

PRODUCT RANGE 2020 / 2021



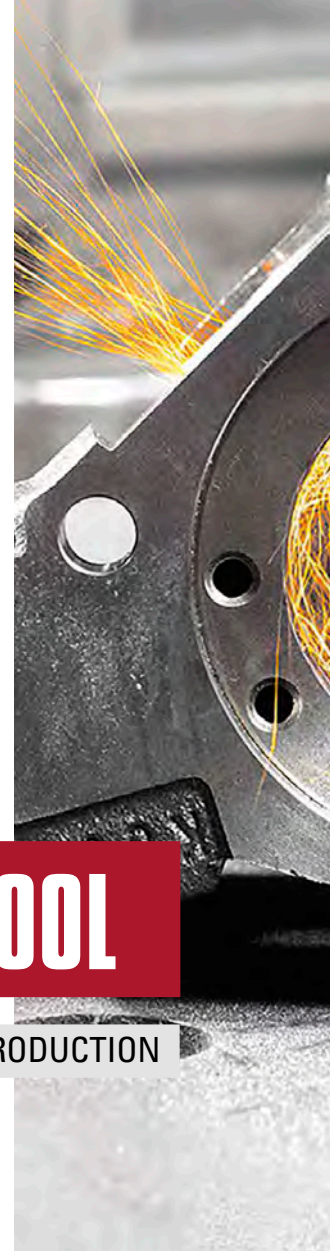




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# ALWAYS THE RIGHT TOOL

EXCELLENT AVAILABILITY • BROAD RANGE OF PRODUCTS • CUSTOMISED PRODUCTION

**700**  
EMPLOYEES

**TAKE THE FUTURE INTO YOUR HANDS TODAY**  
LUKAS has been manufacturing leading-edge tools for over 80 years. We know that new challenges call for new solutions – so that's exactly what we're working on every day. We combine quality and safety with forward-thinking solutions that always keep new developments in different industries in mind. This focus gave us the lead early in the market and still does to this day.

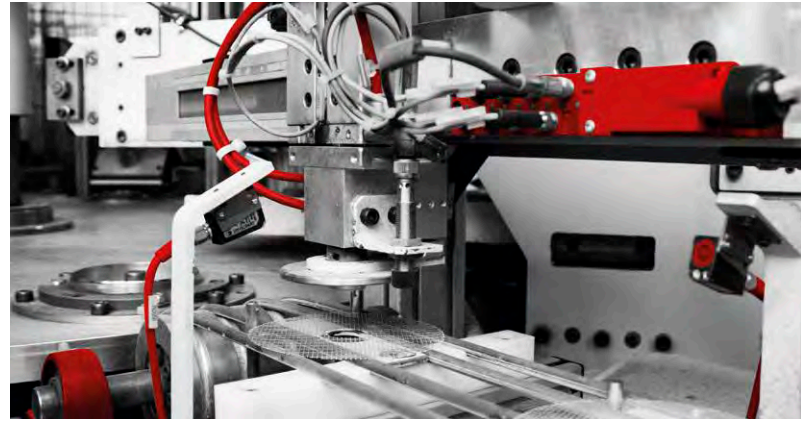
**30000**  
CUSTOMERS WORLD-WIDE

**FIRMLY ESTABLISHED ON THE MARKET**  
With around 700 employees, state-of-the-art production sites, an enormous wealth of experience and a broad product portfolio, LUKAS is well established on the market. We focus on our customers, combining a pioneering spirit with flexibility and a human touch.

GRINDING •

DEVELOPING  
TOOLS FOR**80** YEARS

POLISHING • MILLING • CUTTING • CUSTOMISED TOOLS

**SPECIALIST FOR INNOVATIVE SOLUTIONS**

Today, we are known around the world for our innovative solutions and high-performance tools. If standard solutions don't suit, we develop customised solutions to satisfy every application. This way, both your products and ours will always be ready for whatever the future holds.

**EXPERTISE ON CALL**

Our development team has many years of experience and a deep knowledge of customers, production and industry. This expertise allows us to help you on site with whatever challenges you are facing. Our experienced experts familiarise themselves with your tasks, applications and processes, so that they can develop a solution that fits perfectly. From developing new products or variations to testing and optimisation, we make sure that your products and services are successful.

**10 000**CUSTOMISED SOLUTIONS AND NUMEROUS  
INNOVATIONS DEPLOYED WORLDWIDE





## MODERN LOGISTICS

OPTIMISED PROCESSES FOR ON-DEMAND DELIVERY

### FAST, FLEXIBLE AND ON TIME

Our smart logistics system simplifies your warehouse management. High delivery capability, an ultra-modern logistics centre and our speedy shipping agents ensure that the right tool is always there at the right time.

# 8000

SQUARE METERS OF LOGISTICS SPACE



## PERSONAL ON-SITE CONSULTATION

WE SHARE OUR KNOWLEDGE FOR YOUR SUCCESS

### SHARING OUR KNOWLEDGE.

Visit our TECHNIKUM – where you can have our expertise at your fingertips. Straight after the training class, you'll have a chance to put the theory into practice in our grinding centre next door. And if you have any specific application problems, our application and design engineers have an answer to (almost) every question.

Make the most of our "mobile TECHNIKUM", too. The LUKAS van contains everything you need for a professional tool seminar. Why not use the LUKAS van for a time-saving staff training session at your own premises?

# 200

PEOPLE ATTEND OUR  
SEMINARS EVERY YEAR

# THE RIGHT INFORMATION, ANYTIME AND ANYWHERE

PRODUCT INFORMATION AND MORE FROM AROUND THE WORLD

## LUKAS WEBSITE

Are you looking for information about our products, want to find out about our specialised industrial solutions, or just need the right contact partner in your sales area for questions? Our website has all the information you need. Here you can find everything you need to know about our products and services. From user seminars to advice on surface optimisation, the LUKAS website offers wide-ranging training options and background information about our products.

<https://www.lukas-erzett.com>

ORDER ONLINE AROUND  
THE CLOCK

**365**  
DAYS A YEAR

## LUKAS ONLINE SHOP

From tradespeople and DIY enthusiasts to industry, the LUKAS online shop is the place to purchase our tried-and-tested tools. You can have our tools delivered to your home, office or factory. Whether you want to test and compare or need the right solution to use right away, our online shop has the tools you need for every job.

<https://shop.lukas-erzett.com>

## LUKAS ON FACEBOOK

Get the latest information about our trade fairs, new products and everything that is going on in our company. Our Facebook page provides exciting news from LUKAS every day, including videos and pictures from the world of tool production.

<https://www.facebook.com/LukasErzett>



**4500**

PRODUCTS READY FOR  
SHIPMENT ACROSS EUROPE  
WITHIN 48 HOURS



## EXPERTISE WITH A HUMAN TOUCH

LUKAS SERVICE AND SALES STAFF ARE JUST A CALL AWAY WORLDWIDE

We want our tools to increase your efficiency and success. We know the challenges you face in your day-to-day work. Our experienced LUKAS sales staff have the technical expertise required to give you advice on the phone. They can also come to you

to co-develop the right product and application solutions with you. We speak your language and can help you find the right tool for the job. Get in touch with us!

- expert technical consultation
- local contact partners
- collaborative consultation
- excellent service
- personal customer relations
- help and advice in the event of problems

Contact our sales team at:  
[le@lukas-erzett.de](mailto:le@lukas-erzett.de)



20

SECTORS AND INDUSTRIES  
PUT THEIR TRUST IN OUR  
QUALITY AND EXPERIENCE**TOP-LEVEL QUALITY**

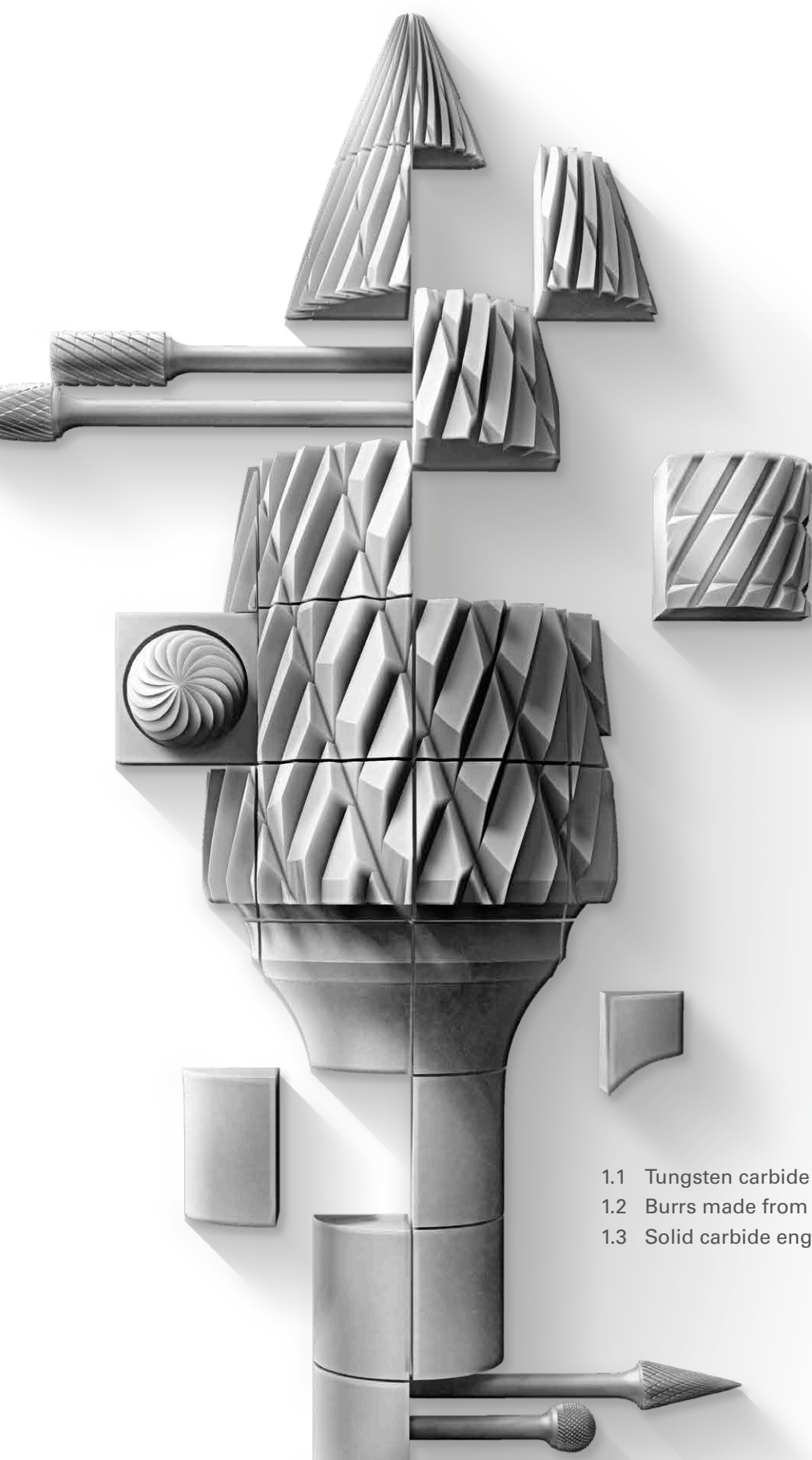
LUKAS IS DEDICATED TO QUALITY

We don't talk about quality, we let it speak for itself, every day, and in everything we do. This practice makes LUKAS tools a safe, reliable factor in your manufacturing process and ensures the best possible production quality.



- made in Germany
- premium raw materials
- modern testing facilities
- quality management system to ISO 9001:2015
- active member of industry associations





# MILLING

- 1.1 Tungsten carbide burrs
- 1.2 Burrs made from HSS
- 1.3 Solid carbide engraving cutters

12–44  
45–55  
56–57

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS tungsten carbide burrs

## QUALITY

LUKAS carbide burrs are manufactured using high-quality solid carbides on modern CNC automatic grinding machines in order to guarantee precision and repeatability of angle, profile and twist. We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

## APPLICATION

Selecting the right cut and speed is key for achieving the best results when working with a variety of materials. Please refer to the tables for cut and cutting speed on **page 15**.

## POWER TOOLS

Electrical or pneumatic tools, with bearings and collets that are in good condition and run true, are key to getting perfect results. Vibration and chatter will cause premature wear and tooth breakage. Excessive working pressure will increase wear but not increase performance.

## SHANKS

For safety reasons, always choose the largest shank diameter available from the table. All burr shanks from LUKAS have a shank diameter tolerance of h9 to ensure safe and smooth assembly. Other shank lengths and diameters are available upon request. See **pages 38–40** for a selection of burrs with extra-long shank.

## ROBOT APPLICATION

LUKAS solid carbide burrs are precision tools that have proven themselves in deburring work with industrial robots. We can also develop the perfect tool to suit your application.

## SPECIAL TOOLS

We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

## PACKAGING

We use plastic packaging. Please refer to the product tables for the respective packaging units.

## RECOMMENDATIONS FOR USE

Select the cut according to the material to be machined. The rule of thumb is: **the harder the material, the finer the cut.**


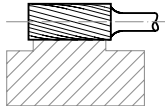

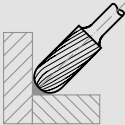

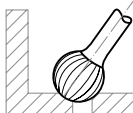

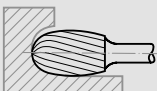
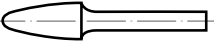
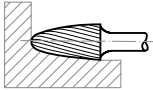

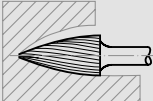

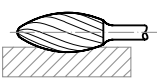
Selecting the right speed is key when it comes to achieving perfect working results and long tool life. The following pages contain information that can help you determine the right speed for your process.


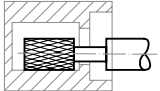
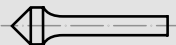
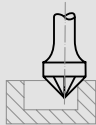

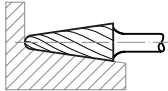

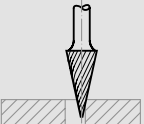
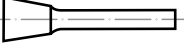
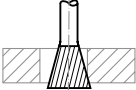

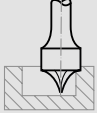
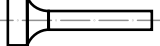
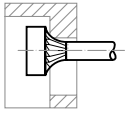
Use the highest speeds possible within the ranges listed. **Speeds that are too low cause vibration, chipping and premature wear!** Reduce the speed of the burrs only when working with large contact angles or materials with low heat conductivity. **Never allow blue discolouration to appear on the shank and head.** For safety reasons, the use of longer shanks requires lower speeds.

Always ensure the settings of your power tool are properly adjusted for the job and material at hand. Avoid a reduction in speed caused by insufficient drive power, especially when using pneumatic machines. Only use collets that run true. Run-out and vibration will result in chipping and premature wear. For the same reasons, make sure that the machine bearings are in perfect condition. To avoid vibrations and shank breakage, select the shortest shank overhang possible.

## SHAPE

## A summary of available shapes

Shape		Application
	<b>HFA</b> Cylindrical	
	<b>HFC</b> Cylindrical round nose	
	<b>HFD</b> Spherical	
	<b>HFE</b> Oval	
	<b>HFF</b> Arch round nose	
	<b>HFG</b> Arch pointed nose	
	<b>HFH</b> Flame	

Shape		Application
	<b>HFI</b> Internal	
	<b>HFJ</b> Counter sink	
	<b>HFL</b> Conical round nose	
	<b>HFM</b> Conical pointed nose	
	<b>HFN</b> Inverted cone	
	Burrs for radius trimming (external)	
	Burrs for radius trimming (internal)	

## LUKAS BURR SETS

Have the right tool for any application. Choose from our assortment of burrs to try out, test, for your toolbox and much more on **page 43**.

## POWER TOOLS

You can find the right power tools for our LUKAS tools on **pages 304–312**. Our power tools are designed for use with LUKAS tools and ensure highly efficient use.

## RECOMMENDATIONS FOR USE AND CUTS

## Three steps to your perfect tungsten carbide burr

## STEP 1

Begin by selecting the right **material** and **machining mode** (coarse to fine) from the table.

## STEP 2

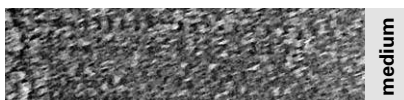
Read off the recommended **cut** and **cutting speed**.

Material	Strength (N/mm <sup>2</sup> )	Machining	Cut	Recommended cutting speed $v_c$ (m/min)
● Steel, cast steel	up to 800	coarse	Z3, Z7 Steel, ZX	500–700
		medium	Z5, Z42 Inox/Steel	300–500
		fine	ZF3	500–700
	800 to 1,200	coarse	Z7 Steel, ZX	400–600
		medium	Z5	300–400
		fine	ZF3	400–600
	from 1,200	coarse	Z7 Steel, Z4	300–500
		medium	Z5	300–400
		fine	ZF3	400–600
● Stainless steel	up to 800	coarse	Z2, Z6	400–500
		medium	Z3, Z7 Steel, Z4, Z5, Z42 Inox/Steel	300–500
		fine	ZF3	400–600
● Cast material	150 to 300	coarse	Cast, Z6	400–600
		medium	Z7 Steel	300–500
	300 to 450	coarse	Cast, Z7 Steel	300–500
		medium	Z5	300–500
		fine	ZF3	400–700
● Aluminium	up to 450	coarse	Z9 Alu	600–1,000
		medium	Z1	500–900
● Brass and bronze	up to 450	coarse	Z9 Alu, Z1	400–800
	from 450	medium	Z2	400–600
		fine	ZF3	500–600
● Titanium	up to 900	coarse	Z6	300–500
		medium	Z7 Steel	300–400
		fine	ZF3	500–700
	900 to 1,500	coarse	Z4	300–400
		medium	Z5	400–500
		fine	ZF3	400–600
● Plastic and wood	20 to 400	coarse	Composite coarse/fine, Z1, Z9 Alu	600–1,000
		fine	Composite coarse/fine, Wood	500–900
	400 to 1,000	coarse	Composite coarse/fine, Z1	500–800
		fine	Composite coarse/fine, Z2, Wood	400–800

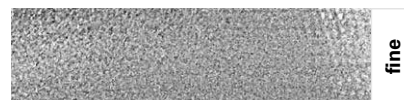
## MACHINING



coarse



medium



fine



## STEP 3




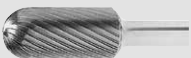
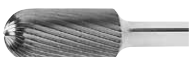
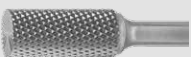

Determine the appropriate **speed** for your power tool in the second table, based on the tool diameter and cutting speed.



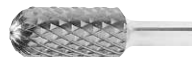


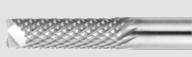

Recommended cutting speed $v_c$ (m/min)									
		300	400	500	600	700	800	900	1,000
Tool diameter (mm)	2	48,000	64,000	80,000	95,000	111,000	127,000	143,000	159,000
	3	32,000	42,000	53,000	64,000	74,000	85,000	95,000	106,000
	4	24,000	32,000	40,000	48,000	56,000	64,000	72,000	80,000
	6	16,000	21,000	27,000	32,000	37,000	42,000	48,000	53,000
	8	12,000	16,000	20,000	24,000	28,000	32,000	36,000	40,000
	10	10,000	13,000	16,000	19,000	22,000	25,000	29,000	32,000
	12	8,000	11,000	13,000	16,000	19,000	21,000	24,000	27,000
	16	6,000	8,000	10,000	12,000	14,000	16,000	18,000	20,000
	20	5,000	6,000	8,000	10,000	11,000	13,000	14,000	16,000
Speed (rpm)									

**TIP:**

You can find the full overview of shapes for your perfect burr on **page 13**.

## CUTS

Cut		Properties	Page
	Z9 Alu	very coarse single cut with faceting for soft materials	31/32
	Z1	coarse cut for soft materials	30
	Z2 Brass	robust single cut for high stock removal	30
	Z3	medium single cut	26/27, 37, 39
	Z5 Hard	very fine single cut for high-quality surfaces	25, 34/35
	ZF1 to ZF3	fine cross cuts from coarse to very fine for perfect surfaces	33/34
	Wood	rasp cut for pattern construction	29

Cut		Properties	Page
	Z42 Inox/Steel	robust faceted toothing for Inox and steel	20
	Z4	fine cross cut for hard materials	22/23
	Z6	robust cross cut	23
	Z7 Steel	medium cross cut	17–19, 38
	Cast	robust cross cut specially designed for cast materials	21
	Composite Coarse and Fine	cross cut for machining plastic	28
	ZX	universal cross cut for almost all applications	40–42

## COATINGS


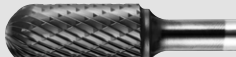



# Custom optimisation with LUKAS coatings

The use of hard coatings like TiN, TiCN, TiAlN and LTE on cutting tools from LUKAS can help:

- increase tool life
- make the tool more efficient and reduce machine load
- improve chip removal

The increase in tool life is mainly the result of the considerably higher surface hardness of the coating in comparison to the base material of the tool itself. The high chemical stability of the coatings also minimises reactions between the cutting edge of the tool and the chip.

