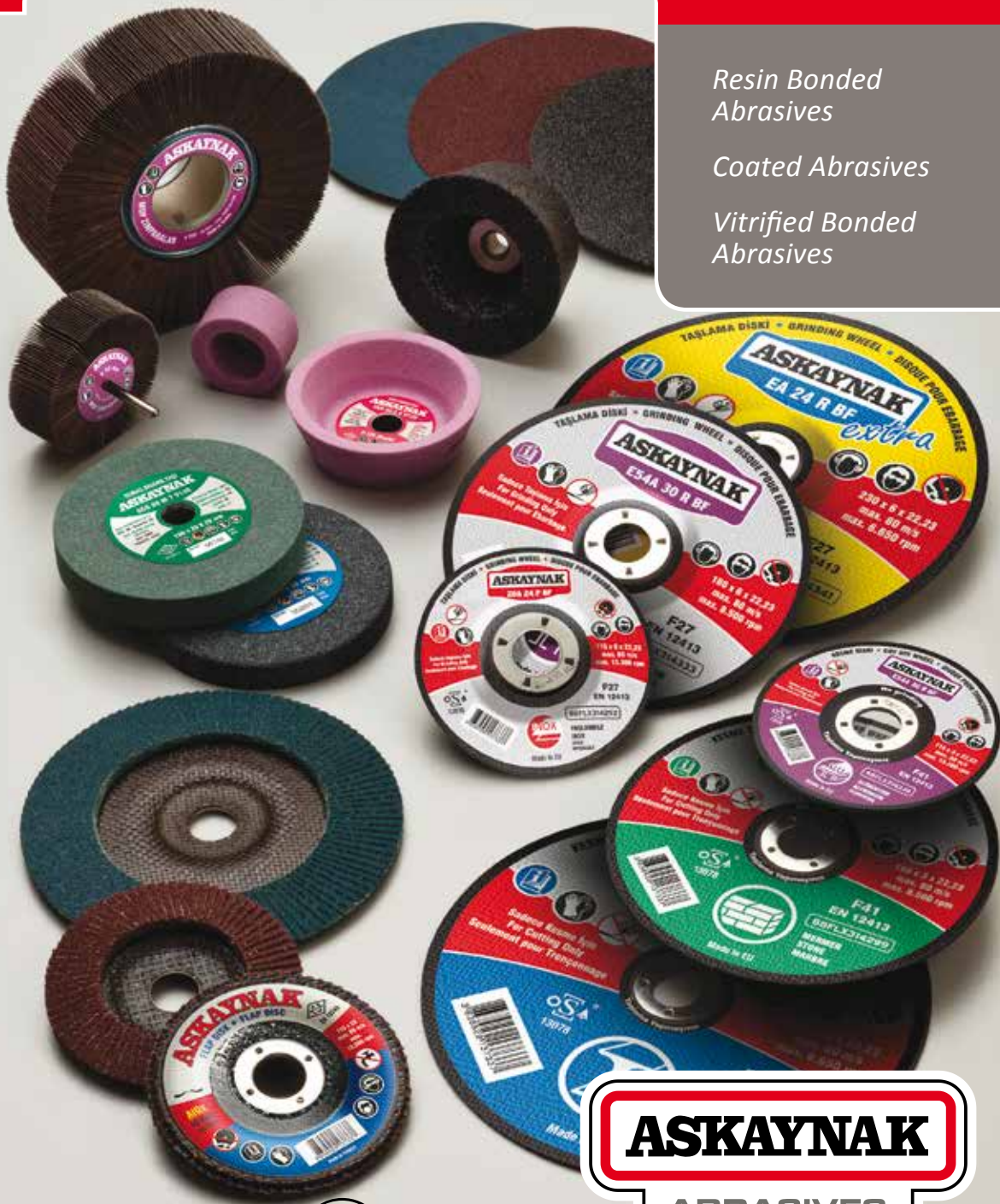


*Resin Bonded
Abrasives*

Coated Abrasives

*Vitrified Bonded
Abrasives*



ASKAYNAK

ABRASIVES



TUV NORD

EN 12413
EN 13743

Quality Certificates

Askaynak Abrasives

KAYNAK TEKNIĞİ SANAYİ ve TİCARET A.Ş. has ISO 9001 Quality Management System Certificate.

Flex cut-off / grinding wheels, mounted points and flap wheels under the brand "Askaynak" are manufactured in accordance with **OSA** (Organization for the Safety of Abrasives) and **FEPA** (Federation of European Producers of Abrasives) norms. FEPA regulates the safety in the use of abrasive products and the products which have OSA label, are approved of safety according to **EN 12413** and **EN 13743** standards.

Besides abrasive products under the brand "Askaynak" are in compliance with following standards. The testing procedures are based on these standards:

- Safety requirements for flex cut-off / grinding wheels and mounted points: **EN 12413**
- Safety requirements for flap wheels: **EN 13743**
- Safety requirements for vitrified bonded abrasives and SC cup wheels: **TS 291-1** (Turkish Standard)
- Safety requirements for flap and fiber discs: **TS EN 13743** (Turkish Standard)



TS EN 13743



TS 291-1

EN 12413
EN 13743

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Askaynak Abrasives

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Proper Storage and Usage

Askaynak Abrasives

Store in dry and well-ventilated areas in temperatures between 10°-30°C and 70 % relative humidity).

During transport, the storage areas should be as close to the place of use in order to avoid mechanical damage.



Do



- ✓ DO always visually inspect wheels before mounting for possible damage. Never use damaged ones.
- ✓ DO always allow new wheels to run at operating speed before grinding and cutting operation for at least 10 seconds to observe if there is something wrong with the wheel or not.
- ✓ DO always switch off the power at the supply before changing the wheel.
- ✓ DO always use the proper tools for changing the wheel.
- ✓ DO always wear protective gear: safety clothing, dust masks, eye protection (glasses or shield), gloves and ear protection.
- ✓ DO use reinforced cutting-off wheels on portable machines.
- ✓ DO always secure the workpiece firmly before beginning cutting or grinding operation. Fix the workpiece if possible.
- ✓ DO use wheels in proper ventilated areas.
- ✓ DO maintain the angle between cutting off wheel and the workpiece 90 degrees in cutting operations.
- ✓ DO grind with the prescribed angle in instructions for use section.

