

SAFETY INSTRUCTIONS AND AREAS OF APPLICATION

Safe polishing with tested tools

SAFETY INSTRUCTIONS

The LUKAS polishing points in groups P1 and P5 are manufactured according to EN 12413 and have a maximum permitted peripheral speed of 50 m/s. Products in group P2 may be operated up to a maximum speed of 16 m/s. The maximum permitted peripheral speed of product group P6 depends on the tool hardness. For MWP, for example, this is 20 m/s.

The ideal speed generally lies below the maximum permitted speed, however. This reduces the generated heat and

prolongs the increases tool life. LUKAS polishing points are delivered with a safety ticket indicating the maximum speeds for the various shank overhangs.

To ensure safe use of polishing points and wheels, please observe the following operating instructions:

- FEPA safety recommendations for the correct use of abrasive products
- FEPA safety code for bonded abrasives

FIND THE RIGHT POLISHING TOOL FOR YOUR PROCESS STEP

The LUKAS range of polishing tools covers a variety of shapes and sizes. Specially developed for fine processing and polishing on surfaces, we offer a broad spectrum of polishing tools to help you achieve the desired result every time. Made from premium raw materials, our polishing points, wheels, sticks and rollers let

you polish in a way that's best suited to the application, all the way to a gloss or high-gloss polish. Simply choose your desired polishing finish from the table below and find the right LUKAS polishing tool group (P1 – P7) to achieve it.

	Polishing tool hardness				
	hard	medium	soft		
Mirror finish	P6 Polyurethane	P4 Polyurethane	P3 Felt and paste		2,000
		P2 Soft rubber			1,200
					800
Matt finish		P5 Rubber with fibre reinforcement		P7 Soft elastomer	400
	P1 Hard rubber				280
					220
Dash-dot matting					150
					120
Marbling					80
					46
Polishing					24
					18

Grit sizes (to ISO 525)

TECHNICAL INFORMATION

Speeds for polishing tools

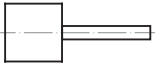
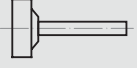
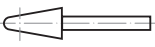



		Recommended cutting speed v_c (m/s)									
		2	5	8	10	16	20	25	32	50	
Polishing group (Bonds)		P1									
		P2/P4/P6 WP/P7									
		P3									
		P5									
		P6 MWP									
Tool diameter (mm)	4	9,500	23,800	38,100	47,700	76,300	95,400	119,300	152,700	238,700	
	6	6,300	15,900	25,400	31,800	50,900	63,600	79,500	101,800	159,100	
	8	4,700	11,900	19,000	23,800	38,100	47,700	59,600	76,300	119,300	
	10	3,800	9,500	15,200	19,000	30,500	38,100	47,700	61,100	95,400	
	16	2,300	5,900	9,500	11,900	19,000	23,800	29,800	38,100	59,600	
	20	1,900	4,700	7,600	9,500	15,200	19,000	23,800	30,500	47,700	
	25	1,500	3,800	6,100	7,600	12,200	15,200	19,000	24,400	38,100	
	32	1,100	2,900	4,700	5,900	9,500	11,900	14,900	19,000	29,800	
	40	900	2,300	3,800	4,700	7,600	9,500	11,900	15,200	23,800	
	50	700	1,900	3,000	3,800	6,100	7,600	9,500	12,200	19,000	
	75	500	1,200	2,000	2,500	4,000	5,000	6,300	8,100	12,700	
	100	300	900	1,500	1,900	3,000	3,800	4,700	6,100	9,500	
	150	200	600	1,000	1,200	2,000	2,500	3,100	4,000	6,300	
	200	100	400	700	900	1,500	1,900	2,300	3,000	4,700	
	250	100	300	600	700	1,200	1,500	1,900	2,400	3,800	
		Speed (rpm)									

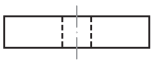
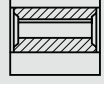




GRINDING AND POLISHING (with bonded tools)

! The ideal/recommended speed for polishing tools is usually lower than the maximum speed. Excessively high speeds generate more heat.

SHAPE

Summary of available shapes

Shape	Available in following product groups
	Cylindrical, type 1 P1, P2, P3, P5, P6
	Cylindrical, type 2 P1, P2
	Conical P1, P2, P3
	Spherical P2, P2, P3, P5
	Arch pointed nose P2, P3, P5
	Cylindrical round nose P1, P2

Shape	Available in following product groups
	Wheel P3, P6
	Roll P6
	Stick P4
	Disc P7
	Lens P7
	Flap disc P6