DESCRIPTION	STD. PKG.	PRODUCT #	PART #
G Mop Series Buffing Pads			
8" G Mop Single-Sided Red Waffle Pad	6	PRF801	780727 44634
Buffing Pads			
8" Single-Sided Lambswool Pad	6	LPS801	780727 45650
8" Double-Sided Wool Pad	6	10045	780727 45643
8" US Advanced Wool Compounding Pad	6	40012	780727 45649
Accessories for G Mop Series Buffing Pads			
3" and 6" Rotary Extension	6		666233 91317
3.5" Back-up Plate	6		666233 91316
8" Double-Sided Pad Adapter	6		666233 91313
8" Double-Sided Quick-Change Pad Adapter	6		666233 91330
8" Back-up Plate	6		666233 91314
Pad Conditioning Brush	6		666233 91489



Micro-Fiber Performance Cloths



Cleaning Cloth – Blue: Used for general-purpose wet or dry applications. Works best when sprayed with a light water mist to deep clean.

Dry Tack Cloth – Red: This woven terry cloth has a low profile to resist snagging and help pick up embedded debris.

Polishing Cloth – Yellow: Streak-free cleaning of mirrors, optical lens and highly-polished items.

SIZE	COLOR	STD. PKG.	PART #
Micro-Fiber Cleaning Cloth			
16" x 16"	Dark Blue (thick)	20	636425 04402
16" x 16"	Light Blue	20	076607 05300
Micro-Fiber Dry Tack Cloth			
16" x 16"	Red	20	076607 04025
Micro-Fiber Polishing Cloth			
16" x 16"	Yellow	20	076607 05301

TECH TIP

- Use these micro-fiber cloths dry for general cleaning
- To remove spills, stains or grime, lightly dampen the cloth for best results
- All micro-fiber cloths can be used with or without chemicals
- Micro-fiber cloths can be washed up to 300+ times without losing cleaning and trapping abilities
- Clean often for best results



It is the user's responsibility to refer to and comply with all safety regulations.





Norton masking tapes feature a special solvent-based, rubber adhesive system and strong holding properties. These tapes adhere and release cleanly while providing clean edges on a variety of flat, contoured, and irregular surfaces. Norton sheetings provides superior solvent, paint, and contaminant penetration resistance. Use them during paint preparation and anywhere you need work area protection. Tear-resistant properties allow movement without ripping.

Products:

Attachment Tape, Masking Tape, Sheeting

Machine Used:



HAND
APPLICATION

Best choice for dynamic bus, truck and trailer bonding applications

**NORBOND A7600
DOUBLE-SIDED ACRYLIC FOAM TAPE**

- High performance, double-sided acrylic foam tape with outstanding viscoelastic and adhesion properties and great conformability to dynamic stress loads
- Offers ideal bonding performance for many interior and exterior industrial and automotive applications
- Formulated for durable, long-lasting adhesion, exceeds industry standards for shear strength and bonding to high surface energy substrates, even at elevated temperatures

Good choice for bonding performance for many interior and exterior commercial applications

PREMIUM ATTACHMENT TAPE

- Double sided, gray foam tape used in bonding performance for many interior and exterior commercial applications
- Good conformability and stretching
- Resistance to weathering degradation (UV and high temperature)

DESCRIPTION	THICKNESS	3/8" x 108'	1/2" x 108'	3/4" x 108'	1" x 108'	1-1/2" x 108'
Norbond A7600						
Double-Sided Acrylic Foam Tape	.043" (1.1mm) .063" (1.6mm)	780727 59979 NS	780727 64821	780727 02902	780727 02903	780727 02904 NS
Rolls/Case		25/1	20/1	10/1	10/1	8/1
DESCRIPTION	THICKNESS	1/4" X 20 YDS	1/2" X 20 YDS	7/8" X 20 YDS		
Premium Attachment Tape						
Gray Double-Sided Acrylic Foam Tape	.043" (1.1mm)	636425 05620	636425 05621	636425 05622		
Rolls/Case		12/1	12/1	12/1		
Adhesion Promoter						
Dauber - 4 oz.		666233 91030				
Qty/Case		6				

NS Non-Stock: Please contact your Norton representative for current lead-times.

Technical Data

Performance tests are run using standard test procedures. The values presented are typical values and should not be used for specification purposes.