Do Not



- ✗ DON'T apply too much force on grinding machine while operating.
- ✗ DON'T mount broken or damaged wheels on grinding machines.
- ✗ DON'T mount the wheels on grinding machines with improper or damaged flanges.
- ✗ DON'T tighten flange excessively. This may cause damage of flange.
- ✗ DON'T use grinding machines with higher operating speed than the speed marked on the wheels.
- ✗ DON'T use damaged, broken down or improper grinding machines.
- ✗ DON'T smell the fume which could be occurred in cutting or grinding operation.
- ✗ DON'T stop the wheel after the operation by applying pressure on the floor or workpiece.
- ✗ DON'T use cutting-off wheels for grinding.
- ✗ DON'T store wheels in a damp atmosphere or in extreme temperatures.
- ✗ DON'T use a machine without a wheel guard.
- ✗ DON'T take the wheels out from the machine by hitting the wheel on the floor or workpiece. This may cause balance out or disintegration failure.

Pictogram Informations of Flex Wheels

Askaynak Abrasives

SAFETY INSTRUCTIONS



Please read the instructions **carefully**.



Use a safety shield or protective eyewear.



Use ear protection.



Use a dust mask.



Use protective gloves.



Use an appropriate safety shield when grinding.



Grinding **prohibited**.



Don't use free-hand grinding or cutting machine



Wet cutting **prohibited**.



Don't use damaged products.

APPLICATION AREAS



Steel



Inox



Aluminium



Cast Iron



Asphalt



Concrete



Stone

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Proper Usage

Askaynak Abrasives



Proper cutting methods of various metal forms.



Cutting of sheet metals



Cutting of thicker pieces

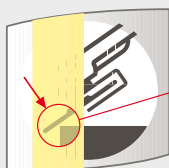


Always maintain the angle between grinding wheel and the workpiece 25-35 degrees to get the best grinding performance.

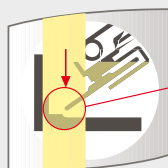
NEVER use cutting-off wheels for grinding!



NEVER grind laterally or using the flat part the grinding wheel!



During grinding be careful not to contact any surfaces which you do not want grind with the grinding wheel!

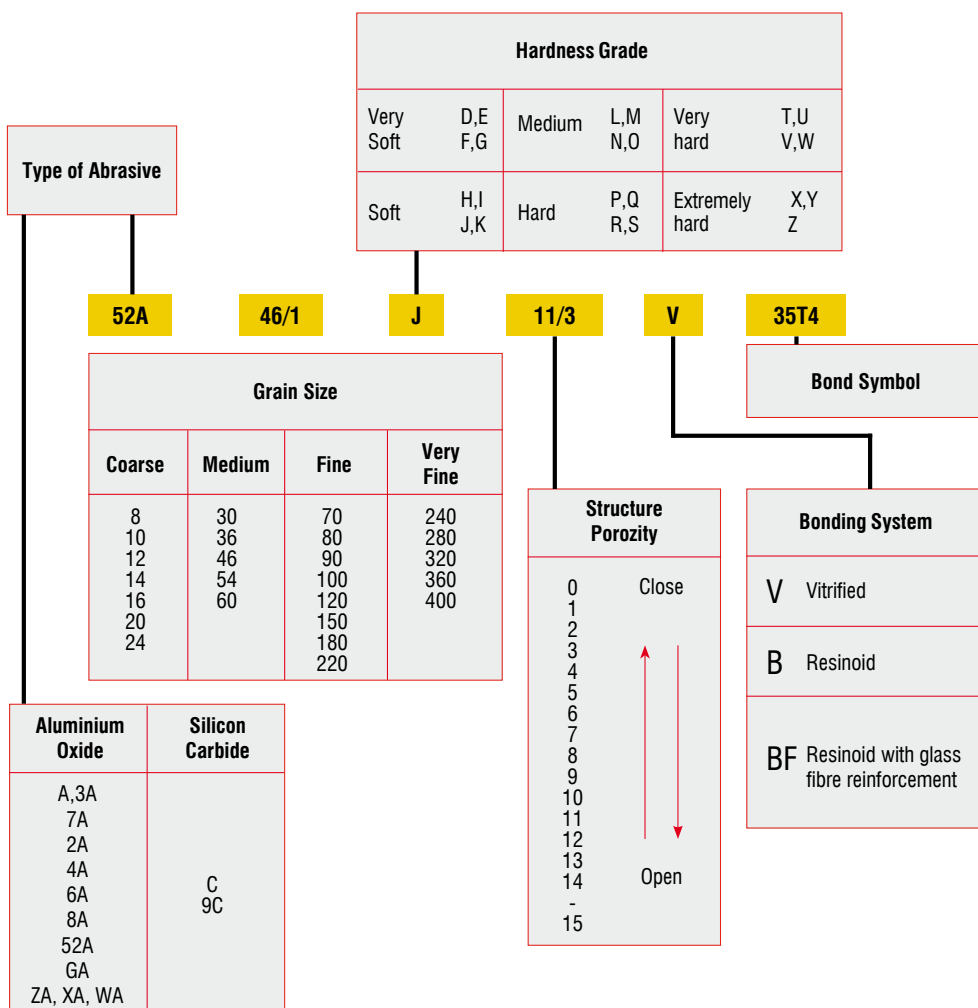


Marking System of Abrasives

Askaynak Abrasives

The specification of a grinding tool is determined by the following elements:

- Type of abrasive grain
- Grain size (and its combination)
- Hardness
- Structure
- Bonding system



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Specification of Abrasives

Askaynak Abrasives

The grinding tool consists of the abrasive grains, the binding components and pores. The abrasive grains function as cutting blades, while the bond holds the cutting particles together and forms together with them a compact unity.

ABRASIVE TYPES

NK -Regular aluminium oxide:

It is suitable for processing low-alloyed, unhardened steels with tensile strength between 300-500 N/mm².

EKW - Semi-friable aluminium oxide:

It is suitable for processing tempered tool steels and HSS.

EKR - Pink aluminium oxide:

It is suitable for processing high-alloyed steels with tensile strength greater than 500 N/mm².

SCG - Green silicon carbide:

Is an extremely hard material. It is suitable for processing carbide metals, grey iron and chilled iron, plastics, rubber, non-ferrous metals, ceramics, glass, nitralloy steels and acid-resistant steels.

SC - Black silicon carbide:

Is a little less brittle than silicon carbide and is used for grinding grey iron, non-ferrous metals, ceramics, glass, nitralloy steels and acid-resistant steels.

GRAIN SIZE

Grain size is specified with grit number which is the designation of abrasive grain size, reflecting the number of the smallest openings per linear inch in the screen through which the grain will pass. According to the fineness of abrasive wheel, grains can be coarse (grains 8-24), medium (grains 30-60), fine (grains 70-220) and very fine (grains 240-360). Abrasive wheels with coarse grains are chosen for coarse grinding of materials, and wheels with fine grains are chosen for precision grinding.

