

TECHNICAL INFORMATION AND PRODUCT INFORMATION

Mounted points from LUKAS

EFFICIENT AND PROFESSIONAL GRINDING

LUKAS mounted points are premium grinding tools with a long tool life that deliver high removal performance. They are perfect for efficient and effective rough processing, fettling, preparing and reworking weld seams, and for deburring.

From cutting to fine machining, we offer a range of mounted points in various shapes, sizes and finishes so that you always have the right grinding tool for the job. LUKAS mounted points are designed for grinding all kinds of material (steel, cast steel, tool steel, cast iron, aluminium alloys, titanium and nickel alloys, plastic, glass, ceramic and many more).

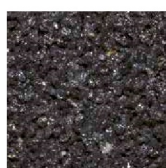
QUALITY

Grinding covers a broad spectrum of processes, from rough cutting to fine machining. This requires mounted points that deliver the right balance of machining performance and tool life, while achieving the desired surface quality. Manufacturing quality mounted points involves knowing the conditions in which the tools will be used, selecting the raw materials and understanding how to combine them in the right specification.

EKR

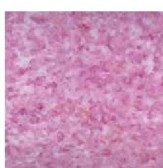
ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with. The following overview contains all raw materials for LUKAS mounted points. The abbreviations for the respective abrasives can be found in the quality designation of the LUKAS tools (see right).



NK
Regular
aluminium oxide

★★☆



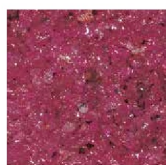
EKR
Pink aluminium oxide

★★☆



EKW
White aluminium oxide

★★☆



EKD
Dark red
aluminium oxide

★★☆



EKbr
Pink aluminium oxide,
type brown

★★☆



MK
Mixture EKR/NK

★★☆



HK
Mixture EKW/NK

★★☆



HKD
Mixture EKW/EKD

★★☆



MKD
Mixture NK/EKD

★★☆



RKD
Mixture of dark red and
pink aluminium oxide

★★☆



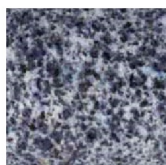
SIC-ALU
Green silicon carbide

★★★



SICdkl
Dark silicon carbide

★★☆



NDW
Mixture of regular
aluminium oxide, dark
red aluminium oxide
and white monocrystal
aluminium oxide

★★★



CERAMIC
Ceramic grain
and monocrystal
aluminium oxide

★★★



HOK
Mixture of spherical al-
uminium oxide

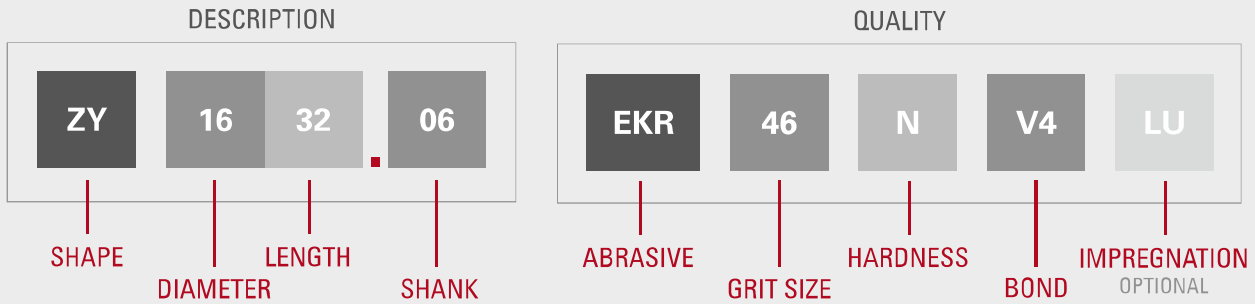
★★☆

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












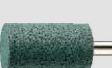

TECHNICAL INFORMATION

Qualities and areas of application

We have created a range of different shapes and dimensions in proven qualities from the full spectrum of possibilities described here. These mounted points are available from stock.

Quality recommendations apply for ideal operating conditions.

 best suitable  suitable

Page	Image	Reference/ Qualities	Cutting speed v_c m/s	Materials											
				Steel/ cast steel	Alloyed/ tempered steels	Tool steels	Rust-, acid- and heat-resistant steel and cast steel	Cast iron	Aluminium, magnesium and copper alloys	Titanium and nickel alloys	Plastic/ wood/ rubber	Glass/ ceramic/ carbides			
78-81		EKR Pink aluminium oxide	approx. 20-35												
82		EKWbr White aluminium oxide type brown	approx. 25-40												
83/84		RKD Dark red and pink aluminium oxide	approx. 30-50												
84		NK-BA soft Regular aluminium oxide iron- and sulphur-free	approx. 40-50												
87		NK-BA hard Regular aluminium oxide	approx. 40-50												
88		HK White aluminium oxide and regular aluminium oxide	approx. 40-50												
89		MK Pink aluminium oxide and regular aluminium oxide	approx. 30-50												
74		NDW Dark red aluminium oxide, regular and monocrystal aluminium oxide	approx. 10-30												
73		Ceramic Ceramic grain and monocrystal aluminium oxide	approx. 30-50												
75		EKW White aluminium oxide	approx. 20-35												
75		EKbr Pink aluminium oxide, type brown	approx. 40-50												
77		SIC-ALU Green silicon carbide	approx. 25-40												
90		HOK Spherical aluminium oxide	approx. 5-20												

GRINDING AND POLISHING (with bonded tools)

TECHNICAL INFORMATION

Speeds for grinding tools



		Recommended cutting speed v_c (m/s)							
		5	10	20	30	40	50	63	80
Tool diameter (mm)	2	47,700	95,500	191,000	286,500	382,000	477,500	601,600	763,900
	3	31,800	63,700	127,300	191,000	254,600	318,300	601,600	509,300
	4	23,900	47,700	95,500	143,200	191,000	238,700	300,800	382,000
	5	19,100	38,200	76,400	114,600	152,800	191,000	240,600	305,600
	6	15,900	31,800	63,700	95,500	127,300	159,200	200,500	254,600
	8	11,900	23,900	47,700	71,600	95,500	119,400	150,400	191,000
	10	9,500	19,100	38,200	57,300	76,400	95,500	120,300	152,800
	13	7,300	14,700	29,400	44,100	58,800	73,500	92,600	117,500
	20	4,800	9,500	19,100	28,600	38,200	47,700	60,200	76,400
	25	3,800	7,600	15,300	22,900	30,600	38,200	48,100	61,100
	32	3,000	6,000	11,900	17,900	23,900	29,800	37,600	47,700
	40	2,400	4,800	9,500	14,300	19,100	23,900	30,100	38,200
	50	1,900	3,800	7,600	11,500	15,300	19,100	24,100	30,600
	60	1,600	3,200	6,400	9,500	12,700	15,900	20,100	25,500
	80	1,200	2,400	4,800	7,200	9,500	11,900	15,000	19,100
	100	1,000	1,900	3,800	5,700	7,600	9,500	12,000	15,300
		Speed (rpm)							

SAFETY ADVICE

Safe grinding

PERIPHERAL SPEEDS

Our mounted points are manufactured to state-of-the-art standards, and carefully checked and tested. Their safety corresponds to EN 12413.

We produce mounted points with vitrified and resin bonds for an increased maximum peripheral speed of 50 m/s.

The maximum peripheral speed is limited by the following criteria:

1. Mass (weight) of the mounted point
2. Shape of the mounted point
3. Shank diameter
4. Shank overhang
5. Shank material
6. The concentricity of the mounted point



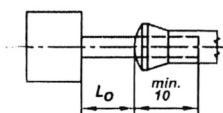

SAFETY

Safety is an essential mark of quality for any grinding tool. When using and storing mounted points, always observe the safety and accident prevention regulations, along with the FEPA safety recommendations.

Our products are delivered with a safety ticket, as shown below, which indicates the maximum permitted speed for a certain overhang length (open shank length).

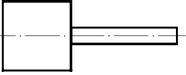
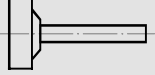
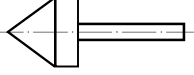
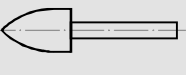
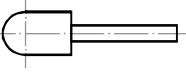
We do not use raw materials in our grinding wheels that are hazardous to health.