	90° PEEL ADHESION ¹ (3-DAY DWELL) lb/in ² (N/cm ²)	T-BLOCK ² lb/in ² (N/cm ²)	DYNAMIC SHEAR ³ lb/in ² (N/cm ²)	STATIC SHEAR ⁴ 7 Days /1 kg S/S	SERVICE TEMPERATURE
WITHOUT LINER	ALUMINUM	ALUMINUM	S/S	S/S	
Norbond A7600	22 (39)	83 (57)	79 (54)	Pass and Exceed	-30°F to 200°F (-35°C to 93°C)
Premium Attachment Tape	33 (57)	100 (69)	48 (33)	Pass and Exceed	-30°F to 200°F (-35°C to 93°C)

¹ Based on ASTM D3330 ² Based on ASTM D897 ³ Based on ASTM D1002 ⁴ Based on ASTM D3654

It delivers very sharp, clean edges on smooth- to moderately-textured surfaces



BLUE CORE 14-DAY TAPE

- Our paint masking tape has a specially formulated adhesive system that provides optimum low- to medium-tack adhesion and clean removal from a variety of surfaces, for up to 14 days
- Blue Core masking tape can be used indoors or out
- The crepe paper backing is designed to enable easy unrolling and to minimize slivering



TIER:	GOOD
TRADENAME:	BLUECORE 14 DAY TAPE
BACKING:	Fine Crepe Paper
ADHESIVE:	Synthetic Rubber
TENSILE STRENGTH:	23 lbs/in (101 N/25mm)
ELONGATION AT BREAK:	11%
TOTAL THICKNESS:	5.5 mils (0.14mm)

METRIC	IMPERIAL	ROLLS/CASE	PART #
Blue Core 14-Day Tape			
36mm x 54.8m	1-1/2" x 60 yards	24	076607 21954
48mm x 54.8m	2" x 60 yards	24	076607 21955

Bulk packed as individual rolls

Good multi-purpose choice provides durability and excellent protection



HIGH DENSITY SHEETING (HDPE)

Our multi-purpose painters' plastic sheeting protects virtually any area from sanding dust and paint overspray with ease – even after repositioning. Our High Density Plastic Sheeting (HDPE) is designed to be one of the strongest most durable products on the market.

- Resists tearing and solvent bleed-through with light weight .31 mil High Density Polyethylene plastic (HDPE)
- Holds in place as it clings to horizontal or vertical surfaces during taping with its natural electrostatic properties
- Attracts and holds sanding debris for a dust-free finish
- Drapes easily over furniture

SIZE	THICKNESS	COLOR	QTY/PACK	PACKS/CASE	PART #
9' x 400'	.31 mil	Clear	1	1	076607 68142
12' x 400'	.31 mil	Clear	1	1	076607 68143

Also available by the pallet.

DON'T LEARN **SAFETY GUIDES** BY ACCIDENT!

SAFETY IS EVERYONE'S JOB

Make the safety of yourself and your team a priority on every job site and learn the proper use and function of all your Norton products and equipment.

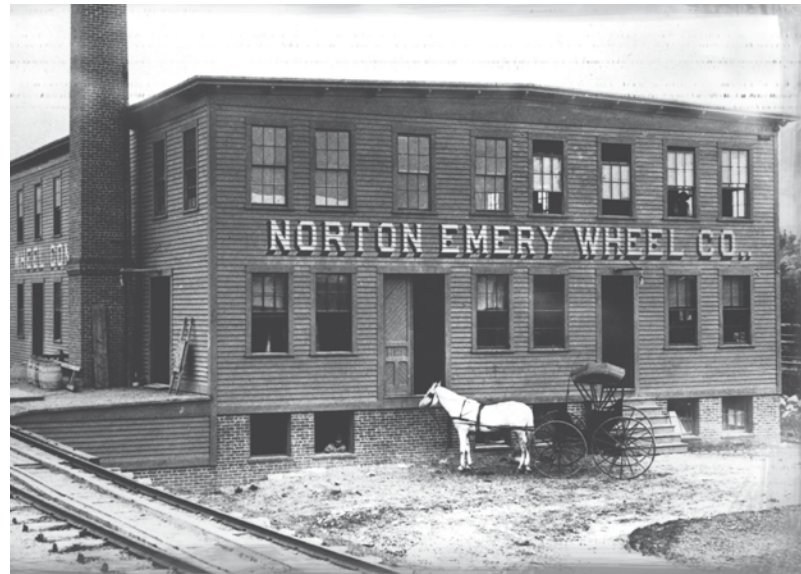


100 Years of Safety Leadership

The year 2016 marked the 100-year anniversary of the leadership of the former Norton Company in the creation of the first ever safety code for abrasives.