HARDNESS GRADE

The hardness of the grinding tools is proportional to the bond strength with which a single grain is tied in the bond-matrix. The grade of hardness is expressed by classes of hardness, designated with English alphabet letter symbols (capitals-D-Z).

It depends on the following:

- The quantity and type of bond
- The structure
- The type of the abrasive grain
- Grinding tool making procedure

STRUCTURE

Structure is determined by the volume and arrangement of abrasive grains within a abrasive tool. It is designated with number symbols from 0-18. It depends upon the relative distance between the individual abrasive grains. "Open" structured products provide better chip clearance, and "closed" structure products are used for low stock removal.

BOND

Wheel bond, how the wheel holds the abrasives, affects finish, coolant, and minimum/maximum wheel speed.

Vitrified Bond (V): This bond is brittle, it has no elasticity and is quite resistant to deformation.

Resinoid (B): This bond is less brittle, a little more elastic and is less resistant to deformation than the vitrified bonds. It also is a little less impact and percussion sensitive and less affected by changes in temperature than vitrified bonds.

Reinforced resinoid bond (BF): It is a variety of resinoid bond with fibreform material added (usually fibreglass-fabric). The bond thus reinforced exhibits a much greater range of strength and gives the products greater hardness as well as enables usage by increased operating speeds and side loads.

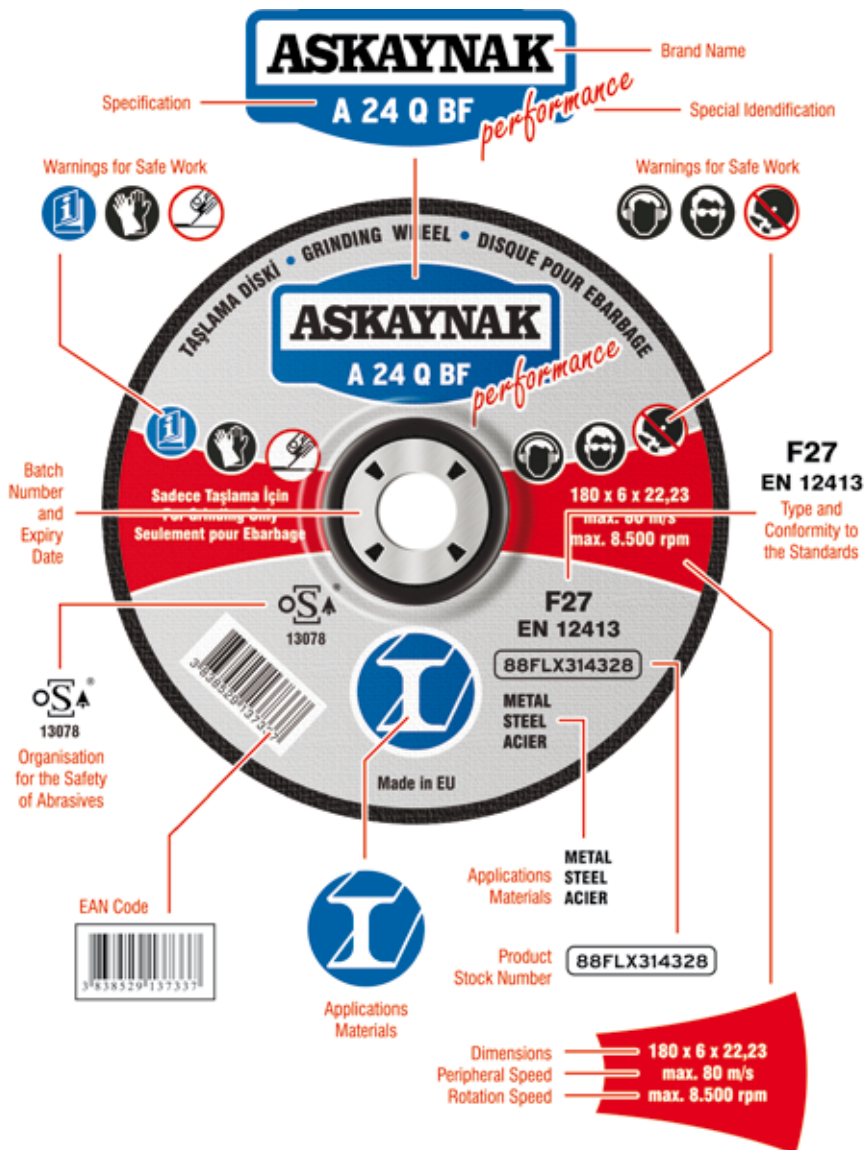
RESIN BONDED ABRASIVES



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Markings on Wheel Labels

Resin Bonded Abrasives



Flex Cut-Off Wheels

Resin Bonded Abrasives



✓✓✓ Excellent performance ✓✓ Good performance ✓ Can also be used on.					
	METAL A30 S	INOX 20A 30 P E20A 60 S E20A 46 S	CAST IRON 19A 30 S	STONE C 30 S	ALUMINIUM E54A 30 R E54A 60 S E54A 46 S
General construction steel	✓✓✓				
High strength construction steel	✓✓				
Tool steel	✓✓				
Low alloyed stainless steel	✓	✓✓✓			
High alloyed stainless steel	✓	✓✓✓			
Stainless steel sheet	✓	✓✓✓			
Grey cast iron	✓✓		✓✓✓		✓✓
Spherical cast iron	✓✓		✓✓✓		✓✓
Malleable cast iron	✓✓		✓✓✓		
Aluminium		✓✓	✓✓		✓✓✓
Brass		✓✓	✓		✓✓✓
Bronze		✓✓	✓		✓✓✓
Brick				✓✓✓	
Concrete				✓✓✓	
Ceramic				✓✓✓	
Marble and Granite				✓✓✓	
Stone				✓✓✓	

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Flex Cut-Off Wheels

Resin Bonded Abrasives

Metal Cut-off Wheels – A30 S BF

Application Area: Used for cutting operation of iron, steel and castings which have moderate hardness.