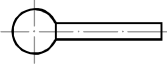
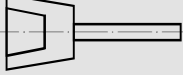
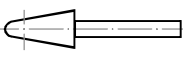
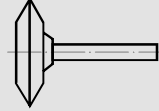
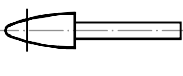
GRINDING AND POLISHING
(with bonded tools)



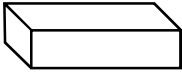
MULTILINGUAL PRODUCT DESIGNATION	Schleifkörper keramisch Brousicí tělíska keramická Mounted points - vitrified Muelas cerámicas Meules vitrifiées Sciernice spojone ceramiczne			PRODUCT LINE									
	A200002032602 ZY 2032.06 EKR 36 N V4				Menge / VPE 20		SAFETY STANDARD						
PRODUCT NUMBER AND PRODUCT SPECIFICATION	<table border="1"> <thead> <tr> <th>L_o(mm)</th> <th>max. rpm</th> </tr> </thead> <tbody> <tr> <td>10</td> <td>40.600</td> </tr> <tr> <td>15</td> <td>34.500</td> </tr> <tr> <td>20</td> <td>29.700</td> </tr> </tbody> </table>		L _o (mm)	max. rpm	10	40.600	15	34.500	20	29.700		FA1488310	SERIAL NUMBER
	L _o (mm)	max. rpm											
10	40.600												
15	34.500												
20	29.700												
TECHNICAL INFORMATION	LUKAS-ERZETT Vereinigte Schleif- und Fräswerkzeugfabriken GmbH & Co. KG Gebrüder-Lukas-Straße 1 - 51786 Engelskirchen Made in Germany			EAN CODE									

SHAPE

Summary of available shapes

Shape	
	ZY Cylindrical, type 1
	ZY2 Cylindrical, type 1
	WKS Cylindrical pointed nose
	SP Arch pointed nose
	WR Cylindrical round nose

Shape	
	KU Spherical
	TO Cup
	KE Conical round nose
	American shape A
	American shape B

Shape	
	Miniature mounted points
	SE Taper-sided grinding wheel
	RU Sharpening stones

GRINDING AND POLISHING
(with bonded tools)

POWER TOOLS

You can find the right power tools for our LUKAS tools on **pages 299–312**. Our power tools are designed for use with LUKAS tools and ensure highly efficient use.



QUALITIES AND PROPERTIES

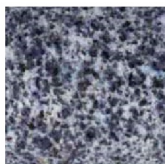
Mounted points for machining tool steels



CERAMIC

Mixture of ceramic grain and monocrystal aluminium oxide

★★★



NDW

Mixture of regular aluminium oxide, dark red aluminium oxide and white monocrystal aluminium oxide

★★★



EKbr

Pink aluminium oxide, type brown

★★☆



EKW

White aluminium oxide

★★☆

MATERIAL PROPERTIES

In the mould and die industry it is all about precision. Tool steels are produced to be hard and strong enough for their purpose. As a result, special grinding tools are required to process workpieces to the limits of their tolerances.

INDUSTRIES

- Tool construction
- Pattern construction
- Mould-making
- Aerospace engineering

PROCESSING EXAMPLES

- Re-grinding transitions
- Groove grinding
- Fine deburring
- Fine grinding
- Lap grinding
- Coordinate grinding
- Ball bearing grinding
- Turbine blades

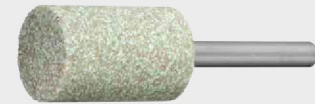
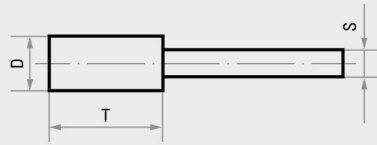
LUKAS GRINDING TOOLS

LUKAS mounted points for mould and die industry are extremely dimensionally stable and can cut even the hardest materials. Ceramic grain is extremely friable due to its microcrystal structure, making it self-sharpening. Materials that are difficult to cut (e.g. nickel-based alloys) can therefore be machined without any problems. Moreover, the use of special grain qualities ensures a long tool life. Our comprehensive product range lets you reach and process even the most inaccessible areas.



Ceramic mounted point

- maximum sharpness and hardness with ceramic self-sharpening effect
- impressive tool life
- high and fast removal rate, especially on hardened surfaces, scale, hard coatings and reinforced weld seams



★★★

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000205377	ZY 0205.03		Ceramic 80 LV118	2	5	3 x 30	20
A200000306377	ZY 0306.03		Ceramic 80 LV118	3	6	3 x 30	20
A200000408377	ZY 0408.03		Ceramic 80 LV118	4	8	3 x 30	20
A200000510377	ZY 0510.03		Ceramic 80 LV118	5	10	3 x 30	20
A200000613377	ZY 0613.03		Ceramic 80 LV118	6	13	3 x 30	20
A200001020677	ZY 1020.06		Ceramic 80 LV118	10	20	6 x 40	20
A200001325677	ZY 1325.06		Ceramic 46 LV118	13	25	6 x 40	20
A200001632677	ZY 1632.06		Ceramic 46 LV118	16	32	6 x 40	20
A200002032677	ZY 2032.06		Ceramic 46 LV118	20	32	6 x 40	20
A201301303377	ZY2 1303.03		Ceramic 80 LV118	13	3	3 x 30	20
A200200306377	SP 0306.03		Ceramic 80 LV118	3	6	3 x 30	20
A200200510377	SP 0510.03		Ceramic 80 LV118	5	10	3 x 30	20
A200200816377	SP 0816.03		Ceramic 80 LV118	8	16	3 x 30	20
A200201320677	SP 1320.06	Ceramic 80 LV118	13	20	6 x 40	20	
A201100404377	KU 0404.03		Ceramic 80 LV118	4	4	3 x 30	20
A201100606377	KU 0606.03		Ceramic 80 LV118	6	6	3 x 30	20
A201101010677	KU 1010.06		Ceramic 46 LV118	10	10	6 x 40	20
A201101313677	KU 1313.06	Ceramic 46 LV118	13	13	6 x 40	20	
A201501632677	KE 1632.06		Ceramic 46 LV118	16	32	6 x 40	20

Recommended for: ● Inox/Steel ● Steel ● Titanium

GRINDING AND POLISHING (with bonded tools)



Ceramic mounted point assortment

- maximum sharpness and hardness with ceramic self-sharpening effect
- 5 different shapes for fast tool changes, in specialist retail packaging
- impressive tool life
- high and fast removal rate, especially on hardened surfaces, scale, hard coatings and reinforced weld seams

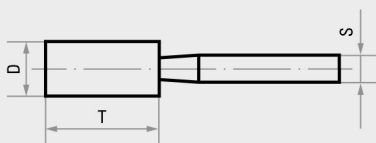


★★★

Product number	Description	Shank diameter mm	Quality	Content	Pack contains
A20480005677F1	Assortment Ceramic	6	Ceramic	5 parts: ZY 1020, ZY 1632, SP 1320, KU 1313, KE 1632	1

Recommended for: ● Inox/Steel ● Steel ● Titanium

NDW mounted point



- improved aluminium oxide mixture for hardened and unhardened tool steels
- high-quality combination of aluminium oxide types for efficiently grinding unhardened tool steels
- abrasive combination made from extremely tough and splittery grains for high removal and a good surface finish

★★★

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200000306353	ZY 0306.03		NDW 100 QU V115	3	6	3 x 50	20	
A2000003063530001	ZY 0306.03		NDW 100 QU V115	3	6	3 x 30	20	
A200000408353	ZY 0408.03		NDW 100 QU V115	4	8	3 x 50	20	
A2000004083530001	ZY 0408.03		NDW 100 QU V115	4	8	3 x 30	20	
A200000610353	ZY 0610.03			NDW 100 QU V115	6	10	3 x 50	20
A2000006103530001	ZY 0610.03			NDW 100 QU V115	6	10	3 x 30	20
A200000810353	ZY 0810.03			NDW 100 QU V115	8	10	3 x 50	20
A2000008103530001	ZY 0810.03			NDW 100 QU V115	8	10	3 x 30	20
A200001013353	ZY 1013.03			NDW 100 QU V115	10	13	3 x 50	20
A2000010133530001	ZY 1013.03			NDW 100 QU V115	10	13	3 x 30	20
A200200510353	SP 0510.03		NDW 100 QU V115	5	10	3 x 50	20	
A2002005103530001	SP 0510.03		NDW 100 QU V115	5	10	3 x 30	20	
A200200810353	SP 0810.03		NDW 100 QU V115	8	10	3 x 50	20	
A2002008103530001	SP 0810.03		NDW 100 QU V115	8	10	3 x 30	20	
A2014010133530001	WR 1013.03		NDW 100 QU V115	10	13	3 x 30	20	
A201401013353	WR 1013.03		NDW 100 QU V115	10	13	3 x 50	20	
A2011004043530001	KU 0404.03		NDW 100 QU V115	4	4	3 x 30	20	
A201100404353	KU 0404.03		NDW 100 QU V115	4	4	3 x 50	20	
A201100606353	KU 0606.03		NDW 100 QU V115	6	6	3 x 50	20	
A2011008083530001	KU 0808.03		NDW 100 QU V115	8	8	3 x 30	20	
A201100808353	KU 0808.03		NDW 100 QU V115	8	8	3 x 50	20	

Recommended for: ● Steel

GRINDING AND POLISHING (with bonded tools)

NDW mounted point assortment



- Always the right tool at hand. The practical assortment of LUKAS tools means you always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the industry, on site or in the hobby workshop
- improved aluminium oxide mixture for hardened and unhardened tool steels
- high-quality combination of aluminium oxide types for efficiently grinding unhardened tool steels

★★★

Product number	Description	Quality	Shank diameter mm	Content 1 per pack	Pack contains
A20100000353	Assortment 10	NDW	3 x 30	10 parts: ZY 0408 ZY 1013 KU 0404 WR 1013 ZY 0610 SP 0510 KU 0606 ZY 0810 SP 0810 KU 0808	1

Recommended for: ● Steel



EKbr mounted point assortment



- Always the right tool at hand. The practical assortment of LUKAS tools means you always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the industry, on site or in the hobby workshop