The reduction of machine load and the improvement in chip removal are achieved through a reduction in the friction between the free cutting zone of the tool and workpiece on the one hand, and the cutting edge of the tool and the chip removed on the other. The reduction in friction is due to the coating improving the surface finish and largely preventing chemical reactions. Our technicians would be pleased to help you in the selection of the correct coating.

	Special feature	Properties	Coating	Friction on steel $\mu\text{m}$
<b>AllCoat*</b> 	general purpose	<ul style="list-style-type: none"> <li>■ general-purpose wear protection when machining ferrous metals (like steel and cast iron) and plastic</li> <li>■ high toughness</li> <li>■ food safe</li> <li>■ biocompatible</li> </ul>	<b>TiN</b> (titanium nitride)	0.65–0.70
<b>HeavyDuty</b> 	suitable for extreme thermal and mechanical shock loads	<ul style="list-style-type: none"> <li>■ high-performance coating with high hardness and low heat conductivity for use when machining highly abrasive and hard materials (such as steel, non-rusting steels and stainless steel)</li> <li>■ for milling under extreme conditions</li> <li>■ for high-performance cutting</li> </ul>	<b>TiAlN</b> (titanium aluminium nitride) see page 17	0.30–0.35
<b>ThermoShock*</b> 	high and sudden thermal shock loads	<ul style="list-style-type: none"> <li>■ wear-resistant coating, particularly well suited to machining difficult-to-process steel alloys (high and low-alloy steels)</li> <li>■ for fine deburring</li> </ul>	<b>TiCN</b> (titanium carbon nitride)	0.10–0.20
<b>LowFriction*</b> 	lotus effect	<ul style="list-style-type: none"> <li>■ special coating with lotus effect for long chip and smearing non-ferrous metals, especially aluminium alloys</li> <li>■ significantly reduces friction and adhesive wear</li> <li>■ reduces loading</li> </ul>	<b>LTE</b> (hard, carbon-based coating)	0.10–0.20
<b>LightFlow</b> 	easy chip removal	<ul style="list-style-type: none"> <li>■ combines high wear resistance with outstanding friction and non-stick properties when used on graphite, aluminium, copper, carbon, wood and titanium alloys</li> <li>■ perfect surface treatment for significantly reduced wear</li> </ul>	<b>TT®-ta-C</b> (carbon layer made from solid carbon) see page 31	0.05–0.10 (dry)

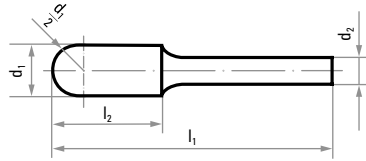
\* upon request



## Z7 Steel burr with HeavyDuty coating

MILLING

- high-performance coating for processing very hard and abrasive materials
- for extreme applications
- for high thermal and mechanical shock loads

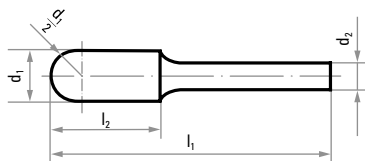
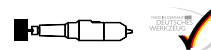


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Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010616608TIALN	HFA 0616.06		Z7 Steel	ZYA 0616	6	16	6	50	1
A10010820608TIALN	HFA 0820.06		Z7 Steel	ZYA 0820	8	20	6	60	1
A10011020608TIALN	HFA 1020.06		Z7 Steel	ZYA 1020	10	20	6	60	1
A10010820608TIAL1	HFAS 0820.06		Z7 Steel	ZYA-S 0820	8	20	6	60	1
A10011020608TIAL1	HFAS 1020.06		Z7 Steel	ZYA-S 1020	10	20	6	60	1
A10011225608TIAL1	HFAS 1225.06		Z7 Steel	ZYA-S 1225	12	25	6	65	1
A10020616608TIALN	HFC 0616.06		Z7 Steel	WRC 0616	6	16	6	50	1
A10020820608TIALN	HFC 0820.06		Z7 Steel	WRC 0820	8	20	6	60	1
A10021020608TIALN	HFC 1020.06		Z7 Steel	WRC 1020	10	20	6	60	1
A10021225608TIALN	HFC 1225.06		Z7 Steel	WRC 1225	12	25	6	65	1
A10030606608TIALN	HFD 0605.06		Z7 Steel	KUD 0605	6	5	6	50	1
A10030808608TIALN	HFD 0807.06		Z7 Steel	KUD 0807	8	7	6	47	1
A10031010608TIALN	HFD 1009.06		Z7 Steel	KUD 1009	10	9	6	49	1
A10101225608TIALN	HFF 1225.06		Z7 Steel	RBf 1225	12	25	6	65	1
A10040618608TIALN	HFG 0618.06		Z7 Steel	SPG 0618	6	18	6	50	1
A10041020608TIALN	HFG 1020.06		Z7 Steel	SPG 1020	10	20	6	60	1
A10041225608TIALN	HFG 1225.06		Z7 Steel	SPG 1225	12	25	6	65	1
A10041630608TIALN	HFG 1630.06		Z7 Steel	SPG 1630	16	30	6	70	1
A10090820608TIALN	HFH 0820.06		Z7 Steel	–	8	20	6	60	1
A10091230608TIALN	HFH 1230.06		Z7 Steel	–	12	30	6	70	1
A10071020608TIALN	HFL 1020.06		Z7 Steel	KEL 1020	10	20	6	60	1
A10051020608TIALN	HFM 1020.06		Z7 Steel	SKM 1020	10	20	6	60	1

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

## Z7 Steel burr













★★☆

- Thanks to the central cross cut, this burr is perfect for use on steel.
- Our choice of shapes lets you find the right tool for every application.

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010313308	HFA 0313.03		Z7 Steel	ZYA 0313	3	13	3	40	1
A10010413608	HFA 0413.06		Z7 Steel	ZYA 0413	4	13	6	50	1
A10010613308	HFA 0613.03		Z7 Steel	ZYA 0613	6	13	3	43	1
A10010616608	HFA 0616.06		Z7 Steel	ZYA 0616	6	16	6	50	1
A10010820608	HFA 0820.06		Z7 Steel	ZYA 0820	8	20	6	60	1
A10011020608	HFA 1020.06		Z7 Steel	ZYA 1020	10	20	6	60	1
A10011025608	HFA 1025.06		Z7 Steel	ZYA 1025	10	25	6	65	1
A10011225608	HFA 1225.06		Z7 Steel	ZYA 1225	12	25	6	65	1
A10011625608	HFA 1625.06		Z7 Steel	ZYA 1625	16	25	6	65	1
A100103133080001	HFAS 0313.03		Z7 Steel	ZYA-S 0313	3	13	3	40	1
A100104136080001	HFAS 0413.06		Z7 Steel	ZYA-S 0413	4	13	6	50	1
A100106133080001	HFAS 0613.03		Z7 Steel	ZYA-S 0613	6	13	3	43	1
A100106166080001	HFAS 0616.06		Z7 Steel	ZYA-S 0616	6	16	6	50	1
A100108206080001	HFAS 0820.06		Z7 Steel	ZYA-S 0820	8	20	6	60	1
A100110136080001	HFAS 1013.06		Z7 Steel	ZYA-S 1013	10	13	6	53	1
A100110206080001	HFAS 1020.06		Z7 Steel	ZYA-S 1020	10	20	6	60	1
A100110256080001	HFAS 1025.06		Z7 Steel	ZYA-S 1025	10	25	6	65	1
A100112256080001	HFAS 1225.06		Z7 Steel	ZYA-S 1225	12	25	6	65	1
A100112258080001	HFAS 1225.08		Z7 Steel	ZYA-S 1225	12	25	8	65	1
A100116256080001	HFAS 1625.06		Z7 Steel	ZYA-S 1625	16	25	6	65	1
A10020210308	HFC 0210.03		Z7 Steel	WRC 0210	2	10	3	40	1
A10020313308	HFC 0313.03		Z7 Steel	WRC 0313	3	13	3	40	1
A10020413608	HFC 0413.06		Z7 Steel	WRC 0413	4	13	6	50	1
A10020613308	HFC 0613.03		Z7 Steel	WRC 0613	6	13	3	43	1
A10020616608	HFC 0616.06		Z7 Steel	WRC 0616	6	16	6	50	1
A10020820608	HFC 0820.06		Z7 Steel	WRC 0820	8	20	6	60	1
A10021020608	HFC 1020.06		Z7 Steel	WRC 1020	10	20	6	60	1
A10021025608	HFC 1025.06		Z7 Steel	WRC 1025	10	25	6	65	1
A10021225608	HFC 1225.06		Z7 Steel	WRC 1225	12	25	6	65	1
A10021225808	HFC 1225.08		Z7 Steel	WRC 1225	12	25	8	65	1
A10021625608	HFC 1625.06		Z7 Steel	WRC 1625	16	25	6	65	1
A10030303308	HFD 0302.03		Z7 Steel	KUD 0302	3	2	3	40	1
A100304043080001	HFD 0403.03		Z7 Steel	KUD 0403	4	3	3	34	1
A10030404608	HFD 0403.06		Z7 Steel	KUD 0403	4	3	6	50	1
A10030606308	HFD 0605.03		Z7 Steel	KUD 0605	6	5	3	35	1
A10030606608	HFD 0605.06		Z7 Steel	KUD 0605	6	5	6	50	1
A10030808608	HFD 0807.06		Z7 Steel	KUD 0807	8	7	6	47	1
A10031010608	HFD 1009.06		Z7 Steel	KUD 1009	10	9	6	49	1
A10031212608	HFD 1210.06		Z7 Steel	KUD 1210	12	10	6	51	1
A10031210808	HFD 1210.08		Z7 Steel	KUD 1210	12	10	8	51	1
A10031616608	HFD 1614.06		Z7 Steel	KUD 1614	16	14	6	54	1
A10032020608	HFD 2018.06		Z7 Steel	KUD 2018	20	18	6	58	1

Recommended for: ● Steel ● Cast material ● Titanium

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains	
A10060307308	HFE 0307.03		Z7 Steel	TRE 0307	3	7	3	40	1	
A10060610308	HFE 0610.03		Z7 Steel	TRE 0610	6	10	3	40	1	
A10060610608	HFE 0610.06		Z7 Steel	TRE 0610	6	10	6	50	1	
A10060813608	HFE 0813.06		Z7 Steel	TRE 0813	8	13	6	53	1	
A10061220608	HFE 1220.06		Z7 Steel	TRE 1220	12	20	6	60	1	
A10061625608	HFE 1625.06		Z7 Steel	TRE 1625	16	25	6	65	1	
A10100313308	HFF 0313.03		Z7 Steel	RBF 0313	3	13	3	40	1	
A10100613308	HFF 0613.03		Z7 Steel	RBF 0613	6	13	3	43	1	
A10100618608	HFF 0618.06		Z7 Steel	RBF 0618	6	18	6	50	1	
A10100820608	HFF 0820.06		Z7 Steel	–	8	20	6	60	1	
A10101020608	HFF 1020.06		Z7 Steel	RBF 1020	10	20	6	60	1	
A10101225608	HFF 1225.06		Z7 Steel	RBF 1225	12	25	6	65	1	
A10101225808	HFF 1225.08		Z7 Steel	RBF 1225	12	25	8	65	1	
A10101230608	HFF 1230.06		Z7 Steel	RBF 1230	12	30	6	70	1	
A10101630608	HFF 1630.06		Z7 Steel	RBF 1630	16	30	6	70	1	
A10040307308	HFG 0307.03		Z7 Steel	SPG 0307	3	7	3	40	1	
A10040313308	HFG 0313.03		Z7 Steel	SPG 0313	3	13	3	40	1	
A10040613308	HFG 0613.03		Z7 Steel	SPG 0613	6	13	3	43	1	
A10040618608	HFG 0618.06		Z7 Steel	SPG 0618	6	18	6	50	1	
A10040820608	HFG 0820.06		Z7 Steel	–	8	20	6	60	1	
A10041020608	HFG 1020.06		Z7 Steel	SPG 1020	10	20	6	60	1	
A10041220608	HFG 1220.06		Z7 Steel	SPG 1220	12	20	6	60	1	
A10041225608	HFG 1225.06		Z7 Steel	SPG 1225	12	25	6	65	1	
A10041230608	HFG 1230.06		Z7 Steel	SPG 1230	12	30	6	70	1	
A10041630608	HFG 1630.06	Z7 Steel	SPG 1630	16	30	6	70	1		
A10090613308	HFH 0613.03		Z7 Steel	–	6	13	3	43	1	
A10090820608	HFH 0820.06		Z7 Steel	–	8	20	6	60	1	
A10091230608	HFH 1230.06		Z7 Steel	–	12	30	6	70	1	
A10091635608	HFH 1635.06		Z7 Steel	–	16	35	6	75	1	
A10070820608	HFL 0820.06		Z7 Steel	–	8	20	6	60	1	
A10071020608	HFL 1020.06		Z7 Steel	KEL 1020	10	20	6	60	1	
A10071225608	HFL 1225.06		Z7 Steel	KEL 1225	12	25	6	65	1	
A10071230608	HFL 1230.06		Z7 Steel	KEL 1230	12	30	6	70	1	
A10071630608	HFL 1630.06		Z7 Steel	KEL 1630	16	30	6	70	1	
A10050307308	HFM 0307.03		Z7 Steel	SKM 0307	3	7	3	40	1	
A10050311308	HFM 0311.03		Z7 Steel	SKM 0311	3	11	3	40	1	
A10050613308	HFM 0613.03		Z7 Steel	SKM 0613	6	13	3	43	1	
A10050618608	HFM 0618.06		Z7 Steel	SKM 0618	6	18	6	50	1	
A10050820608	HFM 0820.06		Z7 Steel	–	8	20	6	60	1	
A10051020608	HFM 1020.06		Z7 Steel	SKM 1020	10	20	6	60	1	
A10051225608	HFM 1225.06		Z7 Steel	SKM 1225	12	25	6	65	1	
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	Pack contains
A10120307308	HFN 0307.03		Z7 Steel	WKN 0307	3	7	3	40	10°	1
A101203073080001	HFNS 0307.03		Z7 Steel	WKN-S 0307	3	7	3	40	10°	1
Recommended for:  Steel  Cast material  Titanium										

Recommended for: ● Steel ● Cast material ● Titanium

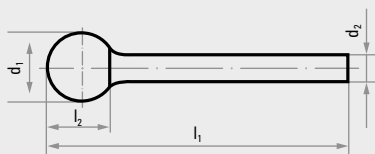
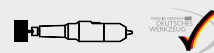
# TWO MATERIALS – ONE BURR

## PERFECTLY PROCESS STEEL AND STAINLESS STEEL WITH JUST A SINGLE BURR

The new cut profile of the Z42 Inox/Steel burr cuts the two most important materials steel and inox quickly and reliably. The robust tooth geometry with faceting prevents chipping and guarantees high removal rates. This helps you save time and equipment costs. The improved chip breaker allows you to work even more ergonomically while achieving the best surface yet.



### Z42 Inox/Steel burr



- high chip volume thanks to coarse cut for quick working
- faceted toothing for perfect surface results
- smoothly running, low-vibration tool without chatter thanks to improved cutting angle



Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010616620	HFA 0616.06		Z42 Inox/Steel	ZYA 0616	6	16	6	50	1
A10010820620	HFA 0820.06		Z42 Inox/Steel	ZYA 0820	8	20	6	60	1
A10011020620	HFA 1020.06		Z42 Inox/Steel	ZYA 1020	10	20	6	60	1
A10011225620	HFA 1225.06		Z42 Inox/Steel	ZYA 1225	12	25	6	65	1
A10020616620	HFC 0616.06		Z42 Inox/Steel	WRC 0616	6	16	6	50	1
A10020820620	HFC 0820.06		Z42 Inox/Steel	WRC 0820	8	20	6	60	1
A10021020620	HFC 1020.06		Z42 Inox/Steel	WRC 1020	10	20	6	60	1
A10021225620	HFC 1225.06		Z42 Inox/Steel	WRC 1225	12	25	6	65	1
A10030605620	HFD 0605.06		Z42 Inox/Steel	KUD 0605	6	5	6	50	1
A10030807620	HFD 0807.06		Z42 Inox/Steel	KUD 0807	8	7	6	47	1
A10031009620	HFD 1009.06		Z42 Inox/Steel	KUD 1009	10	9	6	49	1
A10031210620	HFD 1210.06		Z42 Inox/Steel	KUD 1210	12	10	6	51	1
A10100618620	HFF 0618.06		Z42 Inox/Steel	RBF 0618	6	18	6	50	1
A10100820620	HFF 0820.06		Z42 Inox/Steel	–	8	20	6	60	1
A10101020620	HFF 1020.06		Z42 Inox/Steel	RBF 1020	10	20	6	60	1
A10101225620	HFF 1225.06		Z42 Inox/Steel	RBF 1225	12	25	6	65	1
A10040618620	HFG 0618.06		Z42 Inox/Steel	SPG 0618	6	18	6	50	1
A10040820620	HFG 0820.06		Z42 Inox/Steel	–	8	20	6	60	1
A10041020620	HFG 1020.06		Z42 Inox/Steel	SPG 1020	10	20	6	60	1
A10041225620	HFG 1225.06		Z42 Inox/Steel	SPG 1225	12	25	6	65	1
A10050618620	HFM 0618.06		Z42 Inox/Steel	SKM 0618	6	18	6	50	1
A10050820620	HFM 0820.06		Z42 Inox/Steel	–	8	20	6	60	1
A10051020620	HFM 1020.06		Z42 Inox/Steel	SKM 1020	10	20	6	60	1
A10051225620	HFM 1225.06		Z42 Inox/Steel	SKM 1225	12	25	6	65	1

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



# CAST – THE BURR FOR CAST MATERIAL

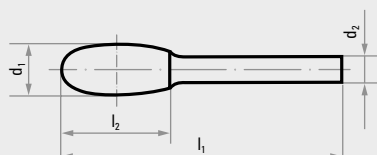
## FOR HIGH REMOVAL RATES ON CAST MATERIALS

With its faceted toothing, the Cast burr for cast material achieves a high degree of stock removal with manual machining – in other words, a large chip volume in a short time. The tool can be guided smoothly and easily in the process. No chipping occurs, even with excessive force. The proven tungsten carbide quality and a reliable soldered joint round off the tool. You can therefore work safely and productively!