- Regular aluminium oxide
- For general applications
- Faster cutting
- Long life
- High cutting performance

FLAT DPC

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	A 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	A 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	A 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	A 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	A 30 S BF	80 m/s	6650	25

THINLINE - A 60 S BF / A 46 S BF

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 1 x 22.23	A 60 S BF	80 m/s	13300	50
115 x 1.6 x 22.23	A 60 S BF	80 m/s	13300	50
125 x 1 x 22.23	A 60 S BF	80 m/s	12250	50
125 x 1.6 x 22.23	A 60 S BF	80 m/s	12250	50
180 x 1.9 x 22.23	A 46 S BF	80 m/s	8500	25
230 x 1.9 x 22.23	A 46 S BF	80 m/s	6650	25

Inox Cut-off Wheels – 20A 30 P BF / E20A 60 S BF / E20A 46 S BF

Application Area: Used for cutting operation of low and high alloyed stainless steel materials, plates and sheets.



- Semi-friable aluminium oxide
- Faster cutting
- Cool cutting
- Long life
- Excellent quality
- THINLINE products are Fe, S and Cl free

FLAT DPC

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 3 x 22.23	20A 30 P BF	80 m/s	13300	25
125 x 3 x 22.23	20A 30 P BF	80 m/s	12250	25
180 x 3 x 22.23	20A 30 P BF	80 m/s	8500	25
230 x 3 x 22.23	20A 30 P BF	80 m/s	6650	25

FLAT

THINLINE - E20A 60 S BF / E20A 46 S BF

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNIT
115 x 1 x 22.23	E20A 60 S BF	80 m/s	13300	50
115 x 1.6 x 22.23	E20A 60 S BF	80 m/s	13300	50
125 x 1 x 22.23	E20A 60 S BF	80 m/s	12250	50
125 x 1.6 x 22.23	E20A 60 S BF	80 m/s	12250	50
180 x 1.9 x 22.23	E20A 46 S BF	80 m/s	8500	25
230 x 1.9 x 22.23	E20A 46 S BF	80 m/s	6650	25

Flex Cut-Off Wheels

Resin Bonded Abrasives

Cast Iron Cut-off Wheels – 19A 30 S BF

Application Area: Used for cutting operation of grey cast iron, spherical cast iron and malleable cast iron.



FLAT  DPC. 

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	19A 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	19A 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	19A 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	19A 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	19A 30 S BF	80 m/s	6650	25

- % 50 Aluminium oxide and % 50 Silicon carbide mixture
- Specially developed for cast iron
- Fast and easy cutting
- Long life
- Excellent quality

Stone Cut-off Wheels – C 30 S BF

Application Area: Used for cutting operation of marble, granite, brick and similar materials.



FLAT  DPC. 

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	C 30 S BF	80 m/s	15300	25
115 x 3 x 22.23	C 30 S BF	80 m/s	13300	25
125 x 3 x 22.23	C 30 S BF	80 m/s	12250	25
180 x 3 x 22.23	C 30 S BF	80 m/s	8500	25
230 x 3 x 22.23	C 30 S BF	80 m/s	6650	25

- Silicon carbide
- Specially developed for marble and ceramics
- Long life
- High cutting capacity

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Flex Cut-Off Wheels

Resin Bonded Abrasives

Aluminium Cut-off Wheels – E54A 30 R BF / E54A 60 S BF / E54A 46 S BF

Application Area: Used for cutting operation of aluminium and non-ferrous metals.



FLAT  DPC. 

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 3 x 16	E54A 30 R BF	80 m/s	15300	25
115 x 3 x 22.23	E54A 30 R BF	80 m/s	13300	25
125 x 3 x 22.23	E54A 30 R BF	80 m/s	12250	25
180 x 3 x 22.23	E54A 30 R BF	80 m/s	8500	25
230 x 3 x 22.23	E54A 30 R BF	80 m/s	6650	25

- Semi-friable aluminium oxide
- Specially developed for aluminium and non-ferrous metals
- Long life
- Excellent quality

FLAT 

THINLINE: E54A 60 S BF / E54A 46 S BF

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
115 x 1 x 22.23	E54A 60 S BF	80 m/s	13300	50
115 x 1.6 x 22.23	E54A 60 S BF	80 m/s	13300	50
125 x 1 x 22.23	E54A 60 S BF	80 m/s	12250	50
125 x 1.6 x 22.23	E54A 60 S BF	80 m/s	12250	50
180 x 1.9 x 22.23	E54A 46 S BF	80 m/s	8500	25
230 x 1.9 x 22.23	E54A 46 S BF	80 m/s	6650	25

Flex Cut-Off Wheels

Resin Bonded Abrasives

Stationary Cutting Machine Wheels (NK) – A 30 S BF

Application Area: Used for cutting operation of iron and steel materials at stationary cutting machine.



DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
300 x 3 x 25.4	A 30 S BF	80 m/s	5100	25
300 x 3 x 30	A 30 S BF	80 m/s	5100	25
350 x 3.5 x 25.5	A 30 S BF	80 m/s	4400	10
350 x 3.5 x 30	A 30 S BF	80 m/s	4400	10
400 x 4 x 40	A 24 S BF	80 m/s	3850	10

- Regular aluminium oxide

Stationary Cutting Machine Wheels (SC) – C 30 S BF

Application Area: Used for cutting operation of marble and cast iron at stationary cutting machine.



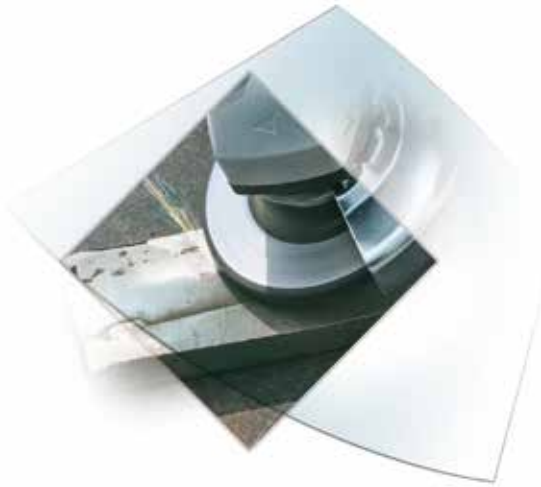
DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
300 x 3 x 25.4	C 30 S BF	80 m/s	5100	25
300 x 3 x 30	C 30 S BF	80 m/s	5100	25
350 x 3.5 x 25.5	C 30 S BF	80 m/s	4400	10
350 x 3.5 x 30	C 30 S BF	80 m/s	4400	10
400 x 4 x 40	C 30 S BF	80 m/s	3850	10