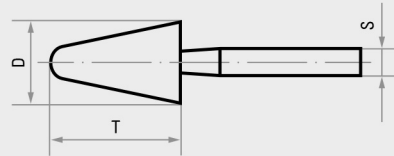
Product number	Description	Quality	Shank diameter mm	Content 1 per pack	Pack contains
A204800003611	Assortment 36	EKbr	3 x 30	36 parts: D1 D2 D3 D4 D5 D6 D7 D8 D9 D10 D11 D12 D13 D14 D15 D16 D17 D18 D19 D20 D21 D22 D23 D24 D25 D26 D27 D28 D29 D30 D31 D32 D33 D34 D35 D36	1

Recommended for: ● Steel

GRINDING AND POLISHING (with bonded tools)



EKRbr mounted point



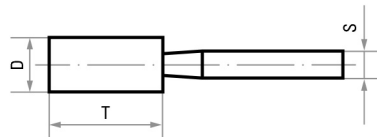
★★☆

Product number	Description	Quality	D mm	T mm	S mm	Pack contains
A201601025606	KE 1025.06	EKRbr 46/60 PV7	10	25	6 x 40	20
A201601645606	KE 1645.06	EKRbr 46/60 PV7	16	45	6 x 40	20

Recommended for: ● Steel



EKW mounted point



★★☆

Product number	Description	Quality	D mm	T mm	S mm	Pack contains
A200000610608	ZY 0610.06	EKW 80 LV1	6	10	6 x 40	20
A200000810608	ZY 0810.06	EKW 80 LV1	8	10	6 x 40	20
A200001010608	ZY 1010.06	EKW 60 LV1	10	10	6 x 40	20
A200002020608	ZY 2020.06	EKW 60 LV1	20	20	6 x 40	20

Recommended for: ● Steel ● Titanium



QUALITIES AND PROPERTIES

Mounted points for machining non-ferrous metals



SIC-ALU

Green silicon carbide

★★★

MATERIAL PROPERTIES

Aluminium and its respective alloys have many varied and positive characteristics, making it the second most widely used metal after steel.

Aluminium has only 1/3 the density of steel. The purer the metal, the weaker it becomes, but this allows for better shape forming. Using unsuitable mounted points, however, can lead to smearing and clogging.

INDUSTRIES

- Transportation (railways, ships, automotive, aerospace)
- Metal construction (bridges, cranes, silos)
- Apparatus engineering
- Aluminium die-cast
- Chemical industry (vessels, pumps, pipes)
- Engines, transmission parts
- and many more

PROCESSING EXAMPLES

- Deburring
- Fettling
- Finishing
- Surface finishing

LUKAS GRINDING TOOLS

Our SIC-ALU mounted points were developed specifically for this application. A special structure ensures maximum tool life whilst preventing material from clogging the pores. The self-sharpening effect is aided by the use of a special impregnation.

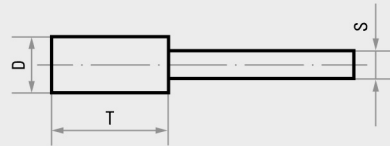
THE SPECIALIST FOR ALUMINIUM

PROCESS EVEN THE SOFTEST MATERIALS WITHOUT SMEARING OR CLOGGING

GRINDING AND POLISHING
(with bonded tools)



SIC-ALU mounted point



■ special quality for grinding aluminium

★★★

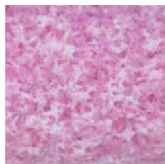
Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200000408318A	ZY 0408.03		SIC-ALU 80 V27 W	4	8	3 x 30	20	
A200000510318A	ZY 0510.03		SIC-ALU 80 V27 W	5	10	3 x 30	20	
A200000610318A	ZY 0610.03		SIC-ALU 80 V27 W	6	10	3 x 30	20	
A200000810318A	ZY 0810.03		SIC-ALU 80 V27 W	8	10	3 x 30	20	
A200001010318A	ZY 1010.03		SIC-ALU 80 V27 W	10	10	3 x 30	20	
A200001013618A	ZY 1013.06		SIC-ALU 80 V27 W	10	13	6 x 40	20	
A200001020618A	ZY 1020.06		SIC-ALU 80 V27 W	10	20	6 x 40	20	
A200001313618A	ZY 1313.06			SIC-ALU 80 V27 W	13	13	6 x 40	20
A200001332618A	ZY 1332.06			SIC-ALU 80 V27 W	13	32	6 x 40	20
A200001616618A	ZY 1616.06			SIC-ALU 80 V27 W	16	16	6 x 40	20
A200001632618A	ZY 1632.06			SIC-ALU 80 V27 W	16	32	6 x 40	20
A200002020618A	ZY 2020.06			SIC-ALU 80 V27 W	20	20	6 x 40	20
A200002025618A	ZY 2025.06			SIC-ALU 80 V27 W	20	25	6 x 40	20
A200002040618A	ZY 2040.06			SIC-ALU 80 V27 W	20	40	6 x 40	20
A200003232618A	ZY 3232.06			SIC-ALU 80 V27 W	32	32	6 x 40	20
A200004020618A	ZY 4020.06			SIC-ALU 80 V27 W	40	20	6 x 40	20
A201501632618A	KE 1632.06				SIC-ALU 80 V27 W	16	32	6 x 40
A201502040618A	KE 2040.06	SIC-ALU 80 V27 W	20		40	6 x 40	20	

Recommended for: ● Aluminium



QUALITIES AND PROPERTIES

Mounted points for machining steel and cast steel



EKR
Pink aluminium oxide

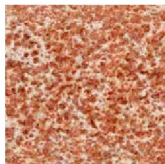
★★☆

MATERIAL PROPERTIES

The wide range of different steel types and workpieces made from them require mounted points with properties that cover this broad spectrum as much as possible.

PROCESSING EXAMPLES

- General rough grinding
- Fettling
- Rough grinding of weld seams
- Finish grinding of weld seams
- Deburring



EKWbr
White aluminium oxide, type brown

★★☆

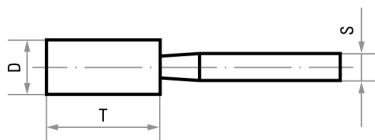
INDUSTRIES

- Mechanical engineering
- Automotive engineering
- Toolbuilding
- Vessel and equipment manufacturing
- Shipyards
- and many more

LUKAS GRINDING TOOLS

The wide selection of LUKAS grinding tools includes countless shapes, sizes and qualities. You will find the correct tool from our standard range to solve most grinding problems, irrespective of the material, type of power tool or any other influencing factors. These mounted points are designed for high stock removal and long tool life.

EKR mounted point

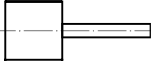
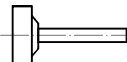


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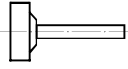
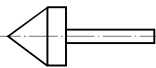
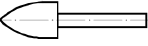
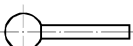
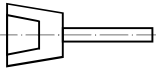
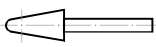
- perfect results on structural steel and for rough grinding with aluminium oxide
- extremely hard and sharp for a long tool life
- also cuts harder materials efficiently

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000104302	ZY 0104.03		EKR 150 NV4	1.5	4	3 x 30	20
A200000205302	ZY 0205.03		EKR 120 NV4	2	5	3 x 30	20
A2000002053020001	ZY 0305.03		EKR 120 NV4	2.5	5	3 x 30	20
A200000306302	ZY 0306.03		EKR 100 NV4	3	6	3 x 30	20
A2000003063020001	ZY 0306.03		EKR 120 QU V4	3	6	3 x 30	20
A200000306602	ZY 0306.06		EKR 100 NV4	3	6	6 x 40	20