### Cast burr

- perfect for cleaning, deburring and chamfering
- high stock removal capability
- long tool life
- ergonomic and smooth running

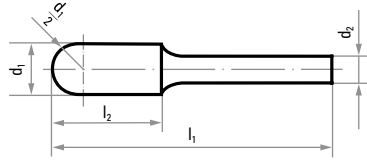
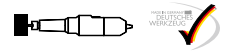


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Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010616621	HFA 0616.06		Cast	ZYA 0616	6	16	6	50	1
A10010820621	HFA 0820.06		Cast	ZYA 0820	8	20	6	60	1
A10011020621	HFA 1020.06		Cast	ZYA 1020	10	20	6	60	1
A10011225621	HFA 1225.06		Cast	ZYA 1225	12	25	6	65	1
A10020616621	HFC 0616.06		Cast	WRC 0616	6	16	6	50	1
A10020820621	HFC 0820.06		Cast	WRC 0820	8	20	6	60	1
A10021020621	HFC 1020.06		Cast	WRC 1020	10	20	6	60	1
A10021225621	HFC 1225.06		Cast	WRC 1225	12	25	6	65	1
A10030605621	HFD 0605.06		Cast	KUD 0605	6	5	6	50	1
A10030807621	HFD 0807.06		Cast	KUD 0807	8	7	6	47	1
A10031009621	HFD 1009.06		Cast	KUD 1009	10	9	6	49	1
A10031210621	HFD 1210.06		Cast	KUD 1210	12	10	6	51	1
A10060610621	HFE 0610.06		Cast	TRE 0610	6	10	6	50	1
A10060813621	HFE 0813.06		Cast	TRE 0813	8	13	6	53	1
A10061016621	HFE 1016.06		Cast	TRE 1016	10	16	6	56	1
A10061220621	HFE 1220.06		Cast	TRE 1220	12	20	6	60	1
A10100618621	HFF 0618.06		Cast	RBF 0618	6	18	6	50	1
A10100820621	HFF 0820.06		Cast	–	8	20	6	60	1
A10101020621	HFF 1020.06		Cast	RBF 1020	10	20	6	60	1
A10101225621	HFF 1225.06		Cast	RBF 1225	12	25	6	65	1
A10040618621	HFG 0618.06		Cast	SPG 0618	6	18	6	50	1
A10040820621	HFG 0820.06		Cast	–	8	20	6	60	1
A10041020621	HFG 1020.06		Cast	SPG 1020	10	20	6	60	1
A10041225621	HFG 1225.06		Cast	SPG 1225	12	25	6	65	1

Recommended for: ● Cast material

## Z4 burr



★★☆

■ fine cross cut for hard materials

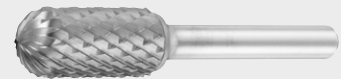
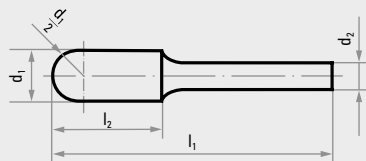
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010313304	HFA 0313.03		Z4	ZYA 0313	3	13	3	40	1
A10010616604	HFA 0616.06		Z4	ZYA 0616	6	16	6	50	1
A10010820604	HFA 0820.06		Z4	ZYA 0820	8	20	6	60	1
A10011020604	HFA 1020.06		Z4	ZYA 1020	10	20	6	60	1
A10011025604	HFA 1025.06		Z4	ZYA 1025	10	25	6	65	1
A10011225604	HFA 1225.06		Z4	ZYA 1225	12	25	6	65	1
A10011225804	HFA 1225.08		Z4	ZYA 1225	12	25	8	65	1
A100103133040001	HFAS 0313.03		Z4	ZYA-S 0313	3	13	3	40	1
A100106166040001	HFAS 0616.06		Z4	ZYA-S 0616	6	16	6	50	1
A100108206040001	HFAS 0820.06		Z4	ZYA-S 0820	8	20	6	60	1
A100110206040001	HFAS 1020.06		Z4	ZYA-S 1020	10	20	6	60	1
A100110256040001	HFAS 1025.06		Z4	ZYA-S 1025	10	25	6	65	1
A100112256040001	HFAS 1225.06		Z4	ZYA-S 1225	12	25	6	65	1
A100112258040001	HFAS 1225.08		Z4	ZYA-S 1225	12	25	8	65	1
A10020313304	HFC 0313.03		Z4	WRC 0313	3	13	3	40	1
A10020413604	HFC 0413.06		Z4	WRC 0413	4	13	6	50	1
A10020616604	HFC 0616.06		Z4	WRC 0616	6	16	6	50	1
A10020820604	HFC 0820.06		Z4	WRC 0820	8	20	6	60	1
A10021020604	HFC 1020.06		Z4	WRC 1020	10	20	6	60	1
A10021020804	HFC 1020.08		Z4	WRC 1020	10	20	8	60	1
A10021225604	HFC 1225.06		Z4	WRC 1225	12	25	6	65	1
A10030303304	HFD 0302.03		Z4	KUD 0302	3	2	3	40	1
A10030404604	HFD 0403.06		Z4	KUD 0403	4	3	6	50	1
A10030606604	HFD 0605.06		Z4	KUD 0605	6	5	6	50	1
A10030808604	HFD 0807.06		Z4	KUD 0807	8	7	6	47	1
A10031010604	HFD 1009.06		Z4	KUD 1009	10	9	6	49	1
A10031212604	HFD 1210.06		Z4	KUD 1210	12	10	6	51	1
A10031212804	HFD 1210.08		Z4	KUD 1210	12	10	8	51	1
A10031616604	HFD 1614.06		Z4	KUD 1614	16	14	6	54	1
A10060610604	HFE 0610.06		Z4	TRE 0610	6	10	6	50	1
A10060813604	HFE 0813.06		Z4	TRE 0813	8	13	6	53	1
A10061220604	HFE 1220.06		Z4	TRE 1220	12	20	6	60	1
A10100307304	HFF 0307.03		Z4	RBF 0307	3	7	3	40	1
A10100618604	HFF 0618.06		Z4	RBF 0618	6	18	6	50	1
A10101020604	HFF 1020.06		Z4	RBF 1020	10	20	6	60	1
A10101225604	HFF 1225.06		Z4	RBF 1225	12	25	6	65	1
A10040313304	HFG 0313.03		Z4	SPG 0313	3	13	3	40	1
A10040618604	HFG 0618.06		Z4	SPG 0618	6	18	6	50	1
A10041020604	HFG 1020.06		Z4	SPG 1020	10	20	6	60	1
A10041225604	HFG 1225.06		Z4	SPG 1225	12	25	6	65	1
A10041230604	HFG 1230.06		Z4	SPG 1230	12	30	6	70	1
A10041630604	HFG 1630.06		Z4	SPG 1630	16	30	6	70	1

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Plastic/Wood

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains		
A10090613304	HFH 0613.03		Z4	–	6	13	3	43	1		
A10090820604	HFH 0820.06		Z4	–	8	20	6	60	1		
A10091230604	HFH 1230.06		Z4	–	12	30	6	70	1		
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	α	Pack contains
A10071225604	HFL 1225.06		Z4	KEL 1225	12	25	6	65	3.3	14°	1
A10071230604	HFL 1230.06		Z4	KEL 1230	12	30	6	70	2.6	14°	1
A10071230804	HFL 1230.08		Z4	KEL 1230	12	30	8	70	2.6	14°	1
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains		
A10050618604	HFM 0618.06		Z4	SKM 0618	6	18	6	50	1		
A10051020604	HFM 1020.06		Z4	SKM 1020	10	20	6	60	1		
A10051225604	HFM 1225.06		Z4	SKM 1225	12	25	6	65	1		
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	α	Pack contains	
A10120607604	HFN 0607.06		Z4	WKN 0607	6	7	6	50	10°	1	
A10121013604	HFN 1013.06		Z4	WKN 1013	10	13	6	53	10°	1	
A10121213604	HFN 1213.06		Z4	WKN 1213	12	13	6	53	20°	1	
A10122013604	HFN 2013.06		Z4	–	20	13	6	53	30°	1	
A101216136040001	HFNS 1613.06		Z4	WKN-S 1613	16	13	6	53	20°	1	
Recommended for: <span>●</span> Inox/Steel <span>●</span> Steel <span>●</span> Titanium <span>●</span> Plastic /Wood											



## Z6 burr



■ burr with robust cross cut

★★☆

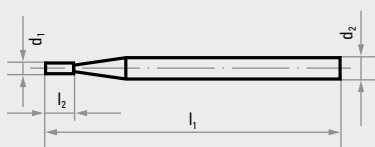
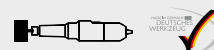
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10020820606	HFC 0820.06		Z6	WRC 0820	8	20	6	60	1
A10021020606	HFC 1020.06		Z6	WRC 1020	10	20	6	60	1
A10021225606	HFC 1225.06		Z6	WRC 1225	12	25	6	65	1
A10101020606	HFF 1020.06		Z6	RBF 1020	10	20	6	60	1

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Plastic/Wood

# PRECISION BURR WITH UNIVERSAL CUT

PERFECTLY PERFORM THE MOST DELICATE OF CUTS

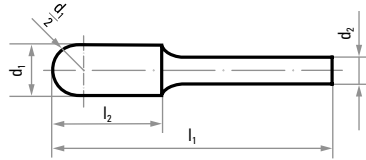
## Universal miniature burr



- with 3 mm shank diameter
- high dimensional accuracy
- high concentricity for smooth running
- universal cut
- made from micro-grain carbide
- finely ground cutting edges

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010104312	HFA 01004.03		Universal	1	4	3	40	1
A100101043120001	HFA 01504.03		Universal	1,5	4	3	40	1
A10010204312	HFA 02004.03		Universal	2	4	3	40	1
A10020104312	HFC 01004.03		Universal	1	4	3	40	1
A100201043120001	HFC 01504.03		Universal	1,5	4	3	40	1
A10020204312	HFC 02004.03		Universal	2	4	3	40	1
A10030101312	HFD 01001.03		Universal	1	0,9	3	40	1
A100301013120001	HFD 01501.03		Universal	1,5	1,35	3	40	1
A10030202312	HFD 02002.03		Universal	2	1,8	3	40	1
A10060104312	HFE 01504.03		Universal	1,5	4	3	40	1
A10100104312	HFF 01504.03		Universal	1,5	4	3	40	1
A10040104312	HFG 01504.03		Universal	1,5	4	3	40	1
A10050104312	HFM 01504.03		Universal	1,5	4	3	40	1

Recommended for: ● Inox/Steel ● Steel ● Titanium



## Z5 small burr

MILLING

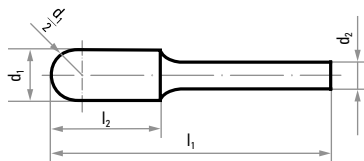
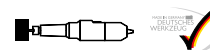
■ with 3 mm shank diameter

★★☆

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010210305	HFA 0210.03		Z5 Hard	ZYA 0210	2	10	3	40	1
A10010313305	HFA 0313.03		Z5 Hard	ZYA 0313	3	13	3	40	1
A10010607305	HFA 0607.03		Z5 Hard	ZYA 0607	6	7	3	37	1
A10010613305	HFA 0613.03		Z5 Hard	ZYA 0613	6	13	3	43	1
A100102103050001	HFAS 0210.03		Z5 Hard	ZYA-S 0210	2	10	3	40	1
A100103133050001	HFAS 0313.03		Z5 Hard	ZYA-S 0313	3	13	3	40	1
A100106073050001	HFAS 0607.03		Z5 Hard	ZYA-S 0607	6	7	3	37	1
A100106133050001	HFAS 0613.03		Z5 Hard	ZYA-S 0613	6	13	3	43	1
A10020210305	HFC 0210.03		Z5 Hard	WRC 0210	2	10	3	40	1
A10020313305	HFC 0313.03		Z5 Hard	WRC 0313	3	13	3	40	1
A10020613305	HFC 0613.03		Z5 Hard	WRC 0613	6	13	3	43	1
A10030303305	HFD 0302.03		Z5 Hard	KUD 0302	3	2	3	40	1
A100304043050001	HFD 0403.03		Z5 Hard	KUD 0403	4	3	3	34	1
A10030606305	HFD 0605.03		Z5 Hard	KUD 0605	6	5	3	35	1
A10060307305	HFE 0307.03		Z5 Hard	TRE 0307	3	7	3	40	1
A10060610305	HFE 0610.03		Z5 Hard	TRE 0610	6	10	3	40	1
A10100307305	HFF 0307.03		Z5 Hard	RBF 0307	3	7	3	40	1
A10100313305	HFF 0313.03		Z5 Hard	RBF 0313	3	13	3	40	1
A10100613305	HFF 0613.03		Z5 Hard	RBF 0613	6	13	3	43	1
A10040307305	HFG 0307.03		Z5 Hard	SPG 0307	3	7	3	40	1
A10040313305	HFG 0313.03		Z5 Hard	SPG 0313	3	13	3	40	1
A10040613305	HFG 0613.03		Z5 Hard	SPG 0613	6	13	3	43	1
A10090307305	HFH 0307.03		Z5 Hard	—	3	7	3	40	1
A10090613305	HFH 0613.03		Z5 Hard	—	6	13	3	43	1
A10050307305	HFM 0307.03		Z5 Hard	SKM 0307	3	7	3	40	1
A10050311305	HFM 0311.03		Z5 Hard	SKM 0311	3	11	3	40	1
A10050613305	HFM 0613.03		Z5 Hard	SKM 0613	6	13	3	43	1
A10120307305	HFN 0307.03		Z5 Hard	WKN 0307	3	7	3	40	1
A10120607305	HFN 0607.03		Z5 Hard	WKN 0607	6	7	3	37	1
A101203073050001	HFNS 0307.03		Z5 Hard	WKN-S 0307	3	7	3	40	1
A101206073050001	HFNS 0607.03		Z5 Hard	WKN-S 0607	6	7	3	37	1

Recommended for: ● Steel ● Inox/Steel ● Titanium

## Z3 Universal burr



■ with single cut for universal applications

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010313303	HFA 0313.03		Z3 Universal	ZYA 0313	3	13	3	40	1
A10010413603	HFA 0413.06		Z3 Universal	ZYA 0413	4	13	6	50	1
A10010616603	HFA 0616.06		Z3 Universal	ZYA 0616	6	16	6	50	1
A10010820603	HFA 0820.06		Z3 Universal	ZYA 0820	8	20	6	60	1
A10011013603	HFA 1013.06		Z3 Universal	ZYA 1013	10	13	6	53	1
A10011020603	HFA 1020.06		Z3 Universal	ZYA 1020	10	20	6	60	1
A10011225603	HFA 1225.06		Z3 Universal	ZYA 1225	12	25	6	65	1
A10011625603	HFA 1625.06		Z3 Universal	ZYA 1625	16	25	6	65	1
A100103133030001	HFAS 0313.03		Z3 Universal	ZYA-S 0313	3	13	3	40	1
A100104136030001	HFAS 0413.06		Z3 Universal	ZYA-S 0413	4	13	6	50	1
A100106166030001	HFAS 0616.06		Z3 Universal	ZYA-S 0616	6	16	6	50	1
A100108206030001	HFAS 0820.06		Z3 Universal	ZYA-S 0820	8	20	6	60	1
A100110136030001	HFAS 1013.06		Z3 Universal	ZYA-S 1013	10	13	6	53	1
A100110206030001	HFAS 1020.06		Z3 Universal	ZYA-S 1020	10	20	6	60	1
A100112256030001	HFAS 1225.06		Z3 Universal	ZYA-S 1225	12	25	6	65	1
A100116256030001	HFAS 1625.06		Z3 Universal	ZYA-S 1625	16	25	6	65	1
A10020313303	HFC 0313.03		Z3 Universal	WRC 0313	3	13	3	40	1
A10020413603	HFC 0413.06		Z3 Universal	WRC 0413	4	13	6	50	1
A10020616603	HFC 0616.06		Z3 Universal	WRC 0616	6	16	6	50	1
A10020820603	HFC 0820.06		Z3 Universal	WRC 0820	8	20	6	60	1
A10021020603	HFC 1020.06		Z3 Universal	WRC 1020	10	20	6	60	1
A10021225603	HFC 1225.06		Z3 Universal	WRC 1225	12	25	6	65	1
A10021625603	HFC 1625.06		Z3 Universal	WRC 1625	16	25	6	65	1
A10021625803	HFC 1625.08		Z3 Universal	WRC 1625	16	25	8	65	1
A10030303303	HFD 0302.03		Z3 Universal	KUD 0302	3	2	3	40	1
A10030404603	HFD 0403.06		Z3 Universal	KUD 0403	4	3	6	50	1
A10030606603	HFD 0605.06		Z3 Universal	KUD 0605	6	5	6	50	1
A10030808603	HFD 0807.06		Z3 Universal	KUD 0807	8	7	6	47	1
A10031010603	HFD 1009.06		Z3 Universal	KUD 1009	10	9	6	49	1
A10031212603	HFD 1210.06		Z3 Universal	KUD 1210	12	10	6	51	1
A10031616603	HFD 1614.06		Z3 Universal	KUD 1614	16	14	6	54	1
A10031616803	HFD 1614.08		Z3 Universal	KUD 1614	16	14	8	54	1
A10032020603	HFD 2018.06		Z3 Universal	KUD 2018	20	18	6	58	1
A10032020803	HFD 2018.08		Z3 Universal	KUD 2018	20	18	8	58	1
A10060307303	HFE 0307.03		Z3 Universal	TRE 0307	3	7	3	40	1
A10060610603	HFE 0610.06		Z3 Universal	TRE 0610	6	10	6	50	1
A10060813603	HFE 0813.06		Z3 Universal	TRE 0813	8	13	6	53	1
A10061220603	HFE 1220.06		Z3 Universal	TRE 1220	12	20	6	60	1
A10061625803	HFE 1625.08		Z3 Universal	TRE 1625	16	25	8	65	1

Recommended for: ● Steel ● Inox/Steel ● Titanium



Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm		Pack contains	
A10100307303	HFF 0307.03		Z3 Universal	RBF 0307	3	7	3	40		1	
A10100618603	HFF 0618.06		Z3 Universal	RBF 0618	6	18	6	50		1	
A10100820603	HFF 0820.06		Z3 Universal	–	8	20	6	60		1	
A10101020603	HFF 1020.06		Z3 Universal	RBF 1020	10	20	6	60		1	
A10101225603	HFF 1225.06		Z3 Universal	RBF 1225	12	25	6	65		1	
A10101225803	HFF 1225.08		Z3 Universal	RBF 1225	12	25	8	65		1	
A10101230603	HFF 1230.06		Z3 Universal	RBF 1230	12	30	6	70		1	
A10101630803	HFF 1630.08		Z3 Universal	RBF 1630	16	30	8	70		1	
A10040313303	HFG 0313.03		Z3 Universal	SPG 0313	3	13	3	40		1	
A10040618603	HFG 0618.06		Z3 Universal	SPG 0618	6	18	6	50		1	
A10040820603	HFG 0820.06		Z3 Universal	–	8	20	6	60		1	
A10041020603	HFG 1020.06		Z3 Universal	SPG 1020	10	20	6	60		1	
A10041220603	HFG 1220.06		Z3 Universal	SPG 1220	12	20	6	60		1	
A10041225603	HFG 1225.06		Z3 Universal	SPG 1225	12	25	6	65		1	
A10041225803	HFG 1225.08		Z3 Universal	SPG 1225	12	25	8	65		1	
A10041230603	HFG 1230.06		Z3 Universal	SPG 1230	12	30	6	70		1	
A10041630803	HFG 1630.08	Z3 Universal	SPG 1630	16	30	8	70		1		
A10090613303	HFH 0613.03		Z3 Universal	–	6	13	3	43		1	
A10090820603	HFH 0820.06		Z3 Universal	–	8	20	6	60		1	
A10091230603	HFH 1230.06		Z3 Universal	–	12	30	6	70		1	
A10091230803	HFH 1230.08		Z3 Universal	–	12	30	8	70		1	
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	α	Pack contains
A10070820603	HFL 0820.06		Z3 Universal	–	8	20	6	60	1.5	14°	1
A10071020603	HFL 1020.06		Z3 Universal	KEL 1020	10	20	6	60	2.9	14°	1
A10071225603	HFL 1225.06		Z3 Universal	KEL 1225	12	25	6	65	3.3	14°	1
A10071230603	HFL 1230.06		Z3 Universal	KEL 1230	12	30	6	70	2.6	14°	1
A10071630603	HFL 1630.06		Z3 Universal	KEL 1630	16	30	6	70	4.8	14°	1
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm			Pack contains
A10050307303	HFM 0307.03		Z3 Universal	SKM 0307	3	7	3	40			1
A10050618603	HFM 0618.06		Z3 Universal	SKM 0618	6	18	6	50			1
A10050820603	HFM 0820.06		Z3 Universal	–	8	20	6	60			1
A10051020603	HFM 1020.06		Z3 Universal	SKM 1020	10	20	6	60			1
A10051225603	HFM 1225.06		Z3 Universal	SKM 1225	12	25	6	65			1
A10051225803	HFM 1225.08		Z3 Universal	SKM 1225	12	25	8	65			1
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm		α	Pack contains
A10121013603	HFN 1013.06		Z3 Universal	WKN 1013	10	13	6	53		10°	1
A10121213603	HFN 1213.06		Z3 Universal	WKN 1213	12	13	6	53		20°	1
A10121613803	HFN 1613.08		Z3 Universal	WKN 1613	16	13	8	53		20°	1
A101210136030001	HFNS 1013.06		Z3 Universal	WKN-S 1013	10	13	6	53		10°	1
A101212136030001	HFNS 1213.06		Z3 Universal	WKN-S 1213	12	13	6	53		20°	1
A101216138030001	HFNS 1613.08		Z3 Universal	WKN-S 1613	16	13	8	53		20°	1
A101216138030001	HFNS 1613.08		Z3 Universal	WKN-S 1613	16	13	8	53		20°	1
Recommended for: <span>● Steel</span> <span>● Inox/Steel</span> <span>● Titanium</span>											

Recommended for: ● Steel ● Inox/Steel ● Titanium

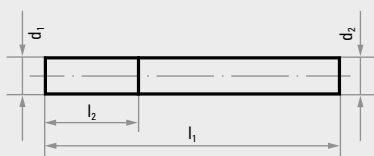
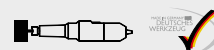
# MANUAL OR MECHANICAL PROCESSING OF FIBRE-REINFORCED MATERIALS

MILL, DRILL AND SAW WITH JUST ONE TOOL

The Composite burr is designed for processing fibre-reinforced material, but is incredibly versatile in this area. It can be used in similar variants for both machine and for manual applications. In addition to milling, the extra-long cutting edge is also suitable for sawing. The fishtail tip is suitable for drilling and end milling of workpieces. This makes the Composite burr an all-rounder that makes multiple tool changes unnecessary and is perfectly suited as a robot tool due to its long tool life.



## Composite Coarse burr



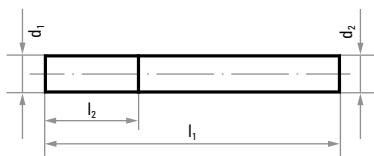
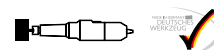
- perfect for drilling, milling and sawing
- extra-long cutting section
- long tool life
- highly economic
- The coarse cut (Coarse) is excellent for stationary use.

★★☆

Product number	Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10180315323	HFAS 0315.03	Composite Coarse	3	15	3	42	1
A10180625623	HFAS 0625.06	Composite Coarse	6	25	6	64	1
A10180828823	HFAS 0828.08	Composite Coarse	8	28	8	73	1

Recommended for: ● Plastic/Wood

## Composite Fine burr



- perfect for drilling, milling and sawing
- extra-long cutting section
- longer tool life
- highly economic
- The fine cut (Fine) is highly precise and ergonomic, even in manual use.

★★☆

Product number	Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10180625624	HFAS 0625.06	Composite Fine	6	25	6	64	1
A10180828824	HFAS 0828.08	Composite Fine	8	28	8	73	1
A101810301024	HFAS 1030.10	Composite Fine	10	30	10	77	1

Recommended for: ● Plastic/Wood

# THE BURR FOR WOOD AND LIGHTWEIGHT CONSTRUCTION MATERIALS

THE PERFECT TOOL FOR PATTERN CONSTRUCTION.