In 1916, following more than a decade of safety research, advocacy, and leadership by the Norton Company (now Norton | Saint-Gobain Abrasives), "The Safety Code for the Use and Care of Abrasive Wheels" was published. This 13-page booklet, containing an unprecedented set of safety device recommendations and procedures, was the spark that changed the entire future of the abrasives industry.

In the 1970s, this code received the ultimate endorsement when selected by OSHA as the basis of new federal regulations concerning abrasive wheel machinery. Today, the ever-evolving "Safety Requirements for the Use, Care and Protection of Abrasive Wheels" (commonly known as the ANSI B7.1 standard) continues to mirror the latest technologies and remains the global authoritative abrasives safety standard.



Breakages/Personal Injury

In the event of on-machine breakage of Norton abrasive products, call your local Norton distributor immediately. Whether involving personal injury or not, the abrasive user should leave the equipment and other evidence undisturbed until a Norton sales representative has been notified and conducts an investigation. Prompt action on the part of abrasive users, distributor, and Norton sales personnel is important to ensure swift determination of the breakage cause and to guard against recurrence.



It is the user's responsibility to refer to and comply with ANSI B7.1 and B7.7 – Contact us for a free copy.



Safety Poster
(Form # 7868-English, 7868-French, 7868-Spanish)

To order this poster for your shop,
<mailto:nortonliterature@saint-gobain.com>

Abrasive Safety References



Safety Information on the Web

Visit our newly updated safety website for safety guides, safety data sheets, videos and lots of additional safety resources. nortonsga.us/safety

UAMA (United Abrasives Manufacturers Association) website at safety.uama.org

Safety Videos







Watch our Safety Videos

[YouTube.com/NortonAbrasives](https://www.youtube.com/NortonAbrasives)

- Safety, It's The Smart Thing To Do (Safety information for portable grinding and cutting wheels)
- Foundry Safety
- First in Precision Grinding Safety
- Proper Grinding Wheel Mounting
- Railroad Abrasive Safety
- Coated Abrasive Belt and Disc Safety












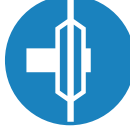

UAMA Approved Safety Icons

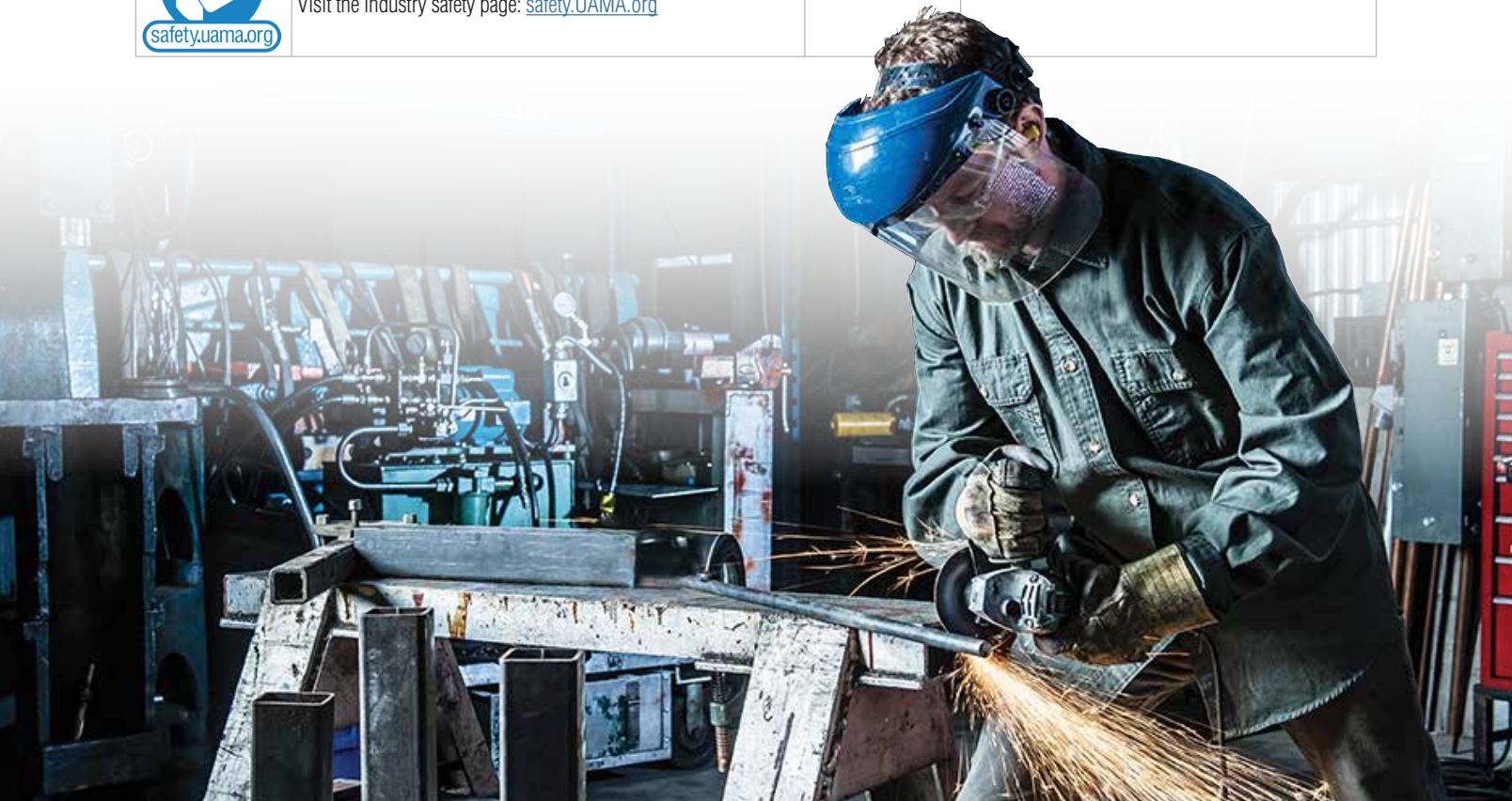
The UAMA has approved a new set of standardized icons to be used throughout the Abrasive industry to convey safety information to the users. Below are the approved icon types and their definitions.