Recommended for: ● Steel

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000408302	ZY 0408.03		EKR 80 NV4	4	8	3 x 30	20
A2000004083020001	ZY 0408.03		EKR 100 QU V4	4	8	3 x 30	20
A200000408602	ZY 0408.06		EKR 80 NV4	4	8	6 x 40	20
A200000510302	ZY 0510.03		EKR 80 NV4	5	10	3 x 30	20
A2000005103020001	ZY 0510.03		EKR 80/100 QU V4	5	10	3 x 30	20
A200000510602	ZY 0510.06		EKR 80 NV4	5	10	6 x 40	20
A200000610302	ZY 0610.03		EKR 60 NV4	6	10	3 x 30	20
A200000610602	ZY 0610.06		EKR 60 NV4	6	10	6 x 40	20
A200000810302	ZY 0810.03		EKR 60 NV4	8	10	3 x 30	20
A2000008103020001	ZY 0810.03		EKR 60/80 QU V4	8	10	3 x 30	20
A200000810602	ZY 0810.06		EKR 60 NV4	8	10	6 x 40	20
A200000816302	ZY 0816.03		EKR 60 NV4	8	16	3 x 30	20
A200000816602	ZY 0816.06		EKR 60 NV4	8	16	6 x 40	20
A200000820602	ZY 0820.06		EKR 60 NV4	8	20	6 x 40	20
A200001010302	ZY 1010.03		EKR 60 NV4	10	10	3 x 30	20
A200001010602	ZY 1010.06		EKR 60 NV4	10	10	6 x 40	20
A200001013302	ZY 1013.03		EKR 60 NV4	10	13	3 x 30	20
A200001013602	ZY 1013.06		EKR 60 NV4	10	13	6 x 40	20
A200001020602	ZY 1020.06		EKR 60 NV4	10	20	6 x 40	20
A2000010206020001	ZY 1020.06		EKR 46 QU V4	10	20	6 x 40	20
A200001032602	ZY 1032.06		EKR 60 NV4	10	32	6 x 40	20
A2000010326020001	ZY 1032.06		EKR 46 QU V4	10	32	6 x 40	20
A200001040602	ZY 1040.06		EKR 60 NV4	10	40	6 x 40	20
A200001313302	ZY 1313.03		EKR 46 NV4	13	13	3 x 30	20
A200001313602	ZY 1313.06		EKR 46 NV4	13	13	6 x 40	20
A200001320602	ZY 1320.06		EKR 46 NV4	13	20	6 x 40	20
A200001325602	ZY 1325.06		EKR 46 NV4	13	25	6 x 40	20
A200001332602	ZY 1332.06		EKR 46 NV4	13	32	6 x 40	20
A200001616602	ZY 1616.06		EKR 46 NV4	16	16	6 x 40	20
A200001620602	ZY 1620.06		EKR 46 NV4	16	20	6 x 40	20
A200001632602	ZY 1632.06		EKR 46 NV4	16	32	6 x 40	20
A200001640602	ZY 1640.06		EKR 46 NV4	16	40	6 x 40	20
A200002020602	ZY 2020.06		EKR 36 NV4	20	20	6 x 40	20
A200002025602	ZY 2025.06		EKR 36 NV4	20	25	6 x 40	20
A200002032602	ZY 2032.06		EKR 36 NV4	20	32	6 x 40	20
A200002040602	ZY 2040.06		EKR 36 NV4	20	40	6 x 40	20
A200002520602	ZY 2520.06		EKR 36 NV4	25	20	6 x 40	20
A200002525602	ZY 2525.06		EKR 36 NV4	25	25	6 x 40	20
A200002532602	ZY 2532.06		EKR 36 NV4	25	32	6 x 40	20
A200003220602	ZY 3220.06		EKR 30 NV4	32	20	6 x 40	20
A200003232602	ZY 3232.06	EKR 30 NV4	32	32	6 x 40	20	
A200003240602	ZY 3240.06	EKR 30 NV4	32	40	6 x 40	20	
A200004020602	ZY 4020.06	EKR 30 NV4	40	20	6 x 40	20	
A200004040602	ZY 4040.06	EKR 30 NV4	40	40	6 x 40	20	
A200005020602	ZY 5020.06	EKR 30 NV4	50	20	6 x 40	20	
A201301303302	ZY2 1303.03		EKR 80 NV4	13	3	3 x 30	20
A201301303602	ZY2 1303.06		EKR 80 NV4	13	3	6 x 40	20
A201301604302	ZY2 1604.03		EKR 60 NV4	16	4	3 x 30	20
A201301604602	ZY2 1604.06		EKR 60 NV4	16	4	6 x 40	20

Recommended for: ● Steel

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A201302006302	ZY2 2006.03		EKR 60 NV4	20	6	3 x 30	20
A201302006602	ZY2 2006.06		EKR 60 NV4	20	6	6 x 40	20
A2013020066020001	ZY2 2006.06		EKR 46 QU V4	20	6	6 x 40	20
A201302506602	ZY2 2506.06		EKR 60 NV4	25	6	6 x 40	20
A201302510602	ZY2 2510.06		EKR 36 NV4	25	10	6 x 40	20
A201303208602	ZY2 3208.06		EKR 46 NV4	32	8	6 x 40	20
A201304010602	ZY2 4010.06		EKR 30 NV4	40	10	6 x 40	20
A201305010602	ZY2 5010.06		EKR 30 NV4	50	10	6 x 40	20
A200402025602	WKS 2025.06			EKR 60 NV4	20	25	6 x 40
A200200306302	SP 0306.03		EKR 100 NV4	3	6	3 x 30	20
A200200510302	SP 0510.03		EKR 80 NV4	5	10	3 x 30	20
A200200510602	SP 0510.06		EKR 80 NV4	5	10	6 x 40	20
A200200816302	SP 0816.03		EKR 60 NV4	8	16	3 x 30	20
A200200816602	SP 0816.06		EKR 60 NV4	8	16	6 x 40	20
A200201020602	SP 1020.06		EKR 60 NV4	10	20	6 x 40	20
A200201320602	SP 1320.06		EKR 46 NV4	13	20	6 x 40	20
A200202032602	SP 2032.06		EKR 36 NV4	20	32	6 x 40	20
A201100606302	KU 0606.03			EKR 60 NV4	6	6	3 x 30
A2011006063020001	KU 0606.03	EKR 80/100 QU V4		6	6	3 x 30	20
A201100606602	KU 0606.06	EKR 60 NV4		6	6	6 x 40	20
A201100808302	KU 0808.03	EKR 60 NV4		8	8	3 x 30	20
A201100808602	KU 0808.06	EKR 60 NV4		8	8	6 x 40	20
A201101010302	KU 1010.03	EKR 60 NV4		10	10	3 x 30	20
A201101010602	KU 1010.06	EKR 60 NV4		10	10	6 x 40	20
A201101313302	KU 1313.03	EKR 46 NV4		13	13	3 x 30	20
A201101313602	KU 1313.06	EKR 46 NV4		13	13	6 x 40	20
A201101616602	KU 1616.06	EKR 46 NV4		16	16	6 x 40	20
A201102020602	KU 2020.06	EKR 36 NV4		20	20	6 x 40	20
A2011020206020001	KU 2020.06	EKR 60 PV21		20	20	6 x 40	20
A201102525602	KU 2525.06	EKR 36 NV4		25	25	6 x 40	20
A201103232602	KU 3232.06	EKR 30 NV4		32	32	6 x 40	20
A202002019602	TO 2020.06			EKR 60 NV4	20	20	6 x 40
A202002524602	TO 2524.06		EKR 60 NV4	25	24	6 x 40	20
A202003229602	TO 3229.06		EKR 60 NV4	32	29	6 x 40	20
A202004036602	TO 4036.06		EKR 60 NV4	40	36	6 x 40	20
A201501632602	KE 1632.06		EKR 46 NV4	16	32	6 x 40	20
A201501640602	KE 1640.06		EKR 46 NV4	16	40	6 x 40	20
A201502032602	KE 2032.06		EKR 36 NV4	20	32	6 x 40	20
A201502040602	KE 2040.06		EKR 36 NV4	20	40	6 x 40	20
A201502570602	KE 2570.06		EKR 36 NV4	25	70	6 x 40	20

Recommended for: ● Steel



EKR mounted point assortment



Assortment Steel



Assortment 14



Assortment 36



Assortment 45



Product number	Description	Quality	Shank diameter mm	Content 1 per pack	Pack contains
A20480005602F1	Assortment Steel	EKR	6	5 parts: ZY 1632.06 EKR 46 N V4 ZY 2525.06 EKR 36 N V4 WKS 2025.06 EKR 60 N V4 KU 2525.06, EKR 36 N V4 KE 1632.06, EKR 46 N V4	1
A204700001402	Assortment 14	EKR	3 x 30	14 parts: ZY 0205 ZY 0306 ZY 0408 ZY 0510 ZY 0610 ZY 0810 ZY 0816 ZY 1010 ZY 1013 ZY 1313 KU 0808 ZY2 1303 ZY2 1604 ZY2 2006	1
A204800003602	Assortment 36	EKR	3 x 30	36 parts: D1 D2 D3 D4 D5 D6 D7 D8 D9 D10 D11 D12 D13 D14 D15 D16 D17 D18 D19 D20 D21 D22 D23 D24 D25 D26 D27 D28 D29 D30 D31 D32 D33 D34 D35 D36	1
A204600000202	Assortment 45	EKR	6 x 40	45 parts: ZY 0306 ZY 0510 ZY 0408 ZY 0610 ZY 0810 ZY 0816 ZY 1010 ZY 1020 ZY 1032 ZY2 1303 ZY 1313 ZY 1320 ZY2 1604 ZY 1616 ZY 1620 ZY 1632 ZY2 2006 ZY 2020 ZY 2025 ZY 2032 ZY 2040 ZY2 2506 ZY2 2510 ZY 2520 ZY 2525 ZY 2532 ZY2 3208 ZY 3220 ZY 3232 ZY2 4010 ZY 4020 SP 0816 SP 1020 SP 1320 SP 2032 KE 1632 KE 1640 KE 2032 KE 2040 KU 1010 KU 1313 KU 1616 KU 2020 KU 2525 KU 3232	1

Recommended for: ● Steel

GRINDING AND POLISHING (with bonded tools)

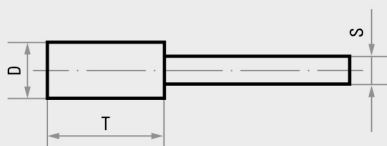
WHITE ALUMINIUM OXIDE, TYPE BROWN

EFFICIENTLY GRIND STEEL, CAST STEEL AND TEMPERED STEELS

GRINDING AND POLISHING
(with bonded tools)



EKWbr mounted point



- perfect results on steel and for rough grinding with aluminium oxide
- extremely hard and sharp for a long tool life
- also cuts harder materials efficiently