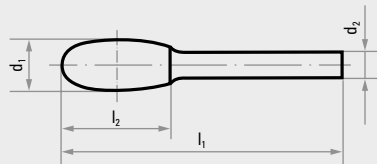
SUITABLE FOR USE ON WOOD, WPC PLASTIC AND NON-FERROUS METALS

Where HSS and stippled burrs quickly fail the Wood rasp burr thrives with its extraordinarily long tool life. This is made possible by manufacturing it from fine-grain tungsten carbide. This means that wood and other lightweight materials can be machined for long periods. Especially when deburring, modelling and smoothing, the Wood rasp burr shows its superiority with fast material removal.

Even with little application of force, it's easy to work quickly with the rasp burr. This is because the coarse cutting edge geometry is always extremely effective and has good cutting properties. The Wood rasp burr does not produce any annoying vibrations. In addition to wood, this tool can machine all types of Plastic and rubber.



- ideal for chamfering, modelling and smoothing
- large cutting angle means high speed
- long tool life thanks to tungsten carbide
- smooth running without vibrations
- Applications: pattern construction and wood, mould making, cores and soft materials



## Wood burr

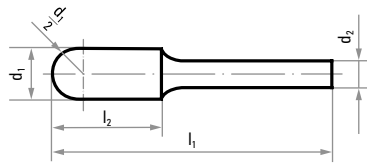


★★★

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10021225618	HFC 1225.06		Wood	12	25	6	65	1
A10031210618	HFD 1210.06		Wood	12	10	6	50	1
A10061220618	HFE 1220.06		Wood	12	20	6	60	1
A10100618618	HFF 0618.06		Wood	6	18	6	58	1
A10100820618	HFF 0820.06		Wood	8	20	6	60	1

Recommended for: Plastic/Wood Steel

## Z2 Brass burr



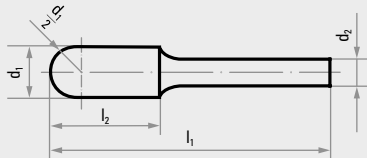
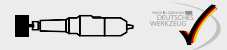
★★☆

■ robust single cut for high stock removal

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10020313302	HFC 0313.03		Z2 Brass	WRC 0313	3	13	3	40	1
A10020616602	HFC 0616.06		Z2 Brass	WRC 0616	6	16	6	50	1
A10021225602	HFC 1225.06		Z2 Brass	WRC 1225	12	25	6	65	1
A10030303302	HFD 0302.03		Z2 Brass	KUD 0302	3	2	3	40	1
A10040618602	HFG 0618.06		Z2 Brass	SPG 0618	6	18	6	50	1
A10041225602	HFG 1225.06		Z2 Brass	SPG 1225	12	25	6	65	1
A10041230602	HFG 1230.06		Z2 Brass	SPG 1230	12	30	6	70	1
A10090613302	HFH 0613.03		Z2 Brass	—	6	13	3	43	1

Recommended for: ● Aluminium ● Cast material ● Plastic/Wood ● Steel

## Z1 burr



★★☆

■ coarse single cut for soft materials (e.g. aluminium and copper)

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	α	Pack contains
A10020616601	HFC 0616.06		Z1	WRC 0616	6	16	6	50	—	—	1
A10021225601	HFC 1225.06		Z1	WRC 1225	12	25	6	65	—	—	1
A10101225601	HFF 1225.06		Z1	RBF 1225	12	25	6	65	—	—	1
A10040618601	HFG 0618.06		Z1	SPG 0618	6	18	6	50	—	—	1
A10071230601	HFL 1230.06		Z1	KEL 1230	12	30	6	70	2.6	14°	1
A10051225601	HFM 1225.06		Z1	SKM 1225	12	25	6	65	—	—	1

Recommended for: ● Aluminium ● Plastic/Wood

# REDUCING WEAR WITH LIGHTFLOW

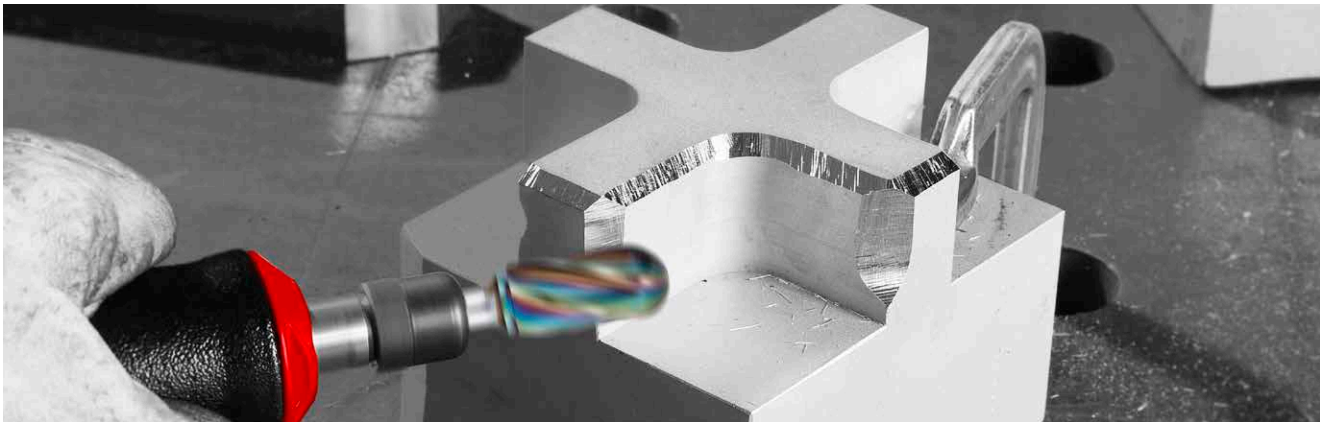
## IDEAL SURFACE TREATMENT WITH OUTSTANDING NON-STICK PROPERTIES

The new LightFlow coating from LUKAS is perfect for reducing friction between the tool and the material surface. It lets you create excellent surfaces while also extending the tool life of the burr. This coating prevents the burr from becoming clogged with aluminium chips, therefore reducing machine load and maintaining a consistent speed. There is no sticking or smear-

ing. This lets you work for longer without having to clean or replace the tool.

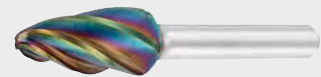
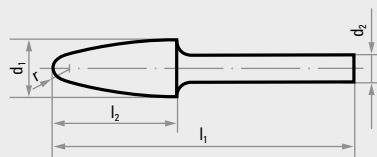
### Application areas of the coating:

cutting graphite, aluminium, copper, carbon composites and wood





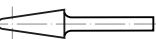


## Z9 Alu burr with LightFlow coating **NEW**

- process aluminium with razor-sharp cutting edges
- the perfect synergies between burr and LightFlow coating
- high chip volume thanks to coarse cut for quick work
- faceted toothing for perfect surface results
- maximum cutting cross section for effortless processing

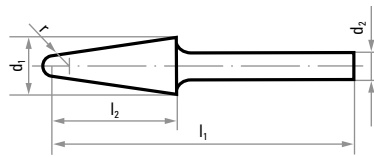
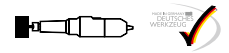


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Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10020616609LF	HFC 0616.06		Z9 Alu	WRC 0616	6	16	6	50	1
A10021225609LF	HFC 1225.06		Z9 Alu	WRC 1225	12	25	6	65	1
A10100618609LF	HFF 0618.06		Z9 Alu	RBF 0618	6	18	6	50	1
A10101225609LF	HFF 1225.06		Z9 Alu	RBF 1225	12	25	6	65	1
A10071230609LF	HFL 1230.06		Z9 Alu	KEL 1230	12	30	6	70	1

Recommended for: ● Aluminium ● Plastic/Wood

## Z9 Alu burr



- the burr for aluminium and non-ferrous metals
- ideal for cutting, chamfering and deburring
- high removal speed
- no clogging
- long tool life

★★☆

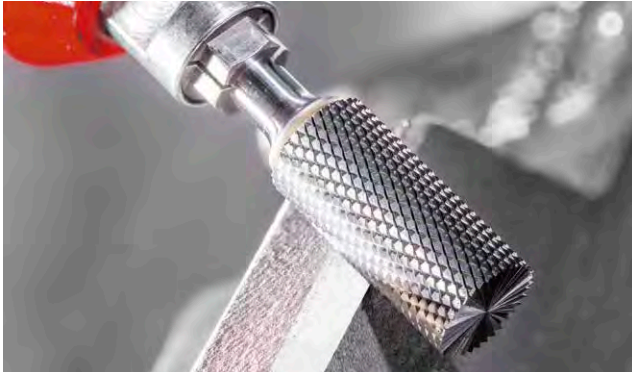
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010313309	HFA 0313.03		Z9 Alu	ZYA 0313	3	13	3	40	1
A10010616609	HFA 0616.06		Z9 Alu	ZYA 0616	6	16	6	50	1
A10011225609	HFA 1225.06		Z9 Alu	ZYA 1225	12	25	6	65	1
A10011225809	HFA 1225.08		Z9 Alu	ZYA 1225	12	25	8	65	1
A10011625609	HFA 1625.06		Z9 Alu	ZYA 1625	16	25	6	65	1
A10020313309	HFC 0313.03		Z9 Alu	WRC 0313	3	13	3	40	1
A10020616609	HFC 0616.06		Z9 Alu	WRC 0616	6	16	6	50	1
A10020820609	HFC 0820.06		Z9 Alu	WRC 0820	8	20	6	60	1
A10021225609	HFC 1225.06		Z9 Alu	WRC 1225	12	25	6	65	1
A10021225809	HFC 1225.08		Z9 Alu	WRC 1225	12	25	8	65	1
A10021625609	HFC 1625.06		Z9 Alu	WRC 1625	16	25	6	65	1
A10030403309	HFD 0403.03		Z9 Alu	KUD 0403	4	3	3	34	1
A10030605609	HFD 0605.06		Z9 Alu	KUD 0605	6	5	6	50	1
A10031212609	HFD 1210.06		Z9 Alu	KUD 1210	12	10	6	50	1
A10031616609	HFD 1614.06		Z9 Alu	KUD 1614	16	14	6	54	1
A10031616809	HFD 1614.08		Z9 Alu	KUD 1614	16	14	8	54	1
A10061225809	HFE 1225.08		Z9 Alu	TRE 1225	12	25	8	65	1
A10061625809	HFE 1625.08		Z9 Alu	TRE 1625	16	25	8	65	1
A10100313309	HFF 0313.03		Z9 Alu	RBF 0313	3	13	3	40	1
A10100618609	HFF 0618.06		Z9 Alu	RBF 0618	6	18	6	50	1
A10101225609	HFF 1225.06		Z9 Alu	RBF 1225	12	25	6	65	1
A10101225809	HFF 1225.08		Z9 Alu	RBF 1225	12	25	8	65	1
A10101630609	HFF 1630.06		Z9 Alu	RBF 1630	16	30	6	70	1
A10101630809	HFF 1630.08		Z9 Alu	RBF 1630	16	30	8	70	1
A10040313309	HFG 0313.03		Z9 Alu	SPG 0313	3	13	3	40	1
A10070820609	HFL 0820.06		Z9 Alu	—	8	20	6	60	1
A10071020609	HFL 1020.06		Z9 Alu	KEL 1020	10	20	6	60	1
A10071225609	HFL 1225.06		Z9 Alu	KEL 1225	12	25	6	65	1
A10071230609	HFL 1230.06		Z9 Alu	KEL 1230	12	30	6	70	1
A10071230809	HFL 1230.08		Z9 Alu	KEL 1230	12	30	8	70	1
A10050618609	HFM 0618.06		Z9 Alu	SKM 0618	6	18	6	50	1

Recommended for: ● Aluminium ● Plastic/Wood



# BENEFITS OF BURR AND FILE IN A SINGLE TOOL

## EVEN CUTS SOFT MATERIALS WITHOUT CLOGGING

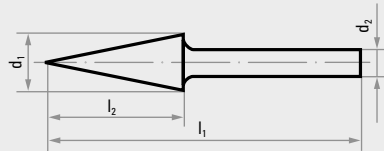


The micro-cut of the solid carbide rotary files is based on the cutting geometry of a file. This prevents the tool from becoming clogged, even when processing soft materials. The precision toothing is produced using modern CNC grinding machines to guarantee perfect concentric running and chatter-free work. This keeps the burrs sharp for longer, leaving a clean surface without any chatter marks. We offer rotary files in a range of shapes and sizes, and with three different cuts from ZF1 (coarse) to ZF3 (fine). This allows you to optimise the conditions for every application and achieve the best surface result.



### ZF1 - ZF3 rotary file


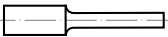



- outstanding surfaces thanks to fine toothing
- long tool life thanks to tungsten carbide
- no clogging
- for outstanding surfaces



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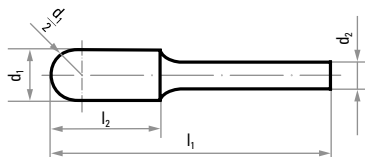
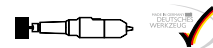
Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A100112256160001	HFAS 1225.06		ZF1	12	25	6	65	1
A10021225616	HFC 1225.06		ZF1	12	25	6	65	1
A10041230616	HFG 1230.06		ZF1	12	30	6	70	1
A100106166150001	HFAS 0616.06		ZF2	6	16	6	50	1
A100112256150001	HFAS 1225.06		ZF2	12	25	6	65	1
A10021225615	HFC 1225.06		ZF2	12	25	6	65	1
A10031009615	HFD 1009.06		ZF2	10	9	6	49	1
A10040618615	HFG 0618.06		ZF2	6	18	6	50	1
A10041230615	HFG 1230.06		ZF2	12	30	6	70	1

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Titanium

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10051225615	HFM 1225.06		ZF2	12	25	6	65	1
A100106166140001	HFAS 0616.06		ZF3	6	16	6	50	1
A10020616614	HFC 0616.06		ZF3	6	16	6	50	1
A10040618614	HFG 0618.06		ZF3	6	18	6	50	1
A10041230614	HFG 1230.06		ZF3	12	30	6	70	1
A10010204300	HFI 0204.03		ZI/ZF	2,5	4	3	40	1
A10010408300	HFI 0408.03		ZI/ZF	4	8	3	50	1
A10010810600	HFI 0810.06		ZI/ZF	8	10	6	65	1


Recommended for: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Titanium

## Z5 Hard burr


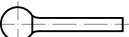




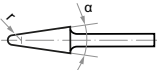




★★☆

■ with very fine single cut for high-quality surfaces with hard materials

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010210305	HFA 0210.03		Z5 Hard	ZYA 0210	2	10	3	40	1
A10010313305	HFA 0313.03		Z5 Hard	ZYA 0313	3	13	3	40	1
A10010607305	HFA 0607.03		Z5 Hard	ZYA 0607	6	7	3	37	1
A10010613305	HFA 0613.03		Z5 Hard	ZYA 0613	6	13	3	43	1
A10010616605	HFA 0616.06		Z5 Hard	ZYA 0616	6	16	6	50	1
A10010820605	HFA 0820.06		Z5 Hard	ZYA 0820	8	20	6	60	1
A10011225605	HFA 1225.06		Z5 Hard	ZYA 1225	12	25	6	65	1
A100102103050001	HFAS 0210.03		Z5 Hard	ZYA-S 0210	2	10	3	40	1
A100103133050001	HFAS 0313.03		Z5 Hard	ZYA-S 0313	3	13	3	40	1
A100106073050001	HFAS 0607.03		Z5 Hard	ZYA-S 0607	6	7	3	37	1
A100106133050001	HFAS 0613.03		Z5 Hard	ZYA-S 0613	6	13	3	43	1
A100106166050001	HFAS 0616.06		Z5 Hard	ZYA-S 0616	6	16	6	50	1
A100108206050001	HFAS 0820.06		Z5 Hard	ZYA-S 0820	8	20	6	60	1
A100112256050001	HFAS 1225.06		Z5 Hard	ZYA-S 1225	12	25	6	65	1

Recommended for: ● Steel ● Inox/Steel ● Titanium

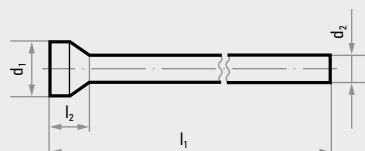
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains		
A10020210305	HFC 0210.03		Z5 Hard	WRC 0210	2	10	3	40	1		
A10020313305	HFC 0313.03		Z5 Hard	WRC 0313	3	13	3	40	1		
A10020613305	HFC 0613.03		Z5 Hard	WRC 0613	6	13	3	43	1		
A10020616605	HFC 0616.06		Z5 Hard	WRC 0616	6	16	6	50	1		
A10020820605	HFC 0820.06		Z5 Hard	WRC 0820	8	20	6	60	1		
A10021020605	HFC 1020.06		Z5 Hard	WRC 1020	10	20	6	60	1		
A10021225605	HFC 1225.06		Z5 Hard	WRC 1225	12	25	6	65	1		
A10030303305	HFD 0302.03		Z5 Hard	KUD 0302	3	2	3	40	1		
A100304043050001	HFD 0403.03		Z5 Hard	KUD 0403	4	3	3	34	1		
A10030606305	HFD 0605.03		Z5 Hard	KUD 0605	6	5	3	35	1		
A10030606605	HFD 0605.06		Z5 Hard	KUD 0605	6	5	6	50	1		
A10030808605	HFD 0807.06		Z5 Hard	KUD 0807	8	7	6	47	1		
A10031010605	HFD 1009.06		Z5 Hard	KUD 1009	10	9	6	49	1		
A10031212605	HFD 1210.06		Z5 Hard	KUD 1210	12	10	6	51	1		
A10060307305	HFE 0307.03		Z5 Hard	TRE 0307	3	7	3	40	1		
A10060610305	HFE 0610.03		Z5 Hard	TRE 0610	6	10	3	40	1		
A10100307305	HFF 0307.03		Z5 Hard	RBF 0307	3	7	3	40	1		
A10100313305	HFF 0313.03		Z5 Hard	RBF 0313	3	13	3	40	1		
A10100613305	HFF 0613.03		Z5 Hard	RBF 0613	6	13	3	43	1		
A10100618605	HFF 0618.06		Z5 Hard	RBF 0618	6	18	6	50	1		
A10040307305	HFG 0307.03		Z5 Hard	SPG 0307	3	7	3	40	1		
A10040313305	HFG 0313.03		Z5 Hard	SPG 0313	3	13	3	40	1		
A10040613305	HFG 0613.03		Z5 Hard	SPG 0613	6	13	3	43	1		
A10040618605	HFG 0618.06		Z5 Hard	SPG 0618	6	18	6	50	1		
A10041020605	HFG 1020.06		Z5 Hard	SPG 1020	10	20	6	60	1		
A10041230605	HFG 1230.06		Z5 Hard	SPG 1230	12	30	6	70	1		
A10090307305	HFH 0307.03		Z5 Hard	–	3	7	3	40	1		
A10090613305	HFH 0613.03		Z5 Hard	–	6	13	3	43	1		
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	α	Pack contains
A10071230605	HFL 1230.06		Z5 Hard	KEL 1230	12	30	6	70	2.6	14°	1
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm			Pack contains
A10050307305	HFM 0307.03		Z5 Hard	SKM 0307	3	7	3	40			1
A10050311305	HFM 0311.03		Z5 Hard	SKM 0311	3	11	3	40			1
A10050613305	HFM 0613.03		Z5 Hard	SKM 0613	6	13	3	43			1
A10050618605	HFM 0618.06		Z5 Hard	SKM 0618	6	18	6	50			1
A10120307305	HFN 0307.03		Z5 Hard	WKN 0307	3	7	3	40			1
A10120607305	HFN 0607.03		Z5 Hard	WKN 0607	6	7	3	37			1
A101203073050001	HFNS 0307.03		Z5 Hard	WKN-S 0307	3	7	3	40			1
A101206073050001	HFNS 0607.03		Z5 Hard	WKN-S 0607	6	7	3	37			1
Recommended for: <span>● Steel</span> <span>● Inox/Steel</span> <span>● Titanium</span>											

Recommended for: ● Steel ● Inox/Steel ● Titanium

# BACK DEBURRING MADE EASY

CREATE CHAMFERS IN PIPES, CONTAINERS AND DESIGN COMPONENTS

## Z3 Universal inverse deburring tool (internal)



- defined 45° bevel
- for different bore diameters
- variable chamfer width
- fast work result

### Applications:

- back deburring of boreholes on difficult-to-reach areas
- excellent for use in pipes, containers and design components
- back chamfering of boreholes

★★☆

Product number	Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10170504303	HFT 0504.03	Z3 Universal	5	4	3	40	1
A10170705303	HFT 0705.03	Z3 Universal	7	5	3	40	1
A10171006603	HFT 1006.06	Z3 Universal	10	6	6	60	1
A10171207603	HFT 1207.06	Z3 Universal	12	7	6	65	1
A10171610603	HFT 1610.06	Z3 Universal	16	10	6	70	1
A10171610803	HFT 1610.08	Z3 Universal	16	10	8	120	1
A10171811803	HFT 1811.08	Z3 Universal	18	11	8	120	1

