



# GRINDING AND POLISHING

(with flexible tools)

GRINDING AND POLISHING  
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## TECHNICAL INFORMATION

# The most important product information at a glance

**GENERAL**

Our flexible grinding and polishing tools are made of high quality abrasive cloth and abrasive fleece. They consist of a flexible backing coated with abrasive grain (see pages 131 to 132).

**▪ Backings used:**

cloth, polyester, fleece, fibre

**▪ Grain types used:**

regular aluminium oxide (NK), silicon carbide (SIC), zirconia alumina (ZK), ceramic (Ceramic)

Our flexible grinding and polishing tools are available in many different shapes and dimensions. Applications range from high chip removal through to achieving an extremely fine surface finish.

**SAFETY ADVICE**

Please note our recommended operating speeds. Pay attention to the safety and accident prevention regulations, including the FEPA safety recommendations, when using and storing flexible grinding and polishing tools. The tools are marked with the appropriate pictograms for correct usage.

**APPLICATION RECOMMENDATIONS**

**At high speed coarse grain produces a finer finish, while at low speed a fine grain produces a coarser finish.**

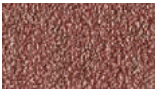




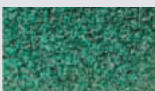

Do not apply too much pressure when using LUKAS grinding tools: excessive pressure does not improve the performance, and will instead result in premature wear. Even if the chip removal is unsatisfactory, you do not apply more pressure. Use a coarser grain instead to prevent unnecessary tool wear and effort. Using grinding additives can also improve efficiency.

## QUALITY AND APPLICATIONS

# The right abrasive for every application

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high quality abrasives from LUKAS are ideal for many industries, areas and requirements, and therefore offer you a very wide choice.

The overview below lists all abrasives for use with flexible grinding and polishing tools. Read through the properties and application areas for various workpiece materials to establish the most suitable abrasive grain type and tools to meet your requirements.

Quality	Properties	Application areas/ machining	available as	Page
	<b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	forged steel, malleable iron, grey cast iron, carbon steel, deep-drawn steel, steel band, zinc die castings, non-ferrous metals, wood	Lamellar flap discs 156 161 Mounted flap wheels 165–170 172–174 Flap wheels 182/183 Flap rolls 190 Abrasive bands 198/199 201–204 207/208 Abrasive rolls 205 Abrasive sleeves 220 Abrasive discs 229 Fibre discs 231–233 238/239
	<b>NKE</b> Abrasive cloth Regular aluminium oxide with active abrasive surface layer	very tough abrasive, high resilience	chrome-nickel and other non-rusting steels, deep-drawn steel, titanium and titanium alloys, heat-resistant steel	Mounted flap wheels 170 Abrasive discs 221
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs 137, 141 144, 146 151/152 154/155 157/158 226 219, 224 237 Abrasive bands 197 Abrasive discs 219, 224 Fibre discs 237
	<b>Z Power</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent removal rate, with long tool life	stainless steel	Lamellar flap discs 140 146 Abrasive bands 196 Abrasive discs 219
	<b>ZKS</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	with M-bonding on polyester backing for excellent removal rate with long tool life	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs 150–152 160
	<b>NKS</b> Abrasive cloth Regular aluminium oxide with active abrasive surface layer	excellent removal rate with long tool life	corrosion and heat-resistant steels, plastics, aluminium and non-ferrous metals	Abrasive caps 212/213
	<b>SIC</b> Abrasive cloth Silicon carbide	minimum heat generation, special quality for the aerospace industry	aluminium and alloys, titanium materials, glass, ceramic, heat-resistant steel, plastic	Lamellar flap discs 147 Mounted flap wheels 171 Abrasive discs 223, 228

Quality	Properties	Application areas/ machining	available as	Page
	<b>Ceramic</b> Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	non-rusting steels, nickel alloys	Lamellar flap discs 140 145 150 164 Mounted flap wheel of abrasive cloth Abrasive bands Abrasive rolls Abrasive caps Abrasive discs Fibre discs 196 206 209 218 236
	<b>Ceramic4x</b> Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	steel, rust- and acid-resistant steel	Lamellar flap discs 141 144 153
	<b>PG</b> Reinforced abrasive cloth with ceramic grain	maximum removal rate and tool life thanks to self-sharpening ceramic grain	inox, steel, hardened/coated surfaces	Compact grinding discs Lamellar flap discs 135 136
	<b>NK</b> Abrasive fleece Regular aluminium oxide	polishing effect with the fibre structure, consistent results thanks to continuous exposure of new abrasive particles	chrome-nickel alloys and other non-rusting steels, zinc die castings, non-ferrous metals, wood	Mounted flap wheels 176/177 179 Mounted flap wheels Flap rolls Flap rolls 184 – 187 188 191
	<b>SIC</b> Abrasive fleece Silicon carbide	polishing effect with the fibre structure, consistent results thanks to continuous exposure of new abrasive particles	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Mounted flap wheels 177 Mounted flap wheels Flap rolls Semi-flexible grinding disc 161 184 – 186 193 240
	<b>Z</b> Abrasive fleece Zirconia alumina	polishing effect with the fibre structure, improved aggressiveness	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals	Mounted flap wheels 175
	<b>TF</b> Abrasive fleece/cloth Regular aluminium oxide reinforced fleece	with the combination mounted flap wheels, the abrasive cloth and fleece flaps wear more evenly, improved removal rate	ideal for surface finishing of sheet metal products made from non-rusting steel such as stainless steel sinks and containers	Mounted flap wheels Flap rolls 178 192
	<b>A</b> Mounted flap wheels Flap rolls	the combination with abrasive cloth enhances the grinding effect	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	Lamellar flap discs 161 Mounted flap wheels 179 Mounted flap wheels Flap rolls 187 192/193
	<b>C</b> Abrasive fleece/cloth Silicon carbide	the combination with abrasive cloth enhances the grinding effect	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Lamellar flap discs 161 Mounted flap wheels 180 Mounted flap wheels 187
	<b>AS</b> Polyamide fleece	impregnated with aggressive abrasive grain	removal of paint and adhesives, cement and concrete resitankss, derusting, cleaning and polishing a wide variety of surfaces, graining and cleaning of wood	Flap disc Grinding wheel 227, 287 288

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS lamellar flap discs – from coarse cutting through to surface finishing

## GENERAL

We offer lamellar flap discs for practically every requirement. These tools are manufactured with a wide selection of backing materials (e.g. glass fabric, plastic, metal, as well as renewable raw materials) to suit every application. The large selection of available grit sizes covers coarse grinding applications (from grit size 36) through to finishing (grit size 240).

## ERGONOMICS

Using lamellar flap discs brings clear advantages in terms of ergonomics compared to conventional grinding discs. Noise levels during grinding are halved and vibrations are also significantly reduced. The tools are also lighter so less pressure needs to be applied. These advantages create a healthy and fatigue-free working environment.

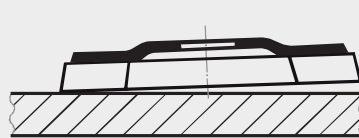
The lamellar flap discs are available in the diameters 100 mm (with 16 mm bore), 115 mm, 125 mm, 150 mm, 178 mm (22.23 mm bore) and 230 mm for use with commercially available angle grinders.

## APPLICATION

You can choose between the flat or angled version depending on the job in hand.

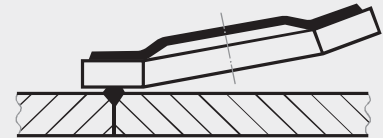
### Application examples:

- deburring
- fettling
- derusting
- smoothening
- weld seam removal



### Using the flat version

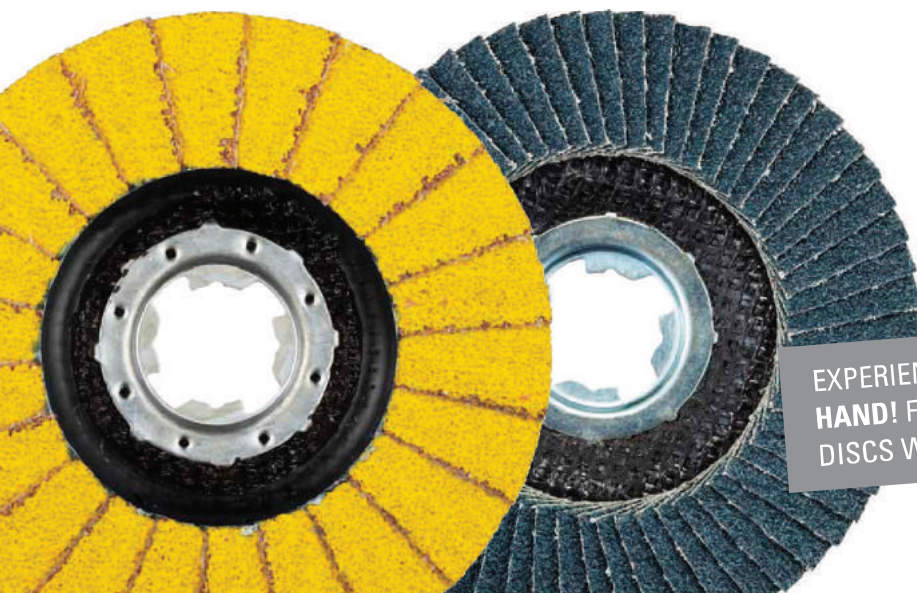
Use this version for grinding edges and flat surfaces with a working angle of 0 – 15°



### Using the angled version

#### for spot grinding

e.g. a weld, with the ideal working angle of 15 – 25°



EXPERIENCE THIS TIME-SAVING INNOVATION AT FIRST HAND! FIND OUT MORE ABOUT OUR LAMELLAR FLAP DISCS WITH X-LOCK SYSTEM ON **PAGES 144 AND 154**

## iQ SERIES FROM LUKAS

## Developed for high-performance applications

Our high-performance tools are grouped together in our iQ series. Among them are the lamellar flap discs, which have a patented flap shape and arrangement for ultimate grinding performance.



## Purple Grain

## Powerful tools for heavy-duty applications

AGGRESSIVE. DURABLE. ERGONOMIC.

- high stability and durability
- integrated backing pad in recycled fibre
- even wearing without overheating, becoming brittle or shredding of the grain
- innovative ceramic grain: sharp to the end



**innovative**  
Ceramic grain



**operating**  
angle  $< 10^\circ$



**no backing**  
pad required



**low**  
vibration

## WITH THE SELF-SHARPENING EFFECT

The self-sharpening ceramic grain ensures sustained cool grinding even at low grinding pressure. The tools retain their sharpness down to the last grain.

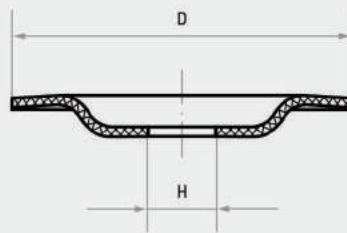


# THE DYNAMIC ALL-ROUNDER WITH A LONG TOOL LIFE

PURPLE GRAIN SINGLE AND PURPLE GRAIN MULTI WITH THREE LAYERS



Even with a minimum effort, "Purple Grain Single" achieves stunning removal rates. The integrated backing pad made of eco-friendly recycled fibre assures high stability and durability. The innovative design provides for even wear without overheating, becoming brittle or shredding of the grain. The deep recess allows you to work at a flat angle. Thanks to its special tool geometry, the "Purple Grain Single" can also reach inaccessible areas, which offers more application possibilities than a conventional tool.



## Purple Grain Single compact grinding disc



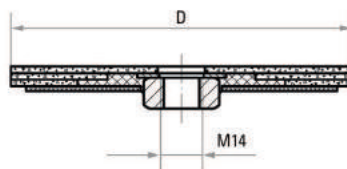
★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27601150361547	Purple Grain Single 115	Ceramic 36	115	22.23	13,300	10
A27601250361547	Purple Grain Single 125	Ceramic 36	125	22.23	12,200	10

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



With its unique multi-layer design, the powerful "Purple Grain Multi" achieves a maximum tool life. Wearing of the three grinding layers is controlled from start to finish, which is reflected in the tangible cost savings compared to conventional tools. The integrated M14 threaded holder ensures ultra-fast tool changing with no annoying clamping nuts. With its flat tool geometry, the "Purple Grain Multi" creates very good surface finishes, thus avoiding the need for reworking.



## Purple Grain Multi compact grinding disc



★★★

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A27621150361547	Purple Grain Multi 115	Ceramic 36	115	M14	13,300	10
A27621250361547	Purple Grain Multi 125	Ceramic 36	125	M14	12,200	10

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

# EXCEPTIONAL GRINDING PERFORMANCE IN INDUSTRIAL APPLICATIONS

V4 PURPLE POWER – FOR ROBOTIC APPLICATIONS

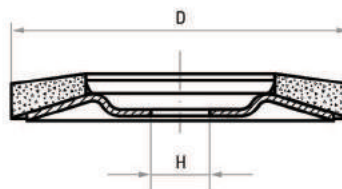


As a highly aggressive grinding tool, the V4 Purple Power is designed to be used on powerful angle grinders. On robots and automatic grinders, this grinding disc shows what it's capable of. It achieves unique performance values, combined with a long tool life for impressive efficiency.

The V4 Purple Power is equipped with a high-performance ceramic abrasive coating for outstanding results. In addition,

the flap shape is optimised for high stock removal. This lamellar flap disc effortlessly grinds steel, inox, cast material and titanium. The V4 Purple Power can convert up to 20 kg of structural steel into fine chips during grinding process. The chip removal rate is up to 250 % greater than conventional tools. With a tool life of approximately 3.5 hours, this grinding tool when used on robots also exceeds all expectations.

## V4 Purple Power



- exceptional grinding performance in industrial applications
- ideal for use with robots, grinding machines and heavy duty machine tools
- exceptional removal rate
- removes more than 20 kg of structural steel when used with a robot
- fewer tool changes
- extremely ergonomic

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A274812503600475	V4 Purple Power 125	Ceramic 36	125	22.23	12,200	5
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkgrey;">●</span> Titanium <span style="color: red;">●</span> Cast material						

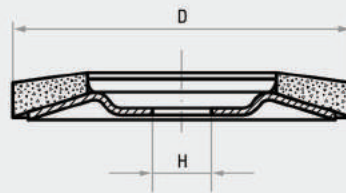


# POWER FOR METALWORKERS

**HIGHLY AGGRESSIVE AND DURABLE  
FOR UNCOMPROMISING GRINDING**

The V4 Master mounted on an angle grinder is used when high stock removal is required. This lamellar flap disc displays its enduring removal performance in rounding off sharp edges and finishing weld seams and thermal cuts. With its powerful cutting performance, it ensures this kind of challenging work can be performed quickly and effortlessly.

LUKAS has developed this grinding tool for various industries: steel and vessel construction, shipyards and offshore, machine and plant engineering, i.e. for any industry that removes a great deal of material from sheet metal and steel. The V4 Master is an excellent choice in this instance. The low force applied, the deep recess around the bore and the low noise and vibration levels when grinding makes for an easy application.



- exceptional cutting performance
- high edge retention
- deep recess
- long tool life
- low noise and vibrations
- ergonomic handling requiring minimum force
- free of iron, sulphur and chlorine

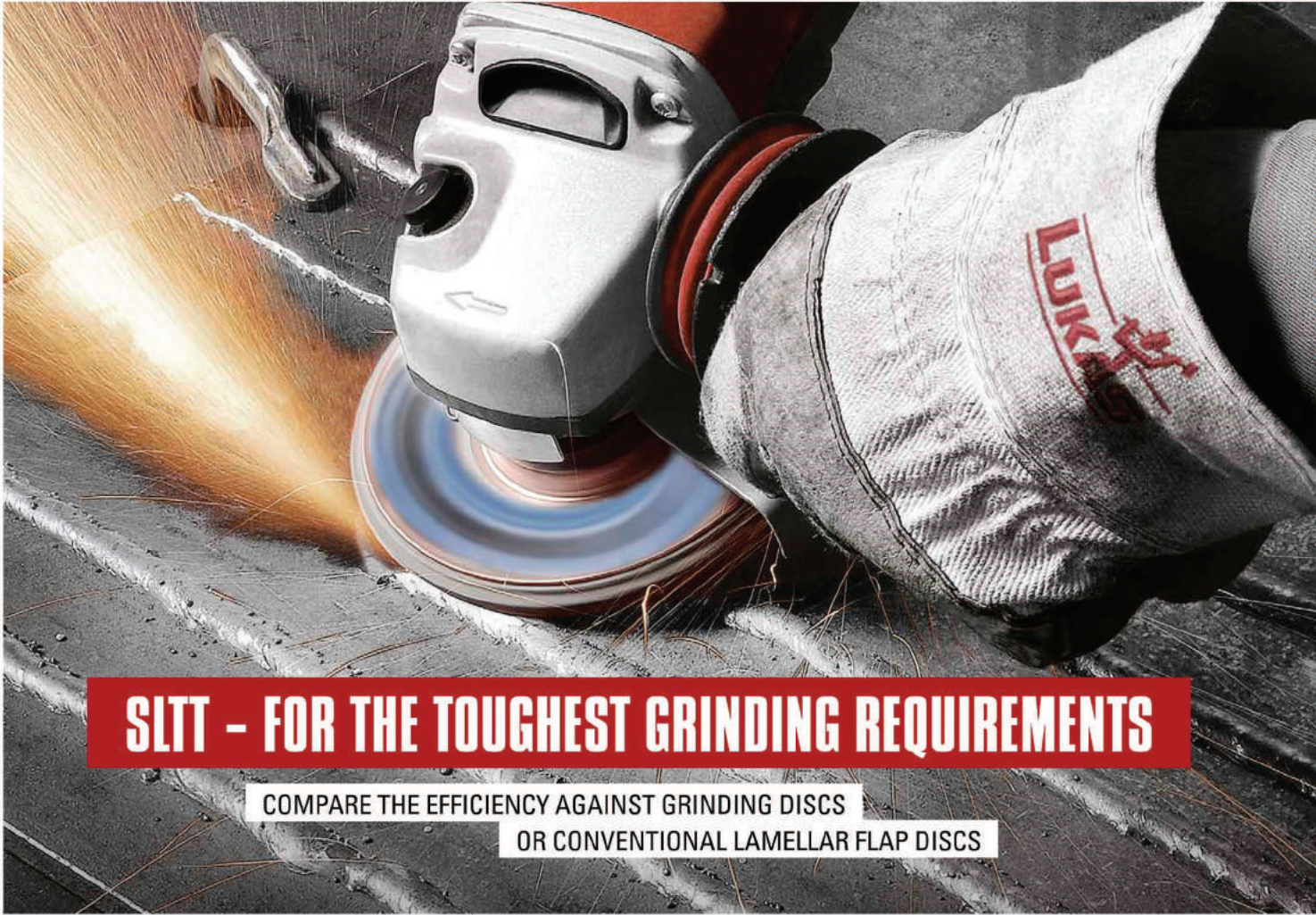


## V4 Master

★★★

Product number	Description	Grit	D mm	H mm	n max rpm	Pack contains
A27471150401465	V4 Master 115	ZK 40	115	22.23	13,300	10
A27471150601465	V4 Master 115	ZK 60	115	22.23	13,300	10
A27471250401465	V4 Master 125	ZK 40	125	22.23	12,200	10
A27471250601465	V4 Master 125	ZK 60	125	22.23	12,200	10
A27471780401465	V4 Master 178	ZK 40	178	22.23	8,500	10

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



## SLTT - FOR THE TOUGHEST GRINDING REQUIREMENTS

COMPARE THE EFFICIENCY AGAINST GRINDING DISCS  
OR CONVENTIONAL LAMELLAR FLAP DISCS

# 70%

OF THE ABRASIVE MATERIAL IS  
LOCATED ON THE OUTER AREA OF  
THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE  
WITH ITS INNOVATIVE FLAP ARRANGEMENT

WIDER  
FLAPS

UP TO

# 6

ABRASIVE LAYERS

ROBUST  
STEEL BACKING PLATE

The efficient, high-performance SLTT lamellar flap discs from LUKAS are a better alternative to grinding discs and conventional lamellar flap discs.

Compared to grinding discs, the LUKAS patented flap shape and arrangement provides for 50 % lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.



**Patented LUKAS flap shape and arrangement** with more abrasive grains than the norm

A particularly large concentration of abrasive grain on the outer perimeter of these tools results in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.



**PROPERTIES**

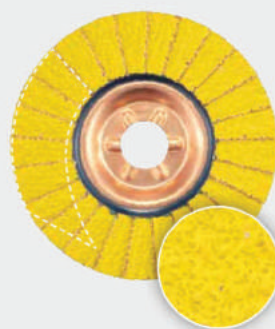
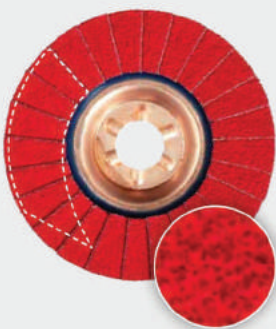
- outstanding cutting performance
- exceptional tool life
- robust steel back plate
- low noise and vibration levels

**APPLICATION**

Ideal for machining welds, deburring, derusting, fettling and smoothening. Thanks to its 22.23 mm bore, it fits onto all commonly used angle grinders.

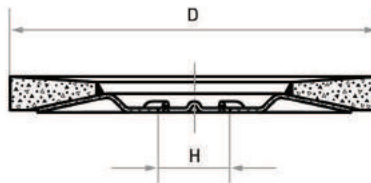
GRINDING AND POLISHING (with flexible tools)

**THE FOUR SLTT VERSIONS**



Heavy Duty Ceramic abrasive cloth	Inox Z Power abrasive cloth	HybridPerfection Ceramic4x abrasive cloth	Steel ZK abrasive cloth
<ul style="list-style-type: none"> <li>■ developed for the most demanding and toughest grinding applications</li> <li>■ especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ innovative development for grinding stainless steel</li> <li>■ no glazing or heating of the flaps thanks to the active abrasive surface layer</li> <li>■ equally efficient for edge and surface applications</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ the professional tool for the toughest jobs involving steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium</li> <li>■ achieves impressively high stock removal rates when rough grinding steel, edging and removal of welds</li> <li>■ with additional active abrasive layer for stainless steel</li> </ul>	<ul style="list-style-type: none"> <li>■ optimised for universal use on a wide variety of steels and aluminium</li> <li>■ exceptionally tough grain and resistant to high pressure</li> </ul>

## SLTT Heavy Duty lamellar flap discs



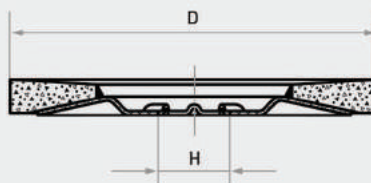
- developed for the most demanding and toughest grinding applications
- especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27201150400050	SLTT 115	Ceramic 40	115	22.23	13,300	10
A27201150600050	SLTT 115	Ceramic 60	115	22.23	13,300	10
A27201250400050A	SLTT 125	Ceramic 40	125	22.23	12,200	10
A27201250600050	SLTT 125	Ceramic 60	125	22.23	12,200	10
A27201500400050	SLTT 150	Ceramic 40	150	22.23	10,200	10
A27201780400050	SLTT 178	Ceramic 40	178	22.23	8,500	10
A27201780600050	SLTT 178	Ceramic 60	178	22.23	8,500	10

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

## SLTT Inox lamellar flap discs



- turbo back plate for machining stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

★★★

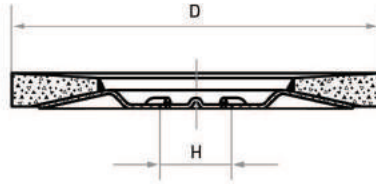
Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27201150400045	SLTT 115	Z-Power 40	115	22.23	13,300	10
A27201150600045	SLTT 115	Z-Power 60	115	22.23	13,300	10
A27201250400045A	SLTT 125	Z-Power 40	125	22.23	12,200	10
A27201250600045	SLTT 125	Z-Power 60	125	22.23	12,200	10
A27201500400045	SLTT 150	Z-Power 40	150	22.23	10,200	10
A27201780400045	SLTT 178	Z-Power 40	178	22.23	8,500	10
A27201780600045	SLTT 178	Z-Power 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel



## SLTT HybridPerfection<sup>Ceramic4x</sup> lamellar flap discs **NEW**

- the professional tool for the toughest jobs on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves impressively high stock removal rates when rough grinding steel, edging and removal of welds
- with additional active abrasive layer for stainless steel
- designed for endurance
- outstanding price-to-performance ratio



★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400044	HybridPerfection 115	Ceramic4x 40	115	22.23	13,300	10
A27201150600044	HybridPerfection 115	Ceramic4x 60	115	22.23	13,300	10
A27201250400044	HybridPerfection 125	Ceramic4x 40	125	22.23	12,200	10
A27201250600044	HybridPerfection 125	Ceramic4x 60	125	22.23	12,200	10

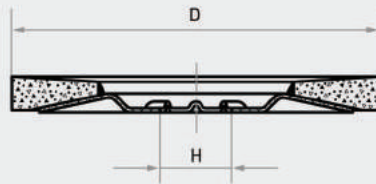
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood

**UNBEATABLE ON STEEL: THE NEW LUKAS HYBRIDPERFECTION**  
Thanks to its innovative Ceramic4x abrasive cloth and patented flaps, this lamellar flap disc quickly achieves exceptionally high stock removal rates on steel.

**EXPERIENCE AT FIRST HAND THE IMPRESSIVE PERFORMANCE OF THE NEW HYBRID PERFECTION AND TEST IT NOW FOR YOURSELF.**

GRINDING AND POLISHING  
(with flexible tools)

## SLTT steel lamellar flap discs



- optimised for steel
- exceptionally tough grain and resistant to high pressure

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400065	SLTT 115	ZK 40	115	22.23	13,300	10
A27201150600065	SLTT 115	ZK 60	115	22.23	13,300	10
A27201250400065A	SLTT 125	ZK 40	125	22.23	12,200	10
A27201250600065	SLTT 125	ZK 60	125	22.23	12,200	10
A27201500400065	SLTT 150	ZK 40	150	22.23	10,200	10
A27201500600065	SLTT 150	ZK 60	150	22.23	10,200	10
A27201780400065	SLTT 178	ZK 40	178	22.23	8,500	10
A27201780600065	SLTT 178	ZK 60	178	22.23	8,500	10

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



## THE V2 POWER – FOR UNIVERSAL USE

EXPERIENCE THE EFFICIENCY COMPARED TO CONVENTIONAL LAMELLAR FLAP DISCS

# 70%

OF THE ABRASIVE MATERIAL IS  
LOCATED ON THE OUTER AREA  
OF THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE  
THANKS TO THE SPECIAL FLAP CONFIGURATION

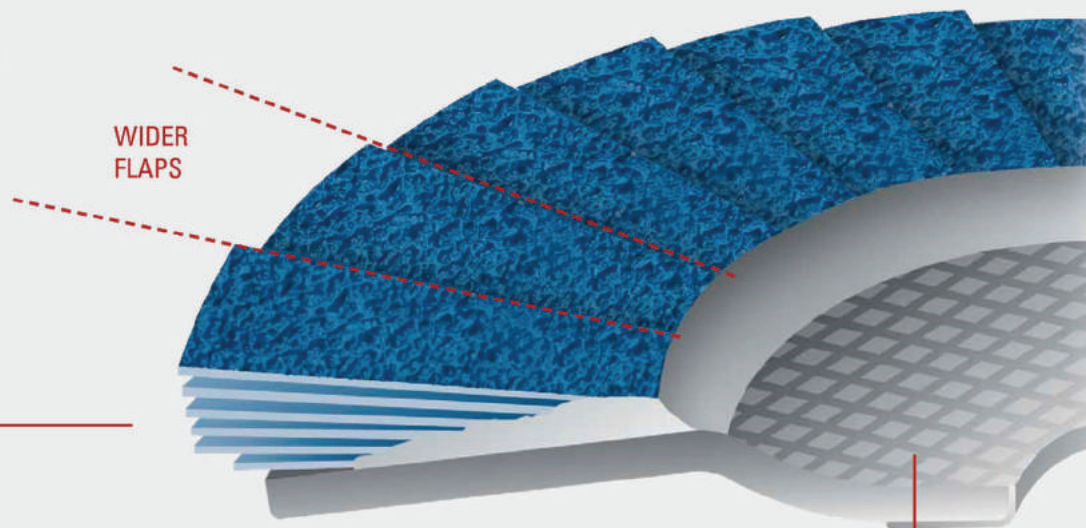
WIDER  
FLAPS

UP TO

# 6

ABRASIVE LAYERS

GLASS FIBRE  
BACKING PLATE



The efficient, high-performance LUKAS V2 Power lamellar flap discs with a glass fibre backing are a better alternative to grinding discs and conventional lamellar flap discs.

The flexibility, light weight and stability of the elastic glass fibre backing result in an exceptional surface finish. The high resistance to shredding and minimal vibration during operation, not to mention its easy handling, perfectly round off the characteristics of the V2 Power lamellar flap disc.

Compared to grinding discs, the LUKAS patented flap shape and arrangement gives 50% lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

A particularly large concentration of abrasive grains on the outer perimeter results



**innovative patented LUKAS flap shape and arrangement** with more abrasive grains than usual

in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs additionally remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.

#### PROPERTIES

- exceptional grinding performance
- long tool life
- robust glass fibre backing

#### APPLICATION

Ideal for machining weld seams, deburring, derusting, fettling and smoothing.



## THE FIVE V2 POWER VERSIONS



X-LOCK Ceramic4x abrasive cloth	Heavy Duty Ceramic abrasive cloth	Inox Z Power abrasive cloth	Steel ZK abrasive cloth	ALU SiC abrasive cloth
<ul style="list-style-type: none"> <li>■ perform the toughest machining jobs and quick tool changing</li> <li>■ all the benefits of the efficient LUKAS V2 Power lamellar flap disc coupled with the latest mounting system</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ developed for the most demanding and toughest grinding applications</li> <li>■ especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ developed for grinding stainless steel</li> <li>■ no glazing or heating of the flaps thanks to the active abrasive surface layer</li> <li>■ equally efficient for edge and surface applications</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ optimised for universal application on a wide variety of steels and aluminium</li> <li>■ exceptionally tough grain and resistant to high pressure</li> </ul>	<ul style="list-style-type: none"> <li>■ particularly suitable for preparing welds and finishing aluminium</li> <li>■ also ideal for fibre-reinforced materials such as CFRP and GFRP</li> </ul>

## V2 POWER WITH X-LOCK MOUNTING SYSTEM

THE HIGH-PERFORMANCE LAMELLAR FLAP DISC  
WITH THE INNOVATIVE MOUNTING SYSTEM

### MOUNTING GRINDING DISCS HAS NEVER BEEN SO EASY

The high-power V2 Power lamellar flap disc is the first tool from LUKAS equipped with the new X-LOCK mounting system. As a result, the outstanding grinding performance is combined with changing the tool in just seconds.

With the new X-LOCK system, you position the flap disc on the mounting fixture and allow it to engage – and you're done. A "click" noise indicates that the disc is firmly mounted. The potential of losing clamping nuts and keys is implemented. As a result, the tool change is fast and easy.