ICON TYPES	EXAMPLE
Safety Icon: A pictorial whose purpose is to relay safety related information to the user.	
Hazard Alert Icon: This type of safety icon conveys information primarily related to the nature of a hazard. It contains a graphical depiction of the hazard drawn within a yellow equilateral triangle.	
Prohibition Icon: This type of safety icon conveys actions that should not be taken. It consists of a red circular band with a 45° diagonal red band from upper left to lower right. The icon contains a black depiction of what should not be done within the red band on a white background.	
Mandatory Action Icon: This type of safety icon conveys actions that should be taken to avoid hazards. It consists of a white image within a solid blue or black circular surround shape.	
Proper Machine Use Icon: This type of icon is designed to show the use of the wheel on a proper machine. The icon can be a bit more realistic to show components such as a safety guard and an auxiliary handle. The recommended angle of use may also be depicted.	

ICON	MEANING	ICON	MEANING
	Improper use may break wheel and cause serious injury or death.		Always use wheel guard for angle grinder.
	No side grinding. Cutting only.		Always use wheel guard for non-portable machine.
	No side grinding. Cutting only		Protect your eyes.
	No cutting. Side grinding only.		Protect your face.
	No cutting. Side grinding only, grouped icon.		Protect your lungs against dust.

UAMA Approved Safety Icons *continued*

ICON	MEANING	ICON	MEANING
	Do not use a damaged wheel.		Protect your hearing.
	Do not use on high-speed gas saws.		Protect your eyes and face.
	Do not use on angle grinders.		Protect your eyes and hearing. Combined icon.
	Do not use on die grinders		Protect your eyes, ears and lungs.
	Warning alert symbol.		Protect your hands.
	Read OSHA and ANSI B7.1.		Use matched diameter, relieved flanges.
	Read OSHA and ANSI B7.1. Visit the industry safety page: safety.UAMA.org		



Coated Abrasive Do's and Don'ts



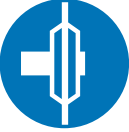




Coated Abrasive Disc and Wheel Safety Do's and Don'ts

Warning



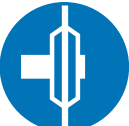




Improper use may cause wheel breakage and serious injury. Comply with ANSI B7.7, OSHA and safety guide provided with the package. Always follow all manufacturer's recommended procedures and safety instructions. Never exceed tool manufacturer's maximum operating speed.

Exposure to DUST generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury. Use dust capture or local exhaust as stated in the SDS. Wear government-approved respiratory protection and eye and skin protection. Failure to follow this warning can result in serious lung damage and/or physical injury.

