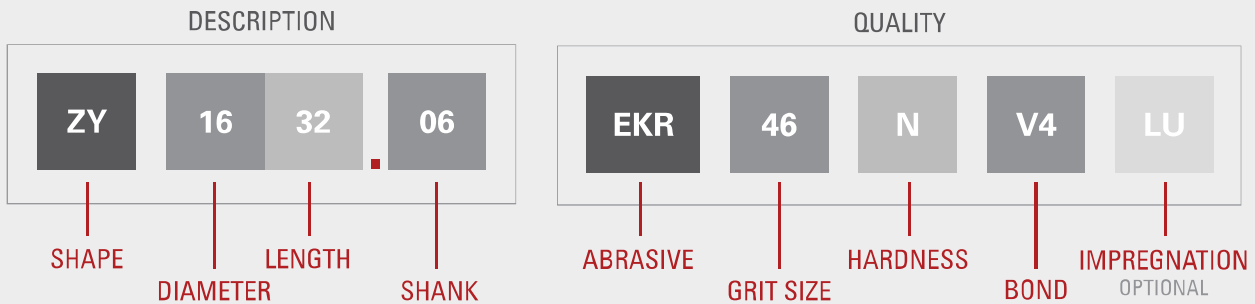


DESIGNATION OF MOUNTED POINTS

All the important information in the product designation

LUKAS bonded grinding and polishing tools have all the important values and identifiers in the product designation, making it easy for you to find the right one for your requirements.

The overview below shows the individual elements and their content.



46

GRIT SIZES AS PER ISO 525

From coarse to very fine, the numerical grit size value is clearly displayed in the quality designation.

| coarse | medium | fine | very fine |
|--------|--------|------|-----------|
| 4 | 30 | 70 | 230 |
| 5 | 36 | 80 | 240 |
| 6 | 46 | 90 | 280 |
| 7 | 54 | 100 | 320 |
| 8 | 60 | 120 | 360 |
| 10 | – | 150 | 400 |
| 12 | – | 180 | 500 |
| 14 | – | 220 | 800 |
| 16 | – | – | 1.200 |
| 20 | – | – | 2.000 |
| 24 | – | – | – |

N

HARDNESS AS PER ISO 525

The hardness indicates the strength holding the abrasive grain bonded to the grinding wheel. It is determined using special measuring tools. Letters are used to indicate the hardness grade. The hardness increases with alphabetical order.

| extreme soft | very soft | soft | medium | hard | very hard | extreme hard |
|--------------|-----------|------|--------|------|-----------|--------------|
| A | E | H | L | P | T | X |
| B | F | I | M | Q | U | Y |
| C | G | Jot | N | R | V | Z |
| D | – | K | O | S | W | – |

V4

BOND

The bond holds the abrasive grain to the grinding wheel. The most important bond types as per ISO 525 are:

Vitrified bond:

- **V** = vitrified bond

The code following the bond identifier is a factory-internal designation.

Organic bond:

- **BA** = resin bond
- **R** = rubber bond or bond using other elastomers
- **RF** = rubber bond, reinforced

LU

IMPREGNATION (OPTIONAL)

Impregnation can improve the grinding properties of all vitrified bonds, especially for processing certain steels:

- **Lu** = with resin
- **W** = with wax