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200000205312	ZY 0205.03		EKWbr 120 O/P V7	2	5	3 x 30	20	
A200000306312	ZY 0306.03		EKWbr 100 O/P V7	3	6	3 x 30	20	
A200000408312	ZY 0408.03		EKWbr 80 O/P V7	4	8	3 x 30	20	
A200000510312	ZY 0510.03		EKWbr 80 O/P V7	5	10	3 x 30	20	
A200000610312	ZY 0610.03		EKWbr 60 O/P V7	6	10	3 x 30	20	
A200000810312	ZY 0810.03		EKWbr 60 O/P V7	8	10	3 x 30	20	
A200000816312	ZY 0816.03		EKWbr 60 O/P V7	8	16	3 x 30	20	
A200001010312	ZY 1010.03			EKWbr 60 O/P V7	10	10	3 x 30	20
A200001013312	ZY 1013.03			EKWbr 60 O/P V7	10	13	3 x 30	20
A200001020612	ZY 1020.06			EKWbr 60 O/P V7	10	20	6 x 40	20
A200001032612	ZY 1032.06			EKWbr 60 O/P V7	10	32	6 x 40	20
A200001313312	ZY 1313.03			EKWbr 60 O/P V7	13	13	3 x 30	20
A200001320612	ZY 1320.06			EKWbr 60 O/P V7	13	20	6 x 40	20
A200001632612	ZY 1632.06			EKWbr 46 O/P V7	16	32	6 x 40	20
A200002040612	ZY 2040.06			EKWbr 46 O/P V7	20	40	6 x 40	20
A201301604312	ZY2 1604.03	EKWbr 60 O/P V7		16	4	3 x 30	20	
A201302006312	ZY2 2006.03		EKWbr 60 O/P V7	20	6	3 x 30	20	
A201100606312	KU 0606.03		EKWbr 60 O/P V7	6	6	3 x 30	20	
A201100808312	KU 0808.03		EKWbr 60 O/P V7	8	8	3 x 30	20	
A201101010312	KU 1010.03		EKWbr 60 O/P V7	10	10	3 x 30	20	
A201102020612	KU 2020.06		EKWbr 46 O/P V7	20	20	6 x 40	20	

Recommended for: ● Steel



QUALITIES AND PROPERTIES

Mounted points for machining non-rusting steels



RKD

Mixture of dark red and pink aluminium oxide

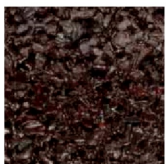
★★☆

MATERIAL PROPERTIES

Non-rusting steels are difficult to machine. They tend to smear due to the nickel content, while their poor heat conductivity often causes the material to overheat within the grinding contact zone.

PROCESSING EXAMPLES

- Rough and finish grinding
- Deburring
- Fettling
- Finishing weld seams
- Surface finishing



NK-BA SOFT

Regular aluminium oxide with resin bond, iron- and sulphur-free

★★☆

INDUSTRIES

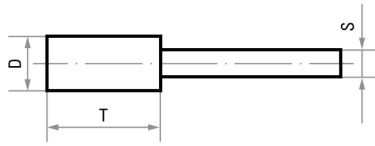
- Steel construction and fabrication (façades, handrails, sanitary equipment)
- Vessel manufacturing
- Casings and panelling
- Medical technology
- Shipyards
- Food industry
- and many more

LUKAS GRINDING TOOLS

LUKAS has developed particularly high-performance tools for non-rusting steels that deliver exceptional stock removal, even under adverse conditions.

These tools do not contain any iron, sulphur or halogens. This generally prevents chemical reactions (corrosion) of the workpiece material in the grinding contact zone.

RKD mounted point



- for non-rusting steels
- excellent removal rates, also under difficult conditions

★★☆

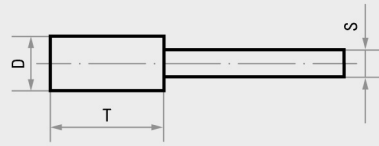
GRINDING AND POLISHING
(with bonded tools)

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200000104347	ZY 0104.03		RKD 150 QU V21	1.5	4	3 x 30	20
A200000205347	ZY 0205.03		RKD 150 QU V21	2	5	3 x 30	20
A200000306347	ZY 0306.03		RKD 120 QU V21	3	6	3 x 30	20
A200000306647	ZY 0306.06		RKD 120 QU V21	3	6	6 x 40	20
A200000408347	ZY 0408.03		RKD 100 QU V21	4	8	3 x 30	20
A200000510347	ZY 0510.03		RKD 100 QU V21	5	10	3 x 30	20
A200000510647	ZY 0510.06		RKD 100 QU V21	5	10	6 x 40	20
A200000610347	ZY 0610.03		RKD 80 QU V21	6	10	3 x 30	20
A200000610647	ZY 0610.06		RKD 80 QU V21	6	10	6 x 40	20
A200000810347	ZY 0810.03		RKD 80 QU V21	8	10	3 x 30	20
A200000816347	ZY 0816.03		RKD 80 QU V21	8	16	3 x 30	20
A200000816647	ZY 0816.06		RKD 80 QU V21	8	16	6 x 40	20
A200001010347	ZY 1010.03		RKD 80 P V21	10	10	3 x 30	20
A200001313347	ZY 1313.03		RKD 60 P (6) V21	13	13	3 x 30	20
A200001313647	ZY 1313.06		RKD 60 P (6) V21	13	13	6 x 40	20
A200001325647	ZY 1325.06		RKD 60 QU V21	13	25	6 x 40	20
A200001616647	ZY 1616.06		RKD 36 O (6) V21	16	16	6 x 40	20
A200001632647	ZY 1632.06		RKD 36 O (6) V21	16	32	6 x 40	20
A200002020647	ZY 2020.06		RKD 36 O (6) V21	20	20	6 x 40	20
A200002032647	ZY 2032.06		RKD 36 O (6) V21	20	32	6 x 40	20
A200002040647	ZY 2040.06		RKD 36 O (6) V21	20	40	6 x 40	20
A200002525647	ZY 2525.06		RKD 30 O (6) V21	25	25	6 x 40	20
A200002532647	ZY 2532.06		RKD 30 O (6) V21	25	32	6 x 40	20
A200003232647	ZY 3232.06		RKD 30 O (6) V21	32	32	6 x 40	20
A200003240647	ZY 3240.06		RKD 30 O (6) V21	32	40	6 x 40	20
A200004020647	ZY 4020.06		RKD 24 O (6) V21	40	20	6 x 40	20
A200004040647	ZY 4040.06		RKD 24 O (6) V21	40	40	6 x 40	20
A200004040847	ZY 4040.08		RKD 24 O (6) V21	40	40	8 x 40	20
A201301303347	ZY2 1303.03		RKD 80 QU V21	13	3	3 x 30	20
A201303208647	ZY2 3208.06		RKD 36 O (6) V21	32	8	6 x 40	20
A201304010647	ZY2 4010.06		RKD 30 O (6) V21	40	10	6 x 40	20
A200200306347	SP 0306.03		RKD 120 QU V21	3	6	3 x 30	20
A200200510347	SP 0510.03		RKD 100 QU V21	5	10	3 x 30	20
A200200816347	SP 0816.03		RKD 80 QU V21	8	16	3 x 30	20
A201101010347	KU 1010.03		RKD 80 P V21	10	10	3 x 30	20
A201101616647	KU 1616.06		RKD 60 P (6) V21	16	16	6 x 40	20
A201102525647	KU 2525.06		RKD 30 QU V21	25	25	6 x 40	20
A201501025647	KE 1025.06		RKD 60 P (6) V21	10	25	6 x 40	20
A2015016456470002	KE 1645.06		RKD 46 O V13	16	45	6 x 40	20
A201502040647	KE 2040.06		RKD 36 O (6) V21	20	40	6 x 40	20
A201503250647	KE 3250.06		RKD 30 O (6) V21	32	50	6 x 40	20

Recommended for: ● Inox/Steel ● Steel



NK soft mounted point



- for non-rusting steels
- excellent removal rates, also under difficult conditions

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200001332627W	ZY 1332.06		NK 24 N BA soft	13	32	6 x 40	20	
A200001632627W	ZY 1632.06		NK 24 N BA soft	16	32	6 x 40	20	
A200002040627W	ZY 2040.06		NK 24 N BA soft	20	40	6 x 40	20	
A200002040827W	ZY 2040.08		NK 24 N BA soft	20	40	8 x 40	20	
A200002532627W	ZY 2532.06		NK 24 N BA soft	25	32	6 x 40	20	
A200003232627W	ZY 3232.06		NK 24 N BA soft	32	32	6 x 40	20	
A200004020627W	ZY 4020.06		NK 24 N BA soft	40	20	6 x 40	20	
A200005020627W	ZY 5020.06		NK 24 N BA soft	50	20	6 x 40	20	
A201302506627	ZY2 2506.06			NK 24 N BA soft	25	6	6 x 40	20
A201304006627	ZY2 4006.06			NK 24 N BA soft	40	10	6 x 40	20
A201304010627W	ZY2 4010.06	NK 24 N BA soft		40	10	6 x 40	20	
A201305004627W	ZY2 5004.06	NK 24 N BA soft		50	4	6 x 40	20	
A201305010627W	ZY2 5010.06	NK 24 N BA soft		50	10	6 x 40	20	
A201306510827	ZY2 6510.08	NK 24 P BA soft		65	10	8 x 40	20	
A201102525627	KU 2525.06		NK 24 N BA soft	25	25	6 x 40	20	