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



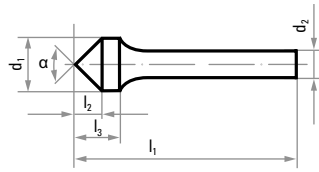
### SAFETY ADVICE

Reduced speed for burrs with a total length  $l_1 = 120$  mm: max. 11,000 m<sup>2</sup>



## Z3 Universal burr for deburring

- Remove burrs quickly and easily with the Z3 Universal burr in shape J for perfect deburring.
- for different bore diameters
- with single cut for universal applications

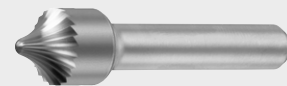
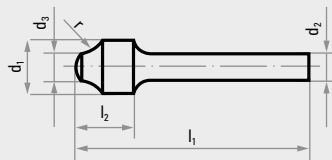


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Product number	Description	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	α	Pack contains
A1008060603	HFJ 0605.06	Z3 Universal	KSJ 0605	6	5	6	50	–	60°	1
A10081090603	HFJ 1010.06	Z3 Universal	KSK 1005	10	5	6	50	10	90°	1
A10081060603	HFJ 1013.06	Z3 Universal	KSJ 1008	10	9	6	53	13	60°	1
A10081690603	HFJ 1613.06	Z3 Universal	KSK 1608	16	8	6	53	13	90°	1
A10081690803	HFJ 1613.08	Z3 Universal	KSK 1608	16	8	8	53	13	90°	1
A10081660603	HFJ 1616.06	Z3 Universal	KSJ 1613	16	14	6	56	16	60°	1
Recommended for: <span>● Steel</span> <span>● Inox/Steel</span> <span>● Aluminium</span> <span>● Cast material</span> <span>● Titanium</span>										



## Z3 + Z5 burrs for deburring (external)

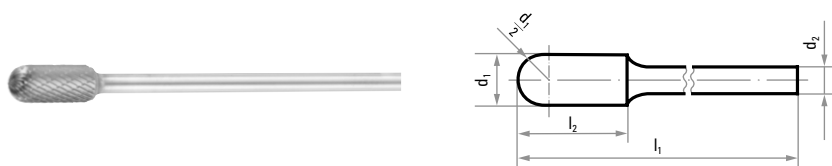
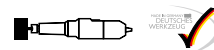


- perfectly shaped to fit boreholes of varying size

★★☆

Product number	Description	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	Pack contains
A10140812603	HFR 0812.06	Z3 Universal	8	12	6	52	3	1
A10141015603	HFR 1015.06	Z3 Universal	10	15	6	55	2	1
A10141215603	HFR 1215.06	Z3 Universal	12	15	6	55	6	1
A10141215803	HFR 1215.08	Z3 Universal	12	15	8	55	6	1
A10141315603	HFR 1315.06	Z3 Universal	13	15	6	55	3	1
A10141315803	HFR 1315.08	Z3 Universal	13	15	8	55	3	1
A10141315605	HFR 1315.06	Z5 Hard	13	15	6	55	3	1
Recommended for: <span>● Steel</span> <span>● Inox/Steel</span> <span>● Aluminium</span> <span>● Cast material</span> <span>● Titanium</span>								

## Z7 Steel burr with extra-long shank



★★★

- shank length: 200 mm
- Thanks to the central cross cut, this burr is perfect for use on steel.

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A10011225608200	HFA 1225.06 L		Z7 Steel	12	25	6	225	2,300	1
A10020616608200	HFC 0616.06 L		Z7 Steel	6	16	6	216	2,300	1
A10020820608200	HFC 0820.06 L		Z7 Steel	8	20	6	220	4,200	1
A10021020608200	HFC 1020.06 L		Z7 Steel	10	20	6	220	4,200	1
A10021225608200	HFC 1225.06 L		Z7 Steel	12	25	6	225	3,400	1
A10030605608200	HFD 0605.06 L		Z7 Steel	6	5	6	205	3,400	1
A10030807608200	HFD 0807.06 L		Z7 Steel	8	7	6	207	2,900	1
A10031009608200	HFD 1009.06 L		Z7 Steel	10	9	6	209	2,300	1
A10031210608200	HFD 1210.06 L		Z7 Steel	12	10	6	210	5,200	1
A10031210808200	HFD 1210.08 L		Z7 Steel	12	10	8	210	5,300	1
A10061220608200	HFE 1220.06 L		Z7 Steel	12	20	6	220	2,500	1
A10100618608200	HFF 0618.06 L		Z7 Steel	6	18	6	218	4,100	1
A10101230808200	HFF 1230.08 L		Z7 Steel	12	30	8	230	3,500	1
A10040618608200	HFG 0618.06 L		Z7 Steel	6	18	6	218	4,100	1
A10041230808200	HFG 1230.08 L		Z7 Steel	12	30	8	230	3,500	1
A10091020608200	HFH 1020.06 L		Z7 Steel	10	20	6	220	2,900	1

Recommended for: ● Steel ● Cast material ● Titanium



### SAFETY ADVICE

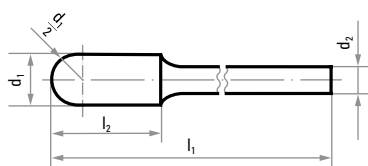
To prevent shank breakage, never exceed the maximum permitted speed when there is no tool contact (see product table). You may work at twice the maximum permitted speed only if the burr is in contact

with the workpiece or inserted into a channel or borehole before the power tool is switched on, and remains there until the power tool comes to a complete standstill.





## Z3 Universal burr with extra-long shank



- shank length: 200 mm
- with single cut for universal applications

★★☆

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A10020616603200	HFC 0616.06 L		Z3 Universal	6	16	6	216	4,200	1
A10020820603200	HFC 0820.06 L		Z3 Universal	8	20	6	220	3,400	1
A10030605603200	HFD 0605.06 L		Z3 Universal	6	5	6	205	5,200	1
A10030807603200	HFD 0807.06 L		Z3 Universal	8	7	6	207	4,600	1
A10031009603200	HFD 1009.06 L		Z3 Universal	10	9	6	209	3,900	1
A10031210603200	HFD 1210.06 L		Z3 Universal	12	10	6	210	3,400	1
A10061220603200	HFE 1220.06 L		Z3 Universal	12	20	6	220	2,500	1
A10100618603200	HFF 0618.06 L		Z3 Universal	6	18	6	218	4,100	1
A10040618603200	HFG 0618.06 L		Z3 Universal	6	18	6	218	4,100	1
A10091020603200	HFH 1020.06 L		Z3 Universal	10	20	6	220	2,900	1

Recommended for: ● Steel ● Inox/Steel ● Titanium



### SAFETY ADVICE

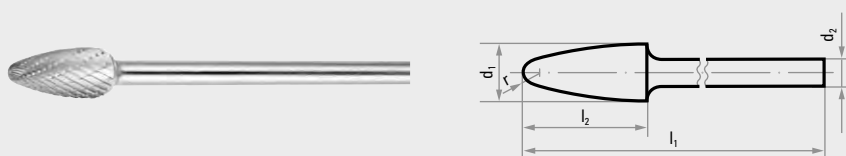
To prevent shank breakage, never exceed the maximum permitted speed when there is no tool contact (see product table). You may work at twice the maximum permitted speed only if the burr is in contact

with the workpiece or inserted into a channel or borehole before the power tool is switched on, and remains there until the power tool comes to a complete standstill.

# ZX UNIVERSAL – SUCCESSFUL ON EVERY MATERIAL

KEEP TOOL CHANGES TO A MINIMUM WITH UNIVERSAL CROSS CUT

## ZX Universal burr with extra-long shank



- shank length: 150 mm
- the all-rounder for universal applications
- with cross cut for high performance

☆☆☆

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A10020820622150	HFC 0820.06 BASE-X		ZX Universal	8	20	6	170	5,500	1
A10021020622150	HFC 1020.06 BASE-X		ZX Universal	10	20	6	170	4,700	1
A10021225622150	HFC 1225.06 BASE-X		ZX Universal	12	25	6	175	3,600	1
Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A10030807622150	HFD 0807.06 BASE-X		ZX UNIVERSAL	8	7	6	157	7,900	1
A10031009622150	HFD 1009.06 BASE-X		ZX UNIVERSAL	10	9	6	159	6,600	1
A10100820622150	HFF 0820.06 BASE-X		ZX UNIVERSAL	8	20	6	170	5,600	1
A10101225622150	HFF 1225.06 BASE-X		ZX UNIVERSAL	12	25	6	175	3,600	1

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



### SAFETY ADVICE

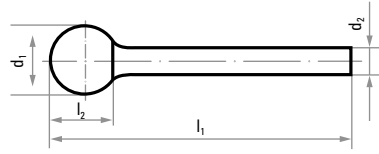
To prevent shank breakage, never exceed the maximum permitted speed when there is no tool contact (see product table). You may work at twice the maximum permitted speed only if the burr is in contact

with the workpiece or inserted into a channel or borehole before the power tool is switched on, and remains there until the power tool comes to a complete standstill.





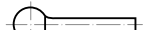


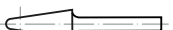





## ZX Universal burr

MILLING



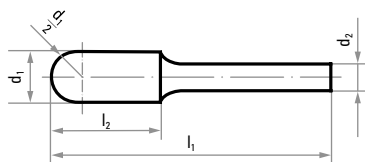
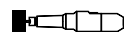
- the all-rounder for universal applications
- with cross cut for high performance

★☆☆

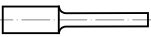
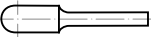

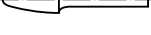
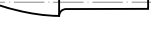






Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm		Pack contains	
A10010313322	HFA 0313.03 BASE-X		ZX Universal	ZYA 0313	3	13	3	40		10	
A10010616622	HFA 0616.06 BASE-X		ZX Universal	ZYA 0616	6	16	6	50		10	
A10010820622	HFA 0820.06 BASE-X		ZX Universal	ZYA 0820	8	20	6	60		10	
A10011020622	HFA 1020.06 BASE-X		ZX Universal	ZYA 1020	10	20	6	60		10	
A10011225622	HFA 1225.06 BASE-X		ZX Universal	ZYA 1225	12	25	6	65		5	
A10020313322	HFC 0313.03 BASE-X		ZX Universal	WRC 0313	3	13	3	40		10	
A10020613322	HFC 0613.03 BASE-X		ZX Universal	WRC 0613	6	13	3	43		10	
A10020616622	HFC 0616.06 BASE-X		ZX Universal	WRC 0616	6	16	6	50		10	
A10020820622	HFC 0820.06 BASE-X		ZX Universal	WRC 0820	8	20	6	60		10	
A10021020622	HFC 1020.06 BASE-X		ZX Universal	WRC 1020	10	20	6	60		10	
A10021225622	HFC 1225.06 BASE-X		ZX Universal	WRC 1225	12	25	6	65		5	
A10030403322	HFD 0403.03 BASE-X		ZX Universal	KUD 0403	4	3	3	34		10	
A10030605322	HFD 0605.03 BASE-X		ZX Universal	KUD 0605	6	5	3	35		10	
A10030807622	HFD 0807.06 BASE-X		ZX Universal	KUD 0807	8	7	6	47		10	
A10031009622	HFD 1009.06 BASE-X		ZX Universal	KUD 1009	10	9	6	49		10	
A10031210622	HFD 1210.06 BASE-X		ZX Universal	KUD 1210	12	10	6	51		5	
A10100313322	HFF 0313.03 BASE-X		ZX Universal	RBF 0313	3	13	3	40		10	
A10100618622	HFF 0618.06 BASE-X		ZX Universal	RBF 0618	6	18	6	50		10	
A10100820622	HFF 0820.06 BASE-X		ZX Universal	–	8	20	6	60		10	
A10101020622	HFF 1020.06 BASE-X		ZX Universal	RBF 1020	10	20	6	60		10	
A10101225622	HFF 1225.06 BASE-X		ZX Universal	RBF 1225	12	25	6	65		5	
A10040313322	HFG 0313.03 BASE-X		ZX Universal	SPG 0313	3	13	3	40		10	
A10040613322	HFG 0613.03 BASE-X		ZX Universal	SPG 0613	6	13	3	43		10	
A10040820622	HFG 0820.06 BASE-X		ZX Universal	SPG 0820	8	20	6	60		10	
A10041020622	HFG 1020.06 BASE-X		ZX Universal	SPG 1020	10	20	6	60		10	
A10041225622	HFG 1225.06 BASE-X		ZX Universal	SPG 1225	12	25	6	65		5	
A10041230622	HFG 1230.06 BASE-X		ZX Universal	SPG 1230	12	30	6	65		5	
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	r mm	α	Pack contains
A10071230622	HFL 1230.06 BASE-X		ZX Universal	KEL 1230	12	30	6	70	2.6	14°	5
A10050311322	HFM 0311.03 BASE-X		ZX Universal	SKM 0311	3	11	3	40	–	14°	10
A10050618622	HFM 0618.06 BASE-X		ZX Universal	SKM 0618	6	18	6	50	–	16°	10
A10051020622	HFM 1020.06 BASE-X		ZX Universal	SKM 1020	10	20	6	60	–	27°	10
A10051225622	HFM 1225.06 BASE-X		ZX Universal	SKM 1225	12	25	6	65	–	26°	5
Recommended for:  Steel  Cast material  Inox/Steel  Titan											

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

## ZX Universal burr with imperial-sized shank



- the all-rounder for universal applications
- with cross cut for high performance

Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> inch	l <sub>1</sub> mm	Pack contains		
A5001082062214	HFA 0820.06 BASE-X		ZX Universal	ZYA 8020	8	20	1/4"	60	10		
A5001102062214	HFA 1020.06 BASE-X		ZX Universal	ZYA 1020	10	20	1/4"	60	10		
A5001122562214	HFA 1225.06 BASE-X		ZX Universal	ZYA 1225	12	25	1/4"	65	5		
A5002061662214	HFC 0616.06 BASE-X		ZX Universal	WRC 0616	6	16	1/4"	50	10		
A5002082062214	HFC 0820.06 BASE-X		ZX Universal	WRC 0820	8	20	1/4"	60	10		
A5002102062214	HFC 1020.06 BASE-X		ZX Universal	WRC 1020	10	20	1/4"	60	10		
A5002122562214	HFC 1225.06 BASE-X		ZX Universal	WRC 1225	12	25	1/4"	65	5		
A5003100962214	HFD 1009.06 BASE-X		ZX Universal	KUD 1009	10	9	1/4"	49	10		
A5003121062214	HFD 1210.06 BASE-X		ZX Universal	KUD 1210	12	10	1/4"	51	5		
A5010082062214	HFF 0820.06 BASE-X		ZX Universal	–	8	20	1/4"	60	10		
A5010102062214	HFF 1020.06 BASE-X		ZX Universal	RBF 1020	10	20	1/4"	60	10		
A5010122562214	HFF 1225.06 BASE-X		ZX Universal	RBF 1225	12	25	1/4"	65	5		
A5004082062214	HFG 0820.06 BASE-X		ZX Universal	SPG 8020	8	20	1/4"	60	10		
A5004102062214	HFG 1020.06 BASE-X		ZX Universal	SPG 1020	10	20	1/4"	60	10		
A5004122562214	HFG 1225.06 BASE-X		ZX Universal	SPG 1225	12	25	1/4"	65	5		
A5004123062214	HFG 1230.06 BASE-X		ZX Universal	SPG 1230	12	30	1/4"	70	5		
Product number	Description	Shape	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> inch	l <sub>1</sub> mm	r mm	α	Pack contains
A5007123062214	HFL 1230.06 BASE-X		ZX Universal	KEL 1230	12	30	1/4"	70	2.6	14°	5
A5005061862214	HFM 0618.06 BASE-X		ZX Universal	SKM 0618	6	18	1/4"	50	–	16°	10
A5005102062214	HFM 1020.06 BASE-X		ZX Universal	SKM 1020	10	20	1/4"	60	–	27°	10
A5005122562214	HFM 1225.06 BASE-X		ZX Universal	SKM 1225	12	25	1/4"	65	–	26°	5
Recommended for:  Steel  Cast material  Inox/Steel  Titan											

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



## Carbide burrs assortments

- Always the right tool at hand. With our practical tool assortments, you can always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry



Set HM STEEL S3



Set HM STEEL S6



Set HM INOX S6



Set HM ALU S3



Set HM ALU S6

★★★

Product number	Description	Cut	Shank Ø mm	Content 1 per pack			Pack contains
A10390010	Set HM STEEL S3	Z7 Steel	3	10 parts: HFA 0313 HFC 0613 HFG 0313 HFF 0313	HFA 0613 HFD 0302 HFG 0613	HFC 0313 HFD 0605 HFM 0613	1
A1039001006	Set HM STEEL S6	Z7 Steel	6	10 parts: HFAS 0616 HFC 1225 HFD 1210 HFF 0820	HFAS 1225 HFC 1225 HFG 0618 HFF 1225	HFC 0616 HFD 0605 HFG 1225	1
Recommended for: <div><div></div> Steel <div></div> Cast material <div></div> Titanium</div>							
A1039001020	Set HM INOX S6	Z42 Inox/ Steel	6	10 parts: HFA 0616 HFC 1225 HFG 0618 HFF 1225	HFA 1225 HFD 0605 HFG 1225	HFC 0616 HFD 1210 HFF 0618	1
Recommended for: <div><div></div> Inox/Steel <div></div> Steel <div></div> Cast material</div>							
A1039000509	Set HM ALU S3	Z9 Alu	3	5 parts: HFA 0313 HFF 0313	HFC 0313 HFG 0313	HFD 0403	1
A10390005096	Set HM ALU S6	Z9 Alu	6	5 parts: HFA 0616 HFF 0618	HFC 0616 HFD 0605	HFM 0618	1
Recommended for: <div><div></div> Aluminium <div></div> Plastic/Wood</div>							



## ZX Universal carbide burrs assortments

- Always the right tool at hand. With our practical tool assortments, you can always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry
- the all-round burr for universal applications, with cross cut for high performance



F5 S3 BASE-X

★★★

Product number	Description	Cut	Shank Ø mm	Content 1 per pack			Pack contains
A10390053	F5 S3 BASE-X	ZX Universal	3	5 parts: HFA 0313 HFF 0313	HFC 0313 HFG 0313	HFD 0605	1
A10390056	F5 S6 BASE-X	ZX Universal	6	5 parts: HFA 1225 HFF 1225	HFC 1225 HFG 1225	HFD 1210	1
Recommended for: <div><div></div> Steel <div></div> Cast material <div></div> Inox/Steel <div></div> Titan</div>							

GET IN TOUCH!

# LUKAS TOOLS – PERFECT FOR USE WITH ROBOTS

OUR CUTTING-EDGE TOOLS FOR YOUR MODERN PRODUCTION PROCESSES

## Tools for stationary use



In addition to rotary burrs, we also produce tungsten carbide milling tools in special shapes and sizes for stationary applications. We supply these milling cutters with a maximum diameter of 20 mm and a maximum length of 250 mm; they differ from our extensive standard range in their shape, tool material and geometry (rake, clearance and helix angles).

Range of applications:

- tool construction
- turbine construction
- aerospace industry
- general engineering

Differential drill, radius mill, shank-end mill, die mill, profile mill

Available upon request

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic /Wood ● Titanium



## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS burrs made from HSS

## QUALITY

LUKAS burrs are made from tried-and-tested steels. Our modern automatic flute grinding machines and heat treatment ensure consistently high quality.

## APPLICATION

Combined with the right cut and speed, LUKAS HSS burrs can be used to efficiently cut a wide range of materials.

Please refer to the table on **page 47** for cutting speeds and the table on **page 46** for information on the various cuts.

### As a rule of thumb:

- soft material = coarse cut
- hard material = fine cut

## POWER TOOLS

LUKAS HSS burrs can be used on any commercially available pneumatic or electrical machinery. Obtaining the best result requires the machine to be run at the correct speed, the collets to run true and the bearings to be in good condition.

## SHANKS

The standard shank length is 40 mm. Extra-long shanks are available on request for inaccessible working areas.

## PACKAGING

Depending on the burr dimensions ordered, we select one of our environmentally friendly standard packages (5 or 10 items).


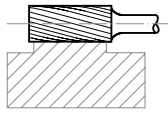

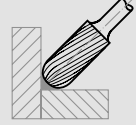
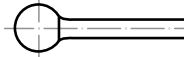
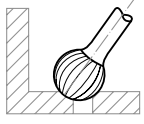
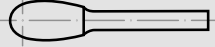
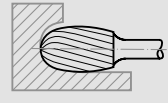

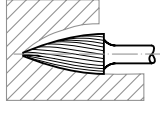
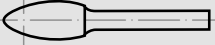
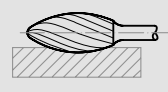

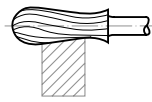
## SPECIAL TOOLS


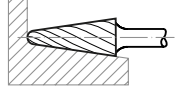

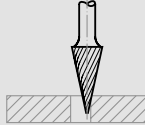
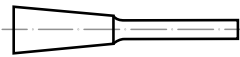
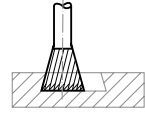

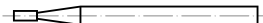
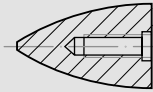
We can produce HSS burrs to the usual high LUKAS quality standards based on your specifications or drawing.