Lead Poisoning can develop as a result of inhalation and/or ingestion of the dust generated from sanding any product containing lead, including lead based paint. Lead Poisoning is an illness which can permanently damage the body's physical, neurological and/or reproductive systems. Care must be taken to avoid the inhalation and/or ingestion of dust containing lead

	DO'S	DON'TS
INSPECT / STORAGE / SPEED  	<ul style="list-style-type: none"> • DO read all manuals, operating instructions and warnings • DO read SDS for the disc/wheel and the work-piece material. • DO check all products for damage before mounting. • DO make sure the machine speed does not exceed the speed marked on the package or back up pad. • DO store products prior to use at 35 – 50% relative humidity and 60 – 80°F. 	<ul style="list-style-type: none"> • DON'T use products that have been dropped or damaged. • DON'T use on machines that do not show a MAX RPM speed.
MOUNT / GUARD  	<ul style="list-style-type: none"> • DO use the wheel guard provided with machine. Position it so it protects the operator and covers the wheel. • DO use recommended back up pad or mandrel for the product. • DO run wheels ONLY in direction of directional arrow stenciled on wheel and in core (except Unified Wheels, which can be run in either direction). • DO run discs/wheels in a protected area for one minute before grinding. 	<ul style="list-style-type: none"> • DON'T remove or modify any guard. ALWAYS use a proper guard. • DON'T use excessive pressure when mounting a wheel. Tighten enough only to hold wheel firmly.
PROTECT  	<ul style="list-style-type: none"> • DO wear ANSI Z87+ safety glasses and face protection, if required. • DO wear safety shoes, arm guards, leather gloves and aprons. • DO employ dust controls and/or protective measures appropriate to the material being ground. 	<ul style="list-style-type: none"> • DON'T use products near bystanders if they are not wearing protective equipment.
OPERATE 	<ul style="list-style-type: none"> • DO support work-piece firmly. • DO hold machine firmly in two hands. • DO stop the equipment at once if chattering or vibration occurs during use. Determine cause of the problem and correct before remounting. • DO ease the disc into the work piece at a 5-10° angle to the work piece surface. 	<ul style="list-style-type: none"> • DON'T allow untrained people to handle, store, mount or use discs/wheels. • DON'T twist, jam or bend any wheel. • DON'T force or bump wheel so that the tool motor stalls. • DON'T use discs/wheels in the presence of combustible materials. • DON'T use disc/wheel for applications other than for which they were designed. Refer to ANSI B7.7.

Portable Grinding Safety Do's and Don'ts

	DO'S	DON'TS
<p>INSPECT / SPEED</p>  	<ul style="list-style-type: none"> • DO read all manuals, operating instructions and warnings. • DO read SDS for the wheel and workpiece material. • DO check all wheels for cracks or other damage before mounting. • DO make sure the machine does not exceed the maximum operating speed marked on the wheel. • DO store according to ANSI B7.1. 	<ul style="list-style-type: none"> • DON'T use wheels that have been dropped or damaged. • DON'T use on grinders that do not show a MAX RPM.
<p>MOUNT / GUARD</p>  	<ul style="list-style-type: none"> • DO use an ANSI B7.1 wheel guard. Position it so it protects the operator. • DO be sure wheel hole or threads fit machine properly and that the flanges are clean, flat, undamaged and the proper type. • DO run wheel in a protected area for one minute before grinding. 	<ul style="list-style-type: none"> • DON'T remove or modify any guard. ALWAYS use a proper guard. • DON'T alter a wheel or force it on to the spindle. • DON'T mount more than one wheel on an arbor. • DON'T use excessive pressure when mounting a wheel. Tighten enough only to hold wheel firmly.
<p>PROTECT</p>  	<ul style="list-style-type: none"> • DO wear ANSI Z87+ safety glasses and face protection, if required. • DO wear gloves, hearing and body protection. • DO employ dust controls and/or protective measures appropriate to the material being ground. • DO comply with OSHA regulations 29 CFR 1926.1153 when working on materials containing crystalline silica such as concrete. 	<ul style="list-style-type: none"> • DON'T use wheels near bystanders if they are not wearing protective equipment.
<p>OPERATE</p> 	<ul style="list-style-type: none"> • DO support work-piece firmly. • DO hold grinder firmly with two hands. 	<ul style="list-style-type: none"> • DON'T allow untrained people to handle, store, mount or use wheels. • DON'T use grinding wheels or cutting wheels on pistol grip air Sanders. • DON'T use any cutting wheel for grinding nor apply side pressure on a cutting wheel. Use for CUTTING ONLY. • DON'T use a cutting wheel to cut curves. Cut in straight lines only. • DON'T twist, bend or jam any wheel. • DON'T force or bump wheel so that the tool motor slows or stalls. • DON'T use wheels in the presence of combustible materials. • DON'T use wheels for applications other than for which they were designed.