Recommended for: ● Inox/Steel ● Steel ● Aluminium

GRINDING AND POLISHING (with bonded tools)



NK BA mounted point assortment

- for non-rusting steels
- 4 different shapes for fast tool changes, in specialist retail packaging
- excellent removal rates, also under difficult conditions



★★☆

Product number	Description	Quality	Shank diameter mm	Content 1 per pack	Pack contains
A20480004627WF1	Assortment Inox	NK BA	6	4 parts: ZY 1332.06 NK 24 N BA soft ZY 2040.06 NK 24 N BA soft ZY 4006.06 NK 24 N BA soft ZY 2040.06 NK 24 N BA soft KU 2525.06 NKB/NK 24 R BA 98	1

Recommended for: ● Inox/Steel ● Steel ● Aluminium



QUALITIES AND PROPERTIES

Mounted points for machining cast materials



NK-BA HARD

Regular aluminium oxide resin-bonded

★★☆



HK

Mixture of white aluminium oxide and regular aluminium oxide

★★☆



MK

Mixture of pink aluminium oxide and regular aluminium oxide

★★☆

MATERIAL PROPERTIES

The characteristics of the various types of cast materials are normally determined by their carbon content and the way in which the carbon is removed from the material structure. Cast materials are generally rough machined. The skin contains inclusions of sand from the casting process; large burrs, sprues and risers, holes and cracks must all be removed by grinding. These areas to be ground are often difficult to reach.

INDUSTRIES

Manufacturers of cast components such as engine blocks, gear box casings, cylinder heads, frames, stands, machine slides, gears, crankshafts, pump and turbine housings, machine tool components and many more.

PROCESSING EXAMPLES

- Deburring
- Fettling
- Polishing
- Finish grinding of repair welds
- Removing holes and cracks

LUKAS GRINDING TOOLS

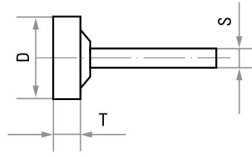
LUKAS mounted points for grinding cast materials contain special grain mixtures and tough bonding systems, delivering excellent performance in the applications mentioned above.

The aggressiveness of the abrasive grain and the smooth running of the mounted points allow for ergonomic machining with minimum force. Mounted points with specially extended shanks are also available on request.



NK hard mounted point

- perfect for grinding cast materials
- special grain mixture ideally suited to the material
- for ergonomical working with minimum force



★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200001020627	ZY 1020.06		NK 46 QU BA hard	10	20	6 x 40	20	
A200001032627	ZY 1032.06		NK 46 QU BA hard	10	32	6 x 40	20	
A200001040627	ZY 1040.06		NK 46 QU BA hard	10	40	6 x 40	20	
A200001320627	ZY 1320.06		NK 46 QU BA hard	13	20	6 x 40	20	
A200001332627	ZY 1332.06		NK 46 QU BA hard	13	32	6 x 40	20	
A200001620627	ZY 1620.06		NK 24 QU BA hard	16	20	6 x 40	20	
A200001632627	ZY 1632.06		NK 24 QU BA hard	16	32	6 x 40	20	
A200001640627	ZY 1640.06		NK 24 QU BA hard	16	40	6 x 40	20	
A200002020627	ZY 2020.06		NK 24 QU BA hard	20	20	6 x 40	20	
A200002032627	ZY 2032.06		NK 24 QU BA hard	20	32	6 x 40	20	
A200002040627	ZY 2040.06		NK 24 QU BA hard	20	40	6 x 40	20	
A200002040827	ZY 2040.08			NK 24 QU BA hard	20	40	8 x 40	20
A200002525627	ZY 2525.06			NK 24 QU BA hard	25	25	6 x 40	20
A200002532627	ZY 2532.06			NK 24 QU BA hard	25	32	6 x 40	20
A200003220627	ZY 3220.06			NK 24 QU BA hard	32	20	6 x 40	20
A200003232627	ZY 3232.06			NK 24 QU BA hard	32	32	6 x 40	20
A200003250827	ZY 3250.08			NK 24 O BA hard	32	50	8 x 40	20
A200004020627	ZY 4020.06			NK 24 QU BA hard	40	20	6 x 40	20
A200004020827	ZY 4020.08			NK 24 QU BA hard	40	20	8 x 40	20
A200004040827	ZY 4040.08			NK 24 QU BA hard	40	40	8 x 40	20
A200005013827	ZY 5013.08	NK 24 QU BA hard		50	13	8 x 40	20	
A200005020627	ZY 5020.06	NK 24 QU BA hard	50	20	6 x 40	20		
A200005020827	ZY 5020.08	NK 24 QU BA hard	50	20	8 x 40	20		
A200005025827	ZY 5025.08	NK 24 QU BA hard	50	25	8 x 40	20		
A201302510627	ZY2 2510.06		NK 24 QU BA hard	25	10	6 x 40	20	
A201303208627	ZY2 3208.06		NK 24 QU BA hard	32	8	6 x 40	20	
A201304010627	ZY2 4010.06		NK 24 QU BA hard	40	10	6 x 40	20	
A201305004627	ZY2 5004.06		NK 24 QU BA hard	50	4	6 x 40	20	
A201305006627	ZY2 5006.06		NK 24 QU BA hard	50	6	6 x 40	20	
A201305010627	ZY2 5010.06		NK 24 QU BA hard	50	10	6 x 40	20	
A201305010827	ZY2 5010.08		NK 24 QU BA hard	50	10	8 x 40	20	
A6013060066270005	ZY2 6006.06		NK 24 QU BA hard	60	6	6 x 40	20	
A201307510827	ZY2 7510.08		NK 24 QU BA hard	75	10	8 x 40	10	

Recommended for: ● Steel ● Cast material

GRINDING AND POLISHING (with bonded tools)

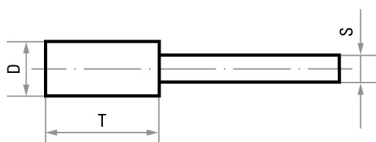
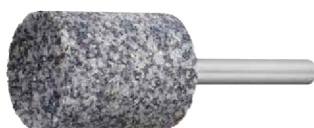
REMOVE LARGE BURRS, SPRUES AND RISERS

SPECIAL GRAIN MIXTURES AND TOUGH BONDS TO GET THE JOB DONE



GRINDING AND POLISHING
(with bonded tools)

HK mounted point



- perfect for grinding cast materials
- special grain mixture ideally suited to the material
- for ergonomical working with minimum force

★★☆

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A200001632633	ZY 1632.06		HK 30 NV13	16	32	6 x 40	20
A200002032633	ZY 2032.06		HK 30 NV13	20	32	6 x 40	20
A200002040633	ZY 2040.06		HK 30 NV13	20	40	6 x 40	20
A200002532633	ZY 2532.06		HK 30 NV13	25	32	6 x 40	20
A200004020633	ZY 4020.06		HK 30 NV13	40	20	6 x 40	20
A200004025833	ZY 4025.08		HK 24/30 PV4	40	25	8 x 40	20
A201305010633	ZY2 5010.06		HK 30 NV13	50	10	6 x 40	20
A201503250833	KE 3250.08		HK 30 NV13	32	50	8 x 40	20

Recommended for: ● Cast material ● Inox/Steel



ROUGH GRINDING THE ERGONOMIC WAY

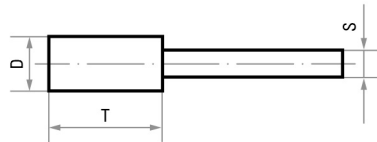
LUKAS MOUNTED POINTS FOR CAST MATERIAL RUN PARTICULARLY SMOOTHLY

GRINDING AND POLISHING
(with bonded tools)



MK mounted point

- perfect for grinding cast materials
- special grain mixture ideally suited to the material
- for ergonomical working with minimum force



Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains	
A200001020616	ZY 1020.06		MK 46 N V10	10	20	6 x 40	20	
A200001632616	ZY 1632.06		MK 36 N V10	16	32	6 x 40	20	
A200001640616	ZY 1640.06		MK 36 N V10	16	40	6 x 40	20	
A200002020616	ZY 2020.06		MK 36 N V10	20	20	6 x 40	20	
A200002032616	ZY 2032.06		MK 36 N V10	20	32	6 x 40	20	
A200002040616	ZY 2040.06		MK 36 N V10	20	40	6 x 40	20	
A200002532616	ZY 2532.06			MK 36 N V10	25	32	6 x 40	20
A200003220616	ZY 3220.06			MK 36 N V10	32	20	6 x 40	20
A200003232616	ZY 3232.06			MK 36 N V10	32	32	6 x 40	20
A200003240616	ZY 3240.06			MK 36 N V10	32	40	6 x 40	20
A200004020616	ZY 4020.06			MK 36 N V10	40	20	6 x 40	20
A200004040816	ZY 4040.08			MK 36 N V10	40	40	8 x 40	20
A200005025616	ZY 5025.06			MK 30 N V10	50	25	6 x 40	20
A201304010616	ZY2 4010.06		MK 36 N V10	40	10	6 x 40	20	
A201501632616	KE 1632.06		MK 36 N V10	16	32	6 x 40	20	
A201502032616	KE 2032.06		MK 36 N V10	20	32	6 x 40	20	
A201502040616	KE 2040.06		MK 36 N V10	20	40	6 x 40	20	

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



QUALITIES AND PROPERTIES

Mounted points for grinding plastic and rubber



HOK
Spherical
aluminium oxide

★★☆

MATERIAL PROPERTIES

Materials such as rubber or plastic are very elastic and have a very low melting point. They flex and generate heat, often resulting in a bad odour and smearing.