THE PERFECT BURRS FOR USE IN  
PATTERN CONSTRUCTION AND  
3D PRINTING **FROM PAGE 52**



## SHAPE



## The available shapes and cuts of our burrs

Shape		Application
	<b>MFA</b> Cylindrical	
	<b>MFC</b> Cylindrical round nose	
	<b>MFD</b> Spherical	
	<b>MFE</b> Oval	
	<b>MFG</b> Arch pointed nose	
	<b>MFH</b> Flame	
	<b>MFK</b> Club	

Shape		Application
	<b>MFL</b> Conical round nose	
	<b>MFM</b> Conical pointed nose	
	<b>MFN</b> Inverted cone	
	<b>MF</b> Miniature burr, shank 3 mm	—
	<b>MF</b> Miniature burr, shank 6 mm	—
	Burr with internal thread	—

## CUTS

Cut		Properties	Page
	Z1	Coarse cut for soft materials	48
	Z2	Robust single cut for high stock removal	49

Cut		Properties	Page
	Z3	Medium single cut	50/51
	Z5	Very fine single cut for high-quality surfaces	51

## RECOMMENDED APPLICATIONS

## Three steps to your perfect burr made from HSS

## STEP 1

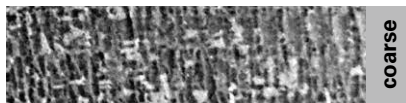
## STEP 2

Begin by selecting the right **material** and **machining mode** (coarse to fine) from the table.

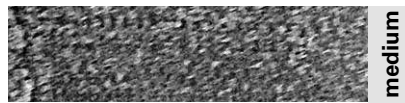
Read off the recommended **cut** and **cutting speed**.

Material	Strength (N/mm <sup>2</sup> )	Machining	Cut	Recommended cutting speed $v_c$ (m/min)
● Steel, cast steel	up to 800	coarse	Z2	50–100
		medium	Z3	100–200
		fine	Z5	50–200
	800 to 1,200	coarse	Z2	50–100
		medium	Z3	100–200
		fine	Z5	50–200
● Non-ferrous metal	up to 450	coarse	Z1	200–300
		medium	Z2	150–300
● Plastic and wood	20 to 400	coarse	Z1	200–300
		fine	Z2	150–300

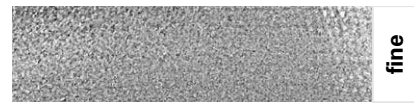
## MACHINING



coarse



medium



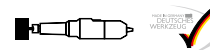
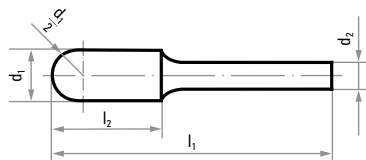
fine

## STEP 3

Determine the appropriate **speed** for your power tool in the second table, based on the tool diameter and cutting speed.

Recommended cutting speed $v_c$ (m/min)							
		50	100	150	200	250	300
Tool diameter (mm)	2	8,000	16,000	24,000	32,000	40,000	48,000
	3	5,000	11,000	16,000	21,000	27,000	32,000
	4	4,000	8,000	12,000	16,000	20,000	24,000
	6	3,000	5,000	8,000	11,000	13,000	16,000
	8	2,000	4,000	6,000	8,000	10,000	12,000
	10	2,000	3,000	5,000	6,000	8,000	10,000
	12	1,000	3,000	4,000	5,000	7,000	8,000
	16	1,000	2,000	3,000	4,000	5,000	6,000
	20	1,000	2,000	2,000	3,000	4,000	5,000
	22	1,000	1,000	2,000	3,000	4,000	4,000
	25	1,000	1,000	2,000	3,000	3,000	4,000
	30	1,000	1,000	2,000	2,000	3,000	3,000
	35	–	1,000	1,000	2,000	2,000	3,000
Speed (rpm)							

## Z1 HSS burr

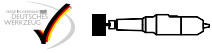


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■ coarse cut for soft materials

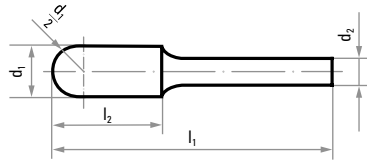
Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12001225601	MFA 1225.06		Z1	12	25	6	65	5
A12001625601	MFA 1625.06		Z1	16	25	6	65	5
A120006166010001	MFAS 0616.06		Z1	6	16	6	56	10
A120012256010001	MFAS 1225.06		Z1	12	25	6	65	5
A120016256010001	MFAS 1625.06		Z1	16	25	6	65	5
A12010620601	MFC 0620.06		Z1	6	20	6	60	10
A12010850601	MFC 0850.06		Z1	8	50	6	90	10
A12011225601	MFC 1225.06		Z1	12	25	6	65	5
A12050808601	MFD 0807.06		Z1	8	7	6	60	10
A12051212601	MFD 1210.06		Z1	12	10	6	60	5
A12051614601	MFD 1614.06		Z1	16	14	6	60	5
A12081220601	MFE 1220.06		Z1	12	20	6	60	5
A12081625601	MFE 1625.06		Z1	16	25	6	60	5
A12060618601	MFG 0618.06		Z1	6	18	6	58	10
A12061220601	MFG 1220.06		Z1	12	20	6	60	5
A12061230601	MFG 1230.06		Z1	12	30	6	70	5
A12061630601	MFG 1630.06		Z1	16	30	6	70	5
A12031630601	MFL 1630.06		Z1	16	30	6	70	5
A12020618601	MFm 0618.06		Z1	6	18	6	58	10
A12021230601	MFm 1230.06		Z1	12	30	6	70	5
A120412136010001	MFNS 1213.06		Z1	12	13	6	53	5

Recommended for: ■ Aluminium ■ Plastic/Wood



## Z2 HSS burr

MILLING



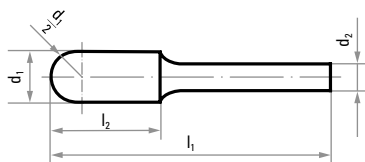
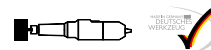
■ robust single cut for high stock removal

★★☆

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12000616602	MFA 0616.06		Z2	6	16	6	56	10
A12001013602	MFA 1013.06		Z2	10	13	6	53	10
A12001225602	MFA 1225.06		Z2	12	25	6	65	5
A12001625602	MFA 1625.06		Z2	16	25	6	65	5
A120006166020001	MFAS 0616.06		Z2	6	16	6	56	10
A120010136020001	MFAS 1013.06		Z2	10	13	6	53	10
A120012256020001	MFAS 1225.06		Z2	12	25	6	65	5
A120016256020001	MFAS 1625.06		Z2	16	25	6	65	5
A12010620602	MFC 0620.06		Z2	6	20	6	60	10
A12010850602	MFC 0850.06		Z2	8	50	6	90	10
A12011225602	MFC 1225.06		Z2	12	25	6	65	5
A120504046020001	MFD 0404.06		Z2	4,5	4	6	60	10
A12050606602	MFD 0605.06		Z2	6	5	6	60	10
A12050808602	MFD 0807.06		Z2	8	7	6	60	10
A12051010602	MFD 1009.06		Z2	10	9	6	60	10
A12051614602	MFD 1614.06		Z2	16	14	6	60	5
A12060618602	MFG 0618.06		Z2	6	18	6	58	10
A12061220602	MFG 1220.06		Z2	12	20	6	60	5
A12061230602	MFG 1230.06		Z2	12	30	6	70	5
A12061630602	MFG 1630.06		Z2	16	30	6	70	5
A12090620602	MFK 0620.06		Z2	6	20	6	60	10
A12091230602	MFK 1230.06		Z2	12	30	6	70	5
A12031020602	MFL 1020.06		Z2	10	20	6	60	10
A12031630602	MFL 1630.06		Z2	16	30	6	70	5
A12020618602	MFM 0618.06		Z2	6	18	6	58	10
A12021020602	MFM 1020.06		Z2	10	20	6	60	10
A12021230602	MFM 1230.06		Z2	12	30	6	70	5

Recommended for: ● Plastic/Wood ● Steel ● Aluminium

## Z3 HSS burr



★★☆

■ medium single cut

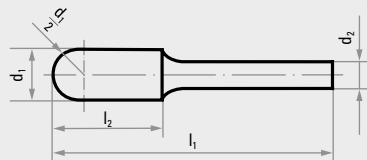
Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12000616603	MFA 0616.06		Z3	6	16	6	56	10
A12000820603	MFA 0820.06		Z3	8	20	6	60	10
A12001013603	MFA 1013.06		Z3	10	13	6	53	10
A12001020603	MFA 1020.06		Z3	10	20	6	60	10
A12001225603	MFA 1225.06		Z3	12	25	6	65	5
A12001625603	MFA 1625.06		Z3	16	25	6	65	5
A120006166030001	MFAS 0616.06		Z3	6	16	6	56	10
A120008206030001	MFAS 0820.06		Z3	8	20	6	60	10
A120010136030001	MFAS 1013.06		Z3	10	13	6	53	10
A120012256030001	MFAS 1225.06		Z3	12	25	6	65	5
A120016256030001	MFAS 1625.06		Z3	16	25	6	65	5
A12010620603	MFC 0620.06		Z3	6	20	6	60	10
A12010820603	MFC 0820.06		Z3	8	20	6	60	10
A12011020603	MFC 1020.06		Z3	10	20	6	60	10
A12011225603	MFC 1225.06		Z3	12	25	6	65	5
A12050303603	MFD 0302.06		Z3	3	2	6	60	10
A120503036030001	MFD 0303.06		Z3	3,5	3	6	60	10
A12050404603	MFD 0403.06		Z3	4	3	6	60	10
A120504046030001	MFD 0404.06		Z3	4,5	4	6	60	10
A12050505603	MFD 0504.06		Z3	5	4	6	60	10
A12050606603	MFD 0605.06		Z3	6	5	6	60	10
A12050808603	MFD 0807.06		Z3	8	7	6	60	10
A12051010603	MFD 1009.06		Z3	10	9	6	60	10
A12051212603	MFD 1210.06		Z3	12	10	6	60	5
A12051614603	MFD 1614.06		Z3	16	14	6	60	5
A12081220603	MFE 1220.06		Z3	12	20	6	60	5
A12081625603	MFE 1625.06		Z3	16	25	6	60	5
A12060618603	MFG 0618.06		Z3	6	18	6	58	10
A12061220603	MFG 1220.06		Z3	12	20	6	60	5
A12061225603	MFG 1225.06		Z3	12	25	6	65	5
A12061230603	MFG 1230.06		Z3	12	30	6	70	5
A12061630603	MFG 1630.06		Z3	16	30	6	70	5
A12070820603	MFH 0820.06		Z3	8	20	6	60	10
A12071230603	MFH 1230.06		Z3	12	30	6	70	5
A12071635603	MFH 1635.06		Z3	16	35	6	75	5
A12090620603	MFK 0620.06		Z3	6	20	6	60	10
A12091230603	MFK 1230.06		Z3	12	30	6	70	5
A12031020603	MFL 1020.06		Z3	10	20	6	60	10
A12031230603	MFL 1230.06		Z3	12	30	6	70	5
A12031630603	MFL 1630.06		Z3	16	30	6	70	5

Recommended for: ● Steel



Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12020618603	MFM 0618.06		Z3	6	18	6	58	10
A12020820603	MFM 0820.06		Z3	8	20	6	60	10
A12021020603	MFM 1020.06		Z3	10	20	6	60	10
A12021225603	MFM 1225.06		Z3	12	25	6	65	5
A12021230603	MFM 1230.06		Z3	12	30	6	70	5
A12041230603	MFN 1230.06		Z3	12	30	6	70	5
A12041213603	MFN 1213.06		Z3	12	13	6	53	5
A120412136030001	MFNS 1213.06		Z3	12	13	6	53	5
A120412306030001	MFNS 1230.06		Z3	12	30	6	70	5

Recommended for: ● Steel



## Z5 HSS burr

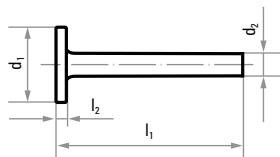
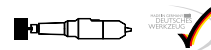
- very fine single cut for high-quality surfaces



Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12000304605	MFA 0304.06		Z5	3	4.5	6	60	10
A12000607605	MFA 0607.06		Z5	6	7	6	60	10
A12001225605	MFA 1225.06		Z5	12	25	6	65	5
A120006166050001	MFAS 0616.06		Z5	6	16	6	56	10
A12010620605	MFC 0620.06		Z5	6	20	6	60	10
A12011225605	MFC 1225.06		Z5	12	25	6	65	5
A12050808605	MFD 0807.06		Z5	8	7	6	60	10
A12051010605	MFD 1009.06		Z5	10	9	6	60	10
A12061230605	MFG 1230.06		Z5	12	30	6	70	5
A12061630605	MFG 1630.06		Z5	16	30	6	70	5
A12031630605	MFL 1630.06		Z5	16	30	6	70	5
A12040303605	MFN 0303.06		Z5	3	3	6	60	10
A12040606605	MFN 0606.06		Z5	6	6	6	60	10

Recommended for: ● Steel

## Z5 HSS miniature burr



- Shank diameter: 3 mm
- very fine single cut for high-quality surfaces

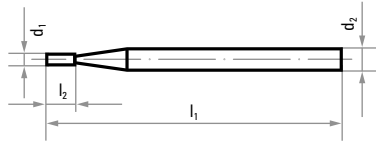
★★☆

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A1236082705	MF 827		Z5	4	2,8	3	40	10
A1236082905	MF 829		Z5	6	4,2	3	41	10
A1236083105	MF 831		Z5	8	5,5	3	43	10
A1236083705	MF 837		Z5	6	6	3	43	10
A1236083905	MF 839		Z5	8	8	3	45	10
A1237084005	MF 840		Z5	1,6	2,8	3	40	10
A1237084105	MF 841		Z5	2,3	4	3	41	10
A1237084205	MF 842		Z5	3,2	5,6	3	43	10
A1237084305	MF 843		Z5	4	7	3	44	10
A1237084405	MF 844		Z5	5	8,7	3	46	10
A1237084505	MF 845		Z5	6	10,5	3	46	10
A1237084705	MF 847		Z5	8	14	3	46	10
A1238084805	MF 848		Z5	1,6	1,5	3	38	10
A1238084905	MF 849		Z5	2,3	2,1	3	39	10
A1238085005	MF 850		Z5	3,2	3	3	40	10
A1238085105	MF 851		Z5	4	3,8	3	41	10
A1238085205	MF 852		Z5	5	4,8	3	42	10
A1238085305	MF 853		Z5	6	5,6	3	43	10
A1238085405	MF 854		Z5	7	6,7	3	44	10
A1238085505	MF 855		Z5	8	7,7	3	45	10
A1235080705	MF 807		Z5	7	10	3	42	10
A1235081305	MF 813		Z5	7	10	3	42	10
A1235081405	MF 814		Z5	6	10	3	42	10
A1235081505	MF 815		Z5	7	12	3	44	10
A1239086405	MF 864		Z5	8	2	3	39	10
A1239086505	MF 865		Z5	10	2,5	3	40	10
A1239086605	MF 866		Z5	12	3	3	40	5
A1239086705	MF 867		Z5	14	3,5	3	41	5
A1240086805	MF 868		Z5	8	2	3	39	10
A1240087005	MF 870		Z5	12	2,6	3	40	5
A1240087105	MF 871		Z5	14	3	3	40	5
A1241087205	MF 872		Z5	6	1	3	38	10
A1241087305	MF 873		Z5	8	1	3	38	10
A1241087405	MF 874		Z5	10	1	3	38	10

Recommended for: ● Steel



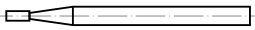

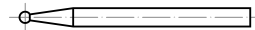

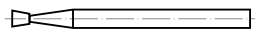

## Z3 + Z5 HSS miniature burr



MILLING

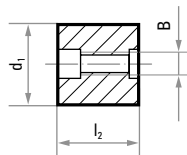
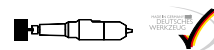
■ shank diameter: 6 mm

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Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A12000304605	MFA 0304.06		Z5	3	4,5	6	60	10
A12000607605	MFA 0607.06		Z5	6	7	6	60	10
A12050303603	MFD 0302.06		Z3	3	2	6	60	10
A120503036030001	MFD 0303.06		Z3	3,5	3	6	60	10
A12040303605	MFN 0303.06		Z5	3	3	6	60	10
A12040606605	MFN 0606.06		Z5	6	6	6	60	10

Recommended for: ● Steel

## HSS burr with internal thread



★★☆

► Suitable mounting arbors for LUKAS burrs with internal thread can be found on **page 317**.

■ Burrs with the designation MFAS have an additional end cut.

Product number	Description	Shape	Cut	d <sub>1</sub> mm	l <sub>2</sub> mm	B Thread	Pack contains
A122030301002	MFA 3030.10		Z2	30	30	M10	2
A122022150803	MFA 2215.08		Z3	22	15	M8	2
A1220303010020001	MFAS 3030.10		Z2	30	30	M10	2
A1220221508030001	MFAS 2215.08		Z3	22	15	M8	2
A122525221001	MFD 2522.10		Z1	25	21	M10	2
A122525221002	MFD 2522.10		Z2	25	21	M10	2
A122520180803	MFD 2018.08		Z3	20	18	M8	2
A122530271203	MFD 3026.12		Z3	30	26	M12	2
A122825351203	MFE 2535.12		Z3	25	35	M12	2
A122635551201	MFG 3555.12		Z1	35	55	M12	2
A122720551001	MFH 2055.10		Z1	20	55/65	M10	2
A122720551002	MFH 2055.10		Z2	20	55/65	M10	2
A122320551001	MFL 2055.10		Z1	20	55	M10	2
A122225401003	MFH 2540.10		Z3	25	40	M10	2

Recommended for: ● Steel ● Aluminium ● Inox/Steel ● Plastic/Wood



## HSS burrs assortments

- Always the right tool at hand. With our practical tool assortments, you can always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry



Set MF Z5 S3



Set MF Z3 S6



Set MF Z3/Z5 S6



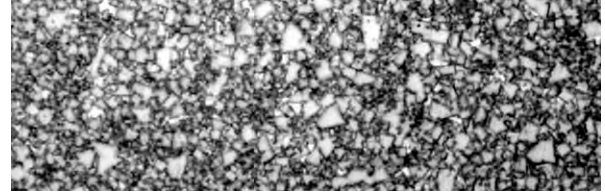
Product number	Description	Cut	Shank Ø mm	Content 1 per pack			Pack contains
A1239000110	Set MF Z5 S3	Z5	3	10 parts: MF 807 MF 845 MF 864 MF 874	MF 813 MF 850 MF 866	MF 841 MF 853 MF 872	1
A12390003	Set MF Z3 S6	Z3	6	10 parts: MFA 0616 MFD 0403 MFG 1230 MFM 0618	MFA 1225 MFD 1210 MFH 1230	MFC 1225 MFE 1220 MFK 0620	1
A12390004	Set MF Z3/Z5 S6	Z3/Z5	6	20 parts: Z3: MFA 0616 MFC 1225 MFE 1220 MFG 1230 MFM 0618 MFN 1230  Z5: MFA 0304 MFN 0606	MFA 1013 MFD 0807 MFE 1625 MFK 1230 MFM 1230  MFA 0607	MFA 1225 MFD 1210 MFG 1220 MFL 1630 MFN 1213  MFN 0303	1
Recommended for: <span>● Steel</span> <span>● Aluminium</span>							

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## Engraving cutters made from solid carbide K10F

## K10F SOLID CARBIDE

Fine-grain carbide is best suited for processing steel, grey cast iron, non-ferrous metals and plastics and offers excellent stability.



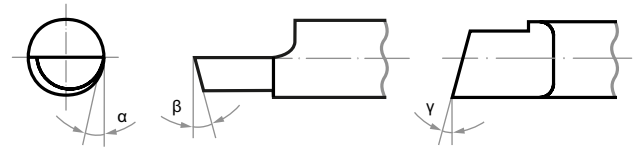
## ENGRAVING CUTTER FROM LUKAS

LUKAS has the right engraving cutter for virtually every engraving task. Whether you're working with plastic, acrylic, stainless steels, non-ferrous metals or other materials, we can help you get the job done cleanly, quickly and professionally. We have a variety of engraving cutters in different shapes and hardnesses,

so that you always have the right tool for the job. All LUKAS engraving cutters are designed and produced to last, thus keeping your production costs down. We deliver our LUKAS engraving cutters as semi-finished products with a pre-ground profile (+0.1 mm) or finished and ground to your specifications.

## CUSTOMISATIONS

We can customise the application parameters to the respective material to make sure you get perfect results. The values in the following tables are reference values.