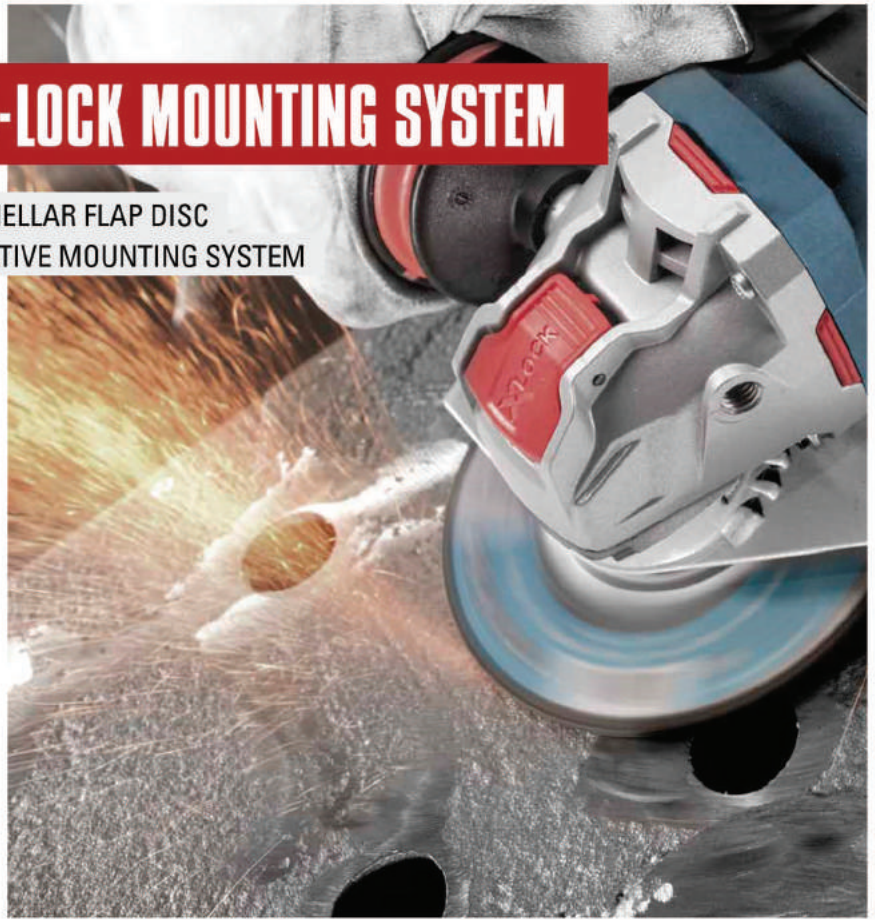
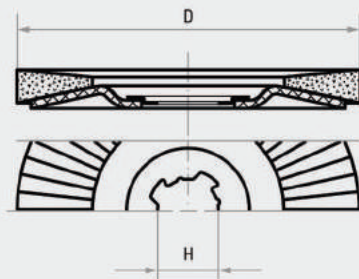


Photo: Bosch

### NEW V2 Power X-LOCK lamellar flap disc

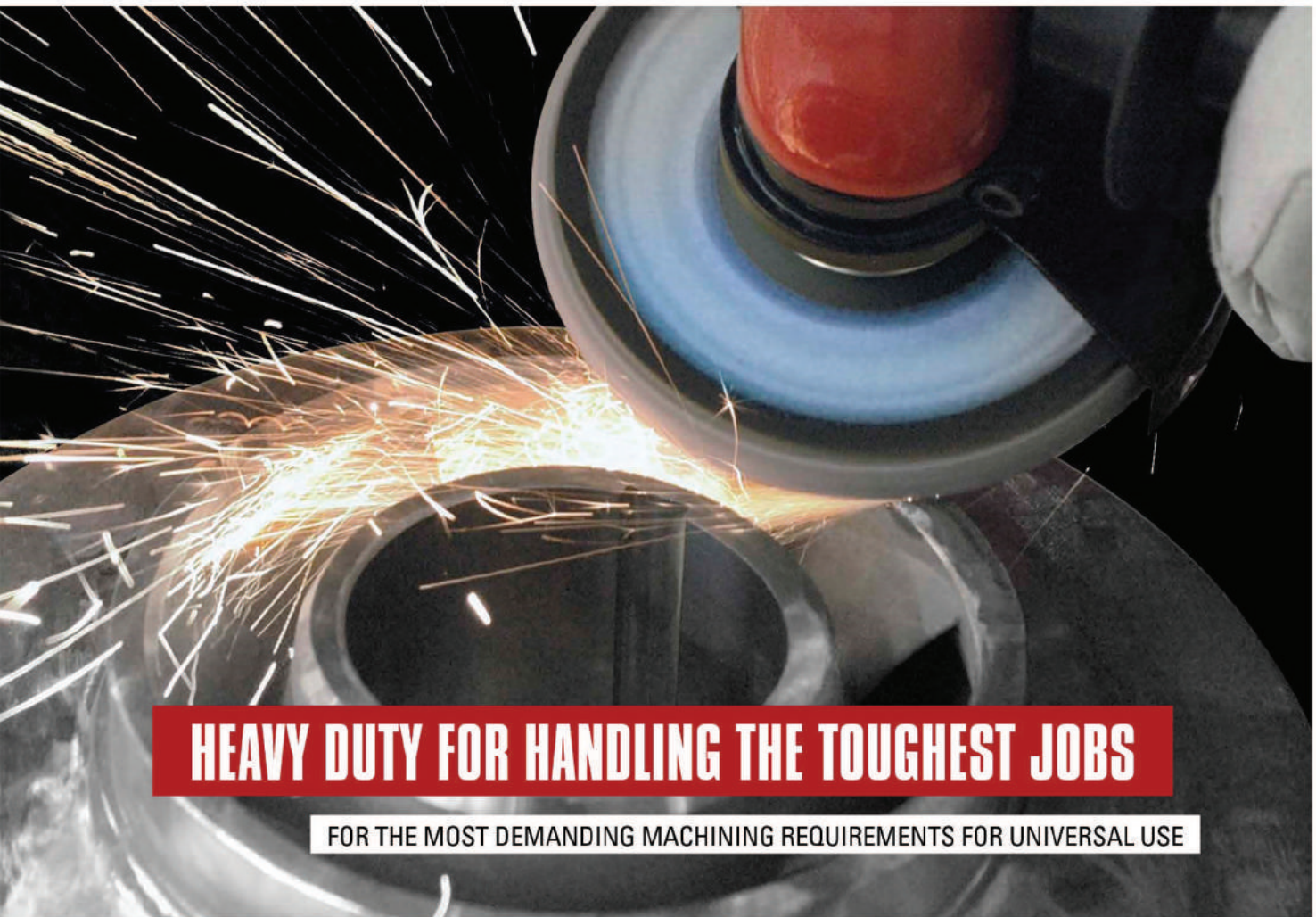


- the professional tool for the toughest jobs on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves impressively high stock removal rates when rough grinding steel, edging and removing of welds
- keyless tool changing in no time at all
- all the benefits of the efficient LUKAS V2 Power lamellar flap disc coupled with the latest mounting system
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A67441250401844	V2 Power 125	Ceramic4x 40	125	X-LOCK/22.23	12,200	10
A67441250601844	V2 Power 125	Ceramic4x 60	125	X-LOCK/22.23	12,200	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood						
A67441250401865	V2 Power 125	ZK 40	125	X-LOCK/22.23	12,200	10
A67441250601865	V2 Power 125	ZK 60	125	X-LOCK/22.23	12,200	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material						





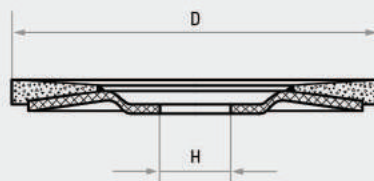
# HEAVY DUTY FOR HANDLING THE TOUGHEST JOBS

FOR THE MOST DEMANDING MACHINING REQUIREMENTS FOR UNIVERSAL USE

GRINDING AND POLISHING  
(with flexible tools)



## V2 Power Heavy Duty lamellar flap disc



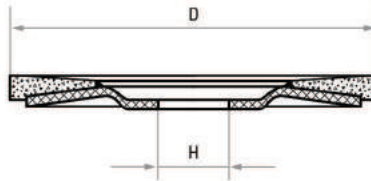
- especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27441150401450	V2 Power 115	Ceramic 40	115	22.23	13,300	10
A27441150601450	V2 Power 115	Ceramic 60	115	22.23	13,300	10
A27441250401450	V2 Power 125	Ceramic 40	125	22.23	12,200	10
A27441250601450	V2 Power 125	Ceramic 60	125	22.23	12,200	10
A27441780401450	V2 Power 178	Ceramic 40	178	22.23	8,500	10
A27441780601450	V2 Power 178	Ceramic 60	178	22.23	8,500	10
A27442300401428	V2 Power 230	Ceramic 40	230	22.23	6,600	10

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

## V2 Power Inox lamellar flap disc



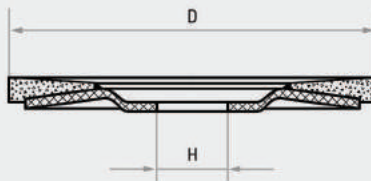
- optimised for grinding stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27441150401445	V2 Power 115	Z-Power 40	115	22.23	13,300	10
A27441150601445	V2 Power 115	Z-Power 60	115	22.23	13,300	10
A27441250401445	V2 Power 125	Z-Power 40	125	22.23	12,200	10
A27441250601445	V2 Power 125	Z-Power 60	125	22.23	12,200	10
A27441780401445	V2 Power 178	Z-Power 40	178	22.23	8,500	10
A27441780601445	V2 Power 178	Z-Power 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel

## V2 Power Steel lamellar flap disc

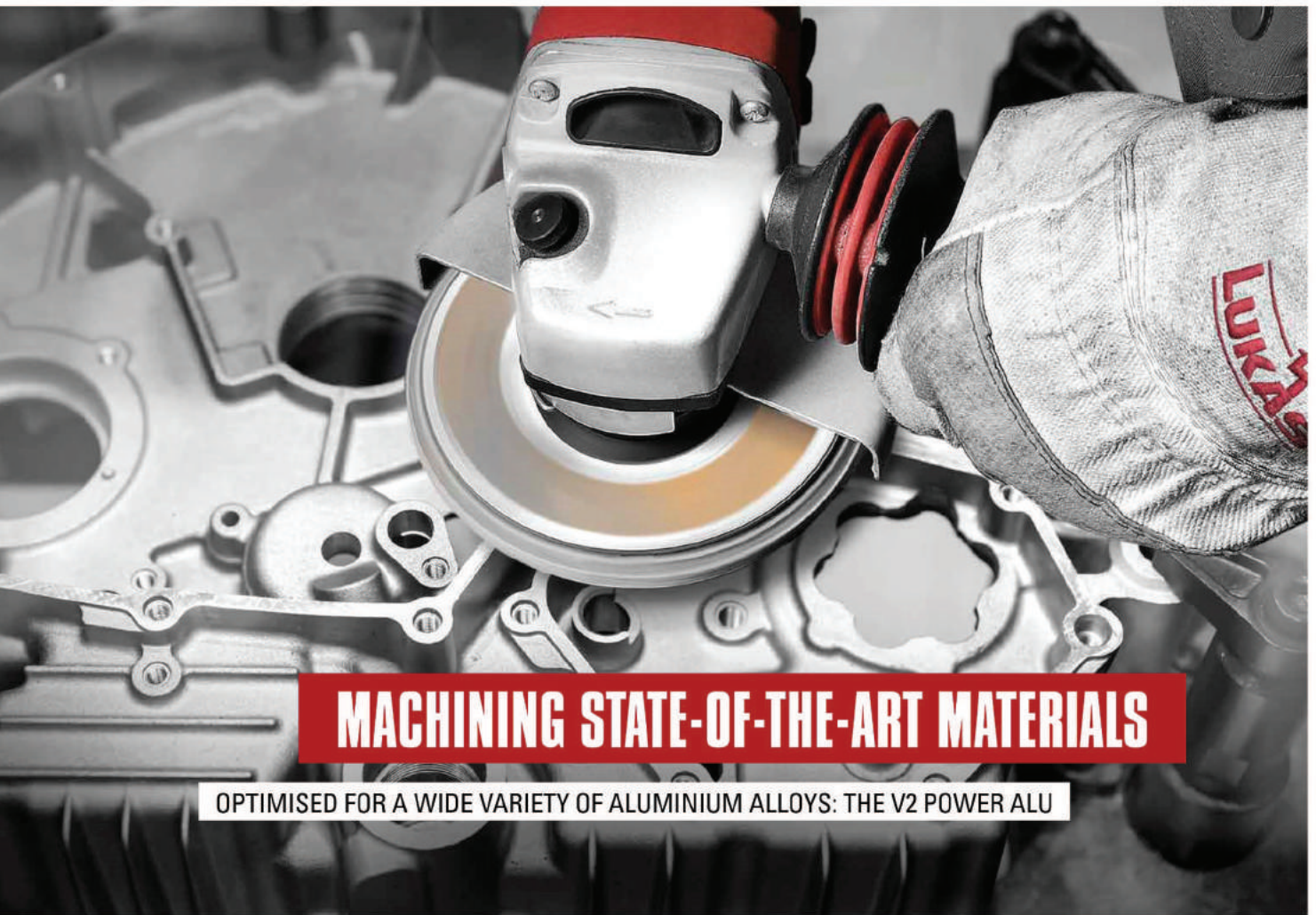


- ideally suited for universal use on steel
- exceptionally tough grain and resistant to high pressure

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27441000401465	V2 Power 100	ZK 40	100	16.00	15,300	10
A27441000601465	V2 Power 100	ZK 60	100	16.00	15,300	10
A27441150401465	V2 Power 115	ZK 40	115	22.23	13,300	10
A27441150601465	V2 Power 115	ZK 60	115	22.23	13,300	10
A27441250401465A	V2 Power 125	ZK 40	125	22.23	12,200	10
A27441250601465	V2 Power 125	ZK 60	125	22.23	12,200	10
A27441780401465	V2 Power 178	ZK 40	178	22.23	8,500	10
A27441780601465	V2 Power 178	ZK 60	178	22.23	8,500	10
A27442300401418	V2 Power 230	ZKS 40	230	22.23	6,600	5

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



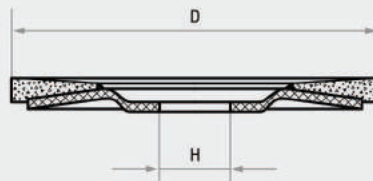
## MACHINING STATE-OF-THE-ART MATERIALS

OPTIMISED FOR A WIDE VARIETY OF ALUMINIUM ALLOYS: THE V2 POWER ALU

GRINDING AND POLISHING  
(with flexible tools)



### V2 Power Alu lamellar flap disc



★★★

- Silicon carbide (SiC) is ideally suited for the preparation and finishing of welds of various aluminium alloys.
- Silicon carbide (SiC) is also very suitable for machining modern materials such as CFRP and GFRP.

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27441150401434	V2 Power 115	SIC 40	115	22.23	13,300	10
A27441250361434	V2 Power 125	SIC 36	125	22.23	12,200	10
A27441250401434	V2 Power 125	SIC 40	125	22.23	12,200	10
A27441780241434	V2 Power 178	SIC 24	178	22.23	8,500	10
A27441780361434	V2 Power 178	SIC 36	178	22.23	8,500	10

Recommended for: ● Aluminium ● Titanium ● Plastic/Wood

## SLTflex – FOR MACHINING INACCESSIBLE AREAS

EXPERIENCE THE EFFICIENCY COMPARED TO FIBRE,  
GRINDING OR CONVENTIONAL LAMELLAR FLAP STOCK DISCS



The flexible SLTflex flap discs from LUKAS for machining hard-to-reach areas are the improved alternative to grinding discs or conventional lamellar flap discs.

The small resin core of the backing plate and its practical M14 thread allows for a larger flap projection. This makes the disc flexible, it can adapt itself to uneven surfaces, and requires little effort in use. With its long tool life, it is ideally suitable for fillet weld grinding. There is no risk of the workpiece being damaged by the back plate.

Compared to grinding discs, the LUKAS patented flap shape and arrangement gives 50 % lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

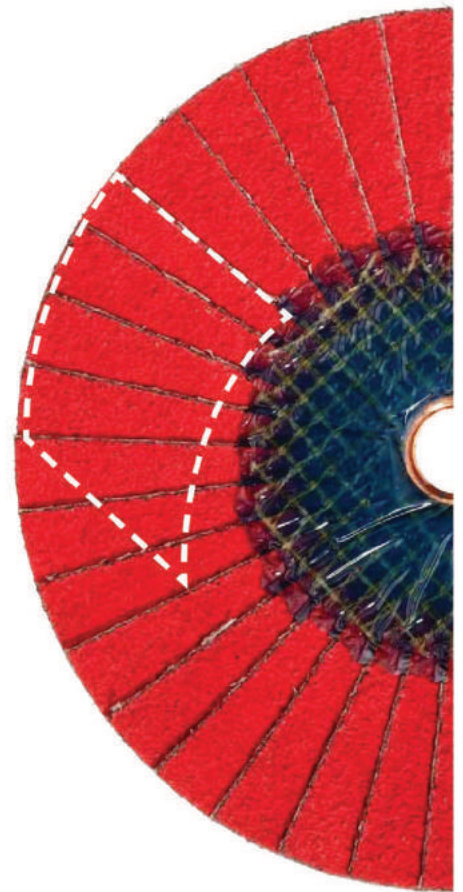
A particularly large concentration of abrasive grains on the outer perimeter results in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.

#### PROPERTIES

- high flexibility thanks to the wide flap projection
- exceptionally long tool life
- easy tool changing

#### APPLICATION

ideal for machining weld seams, deburring, derusting, fettling and smoothing

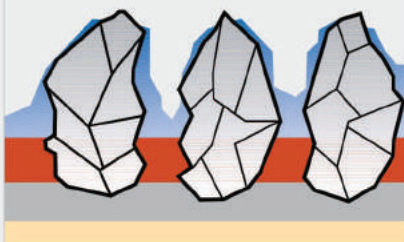


GRINDING AND POLISHING  
(with flexible tools)

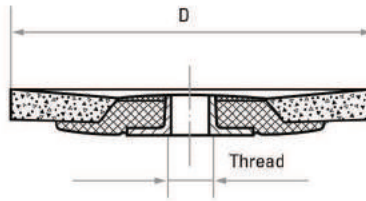
#### FLEXIBLE FLAP ARRANGEMENT

##### ABRASIVE CLOTH

Using high-performance abrasive cloth (with additional abrasive surface layer)



## SLTflex Ceramic lamellar flap disc



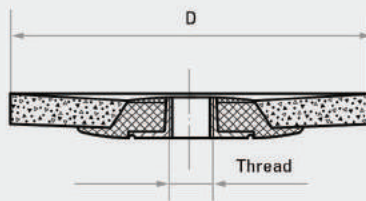
- The efficient grinding tools for radii and fillet welds
- high flexibility thanks to the wide flap projection (no interference from backing plate)
- easy tool changing (backing pad and clamping nut are not required)
- exceptionally long tool life

★★★

Product number	Description	Grit	D mm	Thread	$n_{max}$ rpm	Pack contains
A272711504070	SLTflex 115	Ceramic 40	115	M14	13,300	10
A272711506070	SLTflex 115	Ceramic 60	115	M14	13,300	10
A272712504070	SLTflex 125	Ceramic 40	125	M14	12,200	10
A272712506070	SLTflex 125	Ceramic 60	125	M14	12,200	10

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

## SLTsflex super flexible lamellar flap disc



- even greater flap projection
- even more flexibility
- M14 quick-clamping thread
- super-soft grinding action
- for perfect surface finishes
- fast tool change
- no backing pad and mounting nut required

★★★

Product number	Description	Grit	D mm	Thread	$n_{max}$ rpm	Pack contains
A272910004018	SLTs-flex 100	ZKS 40	100	M10	12,100	10
A272910006018	SLTs-flex 100	ZKS 60	100	M10	12,100	10
A272910008018	SLTs-flex 100	ZKS 80	100	M10	12,100	10
A672911504018	SLTs-flex 115	ZKS 40	115	M14	13,300	10
A672911506018	SLTs-flex 115	ZKS 60	115	M14	13,300	10
A672911508018	SLTs-flex 115	ZKS 80	115	M14	13,300	10
A672912504018	SLTs-flex 125	ZKS 40	125	M14	12,200	10
A672912506018	SLTs-flex 125	ZKS 60	125	M14	12,200	10
A672912508018	SLTs-flex 125	ZKS 80	125	M14	12,200	10
A272917804018	SLTs-flex 178	ZKS 40	178	M14	8,500	10
A272917806018	SLTs-flex 178	ZKS 60	178	M14	8,500	10
A272917808018	SLTs-flex 178	ZKS 80	178	M14	8,500	10

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

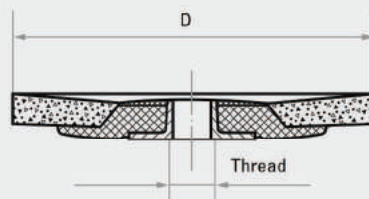


# MAXIMUM FLEXIBILITY THANKS TO LARGE FLAP PROJECTION

EASY MACHINING OF RADII AND FILLET WELDS



## SLTflex lamellar flap disc



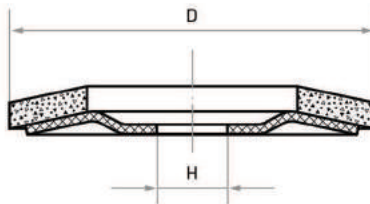
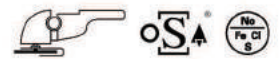
- for machining radii and fillet welds
- high flexibility thanks to the large flap projection (no interference from backing plate)
- easy tool changing (backing pad and clamping nut are not required)
- long tool life

★★★

Product number	Description	Grit	D mm	Thread	$n_{max}$ rpm	Pack contains
A272711504018	SLTflex 115	ZKS 40	115	M14	13,300	10
A272811504018	SLTflex 115	ZKS 40	115	5/8"	13,300	10
A272711506018	SLTflex 115	ZKS 60	115	M14	13,300	10
A272811506018	SLTflex 115	ZKS 60	115	5/8"	13,300	10
A272711508016	SLTflex 115	ZK 80	115	M14	13,300	10
A272811508018	SLTflex 115	ZK 80	115	5/8"	13,300	10
A272711512016	SLTflex 115	ZK 120	115	M14	13,300	10
A272811512018	SLTflex 115	ZK 120	115	5/8"	13,300	10
A272712504018	SLTflex 125	ZKS 40	125	M14	12,200	10
A272812504018	SLTflex 125	ZKS 40	125	5/8"	12,200	10
A272712506018	SLTflex 125	ZKS 60	125	M14	12,200	10
A272812506018	SLTflex 125	ZKS 60	125	5/8"	12,200	10
A272712508016	SLTflex 125	ZK 80	125	M14	12,200	10
A272812508018	SLTflex 125	ZK 80	125	5/8"	12,200	10
A272712512016	SLTflex 125	ZK 120	125	M14	12,200	10
A272812512018	SLTflex 125	ZK 120	125	5/8"	12,200	10

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

## SLTR Control lamellar flap disc



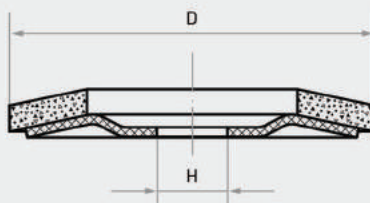
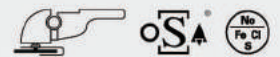
- grinding tool with apertures: keep a constant check on how your work is progressing
- protect sensitive surfaces against damage during grinding

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27461150401406	SLTR 115 Control	ZK 40 INOX	115	22.23	13,300	10
A27461150601406	SLTR 115 Control	ZK 60 INOX	115	22.23	13,300	10
A27461150801406	SLTR 115 Control	ZK 80 INOX	115	22.23	13,300	10
A27461250401406	SLTR 125 Control	ZK 40 INOX	125	22.23	12,200	10
A27461250601406	SLTR 125 Control	ZK 60 INOX	125	22.23	12,200	10
A27461250801406	SLTR 125 Control	ZK 80 INOX	125	22.23	12,200	10

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

## SLTZ lamellar flap disc



- lamellar flap disc with active grinding additives
- outstanding grinding performance
- best results with the special formulation
- outstanding tool life
- suitable for most material
- suitable for deburring, fettling, derusting and smoothing
- **Application:** Shipbuilding, steel construction, VA stainless steel and many other applications

★★★

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27261150401418	SLTZ 115	ZKS 40	115	22.23	13,300	10
A27261150601418	SLTZ 115	ZKS 60	115	22.23	13,300	10
A27261150801418	SLTZ 115	ZKS 80	115	22.23	13,300	10
A27261250401418	SLTZ 125	ZKS 40	125	22.23	12,200	10
A27261250601418	SLTZ 125	ZKS 60	125	22.23	12,200	10
A27261250801418	SLTZ 125	ZKS 80	125	22.23	12,200	10

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



# IMPRESSIVE TOOL LIFE

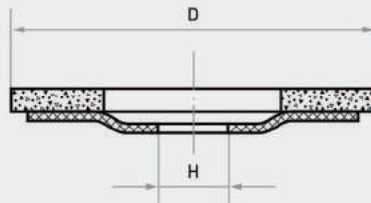
# WITH HIGH ERGONOMICS

## HIGH-PERFORMANCE LUKAS LAMELLAR FLAP DISCS WITH RECTANGULAR FLAPS



### SLTO<sup>Ceramic4x</sup> / SLTR<sup>Ceramic4x</sup> lamellar flap disc **NEW**

- ideal for deburring, fettling, derusting, smoothing and weld seam machining
- for use on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves high removal stock rates when rough grinding steel
- with self-sharpening effect thanks to innovative Ceramic4x abrasive grain
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- Glass fibre backing
- the perfect alternative to grinding discs



★★★

Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27251150401444	SLTO 115	Ceramic4x 40		115	22.23	13,300	10
A27251250401444	SLTO 125	Ceramic4x 40		125	22.23	12,200	10
A27251250601444	SLTO 125	Ceramic4x 60		125	22.23	12,200	10
A27251250801444	SLTO 125	Ceramic4x 80		125	22.23	12,200	10
A27231150401544	SLTR 115	Ceramic4x 40		115	22.23	13,300	10
A27231150601444	SLTR 115	Ceramic4x 60		115	22.23	13,300	10
A27231150801444	SLTR 115	Ceramic4x 80		115	22.23	13,300	10
A27231250401544	SLTR 125	Ceramic4x 40		125	22.23	13,300	10
A27231250601544	SLTR 125	Ceramic4x 60		125	22.23	12,200	10
A27231250801544	SLTR 125	Ceramic4x 80		125	22.23	12,200	10
A27231780401544	SLTR 178	Ceramic4x 40		178	22.23	8,500	10
A27231780601444	SLTR 178	Ceramic4x 60		178	22.23	8,500	10

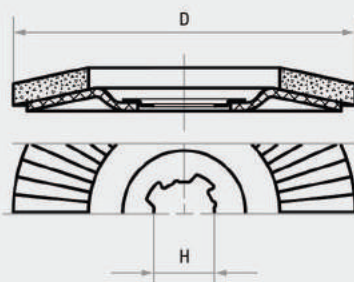
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood



ALL THE BENEFITS OF THE SLTR LAMELLAR FLAP DISC WITH THE INNOVATIVE X-LOCK MOUNTING SYSTEM

Prob: Bosch

## NEW SLTR X-LOCK lamellar flap disc



- keyless tool changing in no time at all
- ideal for deburring, fettling, derusting, smoothing and weld seam machining
- always remains sharp throughout the tool life thanks to the multi-layer coating
- good price-to-performance ratio thanks to the rectangular flaps

★★★

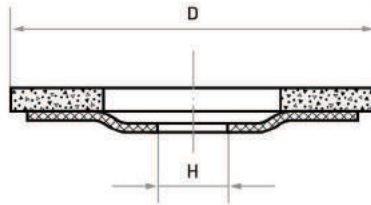
Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A67181250401865	SLTR 125	ZK 40	125	X-LOCK/22.23	12,200	10
A67181250601865	SLTR 125	ZK 60	125	X-LOCK/22.23	12,200	10
A67181250801865	SLTR 125	ZK 80	125	X-LOCK/22.23	12,200	10

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



## SLTO/SLTR lamellar flap disc, zirconia alumina

- achieves high removal rates on hard and tough materials and a long tool life
- for deburring, fettling, derusting, smoothening and weld seam machining
- very good price-to-performance thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing
- the efficient alternative to grinding discs



★★☆

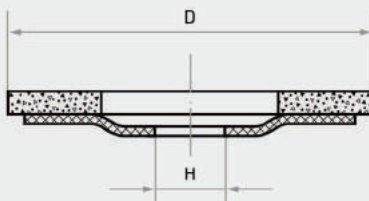
Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains	
A27151150401406	SLTO 115	ZK 40		115	22.23	13,300	10	
A27151150601406	SLTO 115	ZK 60		115	22.23	13,300	10	
A27151150801406	SLTO 115	ZK 80		115	22.23	13,300	10	
A27151250401406	SLTO 125	ZK 40			125	22.23	12,200	10
A27151250601406	SLTO 125	ZK 60			125	22.23	12,200	10
A27151250801406	SLTO 125	ZK 80			125	22.23	12,200	10
A27151780361401	SLTO 178	ZK 36			178	22.23	8,500	10
A27151780401401	SLTO 178	ZK 40			178	22.23	8,500	10
A27151781201401	SLTO 178	ZK 120			178	22.23	8,500	10
A27181000401423	SLTR 100	ZK 40				100	16.00	15,300
A27181000601423	SLTR 100	ZK 60	100			16.00	15,300	10
A27181000801423	SLTR 100	ZK 80	100			16.00	15,300	10
A27181150361406	SLTR 115	ZK 36	115			22.23	13,300	10
A27181150401406	SLTR 115	ZK 40	115			22.23	13,300	10
A27181150601406	SLTR 115	ZK 60	115			22.23	13,300	10
A27181150801406	SLTR 115	ZK 80	115	22.23		13,300	10	
A27181151201406	SLTR 115	ZK 120	115	22.23		13,300	10	
A27181250361406	SLTR 125	ZK 36		125		22.23	12,200	10
A27181250401406	SLTR 125	ZK 40		125		22.23	12,200	10
A27181250601406	SLTR 125	ZK 60		125		22.23	12,200	10
A27181250801406	SLTR 125	ZK 80		125		22.23	12,200	10
A27181251201406	SLTR 125	ZK 120		125		22.23	12,200	10
A27181500401416	SLTR 150	ZK 40		150		22.23	10,200	10
A27181500601416	SLTR 150	ZK 60		150		22.23	10,200	10
A27181500801416	SLTR 150	ZK 80		150		22.23	10,200	10
A27181780361401	SLTR 178	ZK 36		178		22.23	8,500	10
A27181780401401	SLTR 178	ZK 40		178		22.23	8,500	10
A27181780601401	SLTR 178	ZK 60		178		22.23	8,500	10
A27181780801401	SLTR 178	ZK 80		178		22.23	8,500	10

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

# EFFICIENTLY MACHINE WELD SEAMS WITH REGULAR ALUMINIUM OXIDE

EASY TO USE, MINIMUM VIBRATION AND HIGH CRACK RESISTANCE

## SLTO/SLTR lamellar flap disc, regular aluminium oxide



- the good alternative to grinding discs
- for deburring, fettling, derusting, smoothing and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing

★★☆

Product number	Description	Grit	Drawing	D mm	H mm	$n_{max}$ rpm	Pack contains
A27151150601400	SLTO 115	NK 60		115	22.23	13,300	10
A27151150801400	SLTO 115	NK 80		115	22.23	13,300	10
A27181150401400	SLTR 115	NK 40		115	22.23	13,300	10
A27181150601400	SLTR 115	NK 60		115	22.23	13,300	10
A27181150801400	SLTR 115	NK 80		115	22.23	13,300	10
A27181151201400	SLTR 115	NK 120		115	22.23	13,300	10
A27181250401400	SLTR 125	NK 40		125	22.23	12,200	10
A27181250601400	SLTR 125	NK 60		125	22.23	12,200	10
A27181250801400	SLTR 125	NK 80	125	22.23	12,200	10	
A27181251201400	SLTR 125	NK 120	125	22.23	12,200	10	

Recommended for: ● Steel ● Cast material ● Plastic/Wood



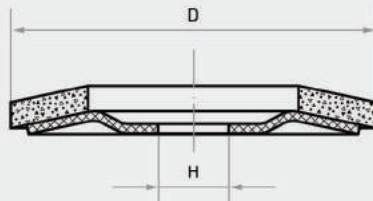
## THE ECONOMICAL BASE-X

ACHIEVE HIGH REMOVAL RATES WITH HARD AND SHARP ZIRCONIA ALUMINA



### SLTO/SLTR BASE-X lamellar flap disc NEW

- the economical alternative to grinding discs
- for deburring, fettling, derusting, smoothing and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing

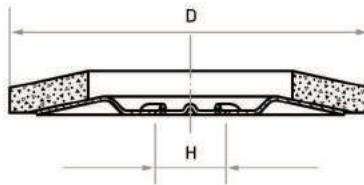
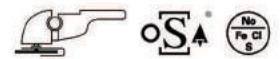


☆☆☆

Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27151150401535	SLTO 115 BASE-X	ZK 40		115	22.23	13,300	10
A27151150601535	SLTO 115 BASE-X	ZK 60		115	22.23	13,300	10
A27151150801535	SLTO 115 BASE-X	ZK 80		115	22.23	13,300	10
A27151151201535	SLTO 115 BASE-X	ZK 120		115	22.23	13,300	10
A27151250401535	SLTO 125 BASE-X	ZK 40		125	22.23	12,200	10
A27151250601535	SLTO 125 BASE-X	ZK 60		125	22.23	12,200	10
A27151250801535	SLTO 125 BASE-X	ZK 80		125	22.23	12,200	10
A27181150401535	SLTR 115 BASE-X	ZK 40			115	22.23	13,300
A27181150601535	SLTR 115 BASE-X	ZK 60	115		22.23	13,300	10
A27181150801535	SLTR 115 BASE-X	ZK 80	115		22.23	13,300	10
A27181151201535	SLTR 115 BASE-X	ZK 120	115		22.23	13,300	10
A27181250401535	SLTR 125 BASE-X	ZK 40		125	22.23	12,200	10
A27181250601535	SLTR 125 BASE-X	ZK 60		125	22.23	12,200	10
A27181250801535	SLTR 125 BASE-X	ZK 80		125	22.23	12,200	10
A27181251201535	SLTR 125 BASE-X	ZK 120		125	22.23	12,200	10
A27181780401535	SLTR 178 BASE-X	ZK 40		178	22.23	8,500	10
A27181780601535	SLTR 178 BASE-X	ZK 60		178	22.23	8,500	10
A27181780801535	SLTR 178 BASE-X	ZK 80		178	22.23	8,500	10
A27181781201535	SLTR 178 BASE-X	ZK 120		178	22.23	8,500	10

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

## SLTB lamellar flap disc



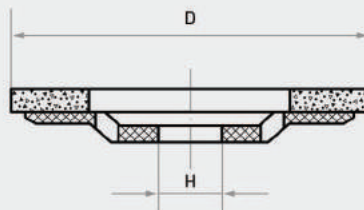
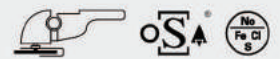
- especially robust lamellar flap disc thanks to the steel backing plate
- well suited for deburring, fettling, derusting, smoothening and weld seam machining
- good heat dissipation for cool grinding
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

★★☆

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A2250115040	SLTB 115	ZK 40	115	22.23	13,300	10
A2250115060	SLTB 115	ZK 60	115	22.23	13,300	10
A2250115080	SLTB 115	ZK 80	115	22.23	13,300	10
A2250125040	SLTB 125	ZK 40	125	22.23	12,200	10
A2250125060	SLTB 125	ZK 60	125	22.23	12,200	10
A2250125080	SLTB 125	ZK 80	125	22.23	12,200	10
A2250178040	SLTB 178	ZK 40	178	22.23	8,500	10
A2250178060	SLTB 178	ZK 60	178	22.23	8,500	10

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

## SLTK lamellar flap disc



- no marking on the workpiece thanks to the practical plastic backing plate
- with integrated cooling slots for cool grinding and minimum reworking
- well suited for deburring, fettling, derusting, smoothening and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

★★☆

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27111150401623	SLTK 115	ZK 40	115	22.23	13,300	10
A27111150601623	SLTK 115	ZK 60	115	22.23	13,300	10
A27111250401623	SLTK 125	ZK 40	125	22.23	12,200	10
A27111250601623	SLTK 125	ZK 60	125	22.23	12,200	10

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

# COOLING AND QUICK-CLAMPING THREAD

SLTK LAMELLAR FLAP DISC WITH PRACTICAL PLASTIC BACKING PLATE

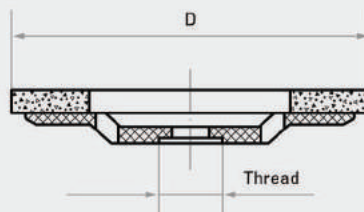
## MINI LAMELLAR FLAP DISC WITH PLASTIC THREAD – TEST IT NOW!