INDUSTRIES

- Rubber processing
- Plastic processing

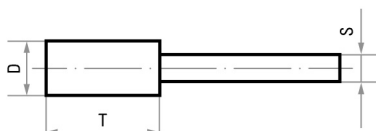
PROCESSING EXAMPLES

- Repairing and re-vulcanising tyres
- Repairing conveyor belts
- Preparation of various areas for adhesion
- Deburring rubber or plastic components

LUKAS GRINDING TOOLS

LUKAS grinding tools for machining rubber and plastic contain special spherical grains (HOK) in a very open ceramic structure. This abrasive creates permanent small razor-sharp cutting edges which pluck out the material from the surface. Consequently, these mounted points are ideally suited for the machining applications listed above.

HOK mounted point



★★☆

■ specialist for machining rubber and plastic

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A202202025626	ZY 2025.06		HOK 0-3 V9	20	25	6 x 40	20
A202204020626	ZY 4020.06		HOK 0-3 V9	40	20	6 x 40	20
A201902525626	KU 2525.06		HOK 0-3 V9	25	25	6 x 40	20
A201903838626	KU 3838.06		HOK 0-3 V9	38	38	6 x 40	20

Recommended for: ● Plastic/Rubber

ADAPTED TO AMERICAN DIMENSIONS

MOUNTED POINTS IN PROVEN LUKAS QUALITY IN AMERICAN SHAPES



AMERICAN SHAPE A



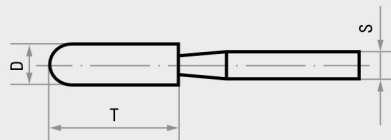
AMERICAN SHAPE B

We offer LUKAS mounted points in a wide range of shapes, sizes and qualities. American shapes are often required overseas. You can rest assured that we have the right products for your challenges in proven LUKAS quality.

GRINDING AND POLISHING
(with bonded tools)



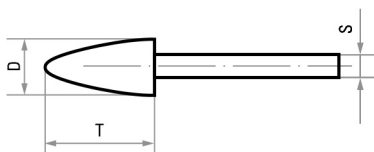
Mounted point American shape A



Product number	Description	Shape	Quality	D inch	T inch	D mm	T mm	S mm	Pack contains
A206202263633	A1 2263.06		HK 36/46 M V13	7/8	2 1/2	22	63	6 x 40	20
A206201645633	AS-3 1645.06		HK 36/46 M V13	5/8	1 3/4	16	45	6 x 40	20
A2062025706020001	A3 2570.06		EKR 36 N V4	1	2 3/4	25	70	6 x 40	20
A206202570633	A3 2570.06		HK 36/46 M V13	1	2 3/4	25	70	6 x 40	20
A206402570833	A3 2570.08		HK 36/46 M V13	1	2 3/4	25	70	8 x 40	20
A206202250602	A11 2250.06		EKR 36 QU V4	7/8	2	22	50	6 x 40	20
A2062022506020001	A11 2250.06		EKR 36 N V4	7/8	2	22	50	6 x 40	20
A206202250633	A11 2250.06		HK 36/46 M V13	7/8	2	22	50	6 x 40	20
A206202250626	A11 2250.06		HOK 0-3 V9	7/8	2	22	50	6 x 40	20
A206200625602	A15 0625.06		EKR 80/100 QU V4	1/4	1	6	25	6 x 40	20
A206200625633	A15 0625.06		HK 46/60 N V13	1/4	1	6	25	6 x 40	20
A206200620602	A24 0620.06		EKR 60/80 QU V4	1/4	3/4	6	20	6 x 40	20
A206204010608	A36 4010.06		EKW 60 L (2) V13	1 5/8	3/8	40	10	6 x 40	20

Recommended for: ● Cast material (HK) ● Plastic/Rubber ● Titanium (EKW) ● Inox/Steel (HK) ● Steel (EKW)

Mounted point American shape B



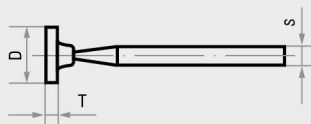
★★☆

Product number	Description	Shape	Quality	D inch	T inch	D mm	T mm	S mm	Pack contains
A206601616302	B41 1616.03		EKR 60/80 QU V4	5/8	5/8	16	16	3 x 30	20
A206601020302	B52 1020.03		EKR 46 QU V4	3/8	3/4	10	20	3 x 30	20
A206600816302	B53 0816.03		EKR 60/80 QU V4	5/16	5/8	8	16	3 x 30	20

Recommended for: ● Steel

GRINDING AND POLISHING (with bonded tools)

Miniature mounted point

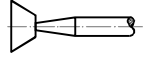
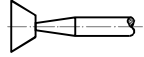
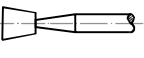
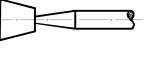
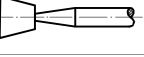
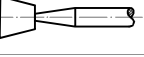
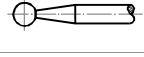
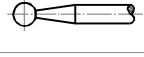





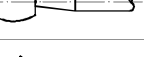

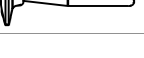


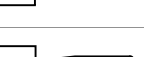
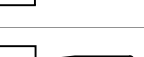



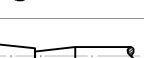
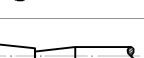
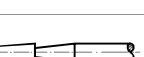




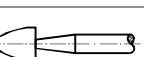
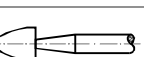
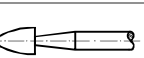
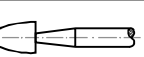
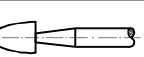
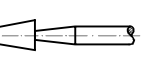
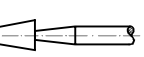




★★☆

■ perfect mounted points for use in pattern making and 3D printing

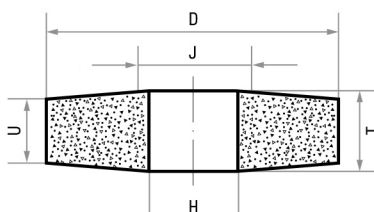
Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A202900001302	D1		EKR 100 NV4	9	2	3 x 30	20
A202900001311	D1		EKbr 100 MV1/6	9	2	3 x 30	20
A202900002302	D2		EKR 80 NV4	9	3	3 x 30	20
A202900002311	D2		EKbr 80 MV1/6	9	3	3 x 30	20
A202900003302	D3		EKR 100 NV4	8	2	3 x 30	20
A202900003311	D3		EKbr 100 MV1/6	8	2	3 x 30	20
A202900004302	D4		EKR 100 NV4	4	1	3 x 30	20
A202900005302	D5		EKR 80 NV4	5	3	3 x 30	20
A202900005311	D5		EKbr 80 MV1/6	5	3	3 x 30	20
A202900006302	D6		EKR 80 NV4	7/4	6	3 x 30	20
A202900007302	D7		EKR 100 NV4	2.5/5	2.5	3 x 30	20
A202900008302	D8		EKR 100 NV4	2.5/6	3	3 x 30	20