Material to be machined	Recommended cutting and lead angles			Recommended cutting speeds in $v_c$ m/min	Recommended feed rates $f_z$ mm
	$\alpha$	$\beta$	$\gamma$		
Cast material, cast steel	25°	15°	5°	60–100	0.04–0.10
Steel up to 900 N/mm <sup>2</sup>	25°	15°	5°	120–160	0.05–0.08
Steel above 900 N/mm <sup>2</sup>	25°	15°	5°	50–70	0.04–0.08
Brass, aluminium	30°	15°	5°	200–400	0.08–0.15
Plastic, reinforced and non-reinforced	35°	15°	5°	200–600	0.05–0.20



# PERFECT ENGRAVINGS WITH

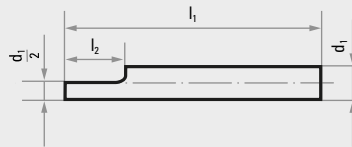
# LUKAS ENGRAVING CUTTERS

**MADE TO LAST**


## Engraving cutters made from solid carbide

### Note on the listed dimensions:

- as semi-finished cutting edge with 0.1 mm tolerance
- optional: precise halving with tolerance of +0.02 mm (10 % surcharge)
- optional: relief grinding (25 % surcharge)
- optional: finished cut on request



### Applications for spiral-fluted engraving cutters (HGS):

- zero-burr engraving of non-ferrous metals and plastics

★★☆

Product number	Description	Shape	Profile	d <sub>1</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	Pack contains
A1300404012	HGA 04.040			4	40	6	1
A1300405012	HGA 04.060			4	60	6	1
A1300407012	HGA 06.070			6	70	8	1
A1300408112	HGA 08.100			8	100	12	1
A1300409112	HGA 10.100			10	100	14	1
A1300410112	HGA 12.100			12	100	16	1
A1300403042	HGA 03.040			3	40	6	1
A1300405042	HGA 04.060			4	60	6	1
A1300407042	HGA 06.070			6	70	8	1
A1300404062	HGA 04.040			4	40	6	1
A1300484071	HGS 03.040			3	40	15	1
A1300485071	HGS 04.040			4	40	20	1
A1300486071	HGS 06.050			6	50	22	1

 Recommended for: ● Steel ● Aluminium ● Cast material ● Plastic/Wood





# DRILLING

# PRECISE DRILLING AND SECURE ANCHORING

THE HZB DRILLS HOLES ACCURATELY AND TO SIZE IN VERTICALLY-PERFORATED AND AIR BRICKS

## HIGHLY VERSATILE

The HZB special drill is your first choice when you need to anchor structural elements into brickwork. This drill bit makes it easy to install doors, windows and other structural elements. The HZB also ensures scaffolding is safely anchored; the hole guarantees the strongest possible fixing, even in perforated brickwork. When attaching façade cladding, it becomes a problem-solver for walls that are porous or difficult to drill.

# 200%

GREATER HOLDING STRENGTH  
USING THE CORRECT FASTENERS

# 20 TIMES

 LONGER TOOL LIFE


## IDEAL FOR DIFFICULT BUILDING MATERIALS

Due to their insulating properties, vertically-perforated and air bricks are one of the most important building materials in structural engineering. The HZB makes drilling into this type of brick no longer problematic. In contrast to conventional drills, the HZB does not damage the bricks' inner bars, which often leads to substantially reduced anchoring strength. The HZB tool is also suitable for drilling into glazed tiles.

## LONG-LIFE AND EASY TO USE

The LUKAS HZB special drill can be used on any standard drilling machine with an SDS-plus drill chuck. The drill is made of tungsten carbide, ensuring an exceptionally long tool life: you can count on using it up to 20 times longer than ordinary drills when drilling perforated bricks.



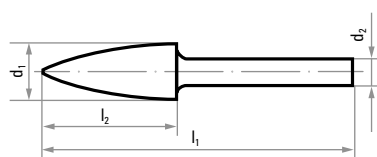
### TIP:

When drilling without impact, the drill gently rotates into the porous material thanks to its special profile.



## HZB special drill with SDS-plus shank NEW

- does not damage the bricks' inner bars
- drills holes accurately and to size
- greater holding strength
- can be used on any drilling machine with an SDS-plus chuck



★★★

Product number	Description	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A100406131008SDS	HZB 0613.10 Z7	6	13	10	263	1
A100408206083SDS	HZB 0820.06 Z7	8	20	6	185	1
A100410208083SDS	HZB 1020.10 Z7	10	20	10	200	1
A100414301208SDS	HZB 1430.12 Z7	14	30	12	250	1

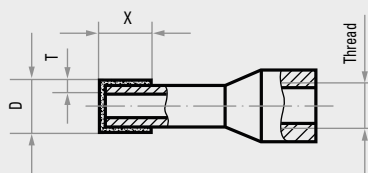
Recommended for: ● Stone/Construction material

DRILLING



## Diamond dry drills

- for use on standard angle grinders
- drills holes in tiles without chipping
- suitable for all applications in construction and plumbing



★★☆

Product number	Description	Diameter D mm	Segment height X mm	Segment width T mm	Thread	n <sub>max</sub> rpm	Pack contains
A345890066315013	DTB 06	6	9	3.0	M14	13,300	1
A345890086315013	DTB 08	8	9	3.0	M14	13,300	1
A345890106315013	DTB 10	10	9	3.0	M14	13,300	1
A345890126315013	DTB 12	12	9	3.0	M14	13,300	1
A345890146315013	DTB 14	14	9	3.0	M14	13,300	1
A345890206315013	DTB 20	20	9	3.0	M14	13,300	1
A345890256315013	DTB 25	25	9	3.0	M14	13,300	1
A345890326315013	DTB 32	32	9	3.0	M14	13,300	1
A345890386315013	DTB 38	38	9	3.0	M14	13,300	1
A345890456315013	DTB 45	45	9	3.0	M14	13,300	1
A345890586315013	DTB 58	58	9	3.0	M14	13,300	1
A345890686315013	DTB 68	68	9	3.0	M14	13,300	1

Recommended for: ● Stone/Construction material





# SET OF HGW CORE DRILLS

SPECIALLY DESIGNED FOR DRILLING SOCKET OUTLETS

Lukas HGW tools are specifically designed for special applications. A special soldering process is used to bond the grit to the core.



**APPLICATIONS**  
The LUKAS core drill set is the first choice in HGW tools used in the construction industry thanks to their long tool life and durability when drilling socket outlets. This high-quality tool is also used for drilling glass, ceramic and hard metal.

## Set of HGW core drills



★★☆

- long tool life and high durability
- suitable for drilling glass, ceramic and hard metal
- used in the construction industry for drilling socket outlets

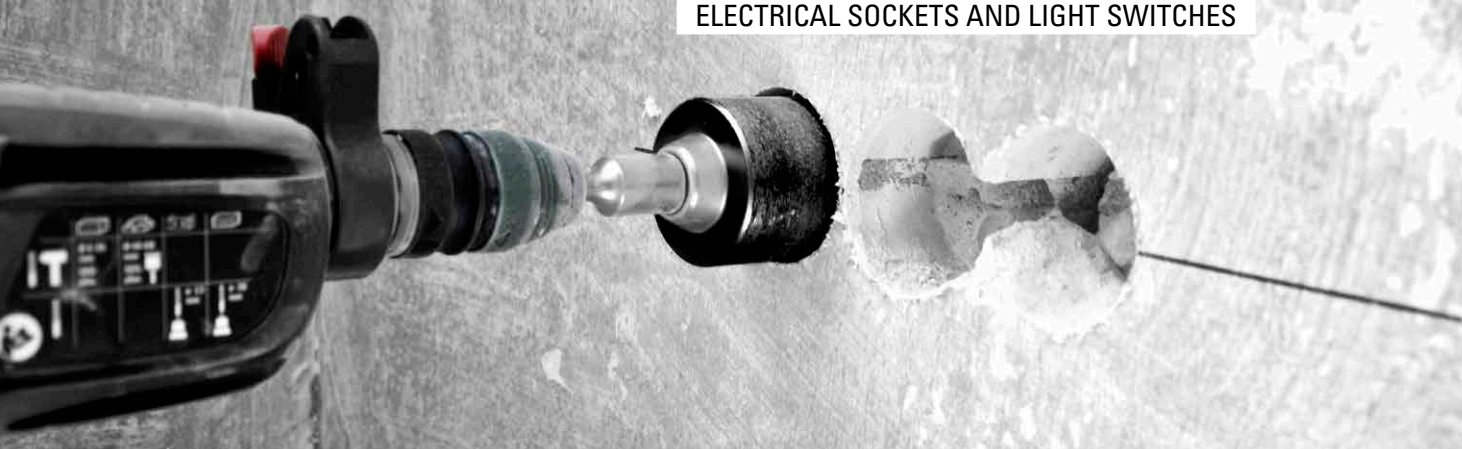
Product number	Description	Grit	Content	Pack contains
A18300012E	HGWB Set	0.8 – 1.2 E	4 core drill bits (Ø 33, 53, 63 and 73 mm) Including base plate, carbide centre point and hexagonal shank (SW9)	1

Recommended for: ● Stone/Construction material ● Plastic/Wood

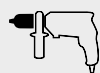


# LUKAS DIAMOND DRILL BIT FOR SOCKET OUTLETS

QUICK AND EASY INSTALLATION OF SOCKETS,  
ELECTRICAL SOCKETS AND LIGHT SWITCHES

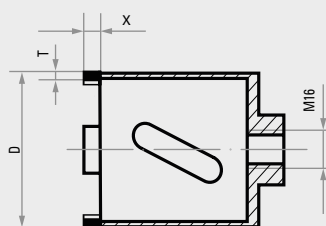


DRILLING



## Diamond drill bit for socket outlets

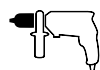
- allows quick and easy relocation of sockets in electrical installations
- for use on standard drilling machines
- mounting in three-jaw chucks or SDS quick-clamping systems
- Due to diamond coating well-suited for construction materials such as brick and masonry, roof tiles, aerated concrete and pumice stone as well as sand-lime brick.



★★★☆☆

Product number	Description	Diameter D mm	Segment height X mm	Segment width T mm	Thread	n <sub>max</sub> rpm	Pack contains
A346350687208043	DSK 68	68	8	3.5	M16	4,000	1
A346350827208043	DSK 82	82	8	3.5	M16	4,000	1

Recommended for: ● Stone/Construction material



## Accessory set for diamond drill bit for socket outlets



★★★☆☆

Product number	Description	Content	Pack contains
A346390006	DSK accessory set	Hex adapter, centre drill bit, drift key	1
A346390SDS	DSK accessory set	SDS adapter, centre drill bit, drift key	1





- 3.1 Mounted points
- 3.2 Polishing tools
- 3.3 Precision tools – CBN and diamond

# GRINDING AND POLISHING

(with bonded tools)

66–96  
97–123  
124–128

## 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).

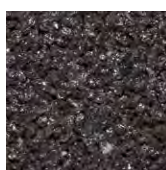
## QUALITY

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

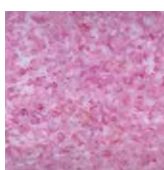
LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with. The following overview contains all raw materials for LUKAS mounted points. The abbreviations for the respective abrasives can be found in the quality designation of the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



#### NK

Regular  
aluminium oxide

★★☆



#### EKR

Pink aluminium oxide

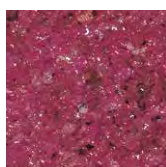
★★☆



#### EKW

White aluminium oxide

★★☆



#### EKD

Dark red  
aluminium oxide

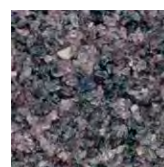
★★☆



#### EKbr

Pink aluminium oxide,  
type brown

★★☆



#### MK

Mixture EKR/NK

★★☆



#### HK

Mixture EKW/NK

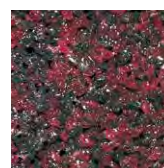
★★☆



#### HKD

Mixture EKW/EKD

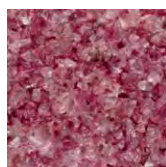
★★☆



#### MKD

Mixture NK/EKD

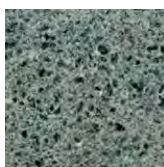
★★☆



#### RKD

Mixture of dark red and  
pink aluminium oxide

★★☆



#### SIC-ALU

Green silicon carbide

★★★



#### SICdki

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

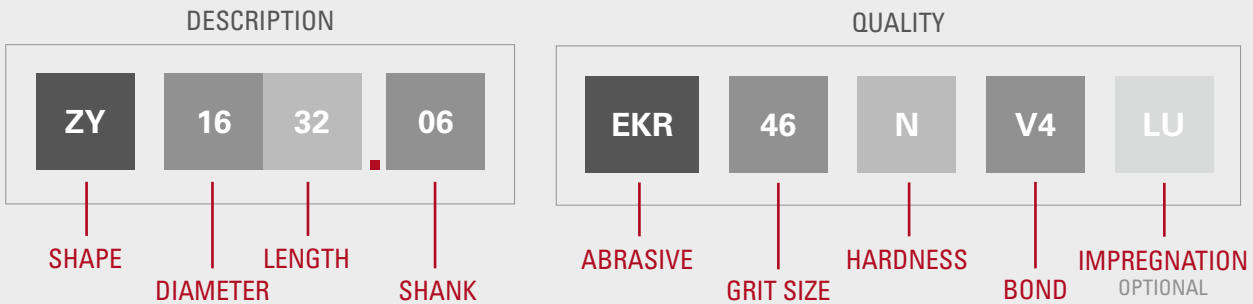
★★☆

## 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		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		<b>EKR</b> Pink aluminium oxide	approx. 20–35									
82		<b>EKWbr</b> White aluminium oxide type brown	approx. 25–40									
83/84		<b>RKD</b> Dark red and pink aluminium oxide	approx. 30–50									
84		<b>NK-BA soft</b> Regular aluminium oxide iron- and sulphur-free	approx. 40–50									
87		<b>NK-BA hard</b> Regular aluminium oxide	approx. 40–50									
88		<b>HK</b> White aluminium oxide and regular aluminium oxide	approx. 40–50									
89		<b>MK</b> Pink aluminium oxide and regular aluminium oxide	approx. 30–50									
74		<b>NDW</b> Dark red aluminium oxide, regular and monocrystal aluminium oxide	approx. 10–30									
73		<b>Ceramic</b> Ceramic grain and monocrystal aluminium oxide	approx. 30–50									
75		<b>EKW</b> White aluminium oxide	approx. 20–35									
75		<b>EKbr</b> Pink aluminium oxide, type brown	approx. 40–50									
77		<b>SIC-ALU</b> Green silicon carbide	approx. 25–40									
90		<b>HOK</b> Spherical aluminium oxide	approx. 5–20									



## TECHNICAL INFORMATION

## Speeds for grinding tools

GRINDING AND POLISHING  
(with bonded 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



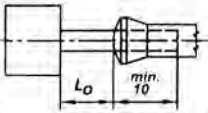

## SAFETY

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.

MULTILINGUAL  
PRODUCT DESIGNATIONPRODUCT NUMBER AND  
PRODUCT SPECIFICATIONTECHNICAL  
INFORMATION

Schleifkörper keramisch Brousicí tělíska keramická Mounted points - vitrified Muelas cerámicas Meules vitrifiées Sciernice spojone ceramiczne		 ★★☆☆	
A200002032602 ZY 2032.06 EKR 36 N V4		Menge / VPE 20	 EN 12413
L <sub>o</sub> (mm)    max. rpm 10            40.600 15            34.500 20            29.700			FA1488310  4 027497 013296
LUKAS-ERZETT Vereinigte Schleif- und Fräswerkzeugfabriken GmbH & Co. KG Gebrüder-Lukas-Straße 1 • 51786 Engelskirchen Made in Germany			

## PRODUCT LINE

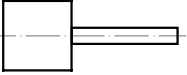
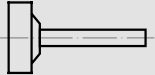
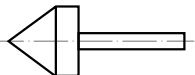
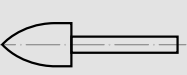
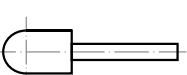
## SAFETY STANDARD


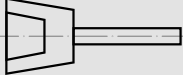

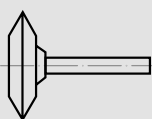
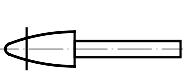
## SERIAL NUMBER



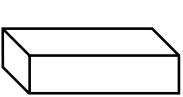
## EAN CODE

## SHAPE

## Summary of available shapes

Shape	
	<b>ZY</b> Cylindrical, type 1
	<b>ZY2</b> Cylindrical, type 1
	<b>WKS</b> Cylindrical pointed nose
	<b>SP</b> Arch pointed nose
	<b>WR</b> Cylindrical round nose

Shape	
	<b>KU</b> Spherical
	<b>TO</b> Cup
	<b>KE</b> Conical round nose
	American shape A
	American shape B

Shape	
	Miniature mounted points
	<b>SE</b> Taper-sided grinding wheel
	<b>RU</b> Sharpening stones

## 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

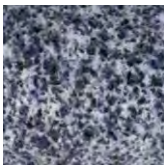
Mixture of ceramic grain and monocrystal aluminium oxide

### 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.

### 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.



★★★

### NDW

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

### INDUSTRIES

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



★★☆

### EKbr

Pink aluminium oxide, type brown

### PROCESSING EXAMPLES

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



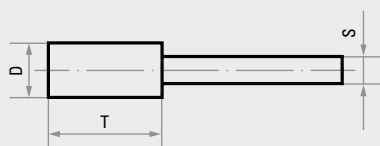
★★☆

### EKW

White aluminium oxide



- 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



## Ceramic mounted point



★★★

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)

- 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

## Ceramic mounted point assortment

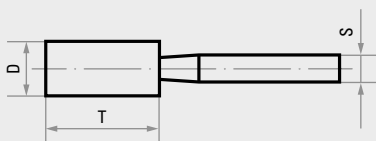


★★★

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

## 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



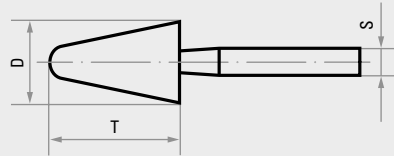
- Always the right tool at hand. The practical assortment of LUKAS tools means you always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the industry, on site or in the hobby workshop

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



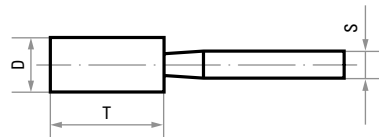
★★☆

Product number	Description	Quality	D mm	T mm	S mm	Pack contains
A201601025606	KE 1025.06	EKRbr 46/60 P V7	10	25	6 x 40	20
A201601645606	KE 1645.06	EKRbr 46/60 P V7	16	45	6 x 40	20

Recommended for: ● Steel



## EKW mounted point



★★☆

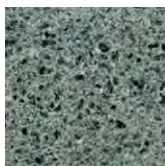
Product number	Description	Quality	D mm	T mm	S mm	Pack contains
A200000610608	ZY 0610.06	EKW 80 L V1	6	10	6 x 40	20
A200000810608	ZY 0810.06	EKW 80 L V1	8	10	6 x 40	20
A200001010608	ZY 1010.06	EKW 60 L V1	10	10	6 x 40	20
A200002020608	ZY 2020.06	EKW 60 L V1	20	20	6 x 40	20

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.