- Silicon carbide

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Flex Grinding Wheels

Resin Bonded Abrasives



✓✓✓ Excellent performance ✓✓ Good performance ✓ Can also be used on..								
	METAL PERFORMANCE A 24 Q	METAL ENDURO A 24 S	METAL EXTRA EA 24 R	METAL INOX 20 A 24 P	INOX 20A 24 P	CAST IRON 19A 24S	STONE C 24 S	ALUMINIUM E54A 30 R
General construction steel	✓✓✓	✓✓✓	✓✓✓	✓✓✓				
Heat treated steel	✓✓	✓	✓✓✓	✓✓✓				
For welding groove	✓✓✓	✓✓	✓✓✓	✓✓				
Welding burr grinding	✓✓✓	✓✓	✓✓✓	✓✓✓				
High strength construction steel	✓✓	✓✓	✓✓✓	✓✓✓				
Tool steels	✓✓	✓	✓✓✓	✓✓✓				
Low alloyed stainless steel	✓	✓	✓✓	✓✓	✓✓✓			
High alloyed stainless steel	✓	✓	✓✓	✓✓	✓✓✓			
Stainless steel sheet	✓	✓	✓✓	✓✓✓	✓✓✓			
Grey cast iron	✓	✓✓				✓✓✓		✓✓
Spherical cast iron	✓	✓✓				✓✓✓		✓✓
Malleable cast iron	✓	✓✓				✓✓✓		
Aluminium			✓	✓	✓✓	✓✓		✓✓✓
Brass			✓	✓	✓✓	✓✓		✓✓✓
Bronze			✓	✓	✓✓	✓✓		✓✓✓
Marble and granite							✓✓✓	
Stone							✓✓	

Flex Grinding Wheels

Resin Bonded Abrasives

Metal Grinding Wheels / Performance – A 24 Q BF

Application Area: Used for grinding operation of iron, steel and castings at moderate hardness with high stock removal performance.



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	A 24 Q BF	80 m/s	15300	10
115 x 6 x 22.23	A 24 Q BF	80 m/s	13300	10
125 x 6 x 22.23	A 24 Q BF	80 m/s	12250	10
180 x 6 x 22.23	A 24 Q BF	80 m/s	8500	10
180 x 8 x 22.23	A 24 Q BF	80 m/s	8500	10
180 x 10 x 22.23	A 24 Q BF	80 m/s	8500	10
230 x 6 x 22.23	A 24 Q BF	80 m/s	6650	10
230 x 8 x 22.23	A 24 Q BF	80 m/s	6650	10
230 x 10 x 22.23	A 24 Q BF	80 m/s	6650	10

- Regular aluminium oxide
- Easy use
- For general applications
- High performance
- Efficiency advantage

Metal Grinding Wheels / Enduro – A 24 S BF

Application Area: Used for grinding operation of iron, steel and castings at moderate hardness with long life



DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	A 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	A 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	A 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	A 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	A 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	A 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	A 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	A 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	A 24 S BF	80 m/s	6650	10

- Regular aluminium oxide
- For general applications
- Long life
- Specially developed for high strength steels

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Flex Grinding Wheels

Resin Bonded Abrasives

Metal Grinding Wheels / Extra – EA 24 R BF

Application Area: Primarily used for grinding operation of hardened steel and stainless steels, and also for grinding welding grooves and burrs.



- Regular aluminium oxide
- For general applications
- Cool cutting
- Long life
- High grinding performance
- Fast grinding

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	EA 24 R BF	80 m/s	15300	10
115 x 6 x 22.23	EA 24 R BF	80 m/s	13300	10
125 x 6 x 22.23	EA 24 R BF	80 m/s	12250	10
180 x 6 x 22.23	EA 24 R BF	80 m/s	8500	10
180 x 8 x 22.23	EA 24 R BF	80 m/s	8500	10
180 x 10 x 22.23	EA 24 R BF	80 m/s	8500	10
230 x 6 x 22.23	EA 24 R BF	80 m/s	6650	10
230 x 8 x 22.23	EA 24 R BF	80 m/s	6650	10
230 x 10 x 22.23	EA 24 R BF	80 m/s	6650	10

Metal - Inox Grinding Wheels – A 24 R

Application Area: Used for grinding operation of stainless steel, hardened steel and carbon steel.



- Semi-triangular aluminium oxide
- Specially designed for stainless steel and hardened steel.
- Cool cutting
- Long life

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	20A 24 9 BF	80 m/s	15300	10
115 x 6 x 22.23	20A 24 9 BF	80 m/s	13300	10
125 x 6 x 22.23	20A 24 9 BF	80 m/s	12250	10
180 x 6 x 22.23	20A 24 9 BF	80 m/s	8500	10
180 x 8 x 22.23	20A 24 9 BF	80 m/s	8500	10
230 x 6 x 22.23	20A 24 9 BF	80 m/s	6650	10
230 x 8 x 22.23	20A 24 9 BF	80 m/s	6650	10
230 x 10 x 22.23	20A 24 9 BF	80 m/s	6650	10

Flex Grinding Wheels

Resin Bonded Abrasives

Inox Grinding Wheels – 20A 24 P BF

Application Area: Used for grinding operation of stainless steel materials.



- Semi-friable aluminium oxide
- Specially designed for stainless steel
- Cool grinding
- Long life

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	20A 24 P BF	80 m/s	15300	10
115 x 6 x 22.23	20A 24 P BF	80 m/s	13300	10
125 x 6 x 22.23	20A 24 P BF	80 m/s	12250	10
180 x 6 x 22.23	20A 24 P BF	80 m/s	8500	10
180 x 8 x 22.23	20A 24 P BF	80 m/s	8500	10
180 x 10 x 22.23	20A 24 P BF	80 m/s	8500	10
230 x 6 x 22.23	20A 24 P BF	80 m/s	6650	10
230 x 8 x 22.23	20A 24 P BF	80 m/s	6650	10
230 x 10 x 22.23	20A 24 P BF	80 m/s	6650	10

Cast Iron Grinding Wheels – 19A 24 S BF

Application Area: Used for grinding operation of grey cast iron, spherical cast iron and malleable cast iron.



- % 50 Aluminium oxide and
- % 50 Silicon carbide mixture
- Specially designed for cast iron
- Long life
- Fast grinding

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	19A 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	19A 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	19A 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	19A 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	19A 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	19A 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	19A 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	19A 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	19A 24 S BF	80 m/s	6650	10

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Flex Grinding Wheels

Resin Bonded Abrasives

Stone Grinding Wheels – C 24 S BF

Application Area: Used for grinding operation of marble, granite and ceramic materials.