Self-clamping, mini lamellar flap disc for pneumatic angle grinders: all the benefits of LUKAS lamellar flap discs combined with fast, accessory-free tool changing. Also ideal for use with robotics!

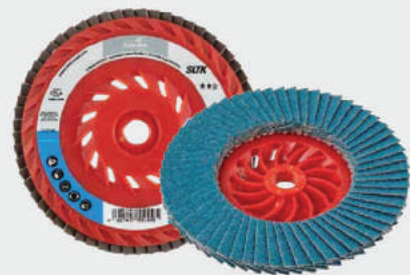
FIND OUT ABOUT OUR SELF-CLAMPING MINI LAMELLAR FLAP DISCS ON **PAGE 226**



- with integrated M14 thread for easy mounting on the angle grinder
- no marking on the workpiece thanks to the practical plastic backing plate
- with integrated cooling slots for cool grinding and minimum reworking
- well suited for deburring, fettling, derusting, smoothing and weld seam machining
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating



## SLTK lamellar flap disc with quick-clamping thread



★★☆

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A27111150401723	SLTK 115	ZK 40	115	M14	13,300	10
A27111150601723	SLTK 115	ZK 60	115	M14	13,300	10
A27111250401723	SLTK 125	ZK 40	125	M14	12,200	10
A27111250601723	SLTK 125	ZK 60	125	M14	12,200	10

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

# ALWAYS WITH THE ENVIRONMENT IN MIND

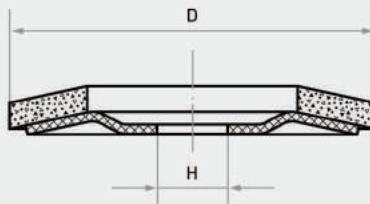
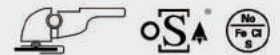
LUKAS HAS BEEN PIONEERING THE USE OF RENEWABLE  
RAW MATERIALS FOR MANUFACTURING TOOLS FOR 30 YEARS.



LUKAS NAWAROFLEX® lamellar flap discs have a backing plate made of renewable raw materials. Although made of paper, these special eco-friendly backing plates are nevertheless very sturdy and offer enough stability for hard grinding applications.

As a pioneer in the tool industry in the use of this technology, LUKAS has been relying on NAWAROFLEX® for 30 years, and currently offers three different tools made with renewable raw materials. You can use LUKAS tools with NAWAROFLEX® for deburring, weld seam machining, refining surfaces or for fine grinding, and in doing so work in an environmentally conscious manner.

## SLTC NAWAROFLEX® lamellar flap disc



- with special zirconia alumina (polyester-based) and active abrasive surface layer
- ideal for machining stainless steel
- for deburring, fettling, derusting, smoothening and weld seam machining
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

★★★

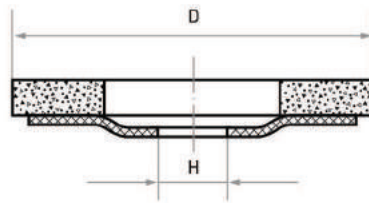
Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27031150360127	SLTC 115	ZKS 36	115	22.23	13,300	10
A27031150400127	SLTC 115	ZKS 40	115	22.23	13,300	10
A27031150500127	SLTC 115	ZKS 50	115	22.23	13,300	10
A27031150600127	SLTC 115	ZKS 60	115	22.23	13,300	10
A27031150800127	SLTC 115	ZKS 80	115	22.23	13,300	10
A27031250400127	SLTC 125	ZKS 40	125	22.23	12,200	10
A27031250600127	SLTC 125	ZKS 60	125	22.23	12,200	10
A27031250800127	SLTC 125	ZKS 80	125	22.23	12,200	10

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





## SLTM NAWAROFLEX® lamellar flap disc



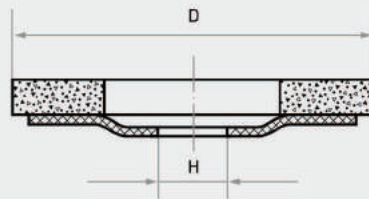
- made from an abrasive cloth and fleece mix for surface enhancement
- can be used without a backing pad on adjustable or low-speed angle grinders
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials

★★☆

Product number	Description	Quality	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27131151040140	SLTM 115	A104/80	NK 100/80	115	22.23	5,300	10
A27131151060140	SLTM 115	A106/150	NK 180/150	115	22.23	5,300	10
A27131151070140	SLTM 115	A107/240	NK 280/240	115	22.23	5,300	10
Recommended use for A qualities: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium							
A27131152040141	SLTM 115	C204/80	SIC 100/80	115	22.23	5,300	10
A27131152060141	SLTM 115	C206/150	SIC 180/150	115	22.23	5,300	10
A27131152070141	SLTM 115	C207/240	SIC 280/240	115	22.23	5,300	10
Recommended use for C qualities: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material							



## SLTV NAWAROFLEX® lamellar flap disc



- made of abrasive fleece for fine grinding, e.g. before polishing
- can be used without a backing pad on adjustable or low-speed angle grinders
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials

★★☆

Product number	Description	Quality	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27221151040130	SLTV 115	A104	NK 100	115	22.23	5,300	10
A27221151060130	SLTV 115	A106	NK 180	115	22.23	5,300	10
A27221151070130	SLTV 115	A107	NK 280	115	22.23	5,300	10
Recommended use for A qualities: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium							
A27221152060130	SLTV 115	C206	SIC 180	115	22.23	5,300	10
A27221152070130	SLTV 115	C207	SIC 280	115	22.23	5,300	10
A27221153061530	SLTV 115	Z306	ZK 180	115	22.23	5,300	10
A27221153071530	SLTV 115	Z307	ZK 280	115	22.23	5,300	10
Recommended use for C qualities: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material							

NEW

NEW

# FROM FINE GRINDING TO POLISHING

## A SMOOTH TRANSITION WITH LUKAS TOOLS

After the fine grinding, is polishing your next job? LUKAS offers a wide assortment of polishing tools especially designed for fine surface treatment and polishing work. Made of high quality raw materials, LUKAS polishing points, discs, sticks and rolls are precisely tailored to achieve the required degree of polishing for each individual application – through to shiny and mirror-like polishing. LUKAS polishing tools are divided into the groups P1 to P7 according to the respective intended use. You can find further information and the products **from page 97**.

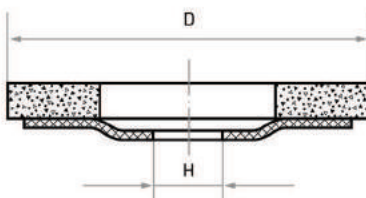
The LUKAS polishing tool range with its huge variety of different shapes allows you to choose the most suitable polishing tools for your specific fine machining (fine and ultra-fine grinding) or polishing requirements. This means that with our tools you can work in an extremely economical and especially effective manner.

### THE LUKAS POLISHING DISC SET

After fine grinding your surfaces with an angle grinder, you can then easily achieve your desired polishing results with the LUKAS polishing disc set. Just use the different polishing discs from the LUKAS polishing set in sequence. Easily and quickly achieve everything from removing rust to a mirror finish with just a few tool changes and without switching machines. The practical LUKAS polishing disc sets can be found on **pages 118 and 119!**



## SLTP polishing disc



- cooler – very efficient for light deburring, cleaning Inox weld seams and surface enhancement
- The fleece fibre design prevents overheating and clogging on the tool.
- minimum edge abrasion for improved productivity
- can be used without a backing pad on adjustable or low-speed grinders

★★☆

Product number	Description	D mm	H mm	Type/hardness	n <sub>max</sub> rpm	Pack contains
A271611523	SLTP 115 M	115	22.23	medium	8,300	5
A271611513	SLTP 115 W	115	22.23	soft	8,300	5

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

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Mounted flap wheels made of abrasive cloth, abrasive fleece and a combination of both

## SFL, MOUNTED FLAP WHEEL MADE OF ABRASIVE CLOTH

These tools comprise individual flaps which are radially fixed around the axis of the tool. They are mainly used on handheld power tools. We offer our mounted flap wheels made of abrasive cloth in the qualities Ceramic, NK, NKE and SIC.

## SFB, SLOTTED FLAP WHEEL

The slits around the circumference of the flaps add greater flexibility compared to a regular mounted flap wheel. This allows the slotted flap wheel to adapt itself even better to the contour of the workpiece.

## SFT, MOUNTED FLAP WHEEL WITH RECESS

These tools are suitable for both face and peripheral grinding.

## SFI AND SFA, MOUNTED FLAP WHEELS MADE OF ABRASIVE CLOTH WITH INTERNAL OR EXTERNAL THREAD INCL. TOOL ADAPTERS

In contrast to the SFL, these mounted flap wheels also have a thread. With the appropriate adapter, the tool can be changed quickly without removing the tool adapter from the power tool. The adapter extends the shaft and optimises set-up time.

## SFV, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE

These tools comprise single fleece flaps fixed radially around the axis of the tool; they are available in regular aluminium oxide (A), silicon carbide (C) and zirconia aluminium oxide (Z). SFV are mainly used on handheld power tools.

## SFR, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE DISCS

These special tools are comprised of individual elastic fleece discs staked one upon the other. This makes them particularly suitable for machining profiled workpieces.

## SFM, MOUNTED FLAP WHEEL MADE OF COMBINED ABRASIVE FLEECE AND CLOTH

These tools comprise single fleece and cloth flaps radially fixed around the axis of the tool; they are available in regular aluminium oxide (A) and silicon carbide (C). The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared with type SFV. SFM are mainly used on handheld power tools.

## SFM, MOUNTED FLAP WHEEL MADE OF TF MATERIAL

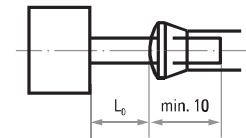
These tools are specially designed for use with non-rusting materials. The abrasive fleece with its reinforced backing guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotating direction of the tool!

### Application examples:

- Smoothing
- Derusting
- Fettling
- Deburring
- Surface grinding
- Texturing
- Beveling

### SPEED

The stated maximum permissible speeds apply for a maximum open shank length  $L_0$  of 20 mm.



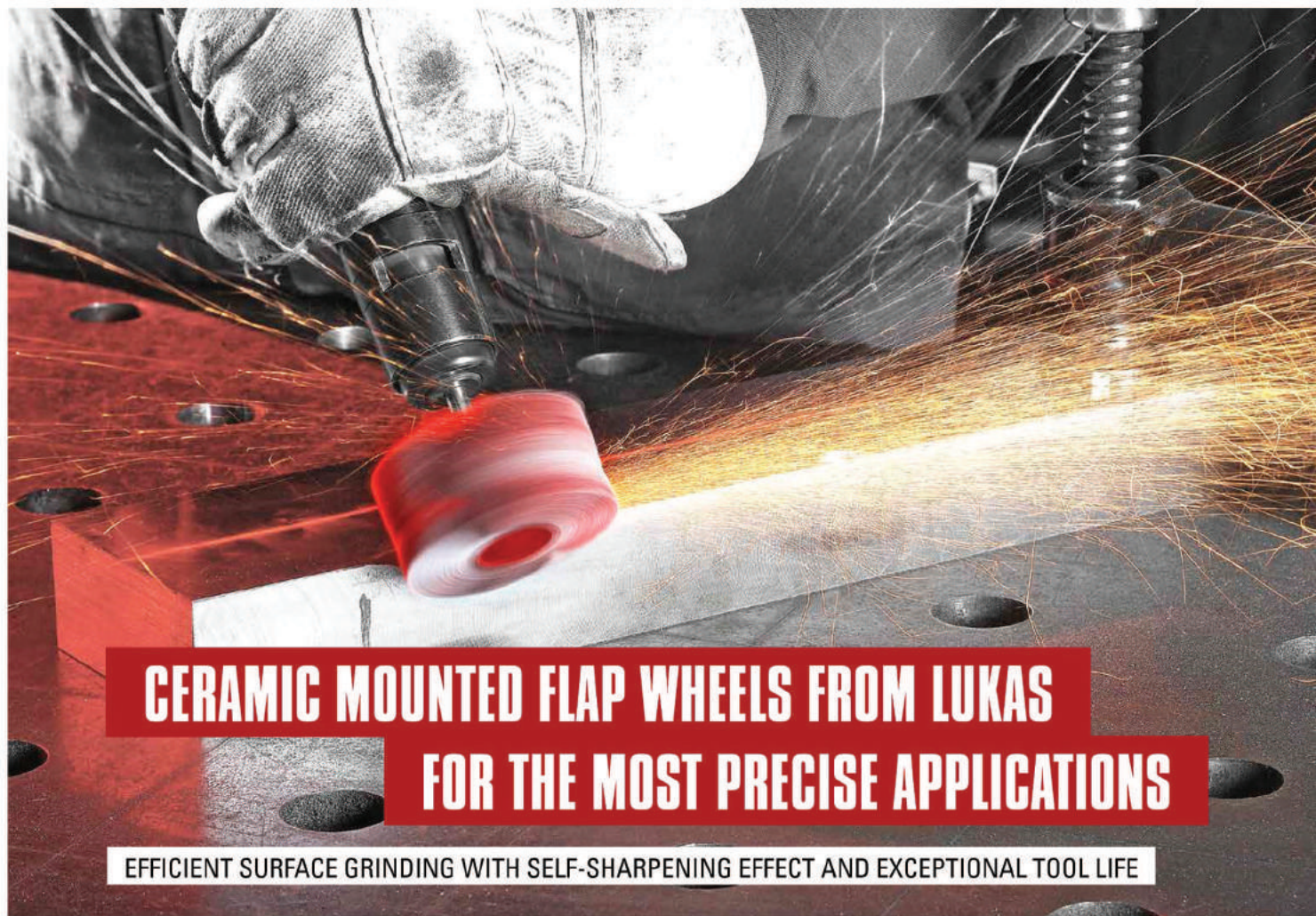
### Application examples:

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

### Application examples:

- Cleaning
- Derusting
- Pre-grinding
- Texturing
- Roughing

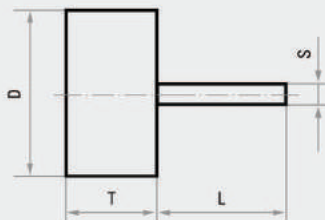
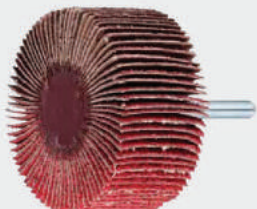
Quality	Abrasive particles	Grit	Surface
A104	Regular aluminium oxide	NK 100	medium
A106	Regular aluminium oxide	NK 180	fine
A107	Regular aluminium oxide	NK 280	very fine
C204	Silicon carbide	SIC 100	medium
C206	Silicon carbide	SIC 180	fine
C207	Silicon carbide	SIC 280	very fine
C208	Silicon carbide	SIC 400	ultra-fine
Z304	Zirconia alumina	ZK 100	medium
Z306	Zirconia alumina	ZK 180	fine
Z307	Zirconia alumina	ZK 280	very fine



## CERAMIC MOUNTED FLAP WHEELS FROM LUKAS FOR THE MOST PRECISE APPLICATIONS

EFFICIENT SURFACE GRINDING WITH SELF-SHARPENING EFFECT AND EXCEPTIONAL TOOL LIFE

### SFL Ceramic mounted flap wheel



- especially high stock removal thanks to self-sharpening ceramic grain
- robust design for a long tool life
- used as a handheld tool, ideal for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling

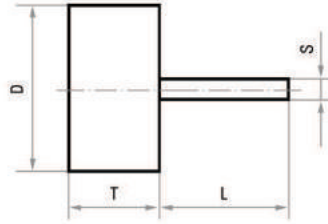
★★★

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2214020206080	SFL 02020.06	Ceramic 80	20	20	6	40	20,000	38,200	10
A2214020206120	SFL 02020.06	Ceramic 120	20	20	6	40	20,000	38,200	10
A2214030106060	SFL 03010.06	Ceramic 60	30	10	6	40	16,000	25,400	10
A2214030106080	SFL 03010.06	Ceramic 80	30	10	6	40	16,000	25,400	10
A2214030106120	SFL 03010.06	Ceramic 120	30	10	6	40	16,000	25,400	10
A2214040206060	SFL 04020.06	Ceramic 60	40	20	6	40	12,000	19,100	10
A2214040206080	SFL 04020.06	Ceramic 80	40	20	6	40	12,000	19,100	10
A2214040206120	SFL 04020.06	Ceramic 120	40	20	6	40	12,000	19,100	10
A2214060156080	SFL 06015.06	Ceramic 80	60	15	6	40	8,000	12,700	10
A2214060156120	SFL 06015.06	Ceramic 120	60	15	6	40	8,000	12,700	10
A2214060306060	SFL 06030.06	Ceramic 60	60	30	6	40	8,000	12,700	10
A2214060306080	SFL 06030.06	Ceramic 80	60	30	6	40	8,000	12,700	10
A2214060306120	SFL 06030.06	Ceramic 120	60	30	6	40	8,000	12,700	10

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



- good tool life on different materials for rough and fine grinding
- regular aluminium oxide for cost-effective applications
- used as a handheld tool, ideal for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling



## SFL mounted flap wheel



Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2200010103080	SFL 01010.03	NK 80	10	10	3	40	26,000	35,000	10
A2200010103120	SFL 01010.03	NK 120	10	10	3	40	26,000	35,000	10
A2200010103150	SFL 01010.03	NK 150	10	10	3	40	26,000	35,000	10
A2200010103240	SFL 01010.03	NK 240	10	10	3	40	26,000	35,000	10
A2200010153080	SFL 01015.03	NK 80	10	15	3	40	24,000	35,000	10
A2200015103080	SFL 01510.03	NK 80	15	10	3	40	24,000	35,000	10
A2200015103150	SFL 01510.03	NK 150	15	10	3	40	24,000	35,000	10
A2200015106080	SFL 01510.06	NK 80	15	10	6	40	24,000	35,000	10
A2200015153080	SFL 01515.03	NK 80	15	15	3	40	24,000	35,000	10
A2200015153120	SFL 01515.03	NK 120	15	15	3	40	24,000	35,000	10
A2200015153150	SFL 01515.03	NK 150	15	15	3	40	24,000	35,000	10
A2200020056120	SFL 02005.06	NK 120	20	5	6	40	20,000	38,200	10
A2200020103080	SFL 02010.03	NK 80	20	10	3	40	20,000	28,000	10
A2200020103120	SFL 02010.03	NK 120	20	10	3	40	20,000	28,000	10
A2200020103150	SFL 02010.03	NK 150	20	10	3	40	20,000	28,000	10
A2200020103320	SFL 02010.03	NK 320	20	10	3	40	20,000	28,000	10
A2200020106080	SFL 02010.06	NK 80	20	10	6	40	20,000	38,200	10
A2200020106120	SFL 02010.06	NK 120	20	10	6	40	20,000	38,200	10
A2200020156060	SFL 02015.06	NK 60	20	15	6	40	20,000	38,200	10
A2200020156080	SFL 02015.06	NK 80	20	15	6	40	20,000	38,200	10
A2200020156120	SFL 02015.06	NK 120	20	15	6	40	20,000	38,200	10
A2200020156150	SFL 02015.06	NK 150	20	15	6	40	20,000	38,200	10
A2200020156240	SFL 02015.06	NK 240	20	15	6	40	20,000	38,200	10
A2200020206060	SFL 02020.06	NK 60	20	20	6	40	20,000	38,200	10
A2200020206080	SFL 02020.06	NK 80	20	20	6	40	20,000	38,200	10
A2200025053120	SFL 02505.03	NK 120	25	5	3	40	16,000	18,000	10
A2200025103080	SFL 02510.03	NK 80	25	10	3	40	16,000	18,000	10
A2200025103120	SFL 02510.03	NK 120	25	10	3	40	16,000	18,000	10
A2200025103150	SFL 02510.03	NK 150	25	10	3	40	16,000	18,000	10
A2200025106080	SFL 02510.06	NK 80	25	10	6	40	16,000	30,600	10
A2200025106120	SFL 02510.06	NK 120	25	10	6	40	16,000	30,600	10
A2200025156080	SFL 02515.06	NK 80	25	15	6	40	16,000	30,600	10
A2200025156120	SFL 02515.06	NK 120	25	15	6	40	16,000	30,600	10
A2200025156150	SFL 02515.06	NK 150	25	15	6	40	16,000	30,600	10
A2200025206080	SFL 02520.06	NK 80	25	20	6	40	16,000	30,600	10
A2200025206120	SFL 02520.06	NK 120	25	20	6	40	16,000	30,600	10
A2200025256080	SFL 02525.06	NK 80	25	25	6	40	16,000	30,600	10
A2200025256150	SFL 02525.06	NK 150	25	25	6	40	16,000	30,600	10
A2200030053060	SFL 03005.03	NK 60	30	5	3	40	16,000	18,000	10
A2200030053080	SFL 03005.03	NK 80	30	5	3	40	16,000	18,000	10

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

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200030053120	SFL 03005.03	NK 120	30	5	3	40	16,000	18,000	10
A2200030053150	SFL 03005.03	NK 150	30	5	3	40	16,000	18,000	10
A2200030053240	SFL 03005.03	NK 240	30	5	3	40	16,000	18,000	10
A2200030053320	SFL 03005.03	NK 320	30	5	3	40	16,000	18,000	10
A2200030056060	SFL 03005.06	NK 60	30	5	6	40	16,000	25,400	10
A2200030056080	SFL 03005.06	NK 80	30	5	6	40	16,000	25,400	10
A2200030056100	SFL 03005.06	NK 100	30	5	6	40	16,000	25,400	10
A2200030056120	SFL 03005.06	NK 120	30	5	6	40	16,000	25,400	10
A2200030056150	SFL 03005.06	NK 150	30	5	6	40	16,000	25,400	10
A2200030056180	SFL 03005.06	NK 180	30	5	6	40	16,000	25,400	10
A2200030056240	SFL 03005.06	NK 240	30	5	6	40	16,000	25,400	10
A2200030056320	SFL 03005.06	NK 320	30	5	6	40	16,000	25,400	10
A2200030103060	SFL 03010.03	NK 60	30	10	3	40	16,000	18,000	10
A2200030103080	SFL 03010.03	NK 80	30	10	3	40	16,000	18,000	10
A2200030103120	SFL 03010.03	NK 120	30	10	3	40	16,000	18,000	10
A2200030103150	SFL 03010.03	NK 150	30	10	3	40	16,000	18,000	10
A2200030103240	SFL 03010.03	NK 240	30	10	3	40	16,000	18,000	10
A2200030103320	SFL 03010.03	NK 320	30	10	3	40	16,000	18,000	10
A2200030106060	SFL 03010.06	NK 60	30	10	6	40	16,000	25,400	10
A2200030106080	SFL 03010.06	NK 80	30	10	6	40	16,000	25,400	10
A2200030106120	SFL 03010.06	NK 120	30	10	6	40	16,000	25,400	10
A2200030106150	SFL 03010.06	NK 150	30	10	6	40	16,000	25,400	10
A2200030106240	SFL 03010.06	NK 240	30	10	6	40	16,000	25,400	10
A2200030106320	SFL 03010.06	NK 320	30	10	6	40	16,000	25,400	10
A2200030156060	SFL 03015.06	NK 60	30	15	6	40	16,000	25,400	10
A2200030156080	SFL 03015.06	NK 80	30	15	6	40	16,000	25,400	10
A2200030156120	SFL 03015.06	NK 120	30	15	6	40	16,000	25,400	10
A2200030156150	SFL 03015.06	NK 150	30	15	6	40	16,000	25,400	10
A2200030206040	SFL 03020.06	NK 40	30	20	6	40	16,000	25,400	10
A2200030206060	SFL 03020.06	NK 60	30	20	6	40	16,000	25,400	10
A2200030206080	SFL 03020.06	NK 80	30	20	6	40	16,000	25,400	10
A2200030206120	SFL 03020.06	NK 120	30	20	6	40	16,000	25,400	10
A2200040056100	SFL 04005.06	NK 100	40	5	6	40	12,200	19,100	10
A2200040103080	SFL 04010.03	NK 80	40	10	3	40	12,000	14,000	10
A2200040103150	SFL 04010.03	NK 150	40	10	3	40	12,000	14,000	10
A2200040106060	SFL 04010.06	NK 60	40	10	6	40	12,000	19,100	10
A2200040106080	SFL 04010.06	NK 80	40	10	6	40	12,000	19,100	10
A2200040106120	SFL 04010.06	NK 120	40	10	6	40	12,000	19,100	10
A2200040106150	SFL 04010.06	NK 150	40	10	6	40	12,000	19,100	10
A2200040106180	SFL 04010.06	NK 180	40	10	6	40	12,000	19,100	10
A2200040106240	SFL 04010.06	NK 240	40	10	6	40	12,000	19,100	10
A2200040106320	SFL 04010.06	NK 320	40	10	6	40	12,000	19,100	10
A2200040156040	SFL 04015.06	NK 40	40	15	6	40	12,000	19,100	10
A2200040156060	SFL 04015.06	NK 60	40	15	6	40	12,000	19,100	10
A2200040156080	SFL 04015.06	NK 80	40	15	6	40	12,000	19,100	10
A2200040156120	SFL 04015.06	NK 120	40	15	6	40	12,000	19,100	10
A2200040156150	SFL 04015.06	NK 150	40	15	6	40	12,000	19,100	10
A2200040156240	SFL 04015.06	NK 240	40	15	6	40	12,000	19,100	10
A2200040156320	SFL 04015.06	NK 320	40	15	6	40	12,000	19,100	10

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

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>racom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200040206040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	10
A2200040206060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	10
A2200040206080	SFL 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A2200040206120	SFL 04020.06	NK 120	40	20	6	40	12,000	19,100	10
A2200040206150	SFL 04020.06	NK 150	40	20	6	40	12,000	19,100	10
A2200040206240	SFL 04020.06	NK 240	40	20	6	40	12,000	19,100	10
A2200040206320	SFL 04020.06	NK 320	40	20	6	40	12,000	19,100	10
A2200040306040	SFL 04030.06	NK 40	40	30	6	40	12,000	19,100	10
A2200040306060	SFL 04030.06	NK 60	40	30	6	40	12,000	19,100	10
A2200040306080	SFL 04030.06	NK 80	40	30	6	40	12,000	19,100	10
A2200050106060	SFL 05010.06	NK 60	50	10	6	40	9,000	15,300	10
A2200050106080	SFL 05010.06	NK 80	50	10	6	40	9,000	15,300	10
A2200050106100	SFL 05010.06	NK 100	50	10	6	40	9,000	15,300	10
A2200050106120	SFL 05010.06	NK 120	50	10	6	40	9,000	15,300	10
A2200050106150	SFL 05010.06	NK 150	50	10	6	40	9,000	15,300	10
A2200050106240	SFL 05010.06	NK 240	50	10	6	40	9,000	15,300	10
A2200050156040	SFL 05015.06	NK 40	50	15	6	40	9,000	15,300	10
A2200050156060	SFL 05015.06	NK 60	50	15	6	40	9,000	15,300	10
A2200050156080	SFL 05015.06	NK 80	50	15	6	40	9,000	15,300	10
A2200050156120	SFL 05015.06	NK 120	50	15	6	40	9,000	15,300	10
A2200050156150	SFL 05015.06	NK 150	50	15	6	40	9,000	15,300	10
A2200050156240	SFL 05015.06	NK 240	50	15	6	40	9,000	15,300	10
A2200050156320	SFL 05015.06	NK 320	50	15	6	40	9,000	15,300	10
A2200050206040	SFL 05020.06	NK 40	50	20	6	40	9,000	15,300	10
A2200050206060	SFL 05020.06	NK 60	50	20	6	40	9,000	15,300	10
A2200050206080	SFL 05020.06	NK 80	50	20	6	40	9,000	15,300	10
A2200050206120	SFL 05020.06	NK 120	50	20	6	40	9,000	15,300	10
A2200050206150	SFL 05020.06	NK 150	50	20	6	40	9,000	15,300	10
A2200050206240	SFL 05020.06	NK 240	50	20	6	40	9,000	15,300	10
A2200050206320	SFL 05020.06	NK 320	50	20	6	40	9,000	15,300	10
A2200050306040	SFL 05030.06	NK 40	50	30	6	40	9,000	15,300	10
A2200050306060	SFL 05030.06	NK 60	50	30	6	40	9,000	15,300	10
A2200050306080	SFL 05030.06	NK 80	50	30	6	40	9,000	15,300	10
A2200050306120	SFL 05030.06	NK 120	50	30	6	40	9,000	15,300	10
A2200050306150	SFL 05030.06	NK 150	50	30	6	40	9,000	15,300	10
A2200050306320	SFL 05030.06	NK 320	50	30	6	40	9,000	15,300	10
A2200060106060	SFL 06010.06	NK 60	60	10	6	40	8,000	12,700	10
A2200060106080	SFL 06010.06	NK 80	60	10	6	40	8,000	12,700	10
A2200060106100	SFL 06010.06	NK 100	60	10	6	40	8,000	12,700	10
A2200060156040	SFL 06015.06	NK 40	60	15	6	40	8,000	12,700	10
A2200060156060	SFL 06015.06	NK 60	60	15	6	40	8,000	12,700	10
A2200060156080	SFL 06015.06	NK 80	60	15	6	40	8,000	12,700	10
A2200060156120	SFL 06015.06	NK 120	60	15	6	40	8,000	12,700	10
A2200060156150	SFL 06015.06	NK 150	60	15	6	40	8,000	12,700	10
A2200060156240	SFL 06015.06	NK 240	60	15	6	40	8,000	12,700	10
A2200060156320	SFL 06015.06	NK 320	60	15	6	40	8,000	12,700	10
A2200060206040	SFL 06020.06	NK 40	60	20	6	40	8,000	12,700	10
A2200060206060	SFL 06020.06	NK 60	60	20	6	40	8,000	12,700	10
A2200060206080	SFL 06020.06	NK 80	60	20	6	40	8,000	12,700	10