Recommended for: ● Steel

Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A202900009302	D9		EKR 80 NV4	3.5/8	4	3 x 30	20
A202900009311	D9		EKbr 80 MV1/6	3.5/8	4	3 x 30	20
A202900010302	D10		EKR 100 NV4	2/3.2	4	3 x 30	20
A202900011302	D11		EKR 80 NV4	5	5	3 x 30	20
A202900012302	D12		EKR 80 NV4	4/7	6	3 x 30	20
A202900012311	D12		EKbr 80 MV1/6	4/7	6	3 x 30	20
A202900013302	D13		EKR 100 NV4	3	3	3 x 30	20
A202900013311	D13		EKbr 100 MV1/6	3	3	3 x 30	20
A202900014302	D14		EKR 80 NV4	4	4	3 x 30	20
A202900014311	D14		EKbr 80 MV1/6	4	4	3 x 30	20
A202900015302	D15		EKR 80 NV4	5	5	3 x 30	20
A202900015311	D15		EKbr 80 MV1/6	5	5	3 x 30	20
A202900017302	D17		EKR 80 NV4	4	5	3 x 30	20
A202900018302	D18		EKR 80 NV4	7	8	3 x 30	20
A202900020302	D20		EKR 100 NV4	7	5	3 x 30	20
A202900021302	D21		EKR 100 NV4	8	1.6	3 x 30	20
A202900022302	D22		EKR 100 NV4	2.5	6	3 x 30	20
A202900022311	D22		EKbr 100 MV1/6	2.5	6	3 x 30	20
A202900023302	D23		EKR 80 NV4	5	6	3 x 30	20
A202900023311	D23		EKbr 80 MV1/6	5	6	3 x 30	20
A202900024302	D24		EKR 60 NV4	6	6	3 x 30	20
A202900024311	D24		EKbr 60 MV1/6	6	6	3 x 30	20
A202900025302	D25		EKR 100 NV4	5	1.5	3 x 30	20
A202900026302	D26		EKR 100 NV4	6	2.5	3 x 30	20
A202900026311	D26		EKbr 100 MV1/6	6	2.5	3 x 30	20
A202900028302	D28		EKR 80 NV4	3.5/ 5.5	11	3 x 30	20
A202900029302	D29		EKR 100 NV4	3	6.4	3 x 30	20
A202900029311	D29		EKbr 100 MV1/6	3	6.4	3 x 30	20
A202900030302	D30		EKR 100 NV4	4.4	10	3 x 30	20
A202900030311	D30		EKbr 100 MV1/6	4.4	10	3 x 30	20
A202900032302	D32		EKR 100 NV4	5	7	3 x 30	20
A202900032311	D32		EKbr 100 MV1/6	5	7	3 x 30	20
A202900033302	D33		EKR 80 NV4	6	8	3 x 30	20
A202900034302	D34		EKR 100 NV4	4.37	7	3 x 30	20
A202900034311	D34		EKbr 100 MV1/6	4.37	7	3 x 30	20
A202900035302	D35		EKR 80 NV4	6	10	3 x 30	20
A202900035311	D35		EKbr 80 MV1/6	6	10	3 x 30	20
A202900036302	D36		EKR 80 NV4	6	11	3 x 30	20
A202900036311	D36		EKbr 80 MV1/6	6	11	3 x 30	20

Recommended for: ● Steel

Taper-sided grinding wheel



■ grinding wheel as per ISO 603-12 in SE4 shape

★★☆

Product number	Description	Quality	D mm	T mm	U mm	H mm	J mm	Pack contains
A2039080200320001	SE4 08020.16	HK 24 M BA soft	80	20	16	16	25	10
A2039080200320002	SE4 08020.16	HK 16 P BA hard	80	20	16	16	25	10
A2039080200320003	SE4 08020.20	HK 24 M BA soft	80	20	16	20	25	10
A2039080200320004	SE4 08020.20	HK 16 P BA hard	80	20	16	20	25	10

Recommended for: ● Cast material ● Inox/Steel

GRINDING AND POLISHING (with bonded tools)



SAFETY ADVICE

This tool must be used with a flange as per DIN 69864.

Sharpening stones



RU 1–4 particularly suitable for:

- profiling
- sharpening
- dressing

of bonded grinding and polishing tools

★★☆

Product number	Description	Quality	L mm	B mm	C mm	Pack contains
A204300000118	RU 1	SICGR 60 O V23/green = fine	50	25	15	5
A204300000122	RU 1	SICGR 24 O V23/dark = coarse	50	25	15	5
A204300000218	RU 2	SICGR 60 O V23/green = fine	100	30	15	5
A204300000222	RU 2	SICGR 24 O V23/dark = coarse	100	30	15	5
A204300000318	RU 3	SICGR 60 O V23/green = fine	100	50	25	5
A204300000322	RU 3	SICGR 24 O V23/dark = coarse	100	50	25	5
A204300000418	RU 4	SICGR 60 O V23/green = fine	150	50	25	5
A204300000422	RU 4	SICGR 24 O V23/dark = coarse	150	50	25	5

Recommended for: ● Stone/Construction material

A2043150251608	RU 5	EKW 100 E (9) V40	150	25	16.5	5
A2043200502508	RU 6	EKW 100 E (9) V40	200	50	25	5

Recommended for: ● Steel

GET YOUR GRINDING AND POLISHING POINTS READY FOR WORK AGAIN QUICKLY

WE ARE FLEXIBLE AND CAN OFFER ALMOST ANY VARIANT

SHARPENING STONES WITH SILICON CARBIDE

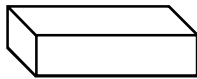

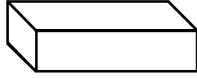
These sharpening stones feature an extremely sharp and rough abrasive grain, delivering perfect results in combination with a hard vitrified bond. This means you can get your grinding and polishing points back in working order in no time. The sharpening stone is ideal for profiling, sharpening, opening pores and removing material from bonded grinding and polishing tools. This silicon carbide tool grinds cool and generates few sparks, making it suitable for use in aerospace engineering. Even hard materials like stone, glass and high-alloy materials can be processed efficiently. The hard and sharp abrasive grain ensures a long service life. Regular tests guarantee high safety and proven quality.

SHARPENING STONES WITH ALUMINIUM OXIDE

Made from white aluminium oxide, this sharpening stone is perfect for finely grinding workpieces by hand in the mould and die industry. The high hardness and sharp grain of the aluminium oxide ensure its long service life. It can also easily process hard materials. Regular tests guarantee high safety and proven quality.

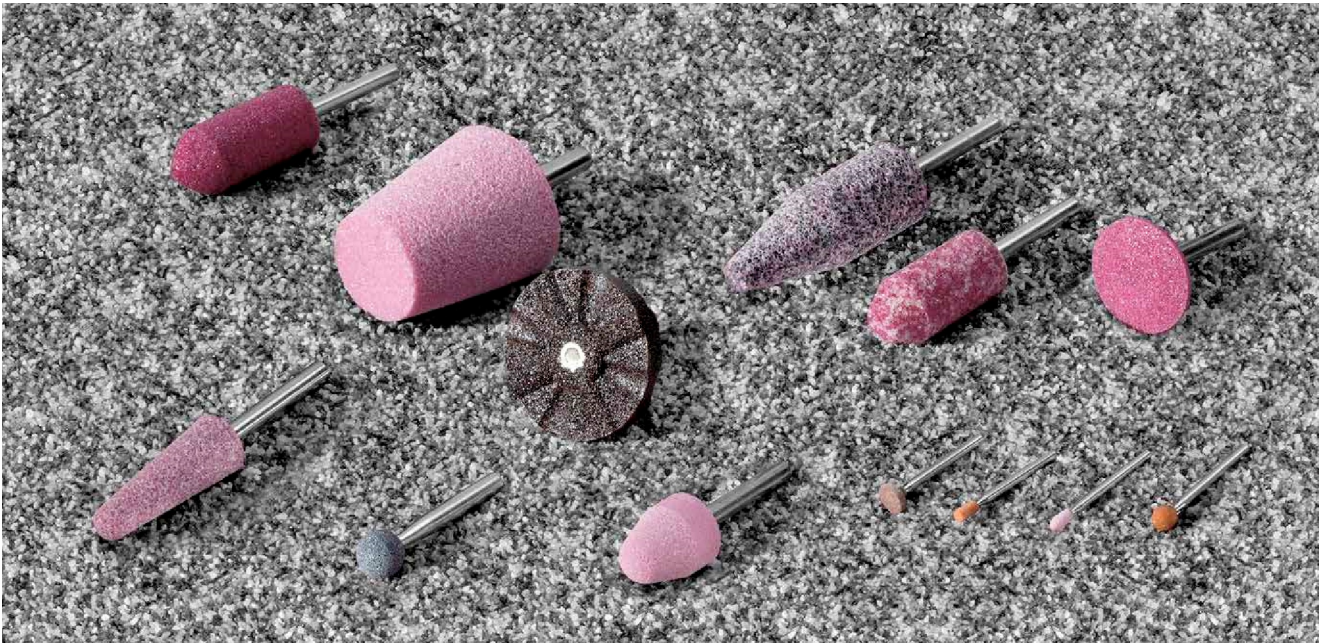
POSSIBLE SHARPENING STONE DIMENSIONS

Here you can find various sharpening stone variants. Simply let us know which dimensions you need.

Shape	Length mm	Width mm	Height mm
	25	15	5-30
	44	35	18-30
	48	19	5-30
	50	25	10-35
	90	70	20-35
	100	30	10-35
	100	50	10-35
	120	10	5-35
	150	25	10-35
	150	50	10-35
 half-round	216	78	20-35
	150	13	5-35

CUSTOMIZED PRODUCTION

Grinding wheels specially developed for your application

**TAILOR-MADE GRINDING WHEELS**

We can also provide you with customised grinding wheels:

- Wheels in special qualities
- Wheels in special dimensions
- Wheels in special profiles
- Mounted points in imperial dimensions and/or with imperial shanks
- Mounted points with internal thread and matching mounting arbors
- Cup wheels
- Grinding wheels – plain and tapered
- Mounted points with extended shanks
- Mounted points with internal thread and matching shank extension
- Sharpening and dressing stones
- and many more

YOUR CUSTOM PRODUCTION REQUEST

Please provide us with all the relevant information about your processing problem when sending your request. This will help us react quicker. This information should include:

- Shape, dimensions, shank, bore size of the grinding wheel (a sketch or technical drawing would be of great assistance)
- Material to be ground
- Type of application (e.g. fettling, deburring...)
- Surface finish requirements
- Power tool speed (rpm)
- Anticipated order quantity
- Tool currently being used (type, quality...)