Portable Grinding Safety

Dangerous Pairing: Die Grinders and Cut-off Wheels

While die grinders and portable cut-off tools may look similar, they are by no means interchangeable. Several crucial differences exist between the two handheld machines.

GUARD

Cut-off wheels must be used on guarded machines for the safety of the operator and bystanders.

SPEED

Cut-off wheels must be used at or below their maximum operating speed, marked clearly on the side of the wheel. Excessive speed can result in breakage and serious personal injury.

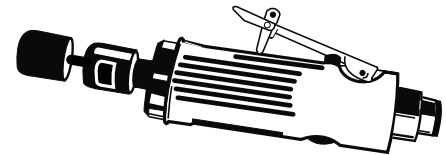
Die grinders often operate above 25,000 rpm and therefore are too fast for abrasive wheels. The speed hazard is increased by the absence of a guard. Portable cut-off tools, however, rotate at speeds compatible with the abrasive wheels for which they are designed. And, their guards prevent use of an oversize wheel.

MOUNTING

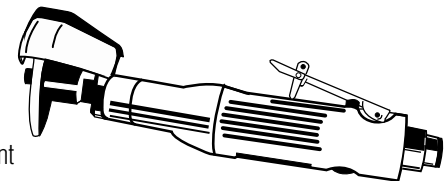
Cut-off wheels must be mounted between proper flanges, as described in the national safety standard for abrasive wheels, ANSI B7.1. Die grinders make use of a collet for mounting

Portable cut-off tools use flanges for mounting, flanges designed according to the ANSI B7.1 safety standard.

Now that you have learned the three crucial differences between die grinders and portable cut-off tools – GUARD, SPEED and MOUNTING – be on watch for the dangerous pairing of cut-off wheels and die grinders, and warn your friends and colleagues of the same.



Die Grinder



Portable Cut-off Tool



Pistol Grip Air Sander

A Deadly Equation

Pistol Grip Air Sander + Grinding Wheel = Certain Injury!

- Never use a high-speed air sander as a portable grinder
- Use only sanding discs specifically designed for sanders
- Because the speed of these sanders far exceeds the maximum rated speeds for grinding wheels, a potentially lethal wheel breakage might occur



Starting a Grinding Wheel / Ring Test

Starting a Grinding Wheel

ANSI's Procedure for Starting an Abrasive Wheel

This article is designed to remind users of the proper procedure when starting a machine with a new abrasive wheel mounted on it, starting a machine after the machine and wheel have been stored for a period of time, or remounting a wheel. ANSI B7.1 requires the following procedure when starting a newly mounted grinding wheel.

9.8 Starting the Wheel (Requirements)

All abrasive wheels shall be run at operating speeds with the safety guard in place or in a protected enclosure for at least one minute before applying work. During this time no one shall stand in front of or in line with the wheel. (See section 4, for safety guard requirements.) This provision shall apply each time one of the following conditions occur: a) a new wheel has been mounted; or b) a used wheel has been remounted.

E 9.8 Starting the Wheel (Explanatory Information)

An abrasive wheel may be damaged in shipment or storage, or the wheel may be subjected to improper, excessive stresses during mounting. Wheels which have been damaged or are under excessive stress, are likely to fracture within the first minute of rotation at operating speed. While this procedure is most important at the time when an abrasive wheel is mounted or remounted, damage may also occur to a wheel during a shut down of the machine on which it is mounted. The user should evaluate the circumstances and length of machine shut down to determine additional times that the operating rule should be followed.

Improper wheel mounting is a major cause of wheel breakages. Always use proper mounting procedures as outlined in ANSI B7.1, machine manufacturer's instructions and those supplied with the abrasive wheel. Be safe, know and follow the rules!



How to Perform a Ring Test on a Grinding Wheel

One method of grinding wheel inspection is called ring testing. OSHA, ANSI and the grinding wheel manufacturers require this method of grinding wheel inspection. It must be performed BEFORE the wheel is mounted on a grinding machine. Ring testing depends on the damping characteristics of a cracked wheel to alter the sound emitted when the wheel is tapped lightly. It is subject to interpretation by the inspector and is primarily applicable to vitrified bonded wheels. To perform the ring test, wheels should be tapped gently with a light nonmetallic implement, such as the handle of a screw driver for light wheels, or a wooden mallet for heavier wheels.