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

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200060206120	SFL 06020.06	NK 120	60	20	6	40	8,000	12,700	10
A2200060206150	SFL 06020.06	NK 150	60	20	6	40	8,000	12,700	10
A2200060206240	SFL 06020.06	NK 240	60	20	6	40	8,000	12,700	10
A2200060206320	SFL 06020.06	NK 320	60	20	6	40	8,000	12,700	10
A2200060306040	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	10
A2200060306060	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	10
A2200060306080	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	10
A2200060306100	SFL 06030.06	NK 100	60	30	6	40	8,000	12,700	10
A2200060306120	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	10
A2200060306150	SFL 06030.06	NK 150	60	30	6	40	8,000	12,700	10
A2200060306240	SFL 06030.06	NK 240	60	30	6	40	8,000	12,700	10
A2200060306320	SFL 06030.06	NK 320	60	30	6	40	8,000	12,700	10
A2200060406040	SFL 06040.06	NK 40	60	40	6	40	8,000	12,700	10
A2200060406060	SFL 06040.06	NK 60	60	40	6	40	8,000	12,700	10
A2200060406080	SFL 06040.06	NK 80	60	40	6	40	8,000	12,700	10
A2200060406120	SFL 06040.06	NK 120	60	40	6	40	8,000	12,700	10
A2200060406150	SFL 06040.06	NK 150	60	40	6	40	8,000	12,700	10
A2200060406240	SFL 06040.06	NK 240	60	40	6	40	8,000	12,700	10
A2200060406320	SFL 06040.06	NK 320	60	40	6	40	8,000	12,700	10
A2200060506040	SFL 06050.06	NK 40	60	50	6	40	8,000	8,500	10
A2200060506060	SFL 06050.06	NK 60	60	50	6	40	8,000	8,500	10
A2200060506080	SFL 06050.06	NK 80	60	50	6	40	8,000	8,500	10
A2200060506120	SFL 06050.06	NK 120	60	50	6	40	8,000	8,500	10
A2200060506150	SFL 06050.06	NK 150	60	50	6	40	8,000	8,500	10
A2200060506240	SFL 06050.06	NK 240	60	50	6	40	8,000	8,500	10
A2200080156060	SFL 08015.06	NK 60	80	15	6	40	6,000	9,500	10
A2200080156080	SFL 08015.06	NK 80	80	15	6	40	6,000	9,500	10
A2200080156120	SFL 08015.06	NK 120	80	15	6	40	6,000	9,500	10
A2200080156240	SFL 08015.06	NK 240	80	15	6	40	6,000	9,500	10
A2200080156320	SFL 08015.06	NK 320	80	15	6	40	6,000	9,500	10
A2200080206060	SFL 08020.06	NK 60	80	20	6	40	6,000	9,500	10
A2200080206080	SFL 08020.06	NK 80	80	20	6	40	6,000	9,500	10
A2200080306040	SFL 08030.06	NK 40	80	30	6	40	6,000	9,500	10
A2200080306060	SFL 08030.06	NK 60	80	30	6	40	6,000	9,500	10
A2200080306080	SFL 08030.06	NK 80	80	30	6	40	6,000	9,500	10
A2200080306120	SFL 08030.06	NK 120	80	30	6	40	6,000	9,500	10
A2200080306150	SFL 08030.06	NK 150	80	30	6	40	6,000	9,500	10
A2200080306320	SFL 08030.06	NK 320	80	30	6	40	6,000	9,500	10
A2200080406060	SFL 08040.06	NK 60	80	40	6	40	6,000	9,500	10
A2200080406080	SFL 08040.06	NK 80	80	40	6	40	6,000	9,500	10
A2200080506040	SFL 08050.06	NK 40	80	50	6	40	6,000	7,500	10
A2200080506060	SFL 08050.06	NK 60	80	50	6	40	6,000	7,500	10
A2200080506080	SFL 08050.06	NK 80	80	50	6	40	6,000	7,500	10
A2200080506120	SFL 08050.06	NK 120	80	50	6	40	6,000	7,500	10
A2200080506150	SFL 08050.06	NK 150	80	50	6	40	6,000	7,500	10
A2200080506240	SFL 08050.06	NK 240	80	50	6	40	6,000	7,500	10
A2200080506320	SFL 08050.06	NK 320	80	50	6	40	6,000	7,500	10
A2200100408040	SFL 10040.08	NK 40	100	40	8	40	5,000	7,500	10
A2200100508080	SFL 10050.08	NK 80	100	50	8	40	5,000	7,500	10
A2200100508150	SFL 10050.08	NK 150	100	50	8	40	5,000	7,500	10

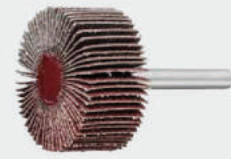
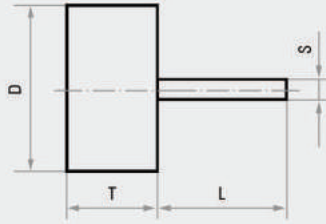
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium





### SFL Base-X mounted flap wheel

- for rough and fine grinding of many different materials
- used as a handheld tool, good for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- good price-to-performance ratio with regular aluminium oxide



Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2230030106060	SFL 03010.06	NK 60	30	10	6	40	16,000	18,000	20
A2230030106080	SFL 03010.06	NK 80	30	10	6	40	16,000	18,000	20
A2230030106120	SFL 03010.06	NK 120	30	10	6	40	16,000	18,000	20
A2230030106150	SFL 03010.06	NK 150	30	10	6	40	16,000	18,000	20
A2230040156080	SFL 04015.06	NK 80	40	15	6	40	12,000	19,100	20
A2230040156120	SFL 04015.06	NK 120	40	15	6	40	12,000	19,100	20
A2230040156150	SFL 04015.06	NK 150	40	15	6	40	12,000	19,100	20
A2230040206040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	20
A2230040206060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	20
A2230050106060	SFL 05010.06	NK 60	50	10	6	40	9,000	15,300	20
A2230050106080	SFL 05010.06	NK 80	50	10	6	40	9,000	15,300	20
A2230050106120	SFL 05010.06	NK 120	50	10	6	40	9,000	15,300	20
A2230050106150	SFL 05010.06	NK 150	50	10	6	40	9,000	15,300	20
A2230050206060	SFL 05020.06	NK 60	50	20	6	40	9,000	15,300	20
A2230050206080	SFL 05020.06	NK 80	50	20	6	40	9,000	15,300	20
A2230060306040	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	20
A2230060306060	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	20
A2230060306080	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	20
A2230060306120	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	20
A2230060306150	SFL 06030.06	NK 150	60	30	6	40	8,000	12,700	20

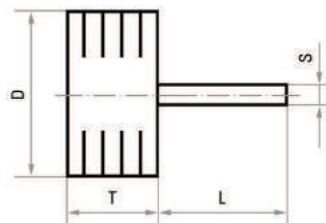
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

GRINDING AND POLISHING (with flexible tools)



### SFB slotted flap wheel

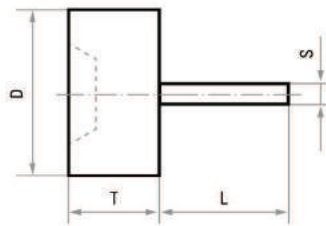
- slitted flaps for greater flexibility
- adapts itself perfectly to the contours of the workpiece
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling



Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2220040206080	SFB 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A2220050206080	SFB 05020.06	NK 80	50	20	6	40	9,000	15,300	10
A2220050306120	SFB 05030.06	NK 120	50	30	6	40	9,000	15,300	10
A2220060306080	SFB 06030.06	NK 80	60	30	6	40	8,000	12,700	10
A2220060306120	SFB 06030.06	NK 120	60	30	6	40	8,000	12,700	10

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

## SFT mounted flap wheel with recess



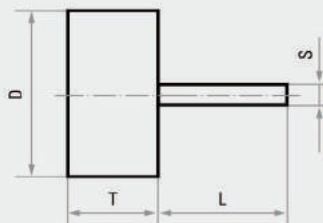
- mounted flap wheels with recess: optimised for face and peripheral grinding
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials

★★★

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A3100040306060	SFT 04030.06	NK 60	40	30	6	40	12,000	19,100	10
A3100040306080	SFT 04030.06	NK 80	40	30	6	40	12,000	19,100	10
A3100040306150	SFT 04030.06	NK 150	40	30	6	40	12,000	19,100	10

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

## SFT mounted flap wheel for stainless steel



- regular aluminium oxide with active abrasive surface layer
- optimised for use on stainless steel
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling

★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2201030103120	SFE 03010.03	NKE 120	30	10	3	40	16,000	18,000	10
A2201030106060	SFE 03010.06	NKE 60	30	10	6	40	16,000	25,400	10
A2201030106080	SFE 03010.06	NKE 80	30	10	6	40	16,000	25,400	10
A2201030106150	SFE 03010.06	NKE 150	30	10	6	40	16,000	25,400	10
A2201040156060	SFE 04015.06	NKE 60	40	15	6	40	12,000	19,100	10
A2201040156080	SFE 04015.06	NKE 80	40	15	6	40	12,000	19,100	10
A2201040156120	SFE 04015.06	NKE 120	40	15	6	40	12,000	19,100	10
A2201060206080	SFE 06020.06	NKE 80	60	20	6	40	8,000	12,700	10
A2201060306060	SFE 06030.06	NKE 60	60	30	6	40	8,000	12,700	10
A2201060306120	SFE 06030.06	NKE 120	60	30	6	40	8,000	12,700	10
A2201080306080	SFE 08030.06	NKE 80	80	30	6	40	6,000	9,500	10
A2201080506080	SFE 08050.06	NKE 80	80	50	6	40	6,000	7,500	10

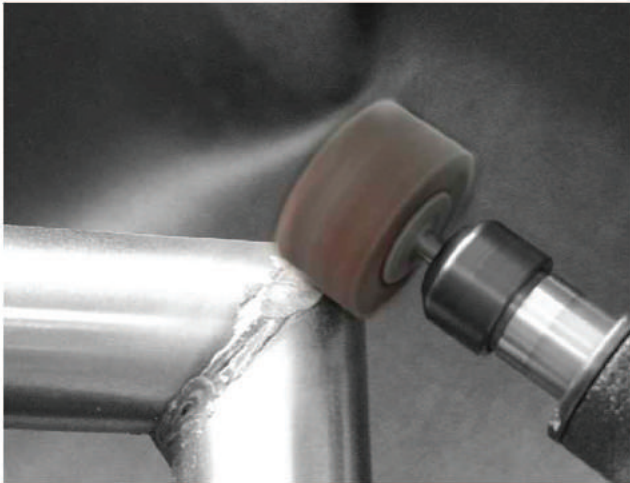
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

# INNOVATIVE TOOLS FOR THE AEROSPACE INDUSTRY

## PRECISION TOOLS FOR THE MOST DEMANDING REQUIREMENTS

LUKAS has been following the developments in the aerospace industry for some considerable time. Today, we are the internationally acknowledged specialist for innovative solutions and the manufacture of high-performance tools for the aerospace industry. We are familiar with the industry's special

requirements, and have developed highly specialised tool solutions. 10,000 special solutions and numerous innovations are in use worldwide – not only our own, but above all your products will always be ready for whatever the future holds.



### HIGH-TECH TOOLS

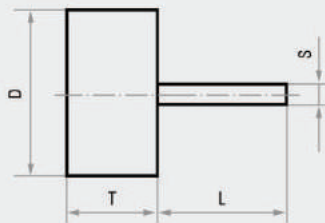
Machining high-tech materials used in the aerospace industry, such as aluminium, titanium, nickel-based alloys or composite materials, requires high-tech tools of the utmost reliability. LUKAS tools for the aerospace industry, e.g. with silicon carbide, can handle the most demanding requirements for reliability, durability and efficiency.

It all comes down to ongoing optimisation of their quality and economic efficiency. The cost-saving potential from selecting the right tool, one that is perfectly suited for the high-tech materials which require processing, also plays a key role. Our goal: the best performance for you!

Discover more tools with silicon carbide for the aerospace industry in all the LUKAS product range.



- special quality, e.g. for the aerospace industry
- ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- used as a handheld tool, suitable for smoothening, derusting, fettling, deburring, surface grinding, texturing and bevelling



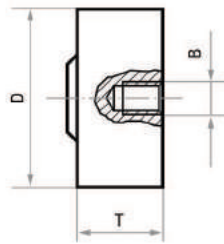
## SFC mounted flap wheel, silicon carbide



Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2202030106080	SFC 03010.06	SIC 80	30	10	6	40	16,000	25,400	10
A2202030106150	SFC 03010.06	SIC 150	30	10	6	40	16,000	25,400	10
A2202040156080	SFC 04015.06	SIC 80	40	15	6	40	12,000	19,100	10
A2202060206080	SFC 06020.06	SIC 80	60	20	6	40	8,000	12,700	10
A2202060206120	SFC 06020.06	SIC 120	60	20	6	40	8,000	12,700	10
A2202060306120	SFC 06030.06	SIC 120	60	30	6	40	8,000	12,700	10

Recommended for: ● Aluminium ● Stone/Construction material ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material

## SFI mounted flap wheel with internal thread



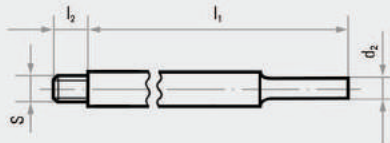
- machine difficult-to-reach areas with the suitable long shank
- thread connection for fast tool changing
- used as a handheld tool, suitable for smoothening, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adapter (see below).

★★☆

Product number	Description	Grit	D mm	T mm	B Thread	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	matching tool adapter	Pack contains
A2207030050120	SFI 03005.M4	NK 120	30	5	M4	16,000	18,000	WADI 0404	10
A2207030100120	SFI 03010.M4	NK 120	30	10	M4	16,000	18,000	WADI 0407	10
A2207030100150	SFI 03010.M4	NK 150	30	10	M4	16,000	18,000	WADI 0407	10
A2207040150080	SFI 04015.M6	NK 80	40	15	M6	10,000	10,000	WADI 0609	10
A2207040150120	SFI 04015.M6	NK 120	40	15	M6	10,000	10,000	WADI 0609	10
A2207050200080	SFI 05020.M6	NK 80	50	20	M6	7,500	7,500	WADI 0612	10

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

## Tool adapters for SFI mounted flap wheels



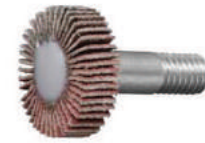
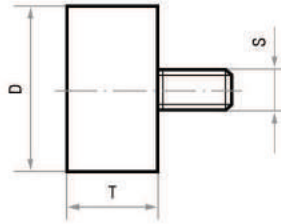
★★☆

Product number	Description	$d_1$ mm	$l_1$ mm	S Thread	$l_2$ mm	Pack contains
A36300404	WADI 0404	6	80	M4	4	1
A36300407	WADI 0407	6	80	M4	7	1
A36300609	WADI 0609	6	100	M6	9	1
A36300612	WADI 0612	6	100	M6	12	1



## SFA mounted flap wheel with external thread

- machine difficult-to-reach areas with the suitable long shank
- thread connection for fast tool changing
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adapter (see below).

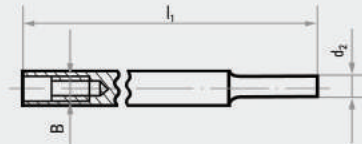


Product number	Description	Grit	D mm	T mm	S Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200015055150	SFA 01505.M5	NK 150	15	5	M5	16,000	18,000	10
A2200015055240	SFA 01505.M5	NK 240	15	5	M5	16,000	18,000	10
A2200020055150	SFA 02005.M5	NK 150	20	5	M5	16,000	18,000	10
A2200020055240	SFA 02005.M5	NK 240	20	5	M5	16,000	18,000	10
A2200030055120	SFA 03005.M5	NK 120	30	5	M5	16,000	18,000	10
A2200030055150	SFA 03005.M5	NK 150	30	5	M5	16,000	18,000	10
A2200030055240	SFA 03005.M5	NK 240	30	5	M5	16,000	18,000	10

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



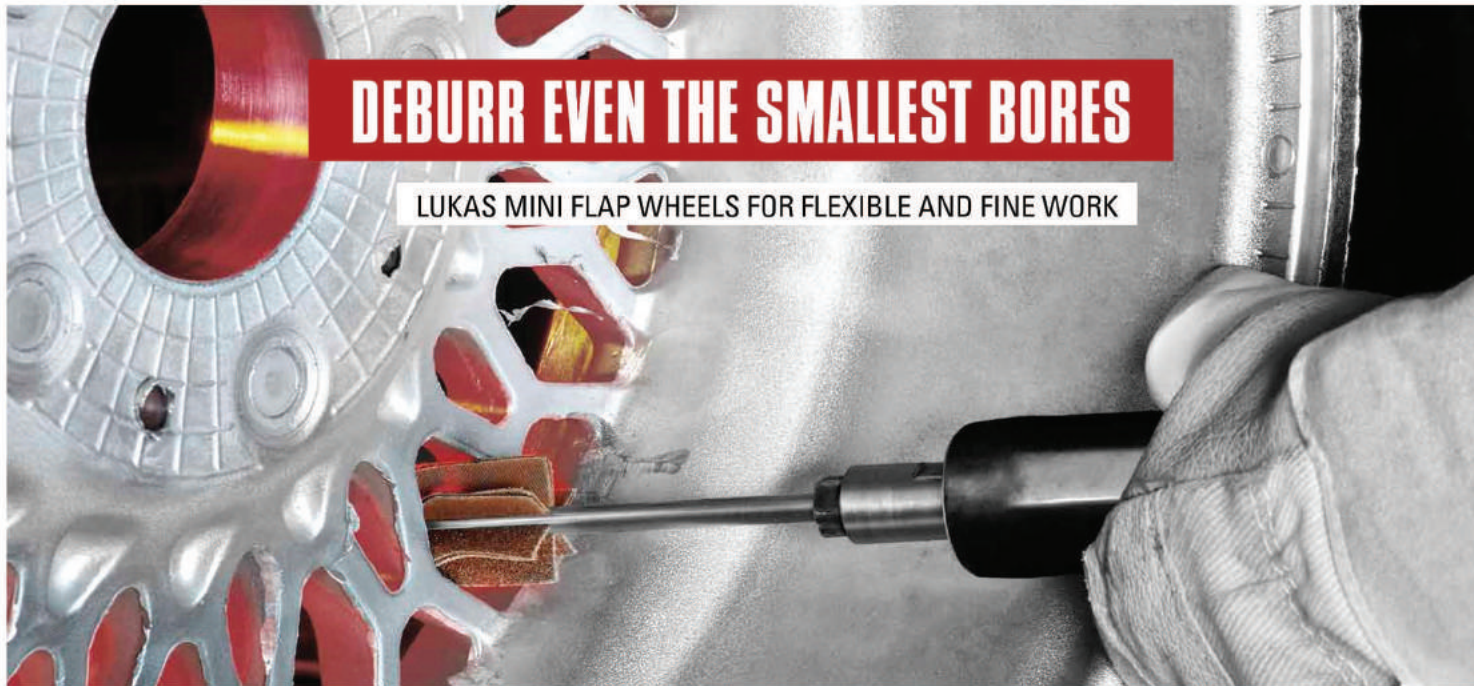
## Tool adapter for SFA mounted flap wheels



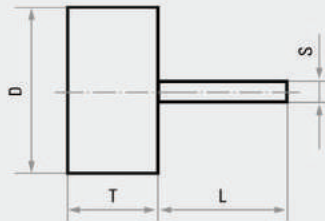
Product number	Description	d <sub>2</sub> mm	l <sub>1</sub> mm	B Thread	Pack contains
A36300518	WADA 05	6	100	M5	1

# DEBURR EVEN THE SMALLEST BORES

LUKAS MINI FLAP WHEELS FOR FLEXIBLE AND FINE WORK



## MFS mini flap wheel



- deburring bores
- manufacturing and cleaning of glass products
- internal pipe machining
- machining aluminium tyre rims
- machining bores in turbine blades
- versatile special applications

★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2205015106150	MFS 01510.06	NK 150	15	10	6	40	18,000	10
A2205015106150001	MFS 01510.06	NK 150	15	10	6	100	18,000	10
A2205015306150	MFS 01530.06	NK 150	15	30	6	40	18,000	10
A2205015306150001	MFS 01530.06	NK 150	15	30	6	100	18,000	10
A2205020106150	MFS 02010.06	NK 150	20	10	6	40	18,000	10
A2205020106150001	MFS 02010.06	NK 150	20	10	6	100	18,000	10
A2205020306150	MFS 02030.06	NK 150	20	30	6	40	18,000	10
A2205020306150001	MFS 02030.06	NK 150	20	30	6	100	18,000	10
A2205025106150	MFS 02510.06	NK 150	25	10	6	40	18,000	10
A2205025106150001	MFS 02510.06	NK 150	25	10	6	100	18,000	10
A2205025306150	MFS 02530.06	NK 150	25	30	6	40	18,000	10
A2205025306150001	MFS 02530.06	NK 150	25	30	6	100	18,000	10

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



### SAFETY INFORMATION

To safely use mini flap wheels with a long shan, they must be placed against the workpiece or inserted into bores or channels

before starting up the power tool. Contact with the workpiece must be assured until the power tool is switched off.

# LUKAS MOUNTED FLAP WHEELS MADE OF ABRASIVE FLEECE

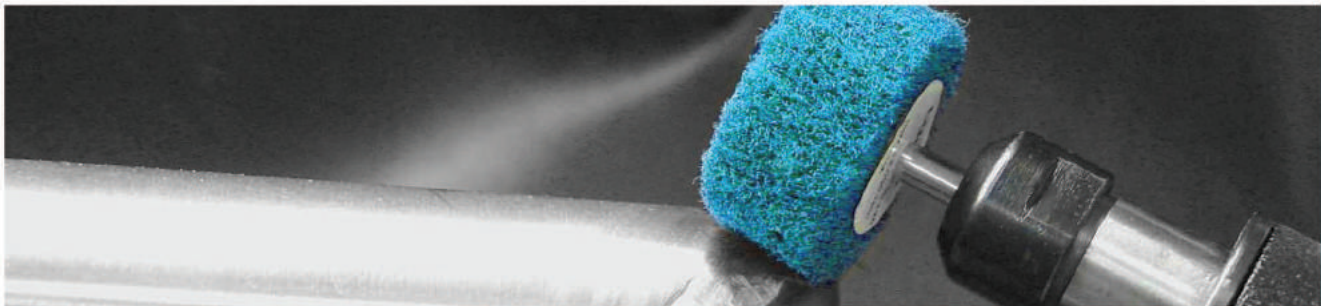
## READY FOR EVERY WORK SCENARIO

The fleece flaps or discs of the LUKAS mounted flap wheels with abrasive fleece are made with regular aluminium oxide, zirconia alumina or silicon carbide. This means that LUKAS can cover a broad spectrum of machining materials from steel and titanium through to ceramics and tungsten carbide. Different designs allow you to specify the application even further.

Abrasive fleece is probably the most flexible of all abrasives and can be used for many different jobs. Its wide variety of designs enables LUKAS to offer you a broad spectrum of machining

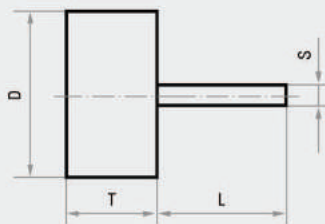
options: matt finishing, satin-matt finishing, polishing, smoothing and final surface finishing – with LUKAS mounted flap wheels made of abrasive fleece, you can master any scenario.

LUKAS mounted flap wheels made of abrasive fleece comprise individual flaps, which are fixed radially around the axis of the tool. Thanks to the use of polyamide, the abrasive fleece also adapts itself perfectly to uneven surfaces. You need less effort and time for your work, and yet still achieve perfect surface results.



## SFV mounted flap wheel, zirconia alumina

- achieves especially high stock removal rates on hard and tough materials such as stainless steel and a long tool life
- manufactured with zirconia alumina for extreme hardness and sharpness
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working

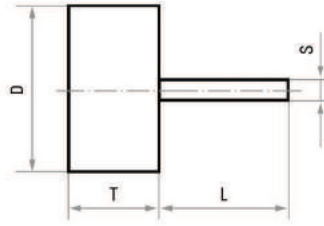


★★★

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2203030106306	SFV 03010.06	Z306	ZK 180	30	10	6	40	10,000	14,000	10
A2203040206306	SFV 04020.06	Z306	ZK 180	40	20	6	40	7,500	14,000	10
A2203050106306	SFV 05010.06	Z306	ZK 180	50	10	6	40	6,000	11,000	10
A2203060306306	SFV 06030.06	Z306	ZK 180	60	30	6	40	5,000	9,000	10
A2203080506306	SFV 08050.06	Z306	ZK 180	80	50	6	40	4,000	7,000	10

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

## SFV mounted flap wheel, regular aluminium oxide



- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working

★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2203030206106	SFV 03020.06	A106	NK 180	30	20	6	40	10,000	14,000	10
A2203030406107	SFV 03040.06	A107	NK 280	30	40	6	40	10,000	14,000	10
A2203040206104	SFV 04020.06	A104	NK 100	40	20	6	40	7,500	14,000	10
A2203040206106	SFV 04020.06	A106	NK 180	40	20	6	40	7,500	14,000	10
A2203040206107	SFV 04020.06	A107	NK 280	40	20	6	40	7,500	14,000	10
A2203040306104	SFV 04030.06	A104	NK 100	40	30	6	40	7,500	14,000	10
A2203040306106	SFV 04030.06	A106	NK 180	40	30	6	40	7,500	14,000	10
A2203040306107	SFV 04030.06	A107	NK 280	40	30	6	40	7,500	14,000	10
A2203050106106	SFV 05010.06	A106	NK 180	50	10	6	40	6,000	11,000	10
A2203050206104	SFV 05020.06	A104	NK 100	50	20	6	40	6,000	11,000	10
A2203050206106	SFV 05020.06	A106	NK 180	50	20	6	40	6,000	11,000	10
A2203050306104	SFV 05030.06	A104	NK 100	50	30	6	40	6,000	11,000	10
A2203050306106	SFV 05030.06	A106	NK 180	50	30	6	40	6,000	11,000	10
A2203050306107	SFV 05030.06	A107	NK 280	50	30	6	40	6,000	11,000	10
A2203050406104	SFV 05040.06	A104	NK 100	50	40	6	40	6,000	11,000	10
A2203050406106	SFV 05040.06	A106	NK 180	50	40	6	40	6,000	11,000	10
A2203050406107	SFV 05040.06	A107	NK 280	50	40	6	40	6,000	11,000	10
A2203060306104	SFV 06030.06	A104	NK 100	60	30	6	40	5,000	9,000	10
A2203060306106	SFV 06030.06	A106	NK 180	60	30	6	40	5,000	9,000	10
A2203060306107	SFV 06030.06	A107	NK 280	60	30	6	40	5,000	9,000	10
A2203060406104	SFV 06040.06	A104	NK 100	60	40	6	40	5,000	9,000	10
A2203060406106	SFV 06040.06	A106	NK 180	60	40	6	40	5,000	9,000	10
A2203060406107	SFV 06040.06	A107	NK 280	60	40	6	40	5,000	9,000	10
A2203060506104	SFV 06050.06	A104	NK 100	60	50	6	40	5,000	9,000	10
A2203060506106	SFV 06050.06	A106	NK 180	60	50	6	40	5,000	9,000	10
A2203060506107	SFV 06050.06	A107	NK 280	60	50	6	40	5,000	9,000	10
A2203080406104	SFV 08040.06	A104	NK 100	80	40	6	40	4,000	7,000	10
A2203080406106	SFV 08040.06	A106	NK 180	80	40	6	40	4,000	7,000	10
A2203080506104	SFV 08050.06	A104	NK 100	80	50	6	40	4,000	7,000	10
A2203080506106	SFV 08050.06	A106	NK 180	80	50	6	40	4,000	7,000	10
A2203080506107	SFV 08050.06	A107	NK 280	80	50	6	40	4,000	7,000	10

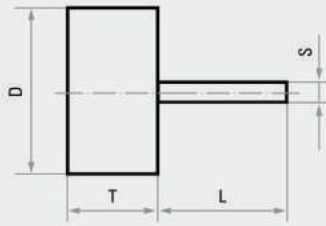
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium





### SFV mounted flap wheel, silicon carbide

- mounted flap wheels with silicon carbide: ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- special quality, e.g. for the aerospace industry
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2203020153207	SFV 02015.03	C207	SIC 280	20	15	3	40	10,000	14,000	10
A2203040206206	SFV 04020.06	C206	SIC 180	40	20	6	40	7,500	14,000	10
A2203040206207	SFV 04020.06	C207	SIC 280	40	20	6	40	7,500	14,000	10
A2203040306207	SFV 04030.06	C207	SIC 280	40	30	6	40	7,500	14,000	10
A2203050206204	SFV 05020.06	C204	SIC 100	50	20	6	40	6,000	11,000	10
A2203050206206	SFV 05020.06	C206	SIC 180	50	20	6	40	6,000	11,000	10
A2203050206207	SFV 05020.06	C207	SIC 280	50	20	6	40	6,000	11,000	10
A2203050306207	SFV 05030.06	C207	SIC 280	50	30	6	40	6,000	11,000	10
A2203050406207	SFV 05040.06	C207	SIC 280	50	40	6	40	6,000	11,000	10
A2203060306204	SFV 06030.06	C204	SIC 100	60	30	6	40	5,000	9,000	10
A2203060306206	SFV 06030.06	C206	SIC 180	60	30	6	40	5,000	9,000	10
A2203060306207	SFV 06030.06	C207	SIC 280	60	30	6	40	5,000	9,000	10
A2203060406204	SFV 06040.06	C204	SIC 100	60	40	6	40	5,000	9,000	10
A2203060406207	SFV 06040.06	C207	SIC 280	60	40	6	40	5,000	9,000	10
A2203080406204	SFV 08040.06	C204	SIC 100	80	40	6	40	4,000	7,000	10
A2203080406206	SFV 08040.06	C206	SIC 180	80	40	6	40	4,000	7,000	10
A2203080406207	SFV 08040.06	C207	SIC 280	80	40	6	40	4,000	7,000	10
A2203080506204	SFV 08050.06	C204	SIC 100	80	50	6	40	4,000	7,000	10
A2203080506206	SFV 08050.06	C206	SIC 180	80	50	6	40	4,000	7,000	10
A2203080506207	SFV 08050.06	C207	SIC 280	80	50	6	40	4,000	7,000	10

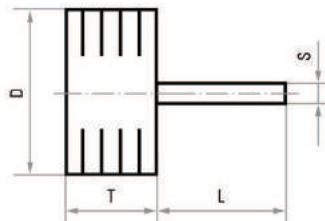
Recommended for: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material

GRINDING AND POLISHING (with flexible tools)



### SFR mounted fleece discs

- manufactured from abrasive fleece discs
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



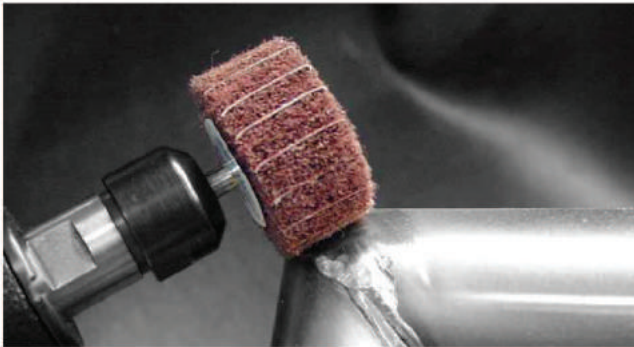
★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2223060506104	SFR 06050.06	A104	NK 100	60	50	6	40	5,000	9,000	10
A2223060506106	SFR 06050.06	A106	NK 180	60	50	6	40	5,000	9,000	10
A2223060506107	SFR 06050.06	A107	NK 280	60	50	6	40	5,000	9,000	10
A2223080506104	SFR 08050.06	A104	NK 100	80	50	6	40	4,000	7,000	10
A2223080506106	SFR 08050.06	A106	NK 180	80	50	6	40	4,000	7,000	10
A2223080506107	SFR 08050.06	A107	NK 280	80	50	6	40	4,000	7,000	10

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

# COMBINATION OF ABRASIVE FLEECE AND ABRASIVE CLOTH

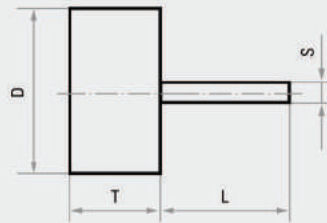
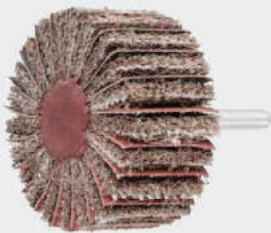
## GREATER STABILITY FOR SUSTAINED USAGE



These LUKAS grinding tools feature a combination of abrasive fleece and abrasive cloth. During the production, the fleece and cloth flaps are fastened alternately and radially to the tool axis.

The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate than can be achieved compared to mounted flap wheels without the cloth. These optimised mounted flap wheels are mainly used on handheld power tools and, thanks to their stability, are ideally suited for cleaning, derusting, surface preparation, texturing and rough grinding.