- Silicon carbide
- Specially designed for marble and granite
- Long life
- High grinding capacity

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	C 24 S BF	80 m/s	15300	10
115 x 6 x 22.23	C 24 S BF	80 m/s	13300	10
125 x 6 x 22.23	C 24 S BF	80 m/s	12250	10
180 x 6 x 22.23	C 24 S BF	80 m/s	8500	10
180 x 8 x 22.23	C 24 S BF	80 m/s	8500	10
180 x 10 x 22.23	C 24 S BF	80 m/s	8500	10
230 x 6 x 22.23	C 24 S BF	80 m/s	6650	10
230 x 8 x 22.23	C 24 S BF	80 m/s	6650	10
230 x 10 x 22.23	C 24 S BF	80 m/s	6650	10

Aluminium Grinding Wheels – E54A 30 R BF

Application Area: Used for grinding operation of aluminium and non-ferrous materials.



- Aluminium oxide
- Specially designed for aluminium
- Long life
- No clogging

DPC.

DIMENSIONS (mm)	SPECIFICATION	PERIPHERAL SPEED	R.P.M	BOX UNITS
100 x 6 x 16	E54A 30 R BF	80 m/s	15300	10
115 x 6 x 22.23	E54A 30 R BF	80 m/s	13300	10
125 x 6 x 22.23	E54A 30 R BF	80 m/s	12250	10
180 x 6 x 22.23	E54A 30 R BF	80 m/s	8500	10
180 x 8 x 22.23	E54A 30 R BF	80 m/s	8500	10
180 x 10 x 22.23	E54A 30 R BF	80 m/s	8500	10
230 x 6 x 22.23	E54A 30 R BF	80 m/s	6650	10
230 x 8 x 22.23	E54A 30 R BF	80 m/s	6650	10
230 x 10 x 22.23	E54A 30 R BF	80 m/s	6650	10

SC Cup Wheels

Resin Bonded Abrasives



Application Area: Used for surface grinding operation of marble, stone and granite materials in the masonry. They are made of silicon carbide abrasive grains.



Flaring Cup Wheel

SC 16 Q 5 BA
SC 24 Q 5 BA

FORM 11 with (M14)
Aluminium Bushing - Conical



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
100 x 45 x 14	16	24	4
100 x 50 x 14	16	24	4
130 x 45 x 14	16	24	4



Flat Cup Wheel

SC 16 Q 5 BA
SC 24 Q 5 BA

FORM 6 with (M14) Aluminium Bushing - Flat



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
100 x 45 x 14	16	24	4
100 x 50 x 14	16	24	4



Flaring Cup Wheel

SC 16 Q 5 BA
SC 24 Q 5 BA

SPECIAL FORM



DIMENSIONS (mm)	GRAIN SIZE		BOX UNITS
110 x 58 x 22	16	24	4

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COATED ABRASIVES



Flap Discs

Coated Abrasives

Aluminium Oxide Flap Discs

Application Area: Used for grinding operation of iron, steel and metals at moderate hardness.



CONICAL



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

FLAT



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

CONICAL



HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

FLAT

HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

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Flap Discs

Coated Abrasives

Zirconium Flap Discs

Application areas: An addition to application areas of aluminium oxide flap discs, zirconia is used for inox materials with cool cutting, high performance and long life.



CONICAL



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

FLAT



STANDARD					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
100 x 16	40	60	80	15300	10
115 x 22	40	60	80	13300	10
125 x 22	40	60	80	12250	10
180 x 22	40	60	80	8500	10

CONICAL



HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

FLAT

HIGH DENSITY (HD)					
DIMENSIONS (mm)	GRAIN SIZE			R.P.M	BOX UNITS
115 x 22	40	60	80	13300	10

Fibre Discs

Coated Abrasives

Aluminium Oxide Fibre Discs

Application Areas: Used for grinding and surface cleaning operation of iron, steel and inox materials at moderate hardness.



- Aluminium oxide
- Used for steel and inox
- High performance and long life
- Cool grinding

FLAT

GRAIN SIZE	DIMENSIONS (mm)				BOX UNITS
16	100 x 16	115 x 22	125 x 22	180 x 22	50
24	100 x 16	115 x 22	125 x 22	180 x 22	50
36	100 x 16	115 x 22	125 x 22	180 x 22	100
40	100 x 16	115 x 22	125 x 22	180 x 22	100
50	100 x 16	115 x 22	125 x 22	180 x 22	100
60	100 x 16	115 x 22	125 x 22	180 x 22	100
80	100 x 16	115 x 22	125 x 22	180 x 22	100
100	100 x 16	115 x 22	125 x 22	180 x 22	100
120	100 x 16	115 x 22	125 x 22	180 x 22	100

Silicon Carbide Fibre Discs

Application Areas: Used for rough and fine grinding operation of marble and stone materials in masonry and construction industry.



- Silicon carbide
- Used for marble and non-ferrous
- High performance
- Long life
- Specially developed for construction industry

FLAT

GRAIN SIZE	DIMENSIONS (mm)				BOX UNITS
16	100 x 16	115 x 22	125 x 22	180 x 22	50
24	100 x 16	115 x 22	125 x 22	180 x 22	50
36	100 x 16	115 x 22	125 x 22	180 x 22	100
40	100 x 16	115 x 22	125 x 22	180 x 22	100
50	100 x 16	115 x 22	125 x 22	180 x 22	100
60	100 x 16	115 x 22	125 x 22	180 x 22	100
80	100 x 16	115 x 22	125 x 22	180 x 22	100
100	100 x 16	115 x 22	125 x 22	180 x 22	100
200	100 x 16	115 x 22	125 x 22	180 x 22	100

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Flap Wheels

Coated Abrasives

A flap wheel is an abrasive wheel made from abrasive strips (flaps) radiating from a center hub. Flap wheels come in many different shapes and sizes. They give high stock removal performance, long work life and perfect surface quality in shaft mounted and unmounted types.

Shaft Mounted Flap Wheels

Application Areas: Used for finishing, cleaning, deburring and preparing for final treatment (e.g. varnishing), especially for steel and stainless steel materials. Particularly suitable for surfaces that are difficult to clean.



DIMENSIONS (mm)	GRAIN SIZE					BOX UNITS
30 x 10	40	60	80	120	150	25
30 x 15	40	60	80	120	150	25
30 x 20	40	60	80	120	150	25
40 x 10	40	60	80	120	150	25
40 x 15	40	60	80	120	150	25
40 x 20	40	60	80	120	150	25
40 x 30	40	60	80	120	150	25
50 x 10	40	60	80	120	150	25
50 x 15	40	60	80	120	150	25
50 x 20	40	60	80	120	150	25
50 x 30	40	60	80	120	150	25
50 x 40	40	60	80	120	150	25
60 x 15	40	60	80	120	150	25
60 x 20	40	60	80	120	150	25
60 x 30	40	60	80	120	150	25
60 x 40	40	60	80	120	150	25
80 x 20	40	60	80	120	150	25
80 x 30	40	60	80	120	150	25
80 x 40	40	60	80	120	150	25
80 x 50	40	60	80	120	150	25

Flap Wheels with Bore

Application Areas: Used for finishing operation of steel, inox and non-ferrous materials, suitable for portable machines and bench grinding machines.