- Tap wheels about 45 degrees each side of the vertical line and about 1" or 2" from the periphery. Rotate the wheel 45 degrees and repeat the test.
- Large and thick wheels may be given the ring test by striking the wheel on the periphery rather than the side of the wheel.
- A sound and undamaged wheel will give a clear tone. If cracked, there will be a dead sound and not a clear ring and the wheel should not be used.
- Wheels must be dry and free of sawdust when applying the ring test, otherwise the sound may be deadened. The ring test is not applicable to certain wheels because of their size, shape or composition.

Conversion Table – Wheel Speeds

REVOLUTIONS PER MINUTE FOR VARIOUS DIAMETERS OF GRINDING WHEELS TO GIVE SURFACE SPEED IN FEET PER MINUTE AS INDICATED (FOR WHEEL MARKING PURPOSES THE CALCULATED RPM FIGURES LISTED BELOW ARE ROUNDED OFF TO THE NEXT 5)

Surface Speed in Feet Per Minute (SFPM)

Diameter of Wheel in Inches	Revolutions Per Minute (RPM)															
	6,500	7,000	7,500	8,000	8,500	9,000	9,500	10,000	12,000	12,500	14,200	16,000	16,500	17,000	19,685	20,000
1	24,828	26,737	28,647	30,558	32,467	34,377	36,287	38,196	45,836	47,745	54,240	61,116	63,025	64,935	75,190	76,395
2	12,414	13,368	14,328	15,278	16,238	17,188	18,143	19,098	22,918	23,875	27,120	30,558	31,510	32,465	37,595	38,195
3	8,276	8,913	9,549	10,186	10,822	11,459	12,096	12,732	15,278	15,915	18,080	20,372	21,010	21,645	25,065	25,465
4	6,207	6,685	7,162	7,640	8,116	8,595	9,072	9,549	11,459	11,940	13,560	15,278	15,755	16,235	18,800	19,100
5	4,966	5,348	5,730	6,112	6,494	6,876	7,258	7,640	9,168	9,550	10,850	12,224	12,605	12,985	15,040	15,280
6	4,138	4,456	4,775	5,092	5,411	5,729	6,048	6,366	7,639	7,960	9,040	10,186	10,505	10,820	12,530	12,730
7	3,547	3,820	4,092	4,366	4,638	4,911	5,183	5,456	6,548	6,820	7,750	8,732	9,005	9,275	10,740	10,915
8	3,103	3,342	3,580	3,820	4,058	4,297	4,535	4,775	5,729	5,970	6,780	7,640	7,880	8,115	9,400	9,550
9	2,758	2,970	3,182	3,396	3,606	3,820	4,032	4,244	5,092	5,305	6,030	6,792	7,000	7,215	8,355	8,490
10	2,483	2,674	2,865	3,056	3,247	3,438	3,629	3,820	4,584	4,775	5,425	6,112	6,300	6,495	7,520	7,640
12	2,069	2,228	2,386	2,546	2,705	2,864	3,023	3,183	3,820	3,980	4,520	5,092	5,250	5,410	6,265	6,365
14	1,773	1,910	2,046	2,182	2,319	2,455	2,592	2,728	3,274	3,410	3,875	4,366	4,500	4,640	5,370	5,455
16	1,552	1,672	1,791	1,910	2,029	2,149	2,268	2,387	2,865	2,985	3,390	3,820	3,940	4,060	4,700	4,775
18	1,379	1,485	1,591	1,698	1,803	1,910	2,016	2,122	2,546	2,655	3,015	3,396	3,500	3,605	4,175	4,245
20	1,241	1,337	1,432	1,528	1,623	1,719	1,814	1,910	2,292	2,390	2,715	3,056	3,150	3,245	3,760	3,820
22	1,128	1,215	1,302	1,388	1,476	1,562	1,649	1,736	2,084	2,170	2,465	2,776	2,865	2,950	3,420	3,470
24	1,034	1,115	1,194	1,274	1,353	1,433	1,512	1,591	1,910	1,990	2,260	2,546	2,625	2,705	3,135	3,185
26	955	1,028	1,101	1,176	1,248	1,322	1,395	1,468	1,762	1,840	2,090	2,352	2,425	2,495	2,890	2,940
28	887	955	1,023	1,092	1,159	1,228	1,296	1,364	1,637	1,705	1,940	2,182	2,250	2,320	2,685	2,730
30	828	891	955	1,018	1,082	1,146	1,210	1,274	1,528	1,595	1,810	2,056	2,100	2,165	2,505	2,545
32	776	836	895	954	1,014	1,074	1,134	1,194	1,432	1,495	1,695	1,910	1,970	2,030	2,350	2,385
34	730	786	843	898	955	1,011	1,067	1,124	1,348	1,405	1,595	1,796	1,855	1,910	2,210	2,245
36	690	742	795	848	902	954	1,007	1,061	1,273	1,330	1,510	1,698	1,750	1,805	2,090	2,120
38	653	704	754	804	854	904	955	1,006	1,206	1,260	1,430	1,608	1,660	1,710	1,980	2,010
40	620	669	716	764	812	860	908	956	1,146	1,195	1,355	1,528	1,575	1,625	1,880	1,910
42	591	636	682	732	775	818	863	908	1,090	1,140	1,295	1,464	1,500	1,545	1,790	1,820