## SFM mounted flap wheel, combined abrasive fleece TF and cloth



- due to its especially stable abrasive fleece made of TF material, this mounted flap wheel wears evenly
- perfect for continuous working
- specially designed for use on non-rusting materials
- used as a handheld tool, ideal for the cleaning, derusting, surface preparation, texturing and rough grinding of workpiece surfaces

★★★

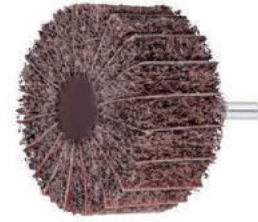
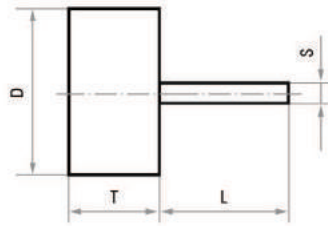
Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2204040206120	SFM 04020.06	TF 120/80	40	20	6	40	7,500	14,000	10
A2204060306120	SFM 06030.06	TF 120/80	60	30	6	40	5,000	9,000	10
A2204080506120	SFM 08050.06	TF 120/80	80	50	6	40	4,000	7,000	10
A2204080406120	SFM 08040.06	TF 120/150	80	40	6	40	4,000	7,000	10

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



## SFM mounted flap wheel, combined abrasive fleece and cloth, regular aluminium oxide

- for continuous working
- used as a handheld tool, ideal for the cleaning, derusting, surface preparation, texturing and roughening of workpiece surfaces



Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2204030306104	SFM 03030.06	A104/80	NK 100/80	30	30	6	40	10,000	14,000	10
A2204040206104	SFM 04020.06	A104/80	NK 100/80	40	20	6	40	7,500	14,000	10
A2204040206106	SFM 04020.06	A106/150	NK 180/150	40	20	6	40	7,500	14,000	10
A2204040206107	SFM 04020.06	A107/240	NK 280/240	40	20	6	40	7,500	14,000	10
A2204040306104	SFM 04030.06	A104/80	NK 100/80	40	30	6	40	7,500	14,000	10
A2204040306106	SFM 04030.06	A106/150	NK 180/150	40	30	6	40	7,500	14,000	10
A2204040306107	SFM 04030.06	A107/240	NK 280/240	40	30	6	40	7,500	14,000	10
A2204050206104	SFM 05020.06	A104/80	NK 100/80	50	20	6	40	6,000	11,000	10
A2204050206106	SFM 05020.06	A106/150	NK 180/150	50	20	6	40	6,000	11,000	10
A2204050306106	SFM 05030.06	A106/150	NK 180/150	50	30	6	40	6,000	11,000	10
A2204050306107	SFM 05030.06	A107/240	NK 280/240	50	30	6	40	6,000	11,000	10
A2204050406104	SFM 05040.06	A104/80	NK 100/80	50	40	6	40	6,000	11,000	10
A2204050406106	SFM 05040.06	A106/150	NK 180/150	50	40	6	40	6,000	11,000	10
A2204060306104	SFM 06030.06	A104/80	NK 100/80	60	30	6	40	5,000	9,000	10
A2204060306106	SFM 06030.06	A106/150	NK 180/150	60	30	6	40	5,000	9,000	10
A2204060306107	SFM 06030.06	A107/240	NK 280/240	60	30	6	40	5,000	9,000	10
A2204060406104	SFM 06040.06	A104/80	NK 100/80	60	40	6	40	5,000	9,000	10
A2204060406106	SFM 06040.06	A106/150	NK 180/150	60	40	6	40	5,000	9,000	10
A2204060406107	SFM 06040.06	A107/240	NK 280/240	60	40	6	40	5,000	9,000	10
A2204060506104	SFM 06050.06	A104/80	NK 100/80	60	50	6	40	5,000	9,000	10
A2204060506106	SFM 06050.06	A106/150	NK 180/150	60	50	6	40	5,000	9,000	10
A2204080406104	SFM 08040.06	A104/80	NK 100/80	80	40	6	40	4,000	7,000	10
A2204080406106	SFM 08040.06	A106/150	NK 180/150	80	40	6	40	4,000	7,000	10
A2204080406107	SFM 08040.06	A107/240	NK 280/240	80	40	6	40	4,000	7,000	10
A2204080506104	SFM 08050.06	A104/80	NK 100/80	80	50	6	40	4,000	7,000	10
A2204080506106	SFM 08050.06	A106/150	NK 180/150	80	50	6	40	4,000	7,000	10
A2204080506107	SFM 08050.06	A107/240	NK 280/240	80	50	6	40	4,000	7,000	10

Recommended for:

● Inox/Steel

● Steel

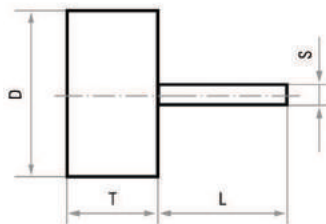
● Aluminium

● Cast material

● Plastic/Wood

● Titanium

## SFM mounted flap wheel, combined abrasive fleece and cloth, silicon carbide



- for continuous working
- mounted flap wheels with silicon carbide: ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- special quality, e.g. for the aerospace industry
- used as a handheld tool, ideal for cleaning, derusting, preparation, texturing and rough of workpiece surfaces

★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2204040206204	SFM 04020.06	C204/80	SIC 100/80	40	20	6	40	7,500	14,000	10
A2204040206206	SFM 04020.06	C206/150	SIC 180/150	40	20	6	40	7,500	14,000	10
A2204040306204	SFM 04030.06	C204/80	SIC 100/80	40	30	6	40	7,500	14,000	10
A2204040306206	SFM 04030.06	C206/150	SIC 180/150	40	30	6	40	7,500	14,000	10
A2204040306207	SFM 04030.06	C207/240	SIC 280/240	40	30	6	40	7,500	14,000	10
A2204050206204	SFM 05020.06	C204/80	SIC 100/80	50	20	6	40	6,000	11,000	10
A2204050206206	SFM 05020.06	C206/150	SIC 180/150	50	20	6	40	6,000	11,000	10
A2204060306204	SFM 06030.06	C204/80	SIC 100/80	60	30	6	40	5,000	9,000	10
A2204060306206	SFM 06030.06	C206/150	SIC 180/150	60	30	6	40	5,000	9,000	10
A2204060306207	SFM 06030.06	C207/240	SIC 280/240	60	30	6	40	5,000	9,000	10
A2204080506204	SFM 08050.06	C204/80	SIC 100/80	80	50	6	40	4,000	7,000	10
A2204080506206	SFM 08050.06	C206/150	SIC 180/150	80	50	6	40	4,000	7,000	10

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

TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Flap wheels from LUKAS

## LSL, FLAP WHEELS OF ABRASIVE CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSL consists of single flaps which are embedded radially to the axis in a solid plastic core. Please pay attention to the rotational direction of the tool!

**Application examples:**

- Cleaning
- Deburring
- Derusting
- Surface preparation
- Texturing
- Roughening

## LSV, FLAP WHEELS OF ABRASIVE FLEECE, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSV consist of abrasive fleece flaps. The use of fibre fleece makes the tool elastic and allows it to adapt itself to the shape of the workpiece.

**Application examples:**

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

## LSM, FLAP WHEELS MADE BY COMBINING ABRASIVE FLEECE AND CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore size, are designed to be used with both handheld and stationary machines. The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LSV. Please pay attention to the rotational direction of the tool!

**Application examples:**

- Cleaning
- Derusting
- Surface preparation
- Texturing
- Roughening

GRINDING AND POLISHING (with flexible tools)

SAMPLE ORDER

# Customised solutions adapted to handle your challenge

We manufacture LUKAS LSL, LSV and LSM flap wheels as well as LUKAS FRV mops according to your specific requirements as individual custom solutions. For this reason, the product tables on **pages 183 – 188** contain a description together with additional information instead of the usual article numbers.

After you have selected the right tool for your application, add the required grit size and bore to the designation (see example on the right). Please state this information in your order. This enables us to provide you with a tool that is precisely tailored to your needs.

**If you have any questions, please contact your LUKAS representative or send an email to [le@lukas-erzett.de](mailto:le@lukas-erzett.de)**

**Please give the following details when placing your order:**



# FLAP WHEELS FOR ANGLE GRINDERS

FOR DERUSTING, PAINT STRIPPING, WELD SEAM MACHINING AND MANY OTHER USES

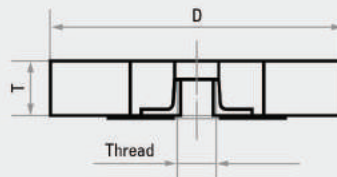
Each flap of this wheel of abrasive cloth is embedded radially to the axis in a solid plastic core. Used with a handheld tool, it is therefore ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities.

The regular aluminium oxide used for this wheel boasts an impressive tool life on many materials and allows you to work in a cost-effective manner.

The integrated M14 thread means that no additional tool is required for fast and easy mounting of the flap wheel.



## LSL, flap wheel of abrasive cloth with thread



- fits on commercially available angle grinders and is used in place of mounted flap wheels with shanks
- can be used without a clamping nut
- ideal for reworking weld seams on stainless steels
- ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities
- grinding is only permitted with the peripheral surface

★★☆

Product number	Description	Grit	D mm	T mm	Thread	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2280125200040	LSL 125020	NK 40	125	20	M14	9,600	12,200	5
A2280125200040001	LSL 125020	NK 40	125	20	5/8"	9,600	12,200	5
A22801252000060	LSL 125020	NK 60	125	20	M14	9,600	12,200	5
A2280125200060001	LSL 125020	NK 60	125	20	5/8"	9,600	12,200	5
A22801252000080	LSL 125020	NK 80	125	20	M14	9,600	12,200	5
A2280125200080001	LSL 125020	NK 80	125	20	5/8"	9,600	12,200	5
A2280125200120	LSL 125020	NK 120	125	20	M14	9,600	12,200	5
A2280125200120001	LSL 125020	NK 120	125	20	5/8"	9,600	12,200	5

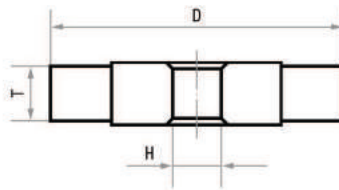
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



# LSL, flap wheel of abrasive cloth

INDIVIDUAL CUSTOMER SOLUTIONS

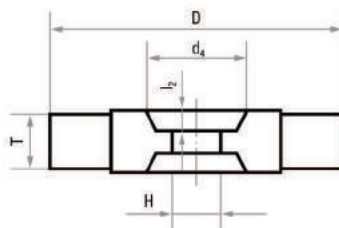
- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- Other dimensions, bores or qualities are available on request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on **page 181**.
- $v_{recom}$  30 m/s in handheld use
- $v_{max}$  50 m/s in stationary use
- $n_{max}$  (rpm) applies for stationary use



Description	Grit	D mm	T mm	H mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSL 125025	NK 60	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 80	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 120	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 150	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 240	125	25	13-16-20	4,500	7,600	25

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

\*minimum order quantity



Description	Grit	D mm	T mm	H mm	recess on both sides $d_4$ mm	recess on both sides $l_2$ mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSL 150050	NK 60	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 80	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 120	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 150	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 240	150	50	13-16-20	47	18	3,800	6,300	25
LSL 165050	NK 60	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 80	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 120	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 150	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 240	165	50	13-16-20	47	18	3,400	5,700	25
LSL 200025	NK 60	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 80	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 120	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 150	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 240	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200050	NK 60	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 80	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 120	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 150	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 240	200	50	20-25-32	71	18	2,800	4,700	25

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

\*minimum order quantity

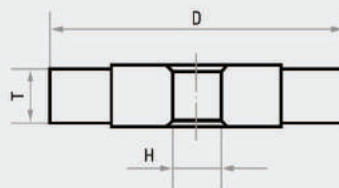
GRINDING AND POLISHING (with flexible tools)

# LUKAS FLAP WHEEL MADE OF ABRASIVE FLEECE

ADAPTED TO HANDLE YOUR SPECIFIC CHALLENGES

## LSV, flap wheel of abrasive fleece

INDIVIDUAL CUSTOMER SOLUTIONS



- for matt finishing, satin finishing, polishing, smoothening and final surface finishing
- Other dimensions, bores or qualities (e.g. "very hard" version or impregnated with polyurethane) are available upon request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on [page 181](#).
- $v_{\max}$  35 m/s

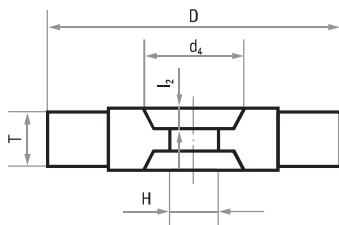
★★☆

Description	Quality	Grit	Type	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
LSV 100050	A104 W	NK 100	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 W	NK 180	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 W	NK 280	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 W	SIC 100	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 W	SIC 180	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 W	SIC 280	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A104 M	NK 100	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 M	NK 180	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 M	NK 280	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 M	SIC 100	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 M	SIC 180	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 M	SIC 280	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A104 H	NK 100	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 H	NK 180	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 H	NK 280	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 H	SIC 100	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 H	SIC 180	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 H	SIC 280	hard	100	50	13-16-20	3,000	6,000	25

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

\*minimum order quantity





Description	Quality	Grit	Type	D mm	T mm	H mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	MOQ* pcs.
LSV 150050	A104 W	NK 100	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 W	NK 180	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 W	NK 280	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 W	SIC 100	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 W	SIC 180	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 W	SIC 280	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A104 M	NK 100	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 M	NK 180	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 M	NK 280	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 M	SIC 100	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 M	SIC 180	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 M	SIC 280	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A104 H	NK 100	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 H	NK 180	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 H	NK 280	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 H	SIC 100	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 H	SIC 180	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 H	SIC 280	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 160050	A104 W	NK 100	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 W	NK 180	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 W	NK 280	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 W	SIC 100	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 W	SIC 180	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 W	SIC 280	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A104 M	NK 100	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 M	NK 180	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 M	NK 280	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 M	SIC 100	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 M	SIC 180	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 M	SIC 280	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A104 H	NK 100	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 H	NK 180	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 H	NK 280	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 H	SIC 100	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 H	SIC 180	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 H	SIC 280	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 200025	A104 W	NK 100	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 W	NK 180	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 W	NK 280	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 W	SIC 100	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 W	SIC 180	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 W	SIC 280	soft	200	25	20-25-32	71	10	1,500	3,000	25

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

\*minimum order quantity

GRINDING AND POLISHING  
(with flexible tools)

Description	Quality	Grit	Type	D mm	T mm	H mm	recess on both sides d <sub>z</sub> mm	recess on both sides l <sub>z</sub> mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	MOQ* pcs.
LSV 200025	A104 M	NK 100	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 M	NK 180	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 M	NK 280	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 M	SIC 100	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 M	SIC 180	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 M	SIC 280	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A104 H	NK 100	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 H	NK 180	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 H	NK 280	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 H	SIC 100	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 H	SIC 180	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 H	SIC 280	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200050	A104 W	NK 100	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 W	NK 180	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 W	NK 280	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 W	SIC 100	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 W	SIC 180	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 W	SIC 280	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A104 M	NK 100	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 M	NK 180	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 M	NK 280	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 M	SIC 100	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 M	SIC 180	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 M	SIC 280	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A104 H	NK 100	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 H	NK 180	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 H	NK 280	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 H	SIC 100	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 H	SIC 180	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 H	SIC 280	hard	200	50	20-25-32	71	18	1,500	3,000	25

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

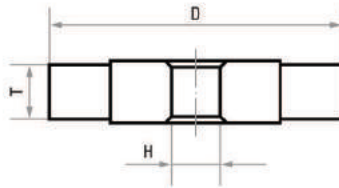
\*minimum order quantity



# LSM, flap wheel of abrasive fleece and cloth in combination

INDIVIDUAL CUSTOMER SOLUTIONS

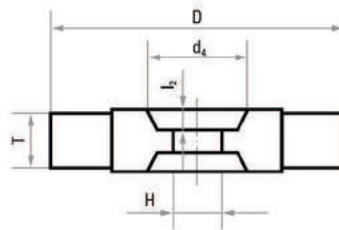
- for cleaning, derusting, surface preparation, texturing and roughening
- Other dimensions, bores or qualities are available on request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on **page 181**.
- $v_{max}$  35 m/s



Description	Quality	Grit	D mm	T mm	H mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSM 080050	A104/80	NK 100/80	80	50	10-13-16	3,800	7,600	25
LSM 080050	A106/150	NK 180/150	80	50	10-13-16	3,800	7,600	25
LSM 080050	A107/240	NK 280/240	80	50	10-13-16	3,800	7,600	25
LSM 080050	C204/80	SIC 100/80	80	50	10-13-16	3,800	7,600	25
LSM 080050	C206/150	SIC 180/150	80	50	10-13-16	3,800	7,600	25
LSM 080050	C207/240	SIC 280/240	80	50	10-13-16	3,800	7,600	25

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

\*minimum order quantity



Description	Quality	Grit	D mm	T mm	H mm	recess on both sides $d_4$ mm	recess on both sides $l_2$ mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSM 150050	A104/80	NK 100/80	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	A106/150	NK 180/150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	A107/240	NK 280/240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C204/80	SIC 100/80	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C206/150	SIC 180/150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C207/240	SIC 280/240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 160050	A104/80	NK 100/80	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	A106/150	NK 180/150	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	A107/240	NK 280/240	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C204/80	SIC 100/80	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C206/150	SIC 180/150	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C207/240	SIC 280/240	160	50	13-16-20	47	18	1,900	3,800	25
LSM 200050	A104/80	NK 100/80	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	A106/150	NK 180/150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	A107/240	NK 280/240	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C204/80	SIC 100/80	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C206/150	SIC 180/150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C207/240	SIC 280/240	200	50	20-25-32	71	18	1,500	3,000	25

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

\*minimum order quantity

GRINDING AND POLISHING (with flexible tools)

# SILKY LUSTRE MATT FINISHING ON STAINLESS STEEL

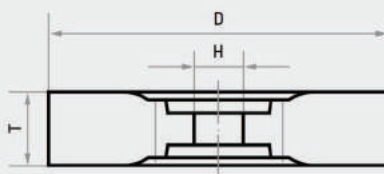
## LUKAS MOPS FOR YOUR APPLICATION



LUKAS mops of abrasive fleece are packed together on a shaft to create rolls of different widths. By adding water or low-viscosity oil, you can further boost the service life of this tool: Water produces matt surfaces on almost all metals and very matt surfaces on aluminium, while oils give a silky lustre finish.

## FRV, mops of abrasive fleece

### INDIVIDUAL CUSTOMER SOLUTIONS



- for silky lustre matt finishing on stainless steel, chrome, nickel and non-ferrous metals
- can also be used for cleaning and smoothing primer coatings and soiled paint surfaces in the wood and plastics industries
- The best cutting speed is between 10 – 20 m/s, applying only slight contact pressure.
- A sample order for this LUKAS custom solution can be found on [page 181](#).

★★☆

Description	Quality	Grit	Surface	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
FRV 200050	A104	NK 100	medium	200	50	20-25-32	1,400	1,900	25
FRV 200050	A106	NK 180	fine	200	50	20-25-32	1,400	1,900	25
FRV 200050	A107	NK 280	very fine	200	50	20-25-32	1,400	1,900	25
FRV 250050	A104	NK 100	medium	250	50	20-25-32	1,100	1,500	25
FRV 250050	A106	NK 180	fine	250	50	20-25-32	1,100	1,500	25
FRV 250050	A107	NK 280	very fine	250	50	20-25-32	1,100	1,500	25
FRV 300060	A104	NK 100	medium	300	60	20-25-32	900	1,200	25
FRV 300060	A106	NK 180	fine	300	60	20-25-32	900	1,200	25
FRV 300060	A107	NK 280	very fine	300	60	20-25-32	900	1,200	25

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

\*minimum order quantity

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

**LUKAS flap rolls**

These rolls have a 19 mm bore and four keyways for use on handheld surface grinding machines (burnishing machines).

**LWL, FLAP ROLLS MADE OF ABRASIVE CLOTH FOR BURNISHING MACHINES**

These tools are comprised of single flaps that are radially fixed around the axis in a plastic core. Please pay attention to the rotational direction of the tool! **Page 190**

**Application examples:**

- Cleaning
- Deburring
- Derusting
- Preparation
- Texturing
- Roughening

**LWV, FLAP ROLLS MADE OF ABRASIVE FLEECE FOR BURNISHING MACHINES**

This design is comprised of abrasive fleece flaps. The use of fibre fleece makes the tool elastic and allows it to adapt itself to the shape of the workpiece. **Page 191**

**Application examples:**

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

**LWM, FLAP ROLLS MADE OF TF MATERIAL**

These rolls with a 19 mm bore and four keyways are specially designed for use on non-rusting materials. The abrasive fleece, with its reinforced backing, guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotational direction of the tool! **Page 192**

**LWM, FLAP ROLLS FOR BURNISHING MACHINES MADE OF ABRASIVE FLEECE/CLOTH IN COMBINATION**

The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LWV. Please pay attention to the rotational direction of the tool! **Pages 192 / 193**

**Application examples:**

- Cleaning
- Derusting
- surface preparation
- Texturing
- Roughening

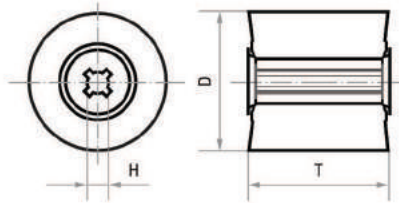
**LWF, SINUS ABRASIVE ROLL MADE OF ABRASIVE FLEECE FOR CONDITIONING MACHINES**

These tools consist of abrasive fleece webs that are wound around the core in a wave pattern. This wave arrangement enables matt finishing of surfaces without visible transitions. The use of fibre fleece makes the LWF elastic and allows it to adapt itself to the shape of the workpiece. **Page 193**

**Application examples:**

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

## LWL, flap roll made of abrasive cloth



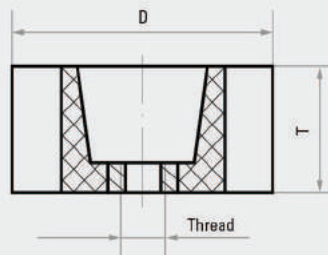
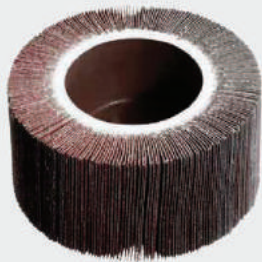
★★☆

- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- for conditioning machines

Product number	Description	Grit	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2280100500040	LWL 100050	NK 40	100	50	19	3,700	6,000	2
A2280100500060	LWL 100050	NK 60	100	50	19	3,700	6,000	2
A2280100500080	LWL 100050	NK 80	100	50	19	3,700	6,000	2
A22801001000040	LWL 100100	NK 40	100	100	19	3,700	6,000	1
A22801001000060	LWL 100100	NK 60	100	100	19	3,700	6,000	1
A22801001000080	LWL 100100	NK 80	100	100	19	3,700	6,000	1

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

## LWL, flap roll made of abrasive cloth with thread

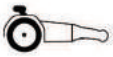


★★☆

- fits on commercially available angle grinders
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

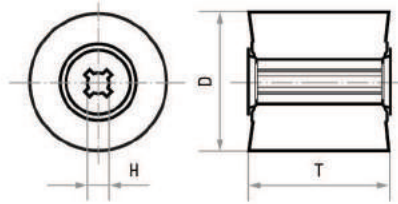
Product number	Description	Grit	D mm	T mm	Thread	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2280100501060	LWL 100050	NK 60	100	50	M14	3,700	6,000	2
A2280100501080	LWL 100050	NK 80	100	50	M14	3,700	6,000	2

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



## LWV, flap roll made of abrasive fleece

- for conditioning machines
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces



★★☆

Product number	Description	Quality	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2286100500104	LWV 100050	A104	NK 100	100	50	19	2,800	6,000	2
A2286100500106	LWV 100050	A106	NK 180	100	50	19	2,800	6,000	2
A2286100500107	LWV 100050	A107	NK 280	100	50	19	2,800	6,000	2
A22861001000104	LWV 100100	A104	NK 100	100	100	19	2,800	6,000	1
A22861001000106	LWV 100100	A106	NK 180	100	100	19	2,800	6,000	1
A22861001000107	LWV 100100	A107	NK 280	100	100	19	2,800	6,000	1

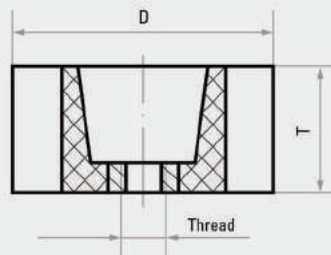
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

GRINDING AND POLISHING (with flexible tools)



## LWV, flap roll made of abrasive fleece with thread

- fits on commercially available angle grinders
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces

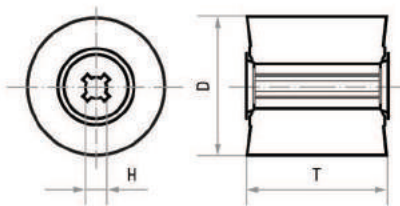


★★☆

Product number	Description	Grit	D mm	T mm	Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2286100501104	LWV 100050	A 104	100	50	M14	2,800	6,000	2
A2286100501106	LWV 100050	A 106	100	50	M14	2,800	6,000	2
A2286100501107	LWV 100050	A 107	100	50	M14	2,800	6,000	2

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

## LWM, flap roll made of abrasive fleece TF and cloth in combination

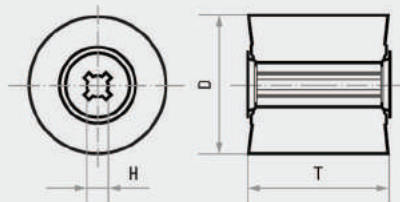


- for conditioning machines
- Due to its highly robust abrasive fleece made of TF material, this mounted flap wheel wears evenly.
- perfect for continuous working
- ideal for machining the surfaces of sheet metal products made from stainless steel such as sinks and containers
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

★★★

Product number	Description	Grit	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A22881001000120	LWM 100100	TF 120/80	100	100	19	2,800	6,000	1
Recommended for:			<span style="color: blue;">●</span> Inox/Steel	<span style="color: grey;">●</span> Steel	<span style="color: orange;">●</span> Aluminium	<span style="color: red;">●</span> Cast material	<span style="color: yellow;">●</span> Plastic/Wood	<span style="color: black;">●</span> Titanium

## LWM, flap roll made of abrasive fleece and cloth in combination



- for conditioning machines
- for continuous working
- better stock removal performance than flap rolls made solely with abrasive fleece
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

★★☆

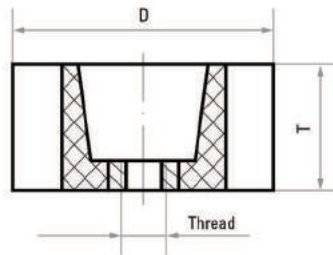
Product number	Description	Quality	Grit	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2288100500104	LWM 100050	A104/80	NK 100/80	100	50	19	2,800	6,000	2
A2288100500106	LWM 100050	A106/150	NK 180/150	100	50	19	2,800	6,000	2
A2288100500107	LWM 100050	A107/240	NK 280/240	100	50	19	2,800	6,000	2
A22881001000104	LWM 100100	A104/80	NK 100/80	100	100	19	2,800	6,000	1
A22881001000106	LWM 100100	A106/150	NK 180/150	100	100	19	2,800	6,000	1
A22881001000107	LWM 100100	A107/240	NK 280/240	100	100	19	2,800	6,000	1
Recommended for:			<span style="color: blue;">●</span> Inox/Steel	<span style="color: grey;">●</span> Steel	<span style="color: orange;">●</span> Aluminium	<span style="color: red;">●</span> Cast material	<span style="color: yellow;">●</span> Plastic/Wood	<span style="color: black;">●</span> Titanium	





## LWM, flap rolls made of combined abrasive fleece and cloth with thread

- fits on commercially available angle grinders
- for continuous working
- better stock removal performance than flap rolls made solely with abrasive fleece
- for cleaning, deburring, derusting, surface preparation, texturing and roughening



★★☆

Product number	Description	Quality	Grit	D mm	T mm	Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2288100501104	LWM 100050	A104/80	NK 100/80	100	50	M14	2,800	6,000	2
A2288100501106	LWM 100050	A106/150	NK 180/150	100	50	M14	2,800	6,000	2

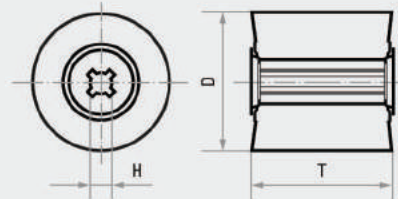
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

GRINDING AND POLISHING (with flexible tools)



## LWF, sinus abrasive roll with abrasive fleece

- fits on commercially available angle grinders
- The wave arrangement enables matt finishing of surfaces without visible imperfections.
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothing and final finishing of workpiece surfaces



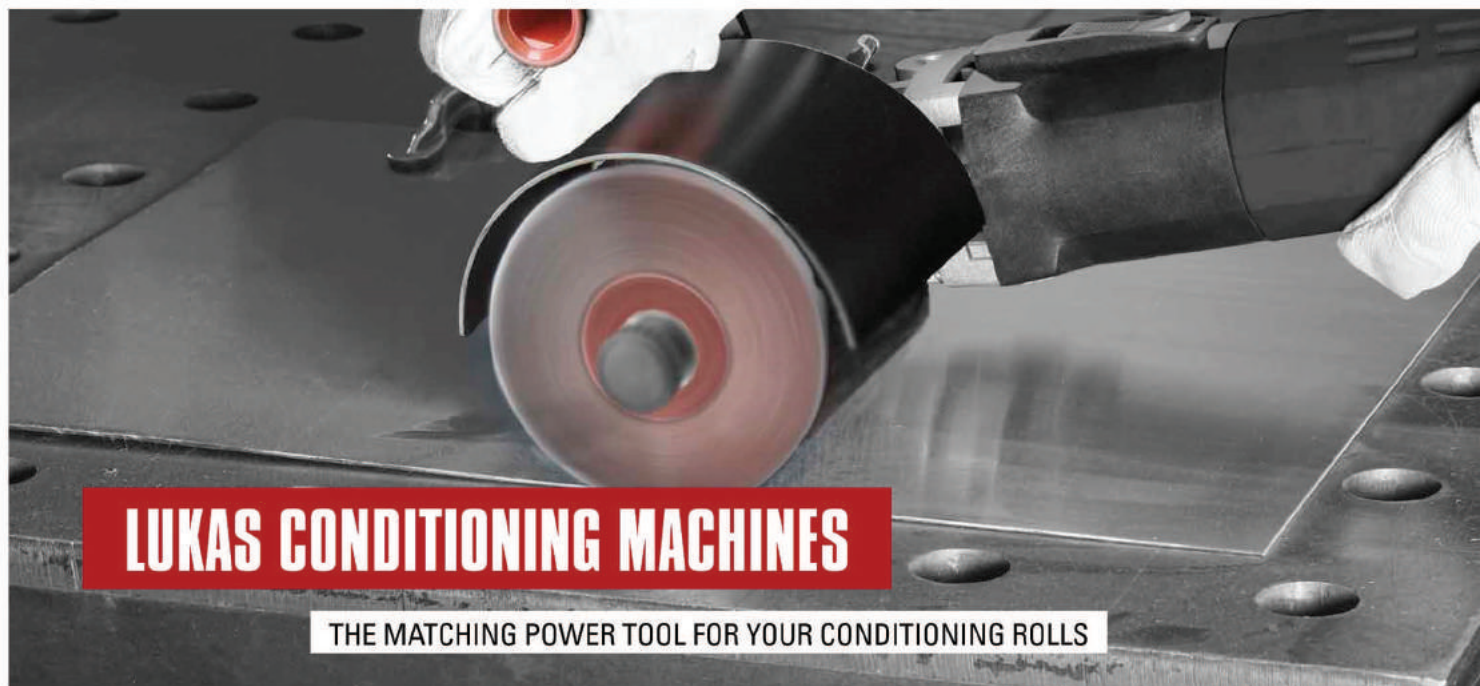
★★☆

Product number	Description	Quality	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A22811001000104	LWF 100100	A104	NK 100	100	100	19	2,800	3,800	1
A22811001000106	LWF 100100	A106	NK 180	100	100	19	2,800	3,800	1

Recommended use for A quality: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium

A2281100500208	LWF 100050	C208	SIC 400	100	50	19	2,800	3,800	2
A22811001000208	LWF 100100	C208	SIC 400	100	100	19	2,800	3,800	1

Recommended use for C quality: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material



## LUKAS CONDITIONING MACHINES

THE MATCHING POWER TOOL FOR YOUR CONDITIONING ROLLS

### Conditioning machine



#### Technical details:

- weight: approx. 2.8 kg
- electronic control with soft start, variable speed control, temperature and overload cut-off

► Further technical details can be found on page 301.

