

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS cutting discs

SHELF LIFE

Resin-bonded cutting discs for handheld use may only be used for up to three years after the manufacture date. The expiry date (month and year) is stamped on the metal ring, e.g. V07/2022.



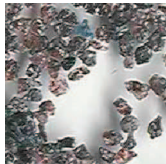
LABELLING SYSTEM FOR RESIN-BONDED CUTTING DISCS

All of the important information about your LUKAS cutting disc is stated on the label: abrasive material, grit size, hardness and type of bond.

The following overview provides all the information concerning the abbreviations and markings.



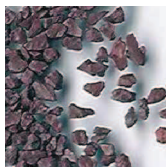
CUTTING



A
Semi-friable
aluminium oxide



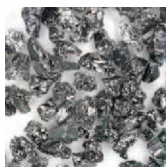
Z
Zirconia alumina



A
Ceramic-coated
annealed aluminium
oxide



CER
Ceramic grain



C
Silicon carbide

ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

Abrasive	
A	Aluminium oxide
C	Silicon carbide
Z	Zirconia alumina
CER	Ceramic grain

GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

coarse	medium	fine
12 to 24	36 to 54	60 to 120

HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

soft	medium	hard
M	R	U
P	S	V
Q	T	Z

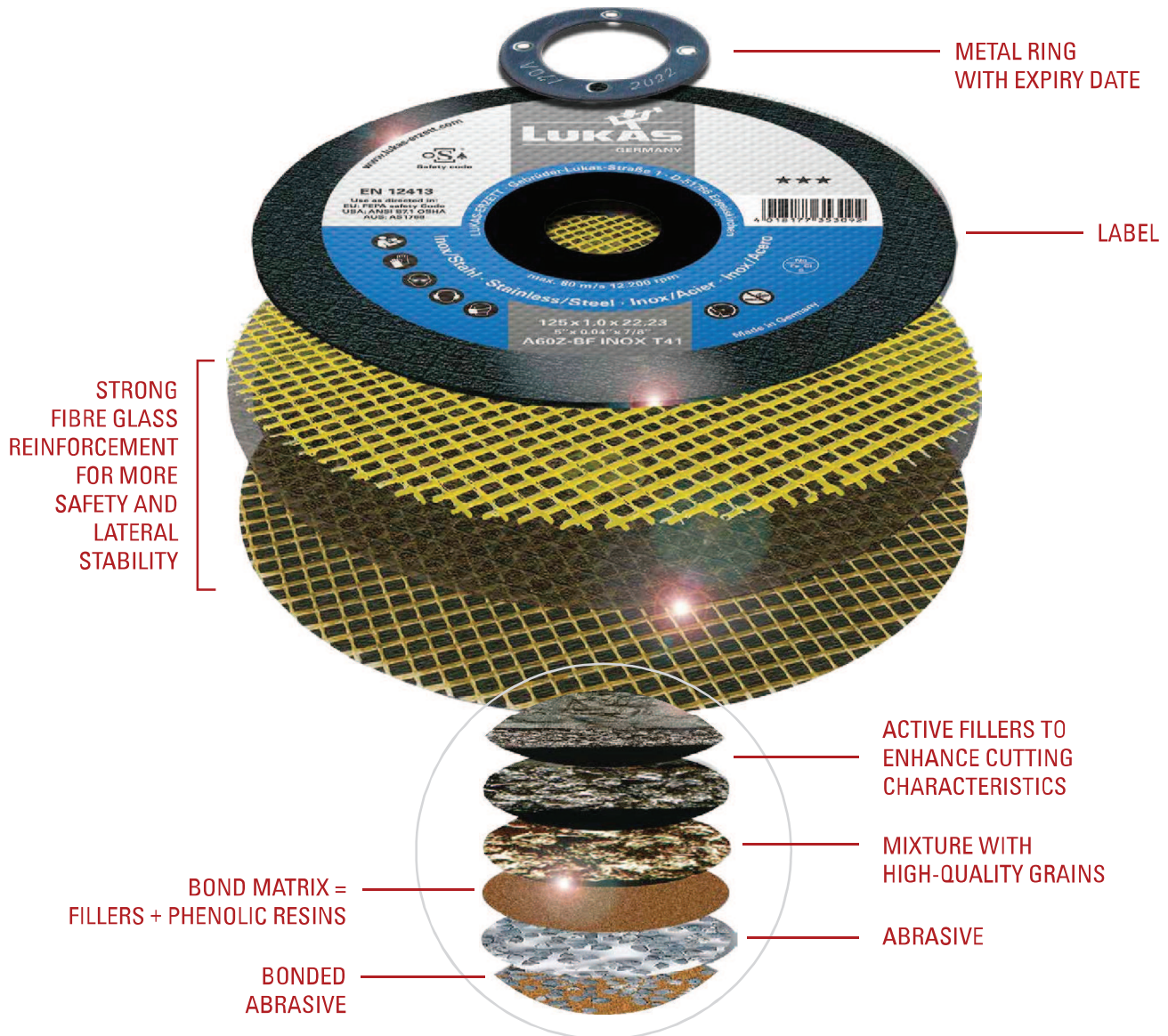
BOND

The bond is to hold the abrasive grain in the disc. LUKAS cutting discs are available with the following two types of bond:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

TECHNICAL INFORMATION

Construction and components of LUKAS cutting discs



OPERATING SPEED

LUKAS cutting discs are developed and tested for specified maximum operating speeds and grinding processes. Before attaching the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the cutting disc.

Maximum operating speed	Cutting disc diameter (mm)										
	50	76	100	115	125	150	180	230	300	350	400
80 m/s	30,500	20,100	15,300	13,300	12,200	10,200	8,500	6,600	5,100	4,400	3,800
100 m/s	38,200	25,100	19,100	16,650	16,600	12,700	10,600	8,300	6,400	5,400	4,700
	rpm										