DIMENSIONS (mm)	GRAIN SIZE			
165 x 30 x 54	60	80	100	120
165 x 50 x 54	60	80	100	120
200 x 50 x 54	60	80	100	120
250 x 50 x 54	60	80	100	120

VITRIFIED BONDED ABRASIVES



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NK Bench Grinding Wheels

Vitrified Bonded Abrasives

Application Area: Used for the grinding operation of tungsten carbide tools, glass, marbles and all non-ferrous metals at bench grinding machines.



FORM 1 



NK 24 Q 6 V130
NK 36 P 6 V130
NK 46 O 6 V130
NK 60 M 6 V130

DIMENSIONS (mm)	GRAIN SIZE				BOX UNITS
75 x 13 x 10	24	36	46	60	10
100 x 13 x 10	24	36	46	60	10
100 x 16 x 20	24	36	46	60	10
100 x 20 x 20	24	36	46	60	10
125 x 16 x 16	24	36	46	60	10
125 x 20 x 20	24	36	46	60	10
150 x 20 x 20	24	36	46	60	10
150 x 25 x 20	24	36	46	60	5
175 x 20 x 20	24	36	46	60	5
175 x 25 x 20	24	36	46	60	5
200 x 20 x 20	24	36	46	60	5
200 x 25 x 20	24	36	46	60	5
200 x 30 x 20	24	36	46	60	4
200 x 32 x 20	24	36	46	60	4
250 x 25 x 25	24	36	46	60	5
250 x 30 x 25	24	36	46	60	4
250 x 32 x 25	24	36	46	60	3
250 x 40 x 25	24	36	46	60	2
300 x 30 x 30	24	36	46	60	2
300 x 32 x 30	24	36	46	60	2
300 x 40 x 32	24	36	46	60	2
350 x 32 x 40	24	36	46	60	2
350 x 40 x 40	24	36	46	60	2
400 x 40 x 40	24	36	46	60	1

SCG Bench Grinding Wheels

Vitrified Bonded Abrasives

Application Area: Used for the grinding operation of tungsten carbide tools, glass, marbles and all non-ferrous metals at bench grinding machines.



SCG 80 M 7 V140

FORM 1 

DIMENSIONS (mm)	GRAIN SIZE	BOX UNITS
125 x 20 x 20	80	10
150 x 20 x 20	80	10
150 x 25 x 20	80	5
175 x 20 x 20	80	5
175 x 25 x 20	80	5
200 x 20 x 20	80	5
200 x 25 x 20	80	5
200 x 32 x 20	80	4
250 x 25 x 25	80	5
250 x 32 x 25	80	4
250 x 40 x 25	80	2
300 x 30 x 30	80	2
300 x 32 x 30	80	2
300 x 40 x 32	80	2
350 x 32 x 40	80	1
350 x 40 x 40	80	1
400 x 40 x 40	80	1

Saw Sharpening Wheels

Vitrified Bonded Abrasives

Saw Sharpening Wheels

Application Area: Used for the sharpening different types of sawtooths.



NK 60 O 4 V130
NEK 60 O 4 V130
EKR 60 O 4 V130

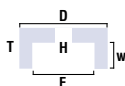
FORM C

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE			BOX UNITS
	NK 60	NEK 60	EKR 60	
150 x 6 x 20	NK 60	NEK 60	EKR 60	10
150 x 8 x 20	NK 60	NEK 60	EKR 60	10
150 x 10 x 20	NK 60	NEK 60	EKR 60	10
175 x 8 x 20	NK 60	NEK 60	EKR 60	10
175 x 10 x 20	NK 60	NEK 60	EKR 60	10
200 x 8 x 20	NK 60	NEK 60	EKR 60	10
200 x 10 x 20	NK 60	NEK 60	EKR 60	10
250 x 10 x 25	NK 60	NEK 60	EKR 60	10

EKR / EKW Cup Wheels

Vitrified Bonded Abrasives

Application Areas: Used for the grinding operation of cutting tools.

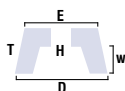


EKR 46 K 6 V130
EKR 60 K 6 V130
EKW 46 K 6 V130
EKW 60 K 6 V130

Form 6 - Flat Cup

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE				BOX UNITS
D-50	EKR 46	EKR 60	EKW 46	EKW 60	10
D-75	EKR 46	EKR 60	EKW 46	EKW 60	10
D-100	EKR 46	EKR 60	EKW 46	EKW 60	10
D-125	EKR 46	EKR 60	EKW 46	EKW 60	4
D-150	EKR 46	EKR 60	EKW 46	EKW 60	3

DIMENSIONS				
D	T	E	W	H
50	32	40	21	13
75	40	66	29	20
100	50	81	36	20
125	63	102	42	20
150	80	124	57	20



EKR 46 K 6 V130
EKR 60 K 6 V130
EKW 46 K 6 V130
EKW 60 K 6 V130

Form 11 - Conical Cup

DIMENSIONS (mm)	ABRASIVE TYPE/GRAIN SIZE				BOX UNITS
E-50	EKR 46	EKR 60	EKW 46	EKW 60	10
E-75	EKR 46	EKR 60	EKW 46	EKW 60	10
E-100	EKR 46	EKR 60	EKW 46	EKW 60	10
E-125	EKR 46	EKR 60	EKW 46	EKW 60	4
E-150	EKR 46	EKR 60	EKW 46	EKW 60	3

DIMENSIONS				
E	T	D	W	H
50	25	32	19	13
75	30	53	22	20
100	35	75	25	20
125	45	92	33	20
150	50	114	38	20

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Mounted Points

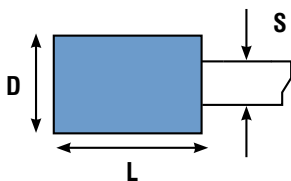
Vitrified Bonded Abrasives



Application Areas: Mounted points are used in toolrooms for manufacturing of various tools and for snagging of castings and forgings. Use A (shaped mounted point wheels with 6mm shank) shapes for medium- to heavy-duty blending.