★★☆

#### Properties:

- heavy-duty motor (durable)
- double gear reduction (long service life)
- dust-protected bearings (low wear)
- Combined with the perfect tool, you can achieve shadow-free metal, wood or plastic surfaces without transitions.

#### With the appropriate tool perfect for:

- satin-matt finishing
- texturing
- polishing
- brushing
- smoothening
- deburring
- matt finishing

Product number	Description	Idle speed rpm	Power consumption W	Tool max. Ø mm	Tool width mm	Tool holder mm	Pack contains
A3995ESM1310	ESM 1310	1,300 – 3,050	1,300	120	100	19	1

For use with LUKAS tools		Dimensions	Catalogue page
ESM 1310	P6 polishing roll	100 x 50 mm, 100 x 100 mm	122
	SBZY abrasive band rolls	100 x 100 mm	203
	LWL/LWV/LWM/LWF abrasive flap rolls	100 x 50 mm, 100 x 100 mm	190–193



Please pay attention to the respective speed specifications on our tool packaging.

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Abrasive bands and mandrels from LUKAS

## SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE

We offer a large selection of abrasive bands and matching mandrels. They are available in many different dimensions and qualities. Abrasive bands are made of abrasive cloth which is spirally wound onto a fabric with a backing. Mounted on matching mandrels, they are used with handheld machines (straight grinders or machines with a flexible shaft). **Pages 196–199**

### Application examples:

- Cleaning
- Light deburring
- Refining
- Surface and contour grinding
- Fine grinding

## STZY ABRASIVE BAND MANDRELS, CYLINDRICAL SHAPE

Our mandrels are used solely for mounting our cylindrical abrasive bands. Due to the special slots in the mandrel, the abrasive bands are firmly secured as speed increases. **Page 200**

## SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE WITHOUT LINING

These particularly flexible abrasive bands are made of abrasive cloth. They are used on handheld machines (straight grinders or machines with flexible shafts) and are mounted on matching soft mandrels. **Page 201**

## SBKE ABRASIVE BANDS, CONICAL SHAPE

Conical abrasive bands are comparable in their design and usage with the cylindrical version. The taper (sleeve shape) allows the grinding of workpieces with hard-to-reach areas. **Page 203**

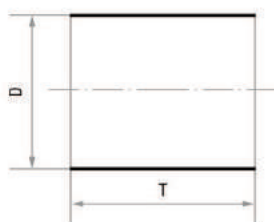
## STKE ABRASIVE BAND MANDRELS, CONICAL SHAPE

Our mandrels are used solely for mounting our conical abrasive bands. Due to the special slot design, the abrasive bands are firmly secured as speed increases. **Page 203**

## STWS ABRASIVE BAND MANDRELS FOR ABRASIVE BAND ROLLS

These especially soft mandrels are provided with a 19 mm bore and four keyways in order to be used with our corresponding abrasive band on handheld surface grinders (conditioning machines). **Page 204**

## SBZY Ceramic abrasive band, cylindrical shape



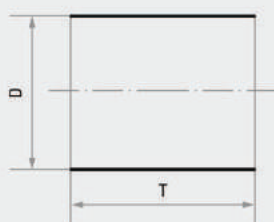
- especially robust ceramic grain for hard materials
- high stock removal rate and long tool life
- Hardened surfaces, wear-resistant steels, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- ▶ The matching mandrels can be found on [page 200](#).

★★★

Product number	Description	Grit	D mm	T mm	Pack contains
A240603030040	SBZY 03030	Ceramic 40	30	30	50
A240603030060	SBZY 03030	Ceramic 60	30	30	50
A240604530040	SBZY 04530	Ceramic 40	45	30	50
A240604530060	SBZY 04530	Ceramic 60	45	30	50
A240604530080	SBZY 04530	Ceramic 80	45	30	50
A240606030040	SBZY 06030	Ceramic 40	60	30	25
A240606030060	SBZY 06030	Ceramic 60	60	30	25

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

## SBZY Z-Power abrasive band, cylindrical shape



- made of zirconia alumina with active abrasive surface layer
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- ▶ The matching mandrels can be found on [page 200](#).

★★★

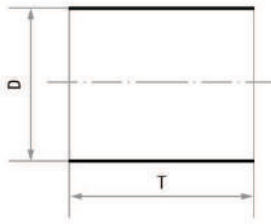
Product number	Description	Grit	D mm	T mm	Pack contains
A241203030036	SBZY 03030	Z-Power 36	30	30	50
A241203030050	SBZY 03030	Z-Power 50	30	30	50
A241203030060	SBZY 03030	Z-Power 60	30	30	50
A241203030080	SBZY 03030	Z-Power 80	30	30	50
A241204530036	SBZY 04530	Z-Power 36	45	30	50
A241204530050	SBZY 04530	Z-Power 50	45	30	50
A241204530080	SBZY 04530	Z-Power 80	45	30	50
A241206030036	SBZY 06030	Z-Power 36	60	30	25
A241206030050	SBZY 06030	Z-Power 50	60	30	25
A241206030080	SBZY 06030	Z-Power 80	60	30	25

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



## SBZY zirconia alumina abrasive band, cylindrical shape

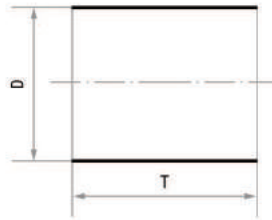
- made of abrasive cloth with zirconia alumina
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- ▶ The matching mandrels can be found on **page 200**.



Product number	Description	Grit	D mm	T mm	Pack contains
A240201325050	SBZY 01325	ZK 50	13	25	50
A240201530050	SBZY 01530	ZK 50	15	30	50
A240201530060	SBZY 01530	ZK 60	15	30	50
A240201530080	SBZY 01530	ZK 80	15	30	50
A240201925036	SBZY 01925	ZK 36	19	25	50
A240201925050	SBZY 01925	ZK 50	19	25	50
A240202220036	SBZY 02220	ZK 36	22	20	50
A240202220050	SBZY 02220	ZK 50	22	20	50
A240202220060	SBZY 02220	ZK 60	22	20	50
A240202525036	SBZY 02525	ZK 36	25	25	50
A240202525050	SBZY 02525	ZK 50	25	25	50
A240202525080	SBZY 02525	ZK 80	25	25	50
A240203030036	SBZY 03030	ZK 36	30	30	50
A240203030050	SBZY 03030	ZK 50	30	30	50
A240203030060	SBZY 03030	ZK 60	30	30	50
A240203030080	SBZY 03030	ZK 80	30	30	50
A240204530036	SBZY 04530	ZK 36	45	30	50
A240204530050	SBZY 04530	ZK 50	45	30	50
A240204530060	SBZY 04530	ZK 60	45	30	50
A240204530080	SBZY 04530	ZK 80	45	30	50
A240206030036	SBZY 06030	ZK 36	60	30	50
A240206030050	SBZY 06030	ZK 50	60	30	50
A240206030060	SBZY 06030	ZK 60	60	30	50
A240206030080	SBZY 06030	ZK 80	60	30	50

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

## SBZY regular aluminium oxide abrasive band, cylindrical shape



- Regular aluminium oxide has good tool life when used on structural steel and for rough grinding.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- ▶ The matching mandrels can be found on **page 200**.

★★☆

Product number	Description	Grit	D mm	T mm	Pack contains
A24000810150	SBZY 00810	NK 150	8	10	50
A240001010080	SBZY 01010	NK 80	10	10	50
A240001010150	SBZY 01010	NK 150	10	10	50
A240001010240	SBZY 01010	NK 240	10	10	50
A240001010320	SBZY 01010	NK 320	10	10	50
A240001020080	SBZY 01020	NK 80	10	20	50
A240001020150	SBZY 01020	NK 150	10	20	50
A240001020240	SBZY 01020	NK 240	10	20	50
A240001020320	SBZY 01020	NK 320	10	20	50
A240001210080	SBZY 01210	NK 80	12	10	50
A240001210150	SBZY 01210	NK 150	12	10	50
A240001213080	SBZY 01213	NK 80	12	13	50
A240001213120	SBZY 01213	NK 120	12	13	50
A240001213240	SBZY 01213	NK 240	12	13	50
A240001225080	SBZY 01225	NK 80	12	25	50
A240001225150	SBZY 01225	NK 150	12	25	50
A240001225240	SBZY 01225	NK 240	12	25	50
A240001225320	SBZY 01225	NK 320	12	25	50
A240001325080	SBZY 01325	NK 80	13	25	50
A240001325150	SBZY 01325	NK 150	13	25	50
A240001510060	SBZY 01510	NK 60	15	10	50
A240001510080	SBZY 01510	NK 80	15	10	50
A240001510150	SBZY 01510	NK 150	15	10	50
A240001510240	SBZY 01510	NK 240	15	10	50
A240001510320	SBZY 01510	NK 320	15	10	50
A240001530040	SBZY 01530	NK 40	15	30	50
A240001530050	SBZY 01530	NK 50	15	30	50
A240001530060	SBZY 01530	NK 60	15	30	50
A240001530080	SBZY 01530	NK 80	15	30	50
A240001530120	SBZY 01530	NK 120	15	30	50
A240001530150	SBZY 01530	NK 150	15	30	50
A240001530240	SBZY 01530	NK 240	15	30	50
A240001530320	SBZY 01530	NK 320	15	30	50
A240001925060	SBZY 01925	NK 60	19	25	50
A240001925080	SBZY 01925	NK 80	19	25	50
A240001925150	SBZY 01925	NK 150	19	25	50
A240002210150	SBZY 02210	NK 150	22	10	50
A240002210240	SBZY 02210	NK 240	22	10	50
A240002210320	SBZY 02210	NK 320	22	10	50
A240002220050	SBZY 02220	NK 50	22	20	50
A240002220060	SBZY 02220	NK 60	22	20	50

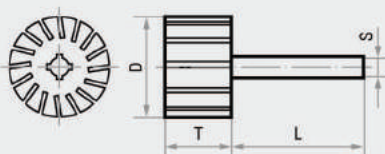
Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

Product number	Description	Grit	D mm	T mm	Pack contains
A240002220080	SBZY 02220	NK 80	22	20	50
A240002220150	SBZY 02220	NK 150	22	20	50
A240002220240	SBZY 02220	NK 240	22	20	50
A240002220320	SBZY 02220	NK 320	22	20	50
A240002525040	SBZY 02525	NK 40	25	25	50
A240002525060	SBZY 02525	NK 60	25	25	50
A240002525080	SBZY 02525	NK 80	25	25	50
A240002525150	SBZY 02525	NK 150	25	25	50
A240003020040	SBZY 03020	NK 40	30	20	50
A240003020050	SBZY 03020	NK 50	30	20	50
A240003020060	SBZY 03020	NK 60	30	20	50
A240003020080	SBZY 03020	NK 80	30	20	50
A240003020150	SBZY 03020	NK 150	30	20	50
A240003020240	SBZY 03020	NK 240	30	20	50
A240003030040	SBZY 03030	NK 40	30	30	50
A240003030050	SBZY 03030	NK 50	30	30	50
A240003030060	SBZY 03030	NK 60	30	30	50
A240003030080	SBZY 03030	NK 80	30	30	50
A240003030150	SBZY 03030	NK 150	30	30	50
A240003030240	SBZY 03030	NK 240	30	30	50
A240003030320	SBZY 03030	NK 320	30	30	50
A240003825040	SBZY 03825	NK 40	38	25	50
A240003825050	SBZY 03825	NK 50	38	25	50
A240003825060	SBZY 03825	NK 60	38	25	50
A240003825080	SBZY 03825	NK 80	38	25	50
A240003825150	SBZY 03825	NK 150	38	25	50
A240004530040	SBZY 04530	NK 40	45	30	50
A240004530050	SBZY 04530	NK 50	45	30	50
A240004530060	SBZY 04530	NK 60	45	30	50
A240004530080	SBZY 04530	NK 80	45	30	50
A240004530150	SBZY 04530	NK 150	45	30	50
A240004530240	SBZY 04530	NK 240	45	30	50
A240004530320	SBZY 04530	NK 320	45	30	50
A240005125040	SBZY 05125	NK 40	51	25	50
A240005125050	SBZY 05125	NK 50	51	25	50
A240005125060	SBZY 05125	NK 60	51	25	50
A240005125080	SBZY 05125	NK 80	51	25	50
A240005125150	SBZY 05125	NK 150	51	25	50
A240006030040	SBZY 06030	NK 40	60	30	50
A240006030050	SBZY 06030	NK 50	60	30	50
A240006030060	SBZY 06030	NK 60	60	30	50
A240006030080	SBZY 06030	NK 80	60	30	50
A240006030150	SBZY 06030	NK 150	60	30	50
A240007530040	SBZY 07530	NK 40	75	30	50
A240007530060	SBZY 07530	NK 60	75	30	50
A240007530080	SBZY 07530	NK 80	75	30	50
A240007530150	SBZY 07530	NK 150	75	30	50
A240010040040	SBZY 10040	NK 40	100	40	25
A240010040060	SBZY 10040	NK 60	100	40	25
A240010040080	SBZY 10040	NK 80	100	40	25
A240010040150	SBZY 10040	NK 150	100	40	25

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

GRINDING AND POLISHING  
(with flexible tools)

## STZY hard abrasive band mandrel, cylindrical shape

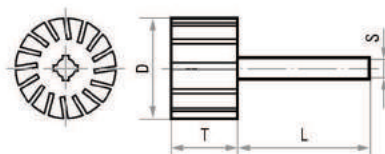


The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2500010103	STZY 01010.03	hard	10	10	3	25	54,000	5
A2500010106	STZY 01010.06	hard	10	10	6	40	57,000	5
A2500010206	STZY 01020.06	hard	10	20	6	40	57,000	5
A2500012106	STZY 01210.06	hard	12	10	6	40	46,500	5
A2500012132	STZY 01213.02	hard	12	13	2.35	40	26,000	5
A2500012256	STZY 01225.06	hard	12	25	6	40	46,500	5
A2500013256	STZY 01325.06	hard	13	25	6	40	44,000	5
A2500015106	STZY 01510.06	hard	15	10	6	40	38,000	5
A2500015306	STZY 01530.06	hard	15	30	6	40	38,000	5
A2500019256	STZY 01925.06	hard	19	25	6	40	30,000	5
A2500022106	STZY 02210.06	hard	22	10	6	40	26,000	5
A2500022206	STZY 02220.06	hard	22	20	6	40	26,000	5
A2500025256	STZY 02525.06	hard	25	25	6	40	22,500	5
A2500030206	STZY 03020.06	hard	30	20	6	40	19,000	5
A2500030306	STZY 03030.06	hard	30	30	6	40	19,000	5
A2500038256	STZY 03825.06	hard	38	25	6	40	15,000	5
A25000453060001	STZY 04530.06	hard	45	30	6	40	13,000	5
A2500051256	STZY 05125.06	hard	51	25	6	40	11,200	5
A25000603060001	STZY 06030.06	hard	60	30	6	40	9,500	5
A2500060308	STZY 06030.08	hard	60	30	8	40	9,500	5
A25000753080001	STZY 07530.08	hard	75	30	8	40	6,500	2

## STZY soft abrasive band mandrel, cylindrical shape



The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2501008103	STZY 00810.03	soft	8	10	3	40	47,500	5
A2501012256	STZY 01225.06	soft	12	25	6	40	31,500	5
A2501015306	STZY 01530.06	soft	15	30	6	40	25,000	5
A2501022206	STZY 02220.06	soft	22	20	6	40	17,000	5
A2501030206	STZY 03020.06	soft	30	20	6	40	12,500	5
A2501030306	STZY 03030.06	soft	30	30	6	40	12,500	5
A25010453060001	STZY 04530.06	soft	45	30	6	40	13,000	5
A25010603060001	STZY 06030.06	soft	60	30	6	40	6,500	5
A25011004080001	STZY 10040.08	soft	100	40	8	40	4,000	2





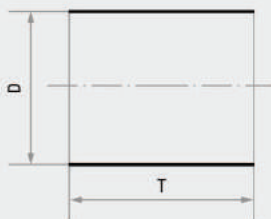
# THE ABRASIVE BAND FOR COMPLEX CONTOURS

FOR FLEXIBLE USE IN COMBINATION WITH A SOFT ABRASIVE BAND MANDREL



## SBZY abrasive band, cylindrical shape, without lining

- abrasive band without lining and therefore particularly flexible
- in combination with soft abrasive band mandrels for use with straight grinders or machines with flexible shafts



★★☆

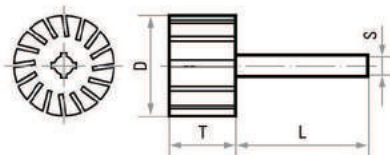
Product number	Description	Grit	D mm	T mm	Pack contains
A300003030080	SBZY 03030	NK 80	30	30	50
A300003030120	SBZY 03030	NK 120	30	30	50
A300003030150	SBZY 03030	NK 150	30	30	50
A300004530120	SBZY 04530	NK 120	45	30	50
A300004530150	SBZY 04530	NK 150	45	30	50

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



## STZY soft abrasive band mandrel, cylindrical shape

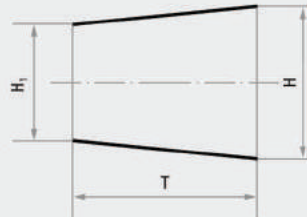
The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!



★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2502030306	STZY 03030.06	soft	30	30	6	40	9,500	5
A2502045306	STZY 04530.06	soft	45	30	6	40	6,300	5
A2502060306	STZY 06030.06	soft	60	30	6	40	4,700	5
A2502075308	STZY 07530.08	soft	75	30	8	40	3,800	2
A2502100408	STZY 10040.08	soft	100	40	8	40	2,800	2

## SBKE regular aluminium oxide abrasive band, conical shape



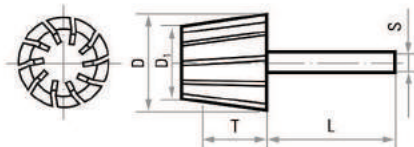
- tapered for grinding on hard-to-reach areas
- For rough grinding, regular aluminium oxide has good tool life when used on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with abrasive band mandrels for use with straight grinders or machines with flexible shafts

★★☆

Product number	Description	Grit	H mm	T mm	H <sub>1</sub> mm	Pack contains
A300002063040	SBKE 02063	NK 40	20	63	14	50
A300002063060	SBKE 02063	NK 60	20	63	14	50
A300002063080	SBKE 02063	NK 80	20	63	14	50
A300002063150	SBKE 02063	NK 150	20	63	14	50
A300002930040	SBKE 02930	NK 40	29	30	22	50
A300002930050	SBKE 02930	NK 50	29	30	22	50
A300002930060	SBKE 02930	NK 60	29	30	22	50
A300002930080	SBKE 02930	NK 80	29	30	22	50
A300002930150	SBKE 02930	NK 150	29	30	22	50
A300003660040	SBKE 03660	NK 40	36	60	22	50
A300003660050	SBKE 03660	NK 50	36	60	22	50
A300003660060	SBKE 03660	NK 60	36	60	22	50
A300003660080	SBKE 03660	NK 80	36	60	22	50
A300003660150	SBKE 03660	NK 150	36	60	22	50

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

## STKE hard abrasive band mandrel, conical shape



The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	D <sub>1</sub> mm	L mm	n <sub>max</sub> rpm	Pack contains
A2500020636	STKE 02063.06	hard	20	63	6	14	40	21,000	5
A2500029306	STKE 02930.06	hard	29	30	6	22	40	21,000	5
A2500036606	STKE 03660.06	hard	36	60	6	22	40	13,500	5

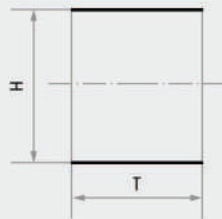
# ABRASIVE BANDS ALSO FOR CONDITIONING MACHINES

MEET EVERY CHALLENGE WITH LUKAS TOOLS

## SBZY abrasive band rolls



- abrasive band rolls in combination with a soft mandrel for use on conditioning machines
- For rough grinding, regular aluminium oxide has good tool life when used on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding



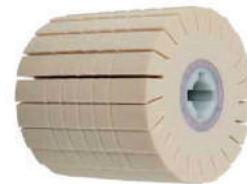
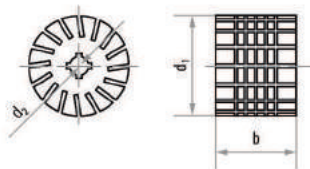
★★☆

Product number	Description	Grit	H mm	T mm	Pack contains
A2400100100060	SBZY 100100	NK 60	100	100	6
A2400100100080	SBZY 100100	NK 80	100	100	6
A2400100100120	SBZY 100100	NK 120	100	100	6
A2400100100150	SBZY 100100	NK 150	100	100	6

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



## STWS soft abrasive band mandrel, cylindrical shape



The 19 mm bore has four 6 mm keyways.

★★☆

Product number	Description	Type	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	n <sub>max</sub> rpm	Pack contains
A2502100100	STWS 100100	soft	100	100	19	2,800	1

## LINISHING BELTS FROM LUKAS

BEST RESULTS TOGETHER WITH THE MATCHING LUKAS POWER TOOL



### SBL linishing belt



★★☆

- can be used on our AMIN 30 BSH pneumatic belt grinder
- operating speed: 28 m/s

Product number	Description	Grit	B mm	Length mm	Backing	Pack contains
A3000130305060T	SBLT	NK 60	13	305	robustly flexible	100
A3000130305080T	SBLT	NK 80	13	305	robustly flexible	100
A3000130305120T	SBLT	NK 120	13	305	robustly flexible	100

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

### Belt grinder, insulated



#### Technical details:

- length: approx. 325 mm
- height: approx. 86 mm
- weight: approx. 0.90 kg
- drive: Vane motor

► Further technical details can be found on page 301.

★★☆

#### Included with the machine:

- clamping arm for linishing belts, dimension 13 x 305 mm
- air hose
- exhaust hose with muffler
- collet 6 mm
- operating tool

#### Special accessories:

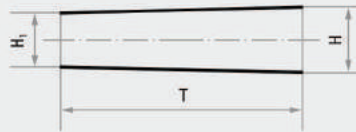
- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"
- belt arms in various dimensions (lengths, widths and roll diameters) available from stock

Product number	Description	Valve	Idle speed (rpm)	Power consumption	Air consumption under load m <sup>3</sup> /min	Peripheral speed of band in m/s	Nominal hose size mm	Pack contains
A3993302113	AMIN 30 BSH	Lever	30,000	0.3	0.45	28	6	1

## SHKE conical abrasive sleeve



- tapered for grinding hard-to-reach areas
- For rough grinding, regular aluminium oxide has good tool life when working on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with abrasive band mandrels for use with straight grinders or machines with flexible shafts



★★☆☆

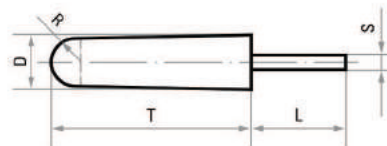
Product number	Description	Grit	H mm	T mm	H <sub>1</sub> mm	Pack contains
A2101108080	SHKE 0885	NK 80	8	85	4.5	25
A2101108150	SHKE 0885	NK 150	8	85	4.5	25
A2101158080	SHKE 1385	NK 80	13	85	9.5	25
A2101158150	SHKE 1385	NK 150	13	85	9.5	25
A2101208080	SHKE 1885	NK 80	18	85	14.5	25
A2101208150	SHKE 1885	NK 150	18	85	14.5	25
A2101258080	SHKE 2385	NK 80	23	85	19.5	25
A2101258150	SHKE 2385	NK 150	23	85	19.5	25

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



## GTKE conical abrasive sleeve mandrel

To reach deep machining areas, LUKAS grinding caps with a round conical shape (pp. 211–213) can also be used on this mandrel with a head length of 85 mm in addition to abrasive sleeves.



★★☆☆

Product number	Description	D mm	T mm	L mm	~ R mm	Shank diameter x length mm	n <sub>max</sub> rpm	Pack contains
A25001086	GTKE 0885	8	85	40	2	6 x 40	24,000	5
A25001586	GTKE 1385	13	85	40	5	6 x 40	17,000	5
A25002086	GTKE 1885	18	85	40	7.5	6 x 40	12,000	5
A25002586	GTKE 2385	23	85	40	9.5	6 x 40	10,000	5

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

**Abrasive rolls and mandrels from LUKAS****SRZY CYLINDRICAL ABRASIVE ROLLS AND SRKE CONICAL ABRASIVE ROLLS**

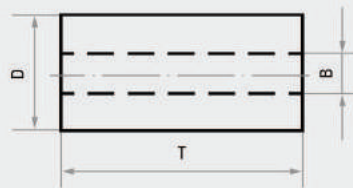
These abrasive rolls consist of wound abrasive cloth. Their design ensures that new abrasive grain is repeatedly exposed during the grinding process as the outer diameter wears down. Please pay attention to the rotational direction during use and mount the abrasive roll so that the bonded side points towards the mandrel.

**Application examples:**

- Deburring
- Cleaning
- Fettling

**SRTR ABRASIVE ROLL MANDREL**

Reusable tool carrier for secure mounting of the cylindrical and conical abrasive rolls.

**SRZY Ceramic abrasive roll, cylindrical**

- continuous grinding of small workpieces
- abrasive roll with ceramic grain for an exceptional tool life
- Hardened surfaces, wear-resistant steels, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- for deburring, cleaning or fettling of small workpieces
- enormous amount of abrasive coating due to the large, cylindrically wound working surface
- ▶ The matching tool carriers can be found on page 208.

★★★

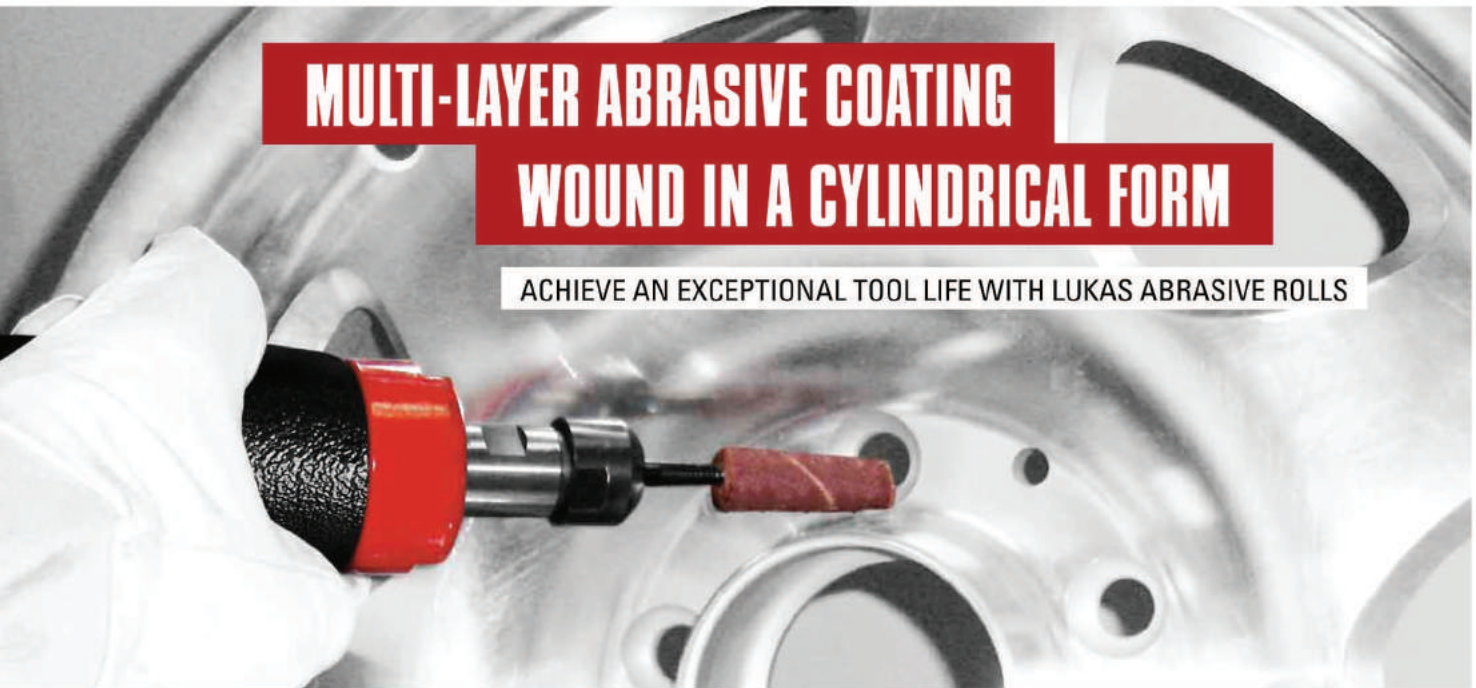
Product number	Description	Grit	D mm	T mm	B mm	$n_{max}$ rpm	Matching abrasive roll mandrels	Pack contains
A2403006380600001	SRZY 0638	Ceramic 60	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403006380800001	SRZY 0638	Ceramic 80	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403006381200001	SRZY 0638	Ceramic 120	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403010380600001	SRZY 1038	Ceramic 60	10	38	3	24,000	SRTR 3070.06	50
A2403010380800001	SRZY 1038	Ceramic 80	10	38	3	24,000	SRTR 3070.06	50
A2403010381200001	SRZY 1038	Ceramic 120	10	38	3	24,000	SRTR 3070.06	50
A2403013380600001	SRZY 1338	Ceramic 60	13	38	3	24,000	SRTR 3070.06	50
A2403013380800001	SRZY 1338	Ceramic 80	13	38	3	24,000	SRTR 3070.06	50
A2403013381200001	SRZY 1338	Ceramic 120	13	38	3	24,000	SRTR 3070.06	50

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

# MULTI-LAYER ABRASIVE COATING

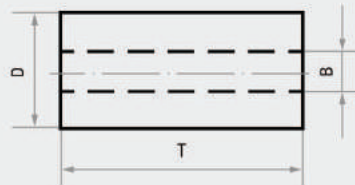
# WOUND IN A CYLINDRICAL FORM

ACHIEVE AN EXCEPTIONAL TOOL LIFE WITH LUKAS ABRASIVE ROLLS



## SRZY regular aluminium oxide abrasive roll, cylindrical

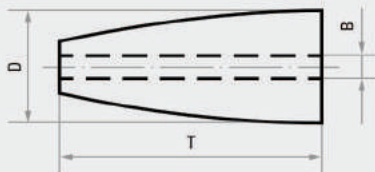
- for deburring, cleaning or fettling of small workpieces
- Regular aluminium oxide has good tool life when used on structural steel, when rough grinding, and ensures cost-effective machining.
- enormous amount of abrasive coating due to the large, cylindrically wound working surface
- ▶ The matching tool carriers can be found on **page 208**.



Product number	Description	Grit	D mm	T mm	B mm	$n_{max}$ rpm	Matching abrasive roll mandrels	Pack contains
A240300625080	SRZY 0625	NK 80	6	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300625150	SRZY 0625	NK 150	6	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300638080	SRZY 0638	NK 80	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300638150	SRZY 0638	NK 150	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025050	SRZY 1025	NK 50	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025080	SRZY 1025	NK 80	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025150	SRZY 1025	NK 150	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301038050	SRZY 1038	NK 50	10	38	3	24,000	SRTR 3070.06	50
A240301038080	SRZY 1038	NK 80	10	38	3	24,000	SRTR 3070.06	50
A240301038150	SRZY 1038	NK 150	10	38	3	24,000	SRTR 3070.06	50
A240301325050	SRZY 1325	NK 50	13	25	3	24,000	SRTR 3063.06	50
A240301325080	SRZY 1325	NK 80	13	25	3	24,000	SRTR 3063.06	50
A240301325150	SRZY 1325	NK 150	13	25	3	24,000	SRTR 3063.06	50
A240301338050	SRZY 1338	NK 50	13	38	3	24,000	SRTR 3070.06	50
A240301338080	SRZY 1338	NK 80	13	38	3	24,000	SRTR 3070.06	50
A240301338150	SRZY 1338	NK 150	13	38	3	24,000	SRTR 3070.06	50
A240302038050	SRZY 2038	NK 50	20	38	5	16,000	SRTR 5085.06	50
A240302038080	SRZY 2038	NK 80	20	38	5	16,000	SRTR 5085.06	50
A240302038150	SRZY 2038	NK 150	20	38	5	16,000	SRTR 5085.06	50
A240302050050	SRZY 2050	NK 50	20	50	5	16,000	SRTR 5085.06	50
A240302050080	SRZY 2050	NK 80	20	50	5	16,000	SRTR 5085.06	50

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

## SRKE regular aluminium oxide abrasive roll, conical



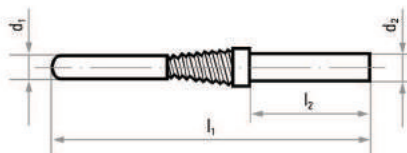
- for deburring, cleaning or fettling of small workpieces
- tapered for grinding hard-to-reach areas
- Regular aluminium oxide has good tool life when used on structural steel, when rough grinding, and ensures cost-effective machining.
- enormous amount of abrasive coating due to the large, cylindrically wound working surface
- ▶ The matching tool carriers can be found at the bottom of this page.