For intermediate diameters not listed use the formula listed in Section 1.2.10 of ANSI B7.1

SFPM = .262 x wheel diameter in inches x RPM.

To convert meters per second (m/s) to SFPM: m/s x 196.85 = SFPM

To convert SFPM to m/s: SFPM/196.85 = m/s.

To convert RPM to SFPM: Wheel Diameter x RPM x 0.262 = SFPM

Silica and What You Need to Know

Background and Health impacts

Silica (SiO₂) is one of the most common minerals in the earth's crust. Glass, beach sand, silicone and granite are all "silica" materials. Products containing silica have been used for thousands of years in building and is a key ingredient in many products we use every day. There are two forms of silica; crystalline and non-crystalline. Crystalline silica is a mineral that occurs in several forms. Quartz, the most common form, is a component of sand, stone, rock concrete, brick, block and mortar. Non-crystalline silica is found in glass, silicon carbide and silicone.

When rocks containing crystalline silica are cut, crushed, ground, drill or used in similar industrial processes, dust particles are produced. These particles are very fine, at least 100 times smaller than ordinary beach sand – known as respirable crystalline silica or RCS. Inhaling very small or respirable crystalline silica particles is most hazardous and may cause multiple diseases such as silicosis, followed in severe cases by lung cancer.

Who is at risk from exposure to crystalline silica?

It is estimated that 2.3 million workers are exposed to crystalline silica on the job. The majority of the workers, about 2 million, are in the construction industry. The hazard exists when specific activities create respirable dust that is released into the air.

The New OSHA Standard

OSHA's recently implemented silica standards for Construction "29 CFR 1926.1153" and General Industry "29 CFR 1910.1053" suggests procedures applicable for work in these environments. This new standard affects all activities that generate silica dust on a jobsite. Trades involving brick, stone, concrete and other materials that are difficult to replace must comply with the standard. This is a change around "process", not specific products.

Impacts on Industry

Industries affected by this regulation include Construction, Glass manufacturing, Pottery products, Structural clay products, Concrete products, Foundries, Cut stone and Stone products, Railroads, Refractory products and Asphalt products manufacturing to name a few. Always read the Safety Data Sheet for the workpiece and abrasive before use.

The Occupational Safety and Health Administration (OSHA) has a number of available resources to help companies understand the general information and requirements to explain the new regulations including:

OSHA's Crystalline Silica Rule: Construction
[osha.gov/Publications/OSHA3681.pdf](https://www.osha.gov/Publications/OSHA3681.pdf)

OSHA Fact Sheet
[osha.gov/publications/OSHA3682.pdf](https://www.osha.gov/publications/OSHA3682.pdf)

Small Entity Compliance Guide for Respirable Crystalline Silica Standard for Construction
[osha.gov/publications/OSHA3902.pdf](https://www.osha.gov/publications/OSHA3902.pdf)

Small Entity Compliance Guide for Respirable Crystalline Silica Standard for General Industry and Maritime
[osha.gov/publications/OSHA3911.pdf](https://www.osha.gov/publications/OSHA3911.pdf)



Product Warranty

WARRANTY – Saint-Gobain Abrasives warrants the products in this catalog to be free from defects in material or workmanship for a period of one year from the date of purchase. Saint-Gobain Abrasives' sole obligation under this warranty shall be to repair or replace, at Saint-Gobain Abrasives' option, any product which is non-conforming provided any such product failure was not caused by a subsequent modification of the product, misuse or a failure to follow any applicable instructions for the product.

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