Form B

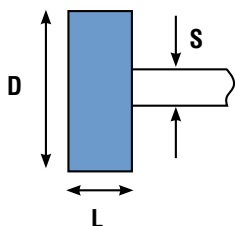


DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 15 x 6	40A 46 P 4 VL	20
15 x 20 x 6	40A 46 P 4 VL	20
15 x 25 x 6	40A 46 P 4 VL	20
15 x 30 x 6	40A 46 P 4 VL	20
15 x 35 x 6	40A 46 P 4 VL	20
15 x 40 x 6	40A 46 P 4 VL	20
20 x 20 x 6	40A 46 P 4 VL	20
20 x 25 x 6	40A 46 P 4 VL	20
20 x 30 x 6	40A 46 P 4 VL	20
20 x 35 x 6	40A 46 P 4 VL	20
20 x 40 x 6	40A 46 P 4 VL	20
25 x 25 x 6	40A 46 P 4 VL	5
25 x 30 x 6	40A 46 P 4 VL	5
25 x 32 x 6	40A 46 P 4 VL	5
25 x 35 x 6	40A 46 P 4 VL	5
25 x 40 x 6	40A 46 P 4 VL	5
30 x 30 x 6	40A 46 P 4 VL	5
30 x 35 x 6	40A 46 P 4 VL	5
30 x 40 x 6	40A 46 P 4 VL	5
32 x 32 x 6	40A 46 P 4 VL	5
32 x 40 x 6	40A 46 P 4 VL	5
40 x 40 x 6	40A 46 P 4 VL	5

Mounted Points

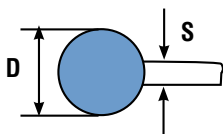
Vitrified Bonded Abrasives

Form A



DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 10 x 6	40A 46 P 4 VL	20
20 x 10 x 6	40A 46 P 4 VL	20
20 x 15 x 6	40A 46 P 4 VL	20
25 x 10 x 6	40A 46 P 4 VL	5
25 x 15 x 6	40A 46 P 4 VL	5
25 x 20 x 6	40A 46 P 4 VL	5
30 x 10 x 6	40A 46 P 4 VL	5
30 x 15 x 6	40A 46 P 4 VL	5
30 x 20 x 6	40A 46 P 4 VL	5
30 x 25 x 6	40A 46 P 4 VL	5
32 x 20 x 6	40A 46 P 4 VL	5
40 x 15 x 6	40A 46 P 4 VL	5
40 x 20 x 6	40A 46 P 4 VL	5
40 x 25 x 6	40A 46 P 4 VL	5
40 x 30 x 6	40A 46 P 4 VL	5

Form H



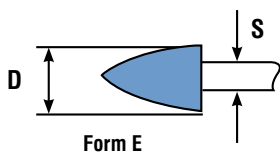
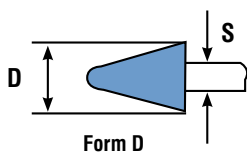
DIMENSIONS (mm) [D x S]	SPECIFICATION	BOX UNITS
15 x 6	40A 46 P 4 VL	20
20 x 6	40A 46 P 4 VL	20
25 x 6	40A 46 P 4 VL	5
30 x 6	40A 46 P 4 VL	5
32 x 6	40A 46 P 4 VL	5

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Mounted Points

Vitrified Bonded Abrasives

Form D / Form E



DIMENSIONS (mm) [D x L x S]	SPECIFICATION	BOX UNITS
15 x 15 x 6	40A 46 P 4 VL	20
15 x 20 x 6	40A 46 P 4 VL	20
15 x 25 x 6	40A 46 P 4 VL	20
15 x 30 x 6	40A 46 P 4 VL	20
15 x 32 x 6	40A 46 P 4 VL	20
15 x 35 x 6	40A 46 P 4 VL	20
15 x 40 x 6	40A 46 P 4 VL	20
20 x 20 x 6	40A 46 P 4 VL	20
20 x 25 x 6	40A 46 P 4 VL	20
20 x 30 x 6	40A 46 P 4 VL	20
20 x 35 x 6	40A 46 P 4 VL	20
20 x 40 x 6	40A 46 P 4 VL	20
25 x 25 x 6	40A 46 P 4 VL	5
25 x 30 x 6	40A 46 P 4 VL	5
25 x 32 x 6	40A 46 P 4 VL	5
25 x 35 x 6	40A 46 P 4 VL	5
25 x 40 x 6	40A 46 P 4 VL	5
30 x 30 x 6	40A 46 P 4 VL	5
30 x 40 x 6	40A 46 P 4 VL	5
32 x 32 x 6	40A 46 P 4 VL	5
32 x 40 x 6	40A 46 P 4 VL	5
35 x 25 x 6	40A 46 P 4 VL	5
40 x 30 x 6	40A 46 P 4 VL	5
40 x 40 x 6	40A 46 P 4 VL	5

Troubleshooting for Flex Wheels

Askaynak Abrasives

PROBLEM	CAUSE	REMEDY
<ul style="list-style-type: none"> F27 not grinding 	<ul style="list-style-type: none"> Flat grinding Wheel too hard 	<ul style="list-style-type: none"> Maintain angle 25°-35° Use softer wheel
<ul style="list-style-type: none"> Wheel not cutting 	<ul style="list-style-type: none"> Wheel glazing 	<ul style="list-style-type: none"> Use softer wheel
<ul style="list-style-type: none"> Wheel wearing too soon 	<ul style="list-style-type: none"> Wheel too soft 	<ul style="list-style-type: none"> Use harder wheel
<ul style="list-style-type: none"> Burning 	<ul style="list-style-type: none"> Wheel too hard 	<ul style="list-style-type: none"> Use softer wheel, Use s freer cutting abrasive
<ul style="list-style-type: none"> Chatter marks 	<ul style="list-style-type: none"> Machine vibration Wheel out of balance Mounting insecure 	<ul style="list-style-type: none"> Check wear in machine bearing Balance the wheel Tighten wheel mounting
<ul style="list-style-type: none"> Uneven use of the wheel 	<ul style="list-style-type: none"> Unbalance Run out not ok Incorrect mounting 	<ul style="list-style-type: none"> Change the wheel Change the wheel Checking (dirt, flange,...)
<ul style="list-style-type: none"> Wheel breakage 	<ul style="list-style-type: none"> To high speed To much pressure To much side pressure Cutting wheel used for grinding 	<ul style="list-style-type: none"> Use prescribed speed Don't use force Maintain angle 90 °(F41, F42) Don't grind with cutting wheel