★★☆

Product number	Description	Grit	D mm	T mm	B mm	$n_{max}$ rpm	Matching abrasive roll mandrels	Pack contains
A240401025050	SRKE 1025	NK 50	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401025080	SRKE 1025	NK 80	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401025150	SRKE 1025	NK 150	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401325050	SRKE 1325	NK 50	13	25	3	24,000	SRTR 3063.06	50
A240401325080	SRKE 1325	NK 80	13	25	3	24,000	SRTR 3063.06	50
A240401325150	SRKE 1325	NK 150	13	25	3	24,000	SRTR 3063.06	50
A240401338050	SRKE 1338	NK 50	13	38	3	24,000	SRTR 3070.06	50
A240401338080	SRKE 1338	NK 80	13	38	3	24,000	SRTR 3070.06	50
A240401338150	SRKE 1338	NK 150	13	38	3	24,000	SRTR 3070.06	50
A240401638050	SRKE 1638	NK 50	16	38	3	16,000	SRTR 3070.06	50
A240401638080	SRKE 1638	NK 80	16	38	3	16,000	SRTR 3070.06	50
A240401638150	SRKE 1638	NK 150	16	38	3	16,000	SRTR 3070.06	50
A240402050036	SRKE 2050	NK 36	20	50	5	16,000	SRTR 5085.06	50
A240402050050	SRKE 2050	NK 50	20	50	5	16,000	SRTR 5085.06	50
A240402050080	SRKE 2050	NK 80	20	50	5	16,000	SRTR 5085.06	50
A240402050150	SRKE 2050	NK 150	20	50	5	16,000	SRTR 5085.06	50

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

## SRTR abrasive roll mandrel



★★☆

Product number	Description	Type	$d_1$ mm	$l_1$ mm	$d_2$ mm	$l_2$ mm	Pack contains
A32030130001	SRTR 3063.03	Inox	3	64	3	27	5
A32030160001	SRTR 3063.06	Inox	3	64	6	27	1
A32030260001	SRTR 3070.06	Inox	3	70	6	25	1
A32030460001	SRTR 5085.06	Inox	5	85	6	35	5



TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS abrasive caps and mandrels

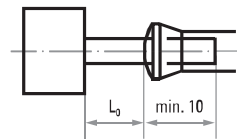
Our abrasive caps and sleeves consist of high-quality abrasive cloth and are manufactured to fit perfectly on our corresponding mandrels. We offer a large assortment of tools with the corresponding mandrel for various applications.

**Application examples:**

- Fine and ultra-fine grinding work, especially in hard-to-reach areas
- Machining in tool- and mouldmaking industry as well as pattern construction

**PERMISSIBLE SPEEDS**

The maximum permissible speeds indicated in the respective table of abrasive cap mandrels apply for a maximum overhang length of 15 mm. The maximum permissible speed must be calculated separately for other overhang lengths!



ABRASIVE CAP CERAMIC	ABRASIVE CAP SPECIAL
★★★	★★☆
	
<p>Self-sharpening ceramic grain for machining the most challenging materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem with this grain.</p>	<p>Special quality for the machining of corrosion and heat-resistant steels in the tool- and mouldmaking industry as well as for the universal machining of plastics, aluminium and non-ferrous metals. The surface layer with active abrasive additives enables enhanced stock removal rate and a longer tool life.</p>

GRINDING AND POLISHING (with flexible tools)

# THE GRINDING TOOL WITH SELF-SHARPENING EFFECT

GRIND LONGER ON THE HARDEST METALS WITH THE LUKAS CERAMIC ABRASIVE CAP



Whether tool steel, cast steel or titanium alloys – an increasing amount of extremely hard and tough metals are machined in industry. With the ceramic abrasive cap, a tool for straight grinders is now available that makes machining smaller parts and deburring extremely easy. An extra-long tool life is an added bonus thanks to the self-sharpening effect.

These abrasive caps are perfect for grinding uneven surfaces, machining small parts, deburring and regrinding small radii. The abrasive caps can even be used for stainless steel because they generate little heat during grinding.

## SELF-SHARPENING EFFECT REDUCES TOOL COSTS

Thanks to self-sharpening, Ceramic abrasive caps achieve a tool life many times that of ordinary caps. Tool changes are required much less frequently, thus reducing tool costs.

**4** DIFFERENT  
SHAPES  
AVAILABLE



**AN ALL-ROUND TOOL  
FOR DEBURRING, GRINDING,  
BEVELLING AND REGRINDING**

## NO MORE GLAZING

The grinding particles embedded in a resin matrix break off when worn and make way for new particles with sharp cutting edges. The dulling known as “glazing” familiar with other grinding tools does not occur when machining hard materials. As a result, the Ceramic abrasive cap continues to work like new despite wear.

## MAXIMUM CUTTING PERFORMANCE

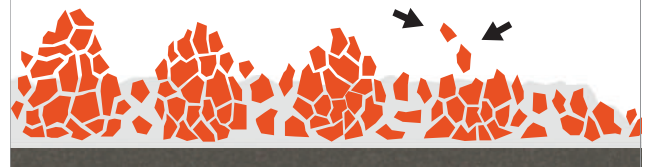
The abrasive caps with ceramic grain were developed for machining the most demanding materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem when using these abrasive caps. Due to its self-sharpening effect, this aggressive grinding behaviour is retained for a very long time.

## THE TROUBLESHOOTER FOR MACHINING METAL

The Ceramic abrasive caps represent a valuable addition as a tool for all industries in which hard metals are machined. These include the tool and mould industries as well as demanding mechanical and steel engineering and also the aerospace industry.

## THE SELF-SHARPENING EFFECT

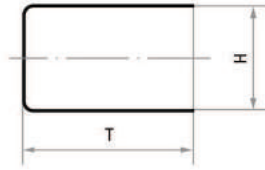
Worn grinding particles break off, exposing new particles with sharp cutting edges. That's why the abrasive cap remains as sharp as new for a long time.





**SK Ceramic abrasive caps** NEW

- self-sharpening
- for the hardest materials
- exceptionally long tool life
- precise fit
- also for stainless steel



★★★

Product number	Description	Shapes	Grit	H mm	T mm	Pack contains	
A21120052080	SKWR 0511		Ceramic 80	5	11	100	
A21120052150	SKWR 0511		Ceramic 150	5	11	100	
A21120072080	SKWR 0713		Ceramic 80	7	13	100	
A21120072150	SKWR 0713		Ceramic 150	7	13	100	
A21120102080	SKWR 1015		Ceramic 80	10	15	100	
A21120102150	SKWR 1015		Ceramic 150	10	15	100	
A21120132080	SKWR 1319		Ceramic 80	13	19	100	
A21120132150	SKWR 1319		Ceramic 150	13	19	100	
A21120162080	SKWR 1626		Ceramic 80	16	26	100	
A21120162150	SKWR 1626		Ceramic 150	16	26	100	
A2112051080	SKKE 0515			Ceramic 80	5	15	100
A2112051150	SKKE 0515			Ceramic 150	5	15	100
A2112112080	SKKE 1125	Ceramic 80		11	25	100	
A2112112150	SKKE 1125	Ceramic 150		11	25	100	
A2112163080	SKKE 1632		Ceramic 80	16	32	100	
A2112163150	SKKE 1632		Ceramic 150	16	32	100	
A2112224080	SKKE 2140		Ceramic 80	21	40	100	
A2112224150	SKKE 2140		Ceramic 150	21	40	100	
A21120051080	SKZY 0510		Ceramic 80	5	10	100	
A21120051150	SKZY 0510		Ceramic 150	5	10	100	
A21120071080	SKZY 0712		Ceramic 80	7	12	100	
A21120071150	SKZY 0712		Ceramic 150	7	12	100	
A21120101080	SKZY 1015		Ceramic 80	10	15	100	
A21120101150	SKZY 1015		Ceramic 150	10	15	100	
A21120131080	SKZY 1317		Ceramic 80	13	17	100	
A21120131150	SKZY 1317		Ceramic 150	13	17	100	
A21120161080	SKZY 1626		Ceramic 80	16	26	100	
A21120161150	SKZY 1626		Ceramic 150	16	26	100	
A21120053080	SKWK 0511			Ceramic 80	5	11	100
A21120053150	SKWK 0511			Ceramic 150	5	11	100
A21120073080	SKWK 0713	Ceramic 80		7	13	100	
A21120073150	SKWK 0713	Ceramic 150		7	13	100	
A21120103080	SKWK 1015		Ceramic 80	10	15	100	
A21120103150	SKWK 1015		Ceramic 150	10	15	100	
A21120133080	SKWK 1319		Ceramic 80	13	19	100	
A21120133150	SKWK 1319		Ceramic 150	13	19	100	
A21120163080	SKWK 1626		Ceramic 80	16	26	100	
A21120163150	SKWK 1626		Ceramic 150	16	26	100	

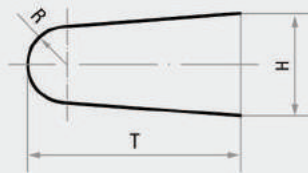
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

GRINDING AND POLISHING  
(with flexible tools)

# THE PROBLEM-SOLVER IN TOOL- AND MOULDMAKING

ENHANCED STOCK REMOVAL RATE AND LONGER TOOL LIFE

## SKS Special abrasive cap

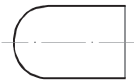
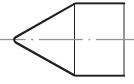
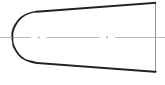


- enhanced stock removal rate using regular aluminium oxide with active abrasive surface layer
- suitable for corrosion and heat-resistant steels as well as for universal machining of plastics, non-ferrous metals and many other materials

★★☆

	Product number	Description	Shapes	Grit	H mm	T mm	Pack contains
	A21020051080	SKZYS 0510		NKS 80	5	10	100
	A21020051150	SKZYS 0510		NKS 150	5	10	100
NEW	A21020051320	SKZYS 0510		NKS 320	5	10	100
	A21020071060	SKZYS 0712		NKS 60	7	12	100
	A21020071080	SKZYS 0712		NKS 80	7	12	100
	A21020071150	SKZYS 0712		NKS 150	7	12	100
NEW	A21020071320	SKZYS 0712		NKS 320	7	12	100
	A21020101060	SKZYS 1015		NKS 60	10	15	100
	A21020101080	SKZYS 1015		NKS 80	10	15	100
	A21020101150	SKZYS 1015		NKS 150	10	15	100
NEW	A21020101320	SKZYS 1015	NKS 320	10	15	100	
NEW	A21020131060	SKZYS 1317	NKS 60	13	17	100	
NEW	A21020131080	SKZYS 1317	NKS 80	13	17	100	
NEW	A21020131150	SKZYS 1317	NKS 150	13	17	100	
NEW	A21020131320	SKZYS 1317	NKS 320	13	17	100	
NEW	A21020161060	SKZYS 1626	NKS 60	16	26	100	
NEW	A21020161080	SKZYS 1626	NKS 80	16	26	100	
NEW	A21020161150	SKZYS 1626	NKS 150	16	26	100	
NEW	A21020161320	SKZYS 1626	NKS 320	16	26	100	
	A21020052080	SKWRS 0511		NKS 80	5	11	100
	A21020052150	SKWRS 0511		NKS 150	5	11	100
NEW	A21020052320	SKWRS 0511		NKS 320	5	11	100

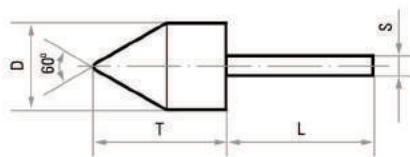
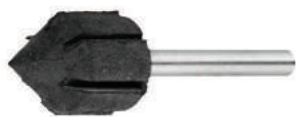
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

Product number	Description	Shapes	Grit	H mm	T mm	Pack contains	
A21020072060	SKWRS 0713		NKS 60	7	13	100	
A21020072080	SKWRS 0713		NKS 80	7	13	100	
A21020072150	SKWRS 0713		NKS 150	7	13	100	
A21020072320	SKWRS 0713		NKS 320	7	13	100 <b>NEW</b>	
A21020102060	SKWRS 1015		NKS 60	10	15	100	
A21020102080	SKWRS 1015		NKS 80	10	15	100	
A21020102150	SKWRS 1015		NKS 150	10	15	100	
A21020102320	SKWRS 1015		NKS 320	10	15	100 <b>NEW</b>	
A21020132060	SKWRS 1319		NKS 60	13	19	100	
A21020132080	SKWRS 1319		NKS 80	13	19	100	
A21020132150	SKWRS 1319		NKS 150	13	19	100	
A21020132320	SKWRS 1319		NKS 320	13	19	100 <b>NEW</b>	
A21020162060	SKWRS 1626	NKS 60	16	26	100 <b>NEW</b>		
A21020162080	SKWRS 1626	NKS 80	16	26	100 <b>NEW</b>		
A21020162150	SKWRS 1626	NKS 150	16	26	100 <b>NEW</b>		
A21020162320	SKWRS 1626	NKS 320	16	26	100 <b>NEW</b>		
A21020053060	SKWKS 0511		NKS 60	5	11	100 <b>NEW</b>	
A21020053080	SKWKS 0511		NKS 80	5	11	100	
A21020053150	SKWKS 0511		NKS 150	5	11	100	
A21020053320	SKWKS 0511		NKS 320	5	11	100 <b>NEW</b>	
A21020073060	SKWKS 0713		NKS 60	7	13	100	
A21020073080	SKWKS 0713		NKS 80	7	13	100	
A21020073150	SKWKS 0713		NKS 150	7	13	100	
A21020073320	SKWKS 0713		NKS 320	7	13	100 <b>NEW</b>	
A21020103060	SKWKS 1015		NKS 60	10	15	100	
A21020103080	SKWKS 1015		NKS 80	10	15	100	
A21020103150	SKWKS 1015		NKS 150	10	15	100	
A21020103320	SKWKS 1015		NKS 320	10	15	100 <b>NEW</b>	
A21020133060	SKWKS 1319		NKS 60	13	19	100	
A21020133080	SKWKS 1319		NKS 80	13	19	100	
A21020133150	SKWKS 1319		NKS 150	13	19	100	
A21020133320	SKWKS 1319		NKS 320	13	19	100 <b>NEW</b>	
A21020163060	SKWKS 1626		NKS 60	16	26	100 <b>NEW</b>	
A21020163080	SKWKS 1626		NKS 80	16	26	100 <b>NEW</b>	
A21020163150	SKWKS 1626		NKS 150	16	26	100 <b>NEW</b>	
A21020163320	SKWKS 1626		NKS 320	16	26	100 <b>NEW</b>	
Product number	Description	Shapes	Grit	H mm	T mm	~ R mm	Pack contains
A2102051080	SKKES 0515		NKS 80	5	15	2	25 <b>NEW</b>
A2102051150	SKKES 0515		NKS 150	5	15	2	25 <b>NEW</b>
A2102112060	SKKES 1125		NKS 60	11	25	5	25 <b>NEW</b>
A2102112080	SKKES 1125		NKS 80	11	25	5	25 <b>NEW</b>
A2102112150	SKKES 1125		NKS 150	11	25	5	25 <b>NEW</b>
A2102163060	SKKES 1632		NKS 60	16	32	7.5	25
A2102163080	SKKES 1632		NKS 80	16	32	7.5	25
A2102163150	SKKES 1632		NKS 150	16	32	7.5	25
A2102224060	SKKES 2140		NKS 60	21	40	9.5	25 <b>NEW</b>
A2102224080	SKKES 2140		NKS 80	21	40	9.5	25 <b>NEW</b>
A2102224150	SKKES 2140		NKS 150	21	40	9.5	25 <b>NEW</b>

GRINDING AND POLISHING  
(with flexible tools)

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

## Abrasive cap mandrel



★★☆

Product number	Description	Shapes	D mm	T mm	Shank diameter x length mm	$n_{max}$ rpm	Pack contains	
A250000511	GTZY 0510		5	10	1/8" x 25	95,000	5	
A250000513	GTZY 0510		5	10	3 x 25	95,000	5	
A250000713	GTZY 0712		7	12	3 x 25	65,000	5	
A250001011	GTZY 1015		10	15	1/8" x 25	45,000	5	
A250001013	GTZY 1015		10	15	3 x 25	45,000	5	
A250001313	GTZY 1317		13	17	3 x 25	35,000	5	
A250001613	GTZY 1626		16	26	3 x 25	18,000	5	
A250001616	GTZY 1626	16	26	6 x 40	30,000	5		
A250000521	GTWR 0511		5	11	1/8" x 25	95,000	5	
A250000523	GTWR 0511		5	11	3 x 25	95,000	5	
A250000721	GTWR 0713		7	13	1/8" x 25	65,000	5	
A250000723	GTWR 0713		7	13	3 x 25	65,000	5	
A250001021	GTWR 1015		10	15	1/8" x 25	45,000	5	
A250001023	GTWR 1015		10	15	3 x 25	45,000	5	
A250001323	GTWR 1319		13	19	3 x 25	35,000	5	
A250001621	GTWR 1626	16	26	1/8" x 25	18,000	5		
A250001623	GTWR 1626	16	26	3 x 25	18,000	5		
A250001626	GTWR 1626	16	26	6 x 40	30,000	5		
A250000531	GTWK 0511		5	11	1/8" x 25	95,000	5	
A250000533	GTWK 0511		5	11	3 x 25	95,000	5	
A250000733	GTWK 0713		7	13	3 x 25	65,000	5	
A250001033	GTWK 1015		10	15	3 x 25	45,000	5	
A250001333	GTWK 1319		13	19	3 x 25	35,000	5	
A250001633	GTWK 1626		16	26	3 x 25	18,000	5	
A250001636	GTWK 1626		16	26	6 x 40	30,000	5	
Product number	Description	Shapes	D mm	T mm	- R mm	Shank diameter x length mm	$n_{max}$ rpm	Pack contains
A25000511	GTKE 0515		5	15	2	1/4" x 40	95,000	5
A25000513	GTKE 0515		5	15	2	3 x 25	57,000	5
A25000516	GTKE 0515		5	15	2	6 x 40	95,000	5
A25001126	GTKE 1125		11	25	5	6 x 40	40,000	5
A25001636	GTKE 1632		16	32	7.5	6 x 40	30,000	5
A25002246	GTKE 2140		21	40	9.5	6 x 40	20,000	5



# LUKAS' COMPREHENSIVE ABRASIVE CAP SET

ALWAYS HAVE THE RIGHT ABRASIVE CAP AT HAND

Be prepared for every eventuality: The LUKAS cap assortment offers you a large selection of different shapes and sizes – of course with the matching mandrel.

This set of special-quality abrasive caps contains a total of 640 caps and 23 mandrels. With its practical transport case, you can use this set whenever you need it at the workplace, in the factory or even in a model workshop. It is also suitable for testing the various shapes of LUKAS abrasive caps.

GRINDING AND POLISHING  
(with flexible tools)



## WS abrasive cap assortment

- consists of 640 abrasive caps and 23 mandrels
- box outer dimensions: 372 x 189 x 46 mm



Product number	Description	Quantity	Content				Pack contains
A21000065001	WS 65 NKS	50 pieces 100 per pack 50 per pack 20 per pack 10 pieces	Abrasive caps, grain NKS 150:				1
			SKKES 0515	SKWRS 0511	SKWKS 0511		
			SKZYS 0510	SKWRS 0713	SKWKS 0713		
			SKZYS 0712	SKWRS 1015	SKWKS 0713		
		SKZYS 1015	SKWRS 1015				
		SKKES 1125					
		20 pieces 10 per pack 15 per pack	Abrasive caps, grain NKS 80:				
			SKWKS 1015	SKWRS 1319	SKWKS 1319	SKKES 1632	
			SKZYS 1317	SKWRS 1626			
			SKWKS 1626	SKWRS 1626			
		2 per pack	Mandrels, shank 3 mm:				
		1 per pack	GTZY 0510	GTWR 0511	GTWK 0511	GTZY 0712	
			GTWR 0713	GTWK 0713			
			GTZY 1015	GTWR 1015	GTWK 1015	GTZY 1317	
			GTWR 1319	GTWK 1319			
		1 per pack	Mandrels, shank 6 mm:				
			GTKE 0515	GTKE 1125	GTWK 1626	GTWR 1626	
			GTKE 1632				

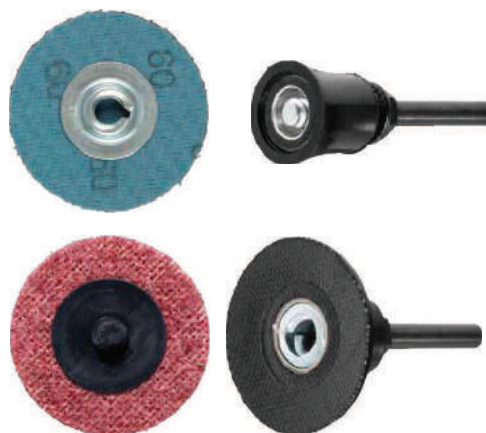
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

**Abrasive discs and carriers from LUKAS****PSG/PSR SELF-CLAMPING ABRASIVE DISCS**

LUKAS abrasive discs – PSG/PSR – are self-clamping. The back of the abrasive discs is fitted with a “quick lock” made of metal or plastic (PSG) or a plastic thread (PSR). The abrasive disc is attached to the corresponding carrier with a small twist. In this tool category, the PSG abrasive discs represents our most extensive range. Numerous diameters, many different grit sizes, and above all abrasive qualities for every application, help you to solve your grinding problem.

► Find out more about these abrasive discs on **pages 218–225**.

**PSK ADHESIVE ABRASIVE DISCS**

LUKAS abrasive discs – PSK – are self-adhesive. The rubberised back of the abrasive discs is covered with a protective film. After removing this film, the abrasive discs are stuck to the respective carrier. These discs are suitable for machining many different surfaces. The adhesive bond does not permit reuse once the disc has been peeled off the carrier. These abrasive discs are available in regular aluminium oxide and silicon carbide as well as with different grit sizes, as illustrated in the following tables.

► Find out more about these abrasive discs on **pages 228/229**.

**PSH SELF-FIXING ABRASIVE DISCS**

LUKAS abrasive discs – PSH – are self-fixing. The abrasive discs have a Velcro backing, with the corresponding carriers covered with hooked fabric. These discs are suitable for machining both flat and concave surfaces. Abrasive discs that have not been completely worn down during machining can be removed and reused another time. These abrasive discs are available in a quality and grit size adapted to the respective application as illustrated in the following tables.

► Find out more about these abrasive discs on **pages 231–234**.



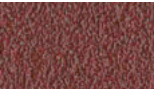




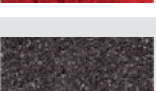
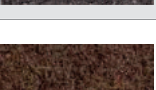
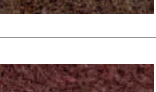
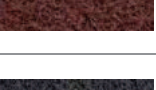


PSG ABRASIVE DISCS

# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

You will find all abrasive discs from the PSG range in the following overview. Read through the properties and application details of the different workpiece materials to find the right quality to meet your requirements.

Quality	Properties	Application areas/machining	Page
 <b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	220
 <b>NKE</b> Abrasive cloth Regular aluminium oxide with reinforced backing material	very tough abrasive, high resilience	The reinforcement makes these discs suitable for the toughest demands and beveling.	221
 <b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	ideal for Hastelloy, Inconel, non-rusting steel and metals that are difficult to machine	219
 <b>Z-Power</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent stock removal rate, long tool life	ideal for machining non-rusting steel; special surface layer prevents clogging	219
 <b>Ceramic</b> Abrasive cloth Ceramic grain	excellent stock removal rate without grain shredding, particularly stable due to reinforced backing, cool cutting	ideal for machining non-rusting steel and nickel alloys	218
 <b>SIC</b> Abrasive cloth Silicon carbide	minimum heat accumulation, special quality for the aerospace industry	Ideal for machining titanium, titanium alloys and aluminium (aviation industry). Plastics and ceramics can also be processed.	223
 Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect with the fibre structure, consistent results due to continuous exposure of new grinding particles; long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of surface quality	222
 Abrasive fleece Regular aluminium oxide medium/red-brown			
 Abrasive fleece Regular aluminium oxide fine/blue			

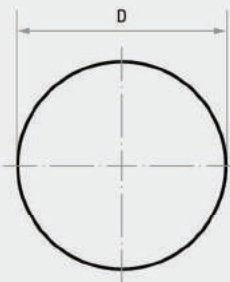
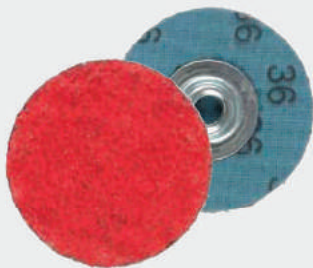
GRINDING AND POLISHING  
(with flexible tools)

# MACHINE ULTRA-HARD MATERIALS

INNOVATIVE CERAMIC GRAIN WITH SELF-SHARPENING EFFECT



## PSG Ceramic self-clamping abrasive disc

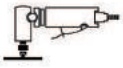


- especially robust ceramic grain for hard materials
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- high stock removal rate and long tool life
- Hardened surfaces, wear-resistant steel, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- ▶ The matching tool carriers can be found on page 223.

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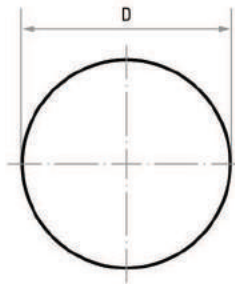
	Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
<b>NEW</b>	A33790250360458	PSG 025	Ceramic 36	25	38,000	GTG 025	100
<b>NEW</b>	A33790250600458	PSG 025	Ceramic 60	25	38,000	GTG 025	100
<b>NEW</b>	A33790250800458	PSG 025	Ceramic 80	25	38,000	GTG 025	100
<b>NEW</b>	A33790251200458	PSG 025	Ceramic 120	25	38,000	GTG 025	100
	A33790380360458	PSG 038	Ceramic 36	38	25,000	GTG 038	100
	A33790380600458	PSG 038	Ceramic 60	38	25,000	GTG 038	100
	A33790380800458	PSG 038	Ceramic 80	38	25,000	GTG 038	100
	A33790381200458	PSG 038	Ceramic 120	38	25,000	GTG 038	100
	A33790500360458	PSG 050	Ceramic 36	50	25,000	GTG 038 and GTG 050	100
<b>NEW</b>	A33790500500458	PSG 050	Ceramic 50	50	25,000	GTG 038 and GTG 050	100
	A33790500600458	PSG 050	Ceramic 60	50	25,000	GTG 038 and GTG 050	100
	A33790500800458	PSG 050	Ceramic 80	50	25,000	GTG 038 and GTG 050	100
	A33790501200458	PSG 050	Ceramic 120	50	25,000	GTG 038 and GTG 050	100
	A33790750360458	PSG 075	Ceramic 36	75	20,000	GTG 075	50
	A33790750600458	PSG 075	Ceramic 60	75	20,000	GTG 075	50
	A33790750800458	PSG 075	Ceramic 80	75	20,000	GTG 075	50
	A33790751200458	PSG 075	Ceramic 120	75	20,000	GTG 075	50

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



## PSG Z-Power self-clamping abrasive disc

- made of zirconia alumina with active abrasive surface layer
- ideal for machining stainless steel
- special surface layer prevents clogging
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on **page 223**.

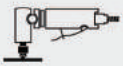


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Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33770380360458	PSG 038	Z-Power 36	38	25,000	GTG 038	100
A33770380600458	PSG 038	Z-Power 60	38	25,000	GTG 038	100
A33770380800458	PSG 038	Z-Power 80	38	25,000	GTG 038	100
A33770381200458	PSG 038	Z-Power 120	38	25,000	GTG 038	100
A33770500360458	PSG 050	Z-Power 36	51	25,000	GTG 038 and GTG 050	100
A33770500600458	PSG 050	Z-Power 60	51	25,000	GTG 038 and GTG 050	100
A33770500800458	PSG 050	Z-Power 80	51	25,000	GTG 038 and GTG 050	100
A33770750360458	PSG 075	Z-Power 36	76	20,000	GTG 075	50
A33770750600458	PSG 075	Z-Power 60	76	20,000	GTG 075	50
A33770750800458	PSG 075	Z-Power 80	76	20,000	GTG 075	50
A33770751200458	PSG 075	Z-Power 120	76	20,000	GTG 075	50

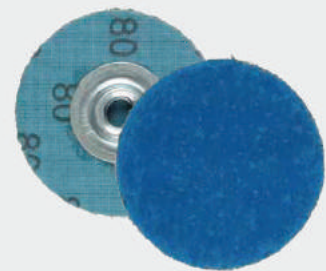
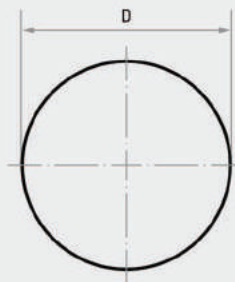
Recommended for: ● Inox/Stel ● Steel ● Cast material ● Titanium

GRINDING AND POLISHING (with flexible tools)



## PSG self-clamping zirconia alumina abrasive disc

- made from abrasive cloth with zirconia alumina
- ideal for Hastelloy, Inconel, stainless steel and metals that are difficult to machine
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on **page 223**.



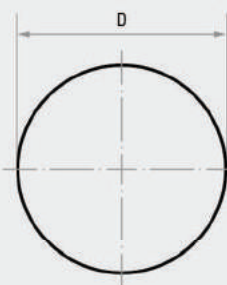
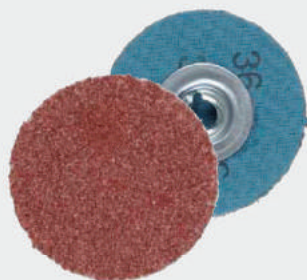
★★☆

Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33530250600458	PSG 025	ZK 60	25	38,000	GTG 025	100
A33530250800458	PSG 025	ZK 80	25	38,000	GTG 025	100
A33530380600458	PSG 038	ZK 60	38	25,000	GTG 038	100
A33530380800458	PSG 038	ZK 80	38	25,000	GTG 038	100
A33530500360458	PSG 050	ZK 36	51	25,000	GTG 038 and GTG 050	100
A33530500600458	PSG 050	ZK 60	51	25,000	GTG 038 and GTG 050	100
A33530500800458	PSG 050	ZK 80	51	25,000	GTG 038 and GTG 050	100
A33530750360458	PSG 075	ZK 36	76	20,000	GTG 075	50
A33530750600458	PSG 075	ZK 60	76	20,000	GTG 075	50

Recommended for: ● Inox/Stel ● Steel ● Cast material ● Titanium



## PSG self-clamping regular aluminium oxide abrasive disc



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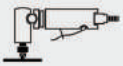
- for universal grinding and deburring work
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on page 223.

Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33510200600458	PSG 020	NK 60	19	47,000	GTG 020	100
A33510200800458	PSG 020	NK 80	19	47,000	GTG 020	100
A33510201200458	PSG 020	NK 120	19	47,000	GTG 020	100
A33510250360458	PSG 025	NK 36	25	38,000	GTG 025	100
A33510250600458	PSG 025	NK 60	25	38,000	GTG 025	100
A33510250800458	PSG 025	NK 80	25	38,000	GTG 025	100
A33510251200458	PSG 025	NK 120	25	38,000	GTG 025	100
A33510380360458	PSG 038	NK 36	38	25,000	GTG 038	100
A33510380600458	PSG 038	NK 60	38	25,000	GTG 038	100
A33510380800458	PSG 038	NK 80	38	25,000	GTG 038	100
A33510381200458	PSG 038	NK 120	38	25,000	GTG 038	100
A33510500360458	PSG 050	NK 36	51	25,000	GTG 038 and GTG 050	100
A33510500500458	PSG 050	NK 50	51	25,000	GTG 038 and GTG 050	100
A33510500600458	PSG 050	NK 60	51	25,000	GTG 038 and GTG 050	100
A33510500800458	PSG 050	NK 80	51	25,000	GTG 038 and GTG 050	100
A33510501200458	PSG 050	NK 120	51	25,000	GTG 038 and GTG 050	100
A33510501800458	PSG 050	NK 180	51	25,000	GTG 038 and GTG 050	100
A33510502400458	PSG 050	NK 240	51	25,000	GTG 038 and GTG 050	100
A33510750600458	PSG 075	NK 60	76	20,000	GTG 075	50
A33510750800458	PSG 075	NK 80	76	20,000	GTG 075	50
A33510751200458	PSG 075	NK 120	76	20,000	GTG 075	50

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

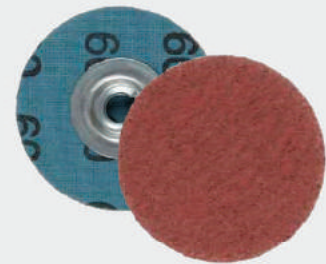
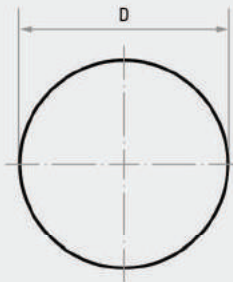
# CAN ALSO HANDLE EDGES

THANKS TO THE REINFORCED BACKING MATERIAL  
ALSO SUITABLE FOR THE TOUGHEST APPLICATIONS



## PSG reinforced self-clamping regular aluminium oxide abrasive disc

- made of abrasive cloth with regular aluminium oxide and reinforced backing material
- The reinforcement makes these discs suitable for the toughest applications and beveling.
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on page 223.

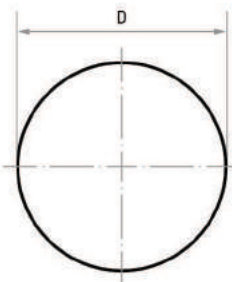
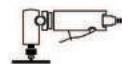


★★☆

Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33520250600458	PSG 025	NKE 60	25	38,000	GTG 025	100
A33520250800458	PSG 025	NKE 80	25	38,000	GTG 025	100
A33520251200458	PSG 025	NKE 120	25	38,000	GTG 025	100
A33520251800458	PSG 025	NKE 180	25	38,000	GTG 025	100
A33520252400458	PSG 025	NKE 240	25	38,000	GTG 025	100
A33520380600458	PSG 038	NKE 60	38	25,000	GTG 038	100
A33520380800458	PSG 038	NKE 80	38	25,000	GTG 038	100
A33520381200458	PSG 038	NKE 120	38	25,000	GTG 038	100
A33520500360458	PSG 050	NKE 36	51	25,000	GTG 038 and GTG 050	100
A33520500600458	PSG 050	NKE 60	51	25,000	GTG 038 and GTG 050	100
A33520500800458	PSG 050	NKE 80	51	25,000	GTG 038 and GTG 050	100
A33520501200458	PSG 050	NKE 120	51	25,000	GTG 038 and GTG 050	100
A33520501800458	PSG 050	NKE 180	51	25,000	GTG 038 and GTG 050	100
A33520502400458	PSG 050	NKE 240	51	25,000	GTG 038 and GTG 050	100
A33520750800458	PSG 075	NKE 80	76	20,000	GTG 075	50

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

## PSG self-clamping abrasive disc, abrasive fleece



- ideal for removing rust or paint, scratches and pre-grinding marks
- Improvement of surface quality
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on page 223.



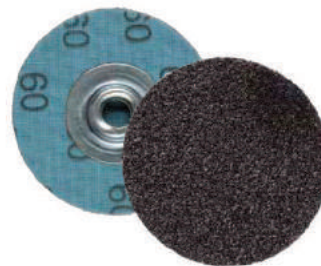
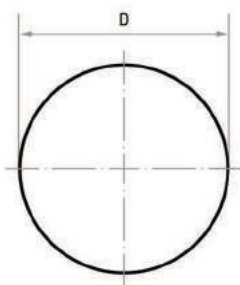
	Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
<b>NEW</b>	A33740250040458	PSG 025	P coarse	25	15,000	GTG 025	50
<b>NEW</b>	A33740250020458	PSG 025	P medium	25	15,000	GTG 025	50
	A33740380050458	PSG 038	P fine	38	10,000	GTG 038	50
	A33740380040458	PSG 038	P coarse	38	10,000	GTG 038	50
	A33740380020458	PSG 038	P medium	38	10,000	GTG 038	50
	A33740500050458	PSG 050	P fine	50	7,500	GTG 038 and GTG 050	50
	A33740500040458	PSG 050	P coarse	50	7,500	GTG 038 and GTG 050	50
	A33740500020458	PSG 050	P medium	50	7,500	GTG 038 and GTG 050	50
	A33740750050458	PSG 075	P fine	75	5,000	GTG 075	25
	A33740750040458	PSG 075	P coarse	75	5,000	GTG 075	25
	A33740750020458	PSG 075	P medium	75	5,000	GTG 075	25
<b>NEW</b>	A33550380040458	PSG 038	V coarse	38	10,000	GTG 038	50
<b>NEW</b>	A33550380020458	PSG 038	V medium	38	10,000	GTG 038	50
<b>NEW</b>	A33550380050458	PSG 038	V fine	38	10,000	GTG 038	50
<b>NEW</b>	A33550500040458	PSG 050	V coarse	50	8,000	GTG 038 and GTG 050	50
<b>NEW</b>	A33550500020458	PSG 050	V medium	50	8,000	GTG 038 and GTG 050	50
<b>NEW</b>	A33550500050458	PSG 050	V fine	50	8,000	GTG 038 and GTG 050	50

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



## PSG self-clamping silicon carbide abrasive disc

- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminium (aerospace industry), as well as plastics and ceramics
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found at the bottom of this page.



★★☆

Product number	Description	Quality / grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33780380360458	PSG 038	SIC 36	38	25,000	GTG 038	100
A33780380600458	PSG 038	SIC 60	38	25,000	GTG 038	100
A33780380800458	PSG 038	SIC 80	38	25,000	GTG 038	100
A33780500600458	PSG 050	SIC 60	51	25,000	GTG 038 and GTG 050	100
A33780500800458	PSG 050	SIC 80	51	25,000	GTG 038 and GTG 050	100
A33780501200458	PSG 050	SIC 120	51	25,000	GTG 038 and GTG 050	100

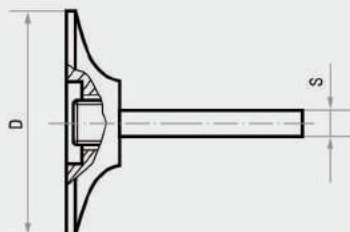
Recommended for: ● Aluminium ● Plastic / Wood ● Titanium ● Inox / Steel ● Steel ● Cast material

GRINDING AND POLISHING (with flexible tools)



## GTG abrasive disc carrier for self-clamping abrasive discs

The carriers are supplied in a universally-used medium hardness. This medium type is suitable for almost every application. Please use the hard type for the toughest machining jobs (Z-Power and Ceramic).



★★☆


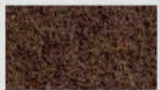


Product number	Description	Type	D mm	S mm	n <sub>max</sub> rpm	Pack contains
A335002000260458	GTG 020.06	medium	18	6	47,000	1
A335002500260458	GTG 025.06	medium	23	6	38,000	1
A335003800260458	GTG 038.06	medium	33	6	30,000	1
A335005000260458	GTG 050.06	medium	45	6	25,000	1
A335005000360458	GTG 050.06	hard	45	6	25,000	1
A335007500260458	GTG 075.06	medium	70	6	20,000	1
A335007500360458	GTG 075.06	hard	70	6	20,000	1

## PSR ABRASIVE DISCS

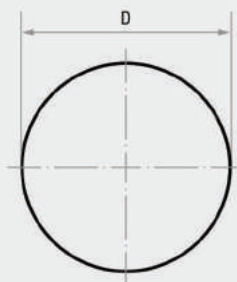
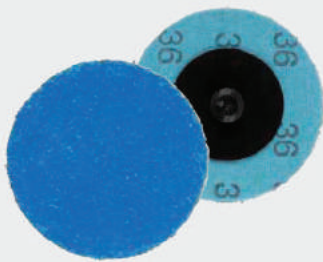
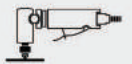
## Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a

very wide selection. You will find all abrasive discs from the PSR range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality	Properties	Application areas/machining	Page
 <b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	ideal for Hastelloy, Inconel, stainless steel and metals that are difficult to machine	224
 Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect with the fibre structure, consistent results due to continuous exposure of new grinding particles; long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of surface quality	225
 Abrasive fleece Regular aluminium oxide medium/red-brown			
 Abrasive fleece Regular aluminium oxide fine/blue			

## PSR self-clamping zirconia alumina abrasive disc



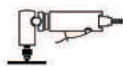
- made from abrasive cloth with zirconia alumina
- ideal for Hastelloy, Inconel, stainless steel and metals that are to machine
- with a plastic thread – fastened to the respective carrier by a small twist
- ▶ The matching tool carrier can be found on **page 227**.

★★☆

Product number	Description	Quality/grit size	D mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33630500360458	PSR 050	ZK 36	51	25,000	GTR 038 and GTR 050	100
A33630500600458	PSR 050	ZK 60	51	25,000	GTR 038 and GTR 050	100
A33630500800458	PSR 050	ZK 80	51	25,000	GTR 038 and GTR 050	100
<b>NEW</b> A33630501200458	PSR 050	ZK 120	51	25,000	GTR 038 and GTR 050	100
A33630750360458	PSR 075	ZK 36	76	20,000	GTR 075	50
A33630750600458	PSR 075	ZK 60	76	20,000	GTR 075	50
A33630750800458	PSR 075	ZK 80	76	20,000	GTR 075	50

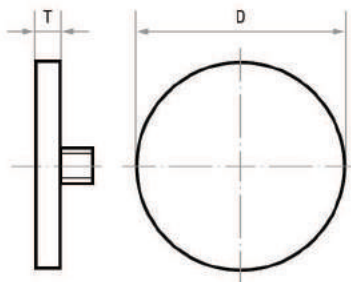
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium





## PSR self-clamping abrasive disc, narrow abrasive fleece

- ideal for removing rust or paint, scratches and pre-grinding marks
- P version with narrow abrasive fleece
- Improvement of surface quality
- with a plastic thread – fastened to the respective carrier by a small twist
- ▶ The matching tool carrier can be found on [page 227](#).



★★☆☆

Product number	Description	Quality/grit size	D mm	T mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33750380020458	PSR 038	P medium	38	6	10,000	GTR 038	50
A33750380050458	PSR 038	P fine	38	6	10,000	GTR 038	50
A33750500040458	PSR 050	P coarse	51	6	7,500	GTR 038 and GTR 050	50
A33750500020458	PSR 050	P medium	51	6	7,500	GTR 038 and GTR 050	50
A33750500050458	PSR 050	P fine	51	6	7,500	GTR 038 and GTR 050	50
A33750750040458	PSR 075	P coarse	76	6	5,000	GTR 038, GTR 050 and GTR 075	25
A33750750050458	PSR 075	P fine	76	6	5,000	GTR 038, GTR 050 and GTR 075	25
A33750750020458	PSR 075	P medium	76	6	5,000	GTR 038, GTR 050 and GTR 075	25

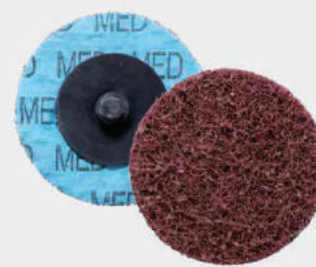
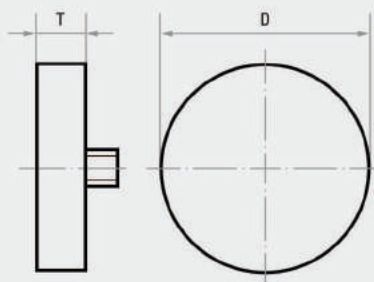
Recommended for: ● Inox/Steel ● Steel ● Plastic/Wood ● Aluminium ● Cast material ● Titanium



## PSR self-clamping abrasive disc, wide abrasive fleece

NEW

- ideal for removing rust or paint, scratches and pre-grinding marks
- V version with wider and softer abrasive fleece
- Improvement of surface quality
- with a plastic thread – fastened to the respective carrier by a small twist
- ▶ The matching tool carrier can be found on [page 227](#).

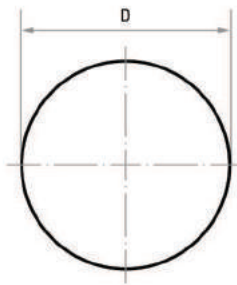
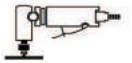


★★☆☆

Product number	Description	Quality/grit size	D mm	T mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A33760500040458	PSR 050	V coarse	51	12	8,000	GTR 038 and GTR 050	50
A33760500020458	PSR 050	V medium	51	10	8,000	GTR 038 and GTR 050	50
A33760500050458	PSR 050	V fine	51	8	8,000	GTR 038 and GTR 050	50

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

## SLTG self-clamping lamellar flap disc

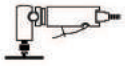


- excellent machining performance
- good grip even at low contact pressure
- long tool life (compared to surface grinding discs)
- Flap projection
- elastic
- perfectly suitable for use with robots
- with a plastic thread – fastened to the respective carrier by a small twist

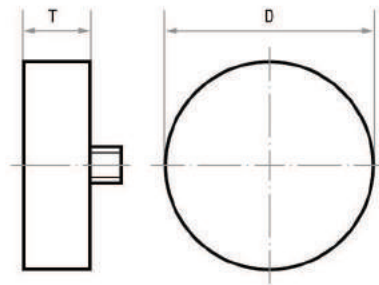


Product number	Description	Grit	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33310500401623	SLTG 050 R	ZK 40	50	19,000	GTR 038.06	10
A33310500601623	SLTG 050 R	ZK 60	50	19,000	GTR 038.06	10
A33310500801623	SLTG 050 R	ZK 80	50	19,000	GTR 038.06	10
A33310501201623	SLTG 050 R	ZK 120	50	19,000	GTR 038.06	10
A33310650401623	SLTG 065 R	ZK 40	65	14,700	GTR 050.06	10
A33310650601623	SLTG 065 R	ZK 60	65	14,700	GTR 050.06	10
A33310650801623	SLTG 065 R	ZK 80	65	14,700	GTR 050.06	10
A33310750401623	SLTG 075 R	ZK 40	75	12,700	GTR 050.06	10
A33310750601623	SLTG 075 R	ZK 60	75	12,700	GTR 050.06	10
A33310750801623	SLTG 075 R	ZK 80	75	12,700	GTR 050.06	10
A33310751201623	SLTG 075 R	ZK 120	75	12,700	GTR 050.06	10

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

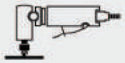

**ASVR self-clamping flap disc** NEW

- the all-rounder for removing paint, adhesive residue and rust, as well as cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long tool life, high stock removal performance and fast operation
- with a plastic thread – fastened to the respective carrier by a small twist

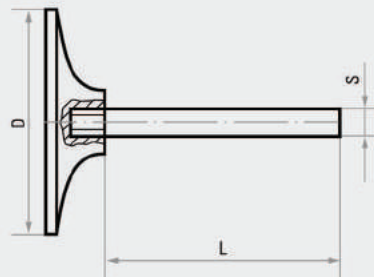


★★☆☆

Product number	Description	D mm	T mm	$n_{max}$ rpm	Matching abrasive disc carrier	Pack contains
A2291050002	ASVR 050	51	16	10,500	GTR 050.06	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material <span style="color: black;">●</span> Titanium						


**GTR abrasive disc carrier for self-clamping abrasive discs and flap discs**

The carriers are supplied in a universally-used medium hardness. This medium type is suitable for almost every application.



★★☆☆

Product number	Description	Type	D mm	L mm	S mm	$n_{max}$ rpm	Pack contains
A336003800260458	GTR 038.06	medium	33	40	6	30,000	1
A336005000260458	GTR 050.06	medium	45	40	6	25,000	1
A336007500260458	GTR 075.06	medium	70	40	6	20,000	1

## PSK ABRASIVE DISCS

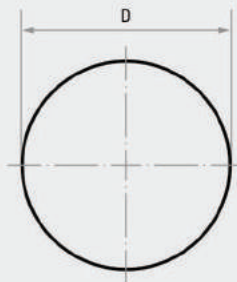
## Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

You will find all abrasive discs from the PSK range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality	Properties	Application areas / machining	Page
 <b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	229
 <b>SIC</b> Abrasive cloth Silicon carbide	minimum heat accumulation, special quality for the aviation industry	Ideal for machining titanium, titanium alloys and aluminium (aerospace industry). Plastics and ceramics can also be processed.	228

## PSK adhesive silicon carbide abrasive disc

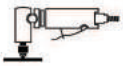


- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminium (aviation industry), as well as plastics and ceramic
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- ▶ The matching tool carrier can be found on **page 230**.

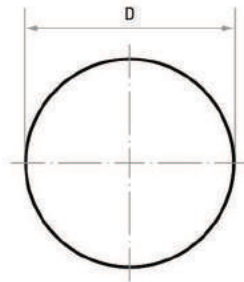
★★☆

Product number	Description	Grit	D mm	Pack contains
A2305018080	PSK 018	SIC 80	21	100
A2305018120	PSK 018	SIC 120	21	100
A2305030080	PSK 030	SIC 80	33	100
A2305030120	PSK 030	SIC 120	33	100
A2305045120	PSK 045	SIC 120	48	100

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



## PSK adhesive regular aluminium oxide abrasive disc



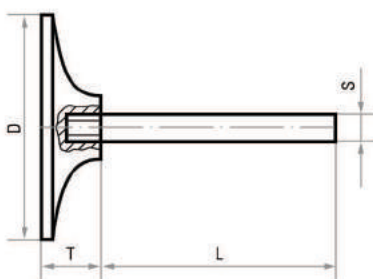
- for universal grinding and deburring
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- ▶ The matching tool carrier can be found on [page 230](#).



Product number	Description	Grit	D mm	Pack contains
A2300018060	PSK 018	NK 60	21	100
A2300018080	PSK 018	NK 80	21	100
A2300018120	PSK 018	NK 120	21	100
A2300018150	PSK 018	NK 150	21	100
A2300018180	PSK 018	NK 180	21	100
A2300018240	PSK 018	NK 240	21	100
A2300030060	PSK 030	NK 60	33	100
A2300030080	PSK 030	NK 80	33	100
A2300030120	PSK 030	NK 120	33	100
A2300030150	PSK 030	NK 150	33	100
A2300030180	PSK 030	NK 180	33	100
A2300030240	PSK 030	NK 240	33	100
A2300045060	PSK 045	NK 60	48	100
A2300045080	PSK 045	NK 80	48	100
A2300045120	PSK 045	NK 120	48	100
A2300045150	PSK 045	NK 150	48	100
A2300045180	PSK 045	NK 180	48	100
A2300045240	PSK 045	NK 240	48	100
A2300060060	PSK 060	NK 60	63	100
A2300060080	PSK 060	NK 80	63	100
A2300060120	PSK 060	NK 120	63	100
A2300060150	PSK 060	NK 150	63	100
A2300075060	PSK 075	NK 60	78	100
A2300075080	PSK 075	NK 80	78	100
A2300075120	PSK 075	NK 120	78	100
A2300075150	PSK 075	NK 150	78	100

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

## GTK abrasive disc carrier for adhesive abrasive discs



The specified maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths.







Product number	Description	D mm	S mm	T mm	L mm	$n_{max}$ rpm	Pack contains
A250301830001	GTK 018.03	18	3	11	30	20,000	5
A250303030001	GTK 030.03	30	3	12	30	12,500	5
A250303060001	GTK 030.06	30	6	12	40	12,500	5
A250304560001	GTK 045.06	45	6	11	40	10,000	5
A250306060001	GTK 060.06	60	6	13	40	8,000	5
A250307560001	GTK 075.06	75	6	15	40	6,000	2

PSH ABRASIVE DISCS

# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a

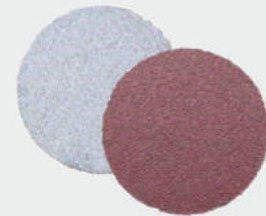
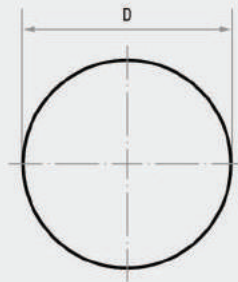
very wide selection. You will find all abrasive discs from the PSH range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality		Properties	Application areas/machining	Page
	<b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	231–233
	Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect due to fibre structure, consistent results thanks to continuous exposure of new grinding particles, long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of the surface finish	234
	Abrasive fleece Regular aluminium oxide medium/red-brown			
	Abrasive fleece Regular aluminium oxide fine/green			

GRINDING AND POLISHING  
(with flexible tools)



## PSH self-fixing regular aluminium oxide abrasive disc



- suitable for the universal machining of both flat and concave surfaces
- with Velcro material for fast tool changes
- ▶ The matching tool carrier can be found on [page 332](#).



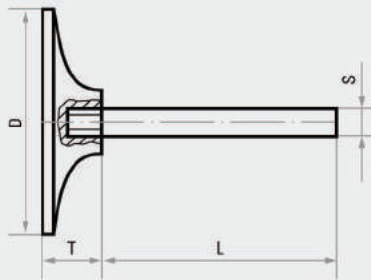
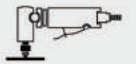
Product number	Description	Grit	D mm	Pack contains
A3300018060	PSH 018	NK 60	20	100
A3300018080	PSH 018	NK 80	20	100
A3300018120	PSH 018	NK 120	20	100
A3300018150	PSH 018	NK 150	20	100
A3300018180	PSH 018	NK 180	20	100
A3300018240	PSH 018	NK 240	20	100
A3300018320	PSH 018	NK 320	20	100
A3300030060	PSH 030	NK 60	33	100
A3300030080	PSH 030	NK 80	33	100
A3300030120	PSH 030	NK 120	33	100
A3300030150	PSH 030	NK 150	33	100
A3300030180	PSH 030	NK 180	33	100
A3300030240	PSH 030	NK 240	33	100

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

Product number	Description	Grit	D mm	Pack contains
A3300030320	PSH 030	NK 320	33	100
A3300045060	PSH 045	NK 60	48	100
A3300045080	PSH 045	NK 80	48	100
A3300045120	PSH 045	NK 120	48	100
A3300045150	PSH 045	NK 150	48	100
A3300045180	PSH 045	NK 180	48	100
A3300045240	PSH 045	NK 240	48	100
A3300060060	PSH 060	NK 60	63	100
A3300060080	PSH 060	NK 80	63	100
A3300060120	PSH 060	NK 120	63	100
A3300060150	PSH 060	NK 150	63	100
A3300060180	PSH 060	NK 180	63	100
A3300060240	PSH 060	NK 240	63	100
A3300060320	PSH 060	NK 320	63	100
A3300075060	PSH 075	NK 60	78	100
A3300075080	PSH 075	NK 80	78	100
A3300075120	PSH 075	NK 120	78	100
A3300075150	PSH 075	NK 150	78	100
A3300075180	PSH 075	NK 180	78	100
A3300075240	PSH 075	NK 240	78	100
A3300075320	PSH 075	NK 320	78	100
A3300120060	PSH 125	NK 60	125	100
A3300120080	PSH 125	NK 80	125	100

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

## GTH abrasive disc carrier for self-fixing abrasive discs



The GTH abrasive disc carriers with diameters of 18 and 30 mm have Inox hooks. Hooks with a diameter of 45 mm and greater are made of polyamide.

The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths.

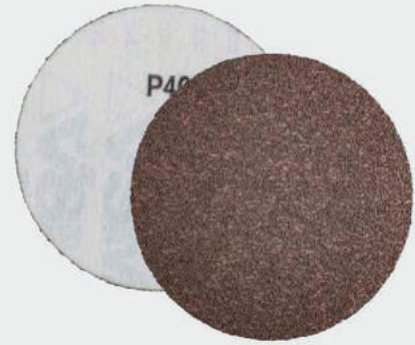
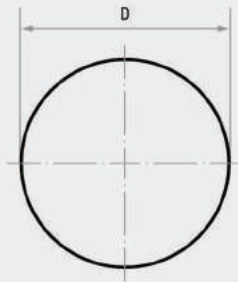


Product number	Description	D mm	S mm	T mm	L mm	$n_{max}$ rpm	Pack contains
A250401830001	GTH 018.03	18	3	11	30	20,000	5
A250403030001	GTH 030.03	30	3	12	30	12,500	5
A250403060001	GTH 030.06	30	6	12	40	12,500	5
A250404560001	GTH 045.06	45	6	11	40	10,000	5
A250406060001	GTH 060.06	60	6	13	40	8,000	5
A250407560001	GTH 075.06	75	6	15	40	6,000	2
A25041206	GTH 120.06	120	6	20	25	4,000	2





## PSH self-fixing compact grain abrasive disc NEW



- With high grain density on cutting edges thanks to compact grain: guarantees extremely high stock removal performance
- does not clog even with soft or smearing materials
- with Velcro material for fast tool changes

★★☆

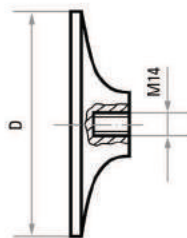
Product number	Description	Grit	D mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A73001150800001	PSH 115	NK 80	115	4,800	8,000	50
A73001151200004	PSH 115	NK 120	115	4,800	8,000	50
A73001152400005	PSH 115	NK 240	115	4,800	8,000	50
A73001154000005	PSH 115	NK 400	115	4,800	8,000	50
A73001158000005	PSH 115	NK 800	115	4,800	8,000	50
A73001151210005	PSH 115	NK 1200	115	4,800	8,000	50
A73001250800005	PSH 125	NK 80	125	4,600	7,650	50
A73001251200005	PSH 125	NK 120	125	4,600	7,650	50
A73001252400005	PSH 125	NK 240	125	4,600	7,650	50
A73001254000005	PSH 125	NK 400	125	4,600	7,650	50
A73001258000005	PSH 125	NK 800	125	4,600	7,650	50
A73001251210005	PSH 125	NK 1200	125	4,600	7,650	50
A73001500800005	PSH 150	NK 80	150	3,800	6,350	50
A73001501200006	PSH 150	NK 120	150	3,800	6,350	50
A73001502400005	PSH 150	NK 240	150	3,800	6,350	50
A73001504000005	PSH 150	NK 400	150	3,800	6,350	50
A73001508000005	PSH 150	NK 800	150	3,800	6,350	50
A73001501210005	PSH 150	NK 1200	150	3,800	6,350	50

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

GRINDING AND POLISHING (with flexible tools)



## GTHX abrasive disc carrier for self-fixing abrasive discs with thread NEW



★★☆

Product number	Description	Quality	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151004	GTHX 115	medium for Velcro discs	115	M14	8,300	1
A38311251004	GTHX 125	medium for Velcro discs	125	M14	7,600	1
A38311501004	GTHX 150	medium for Velcro discs	150	M14	6,300	1

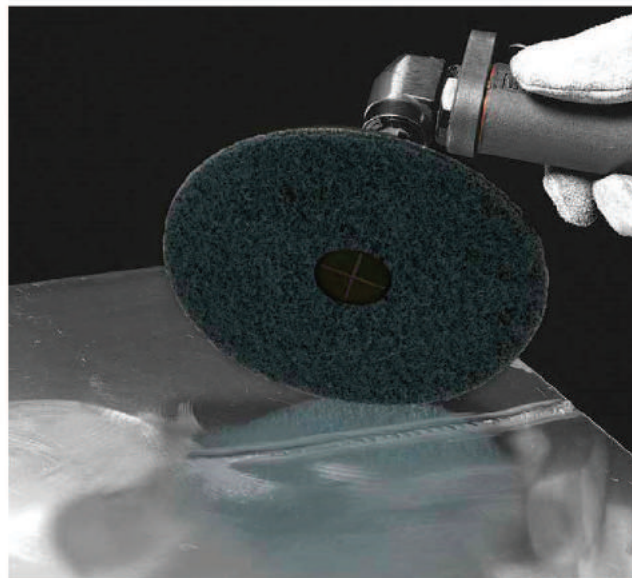
# SELF-FIXING ABRASIVE FLEECE DISCS

ATTACHMENT MADE EASY THANKS TO THE FIXING SYSTEM

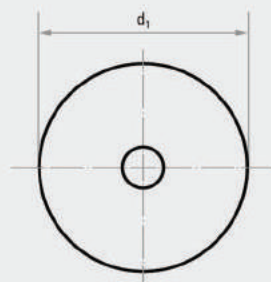
LUKAS PSH abrasive discs made of abrasive fleece are suitable for machining both flat and concave surfaces. Whether for removing rust or paint, scratches or pre-grinding marks, the polyamide material allows these discs to adapt themselves perfectly to uneven surfaces. You need less effort and time for your work, and yet still achieve perfect surface results. The fibre structure of the discs also produces a polishing effect and enables consistent results due to the constant exposure of new abrasive particles.

## SECURE AND FAST

In addition, time-consuming tool changes are also a thing of the past because these abrasive discs are self-fixing. The respective disc carrier uses a Velcro backing quick change system, which keeps the tool firmly in position. This eliminates needless waste of packaging material unlike other self-adhesive discs, for example. Abrasive discs that have not been completely worn down during machining can be removed and reused another time.



## NEW PSH self-fixing abrasive disc, abrasive fleece



- suitable for machining both flat and concave surfaces
- adapts itself to uneven surfaces
- self-fixing to the respective carrier for a quick tool change
- ▶ The matching tool carrier can be found on **page 235**.

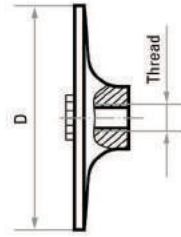
★★☆

Product number	Description	Quality	D mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A3380115102001	PSH 115	Fleece coarse	115	4,100	8,300	10
A3380115104001	PSH 115	Fleece medium	115	4,100	8,300	10
A3380115107001	PSH 115	Fleece very fine	115	4,100	8,300	10
A3380125102001	PSH 125	Fleece coarse	125	3,800	7,600	10
A3380125104001	PSH 125	Fleece medium	125	3,800	7,600	10
A3380125107001	PSH 125	Fleece very fine	125	3,800	7,600	10

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



## GTH abrasive disc carrier for abrasive fleece with centering pin NEW



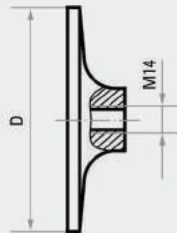
► especially for PSH with centering pin on page 234



Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A25041151402	GTHZ 115	115	M14	8,300	1
A25041251402	GTHZ 125	125	M14	7,600	1

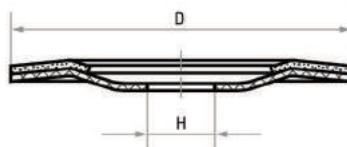


## GTH abrasive disc carrier for abrasive fleece



Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151003	GTH 115	115	M14	8,300	1
A38311251003	GTH 125	125	M14	7,600	1

## SHF semi-flexible grinding disc



- consists of a stable fibre backing with a structured abrasive coating of silicon carbide
- for removing paint, rust and adhesives, but also for machining fibre-reinforced plastics such as CFRP and GFRP (e.g. for wind turbine blades)
- also very suitable for animal hooves
- may only be used with backing pads
- ▶ The matching tool carriers can be found on [page 241](#).



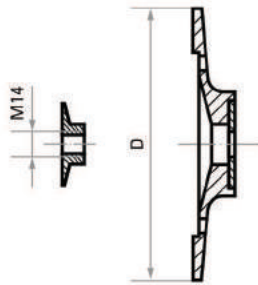
Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A38351150164	SHF 115	SIC 16	115	22.23	13,300	25
A38351150244	SHF 115	SIC 24	115	22.23	13,300	25
A38351150364	SHF 115	SIC 36	115	22.23	13,300	25
A38351150604	SHF 115	SIC 60	115	22.23	13,300	25
A38351250244	SHF 125	SIC 24	125	22.23	12,200	25
A38351250364	SHF 125	SIC 36	125	22.23	12,200	25

Recommended for: ● Steel ● Aluminium ● Stone/Construction material ● Cast material ● Plastic/Wood



## STF HL fibre disc backing pad with cooling slots

The carriers are supplied in a universally applicable degree of hardness; our medium type is suitable for almost every application. Other types are available on request for roughing work or radius grinding. Cooling slots and ventilation holes increase the stock removal rate and tool life.



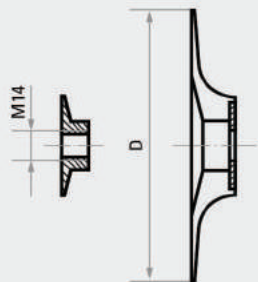
★★★

Product number	Description	D mm	Thread	$n_{max}$ rpm	Pack contains
A38311151002	STF HL	113	M14	13,300	1
A38311251002	STF HL	123	M14	12,200	1
A38311501002	STF HL	148	M14	10,200	1
A38311801002	STF HL	175	M14	8,500	1



## STF fibre disc backing pad

The carriers are supplied in a universally applicable degree of hardness; our medium type is suitable for almost every application. Other types are available on request for roughing work or radius grinding.



★★☆

■ nuts included

Product number	Description	D mm	Thread	$n_{max}$ rpm	Pack contains
A38311151001	STF 115	113	M14	13,300	1
A38311251001	STF 125	123	M14	12,200	1
A38311501001	STF 150	148	M14	10,200	1
A38311701001	STF 180	175	M14	8,500	1