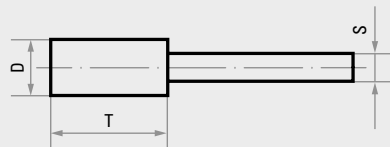
# THE SPECIALIST FOR ALUMINIUM

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	20
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

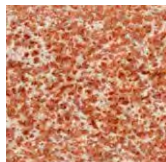
★★☆

## 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

★★☆

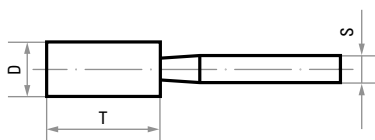
## INDUSTRIES

- 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

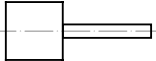
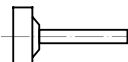


★★☆

- 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 N V4	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 N V4	4	8	6 x 40	20
A200000510302	ZY 0510.03		EKR 80 N V4	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 N V4	5	10	6 x 40	20
A200000610302	ZY 0610.03		EKR 60 N V4	6	10	3 x 30	20
A200000610602	ZY 0610.06		EKR 60 N V4	6	10	6 x 40	20
A200000810302	ZY 0810.03		EKR 60 N V4	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 N V4	8	10	6 x 40	20
A200000816302	ZY 0816.03		EKR 60 N V4	8	16	3 x 30	20
A200000816602	ZY 0816.06		EKR 60 N V4	8	16	6 x 40	20
A200000820602	ZY 0820.06		EKR 60 N V4	8	20	6 x 40	20
A200001010302	ZY 1010.03		EKR 60 N V4	10	10	3 x 30	20
A200001010602	ZY 1010.06		EKR 60 N V4	10	10	6 x 40	20
A200001013302	ZY 1013.03		EKR 60 N V4	10	13	3 x 30	20
A200001013602	ZY 1013.06		EKR 60 N V4	10	13	6 x 40	20
A200001020602	ZY 1020.06		EKR 60 N V4	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 N V4	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 N V4	10	40	6 x 40	20
A200001313302	ZY 1313.03		EKR 46 N V4	13	13	3 x 30	20
A200001313602	ZY 1313.06		EKR 46 N V4	13	13	6 x 40	20
A200001320602	ZY 1320.06		EKR 46 N V4	13	20	6 x 40	20
A200001325602	ZY 1325.06		EKR 46 N V4	13	25	6 x 40	20
A200001332602	ZY 1332.06		EKR 46 N V4	13	32	6 x 40	20
A200001616602	ZY 1616.06		EKR 46 N V4	16	16	6 x 40	20
A200001620602	ZY 1620.06		EKR 46 N V4	16	20	6 x 40	20
A200001632602	ZY 1632.06		EKR 46 N V4	16	32	6 x 40	20
A200001640602	ZY 1640.06		EKR 46 N V4	16	40	6 x 40	20
A200002020602	ZY 2020.06		EKR 36 N V4	20	20	6 x 40	20
A200002025602	ZY 2025.06		EKR 36 N V4	20	25	6 x 40	20
A200002032602	ZY 2032.06		EKR 36 N V4	20	32	6 x 40	20
A200002040602	ZY 2040.06		EKR 36 N V4	20	40	6 x 40	20
A200002520602	ZY 2520.06		EKR 36 N V4	25	20	6 x 40	20
A200002525602	ZY 2525.06		EKR 36 N V4	25	25	6 x 40	20
A200002532602	ZY 2532.06		EKR 36 N V4	25	32	6 x 40	20
A200003220602	ZY 3220.06		EKR 30 N V4	32	20	6 x 40	20
A200003232602	ZY 3232.06		EKR 30 N V4	32	32	6 x 40	20
A200003240602	ZY 3240.06		EKR 30 N V4	32	40	6 x 40	20
A200004020602	ZY 4020.06		EKR 30 N V4	40	20	6 x 40	20
A200004040602	ZY 4040.06		EKR 30 N V4	40	40	6 x 40	20
A200005020602	ZY 5020.06		EKR 30 N V4	50	20	6 x 40	20
A201301303302	ZY2 1303.03		EKR 80 N V4	13	3	3 x 30	20
A201301303602	ZY2 1303.06		EKR 80 N V4	13	3	6 x 40	20
A201301604302	ZY2 1604.03		EKR 60 N V4	16	4	3 x 30	20
A201301604602	ZY2 1604.06		EKR 60 N V4	16	4	6 x 40	20

Recommended for: ● Steel

GRINDING AND POLISHING  
(with bonded tools)

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

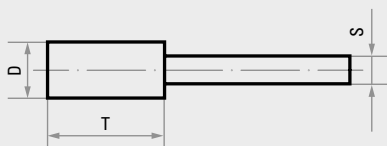
Recommended for: ● Steel



# WHITE ALUMINIUM OXIDE, TYPE BROWN

EFFICIENTLY GRIND STEEL, CAST STEEL AND TEMPERED STEELS

## 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

GRINDING AND POLISHING  
(with bonded tools)

## QUALITIES AND PROPERTIES

# Mounted points for machining non-rusting steels



### RKD

Mixture of dark red and pink aluminium oxide

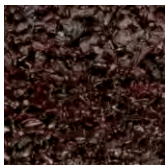
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## MATERIAL PROPERTIES

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

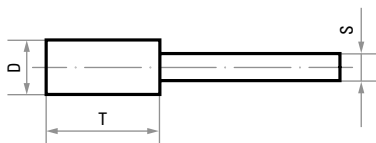
- Steel construction and fabrication (façades, handrails, sanitary equipment)
- Vessel manufacturing
- Casings and panelling
- Medical technology
- Shipyards
- Food industry
- and many more

## 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



★★☆

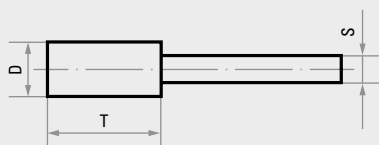
- for non-rusting steels
- excellent removal rates, also under difficult conditions

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

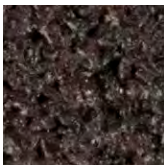
Recommended for: ● Inox/Steel ● Steel ● Aluminium





## 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

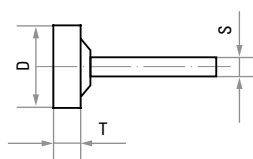
LUKAS mounted points for grinding cast materials contain special grain mixtures and tough bonding systems, delivering excellent performance in the applications mentioned above.

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

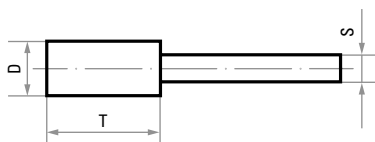
Recommended for: ● Steel ● Cast material



# REMOVE LARGE BURRS, SPRUES AND RISERS

SPECIAL GRAIN MIXTURES AND TOUGH BONDS TO GET THE JOB DONE

## 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 P V4	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

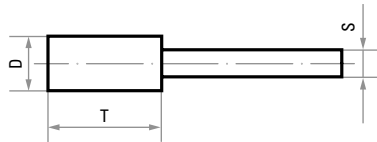
LUKAS MOUNTED POINTS FOR CAST MATERIAL RUN PARTICULARLY SMOOTHLY

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

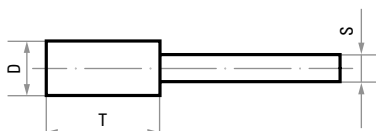
## PROCESSING EXAMPLES

- 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



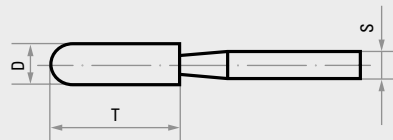
AMERICAN SHAPE B

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

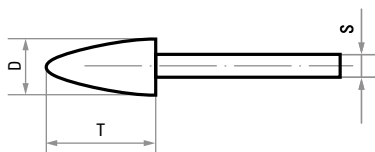


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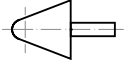
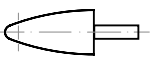
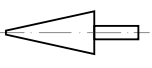
Product number	Description	Shape	Quality	D inch	T inch	D mm	T mm	S mm	Pack contains
A206202263633	A1 2263.06		HK 36/46 M V13	7/8	2 1/2	22	63	6 x 40	20
A206201645633	AS-3 1645.06		HK 36/46 M V13	5/8	1 3/4	16	45	6 x 40	20
A2062025706020001	A3 2570.06		EKR 36 N V4	1	2 3/4	25	70	6 x 40	20
A206202570633	A3 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

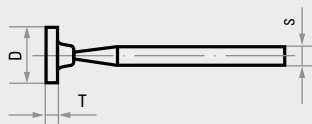


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Product number	Description	Shape	Quality	D inch	T inch	D mm	T mm	S mm	Pack contains
A206601616302	B41 1616.03		EKR 60/80 QU V4	5/8	5/8	16	16	3 x 30	20
A206601020302	B52 1020.03		EKR 46 QU V4	3/8	3/4	10	20	3 x 30	20
A206600816302	B53 0816.03		EKR 60/80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

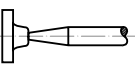
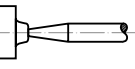

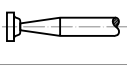
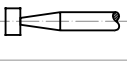
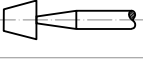
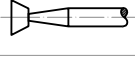
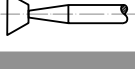
Recommended for: ● Steel

## Miniature mounted point


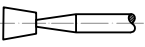






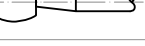

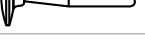



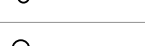











★★☆

■ 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 N V4	9	2	3 x 30	20
A202900001311	D1		EKbr 100 M V1/6	9	2	3 x 30	20
A202900002302	D2		EKR 80 N V4	9	3	3 x 30	20
A202900002311	D2		EKbr 80 M V1/6	9	3	3 x 30	20
A202900003302	D3		EKR 100 N V4	8	2	3 x 30	20
A202900003311	D3		EKbr 100 M V1/6	8	2	3 x 30	20
A202900004302	D4		EKR 100 N V4	4	1	3 x 30	20
A202900005302	D5		EKR 80 N V4	5	3	3 x 30	20
A202900005311	D5		EKbr 80 M V1/6	5	3	3 x 30	20
A202900006302	D6		EKR 80 N V4	7/4	6	3 x 30	20
A202900007302	D7		EKR 100 N V4	2.5/5	2.5	3 x 30	20
A202900008302	D8		EKR 100 N V4	2.5/6	3	3 x 30	20

Recommended for: ● Steel

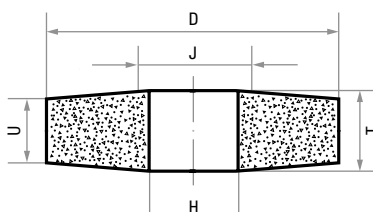
Product number	Description	Shape	Quality	D mm	T mm	S mm	Pack contains
A202900009302	D9		EKR 80 N V4	3.5/8	4	3 x 30	20
A202900009311	D9		EKbr 80 M V1/6	3.5/8	4	3 x 30	20
A202900010302	D10		EKR 100 N V4	2/3.2	4	3 x 30	20
A202900011302	D11		EKR 80 N V4	5	5	3 x 30	20
A202900012302	D12		EKR 80 N V4	4/7	6	3 x 30	20
A202900012311	D12		EKbr 80 M V1/6	4/7	6	3 x 30	20
A202900013302	D13		EKR 100 N V4	3	3	3 x 30	20
A202900013311	D13		EKbr 100 M V1/6	3	3	3 x 30	20
A202900014302	D14		EKR 80 N V4	4	4	3 x 30	20
A202900014311	D14		EKbr 80 M V1/6	4	4	3 x 30	20
A202900015302	D15		EKR 80 N V4	5	5	3 x 30	20
A202900015311	D15		EKbr 80 M V1/6	5	5	3 x 30	20
A202900017302	D17		EKR 80 N V4	4	5	3 x 30	20
A202900018302	D18		EKR 80 N V4	7	8	3 x 30	20
A202900020302	D20		EKR 100 N V4	7	5	3 x 30	20
A202900021302	D21		EKR 100 N V4	8	1.6	3 x 30	20
A202900022302	D22		EKR 100 N V4	2.5	6	3 x 30	20
A202900022311	D22		EKbr 100 M V1/6	2.5	6	3 x 30	20
A202900023302	D23		EKR 80 N V4	5	6	3 x 30	20
A202900023311	D23		EKbr 80 M V1/6	5	6	3 x 30	20
A202900024302	D24		EKR 60 N V4	6	6	3 x 30	20
A202900024311	D24		EKbr 60 M V1/6	6	6	3 x 30	20
A202900025302	D25		EKR 100 N V4	5	1.5	3 x 30	20
A202900026302	D26		EKR 100 N V4	6	2.5	3 x 30	20
A202900026311	D26		EKbr 100 M V1/6	6	2.5	3 x 30	20
A202900028302	D28		EKR 80 N V4	3.5/ 5.5	11	3 x 30	20
A202900029302	D29		EKR 100 N V4	3	6.4	3 x 30	20
A202900029311	D29		EKbr 100 M V1/6	3	6.4	3 x 30	20
A202900030302	D30		EKR 100 N V4	4.4	10	3 x 30	20
A202900030311	D30		EKbr 100 M V1/6	4.4	10	3 x 30	20
A202900032302	D32		EKR 100 N V4	5	7	3 x 30	20
A202900032311	D32		EKbr 100 M V1/6	5	7	3 x 30	20
A202900033302	D33		EKR 80 N V4	6	8	3 x 30	20
A202900034302	D34		EKR 100 N V4	4.37	7	3 x 30	20
A202900034311	D34		EKbr 100 M V1/6	4.37	7	3 x 30	20
A202900035302	D35		EKR 80 N V4	6	10	3 x 30	20
A202900035311	D35		EKbr 80 M V1/6	6	10	3 x 30	20
A202900036302	D36		EKR 80 N V4	6	11	3 x 30	20
A202900036311	D36		EKbr 80 M V1/6	6	11	3 x 30	20

Recommended for: ● Steel

GRINDING AND POLISHING  
(with bonded tools)



## 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



### 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

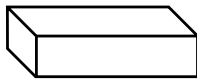

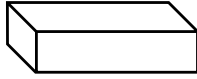
These sharpening stones feature an extremely sharp and rough abrasive grain, delivering perfect results in combination with a hard vitrified bond. This means you can get your grinding and polishing points back in working order in no time. The sharpening stone is ideal for profiling, sharpening, opening 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	200	50	10–35
	216	78	20–35
	150	13	5–35

## CUSTOMIZED PRODUCTION

# Grinding wheels specially developed for your application

GRINDING AND POLISHING  
(with bonded tools)

## 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...)

## GENERAL INFORMATION AND PRODUCT INFORMATION

# Polishing tools from LUKAS – groups P1 to P7

Whether you need to achieve certain technical surface values for your product or just want to make it shine, there are many good reasons to choose polishing tools from LUKAS.

In sectors such as the automotive industry, aerospace, and pump and turbine engineering, there are plenty of sealing surfaces and fits that must be produced with high precision to achieve the right result. In the food and pharmaceutical industries, polished surfaces ensure hygienic clean working conditions. In mould and die industry, surfaces are polished to a mirror finish; with any casting, the result is a perfect end product.

In response to the growing importance of fine machining, LUKAS has developed a wide range of polishing tools, featuring a variety of raw materials, grain combinations and hardness levels. LUKAS polishing tools are categorised into groups P1 to P7 according to the respective application. These tools include polishing wheels, points and sticks to cover a wide variety of applications. The diagram on the next page provides an overview.

Bonding type	Properties
P1	Polishing points consist of a hard rubber bonding with size 100 abrasive grains. They are suitable for fine finishing applications and the preparation of surfaces that require further polishing.
P2	Polishing points and wheels are manufactured using a soft rubber bond in grit sizes 46 to 800. These tools are perfect for creating grained to dash-dot matted finishes on small surface areas. To achieve the required result, tools with different grit sizes should be used one after the other.
P3	Felt polishing tools are used in combination with SIC or diamond polishing paste to achieve the best results, even up to a mirror finish.
P4	Polishing sticks are manufactured from polyurethane (PU). Areas of application and the results are similar to those detailed in group P2. Polishing sticks are used manually.
P5	Polishing points contain a fibre reinforcement for a longer tool life. The surface finish achieved lies between group P1 and P2.
P6	Polishing tools are available in various forms – polishing points, marbling points, rolls for satin finishes, polishing wheels and polishing discs. The hardness of the polyurethane bonding (PU) can be divided into seven grades, from soft to hard, with available grit sizes of SIC 24 to F1200. This makes the tools suitable for many different uses, including larger surfaces. The main application with polishing wheels is on stationary polishing machines, e.g. cylindrical polishing of tubes.
P7	Polishing points with a 2.35 mm shank diameter use SIC grain in sizes 240 or 400 in a silicon bond. These small tools are very soft and are ideal for polishing jewellery and other small parts.



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

Grit sizes (to ISO 525)

## TECHNICAL INFORMATION

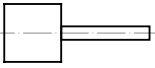
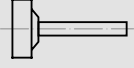
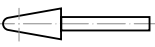



## Speeds for polishing tools

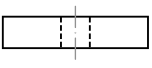

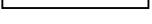



Recommended cutting speed $v_c$ (m/s)										
Polishing group (Bonds)	2	5	8	10	16	20	25	32	50	
	P1									
	P2/P4/P6 WP/P7									
	P3									
	P5									
Tool diameter (mm)	P6 MWP									
	P6 MP									
	P6 HP/P6 SHP									
	P6 SHP CG									
	4	9,500	23,800	38,100	47,700	76,300	95,400	119,300	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)										

**!** 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



## POLISHING GROUP P1

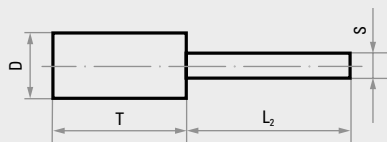
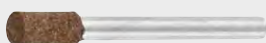
## Hard-rubber polishing points



These polishing points are available in one grit combination only. The surface finish is similar to a finish with grit size 100. The hard rubber bond makes these points particularly suitable

for finishing cast materials, hard and soft steels, as well as alloyed and unalloyed steel. They do not clogg and have a long and efficient tool life when used with moderate pressure.

## P1 polishing point



★★☆

- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel
- manufactured as per DIN 69170

Product number	Description	Shape	D mm	T mm	S mm	L <sub>2</sub> mm	Pack contains
A2600004083	P1ZY 0408.03		4	8	3	30	20
A2600005103	P1ZY 0510.03		5	10	3	30	20
A2600006103	P1ZY 0610.03		6	10	3	30	20
A2600007103	P1ZY 0710.03		7	10	3	30	20
A2600008103	P1ZY 0810.03		8	10	3	30	20
A2600008166	P1ZY 0816.06		8	16	6	40	10
A2600008206	P1ZY 0820.06		8	20	6	40	10
A2600010103	P1ZY 1010.03		10	10	3	30	20
A2600010133	P1ZY 1013.03		10	13	3	30	20
A2600010163	P1ZY 1016.03		10	16	3	30	20
A2600010206	P1ZY 1020.06		10	20	6	40	10
A2600013133	P1ZY 1313.03		13	13	3	30	20
A2600013163	P1ZY 1316.03		13	16	3	30	20
A2600013206	P1ZY 1320.06		13	20	6	40	10

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

Product number	Description	Shape	D mm	T mm	S mm	L <sub>2</sub> mm	Pack contains
A2600016163	P1ZY 1616.03		16	16	3	30	20
A2600016206	P1ZY 1620.06		16	20	6	40	10
A2600016326	P1ZY 1632.06		16	32	6	40	10
A2600020206	P1ZY 2020.06		20	20	6	40	10
A2600020326	P1ZY 2032.06		20	32	6	40	10
A2600040206	P1ZY 4020.06		40	20	6	40	10
A2607013033	P1ZY 1303.03		13	3	3	30	20
A2607016043	P1ZY 1604.03		16	4	3	30	20
A2607020063	P1ZY 2006.03		20	6	3	30	20
A2607032106	P1ZY 3210.06		32	10	6	40	10
A2602016326	P1KS 1632.06		16	32	6	40	10
A2605008083	P1KU 0808.03		8	8	3	30	20
A2605016166	P1KU 1616.06		16	16	6	39	10
A2609020326	P1KE 2032.06		20	32	6	40	10

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



## P1 polishing points assortment



- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel
- manufactured as per DIN 69170
- ready for any polishing challenge
- 14 different shapes for fast tool changes

★★☆

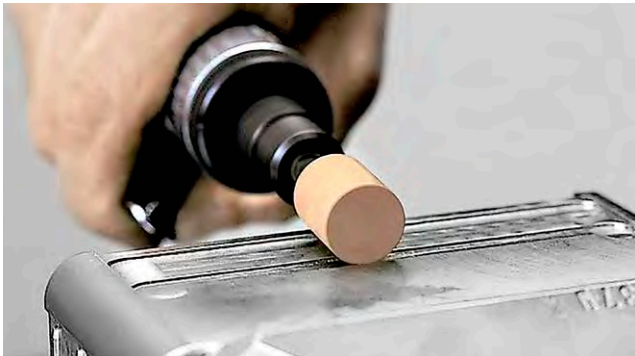
Product number	Description	Content 1 per pack					Pack contains
A2600114	Assortment 114	14 parts: P1ZY 0408.03 P1ZY 1010.03 P1ZY 1316.03	P1ZY 0510.03 P1ZY 1013.03 P1ZY 1604.03	P1ZY 0610.03 P1ZY 1016.03 P1ZY 1616.03	P1ZY 0710.03 P1ZY 1303.03 P1ZY 2006.03	P1ZY 0810.03 P1ZY 1313.03	1

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

POLISHING GROUP P2

Matt finish even on small surfaces

The polishing points in this group are available in the seven grit sizes shown below, and in a variety of shapes and sizes. They are colour-coded to prevent any confusion and to avoid any errors in the polishing process. The soft rubber bonding allows for a very soft grinding effect. Polishing points in the P2 group are mainly used on a pre-machined surface where a fine to gloss polished finish is required. Polishing wheels in this group are also available with a max. diameter of 200 mm in the indicated grit sizes. Exact dimensions and prices are available on request.

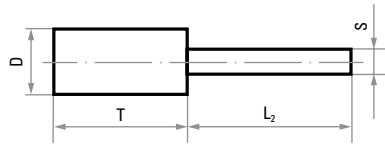


Product image				
Colour	black	pale grey	red	brown
Grit size	46	80	120	220

Product image			
Colour	green	white	orange
Grit size	280	400	600




## P2 polishing point (as per DIN 69170)


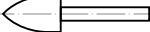
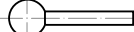


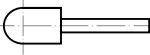
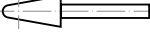


■ manufactured as per DIN 69170

★★☆

Product number	Description	Shape	Grit size	D mm	T mm	S mm	L <sub>2</sub> mm	Pack contains
A2610004083080	P2ZY 0408.03		80	4	8	3	30	20
A2610004083120	P2ZY 0408.03		120	4	8	3	30	20
A2610004083220	P2ZY 0408.03		220	4	8	3	30	20
A2610004083280	P2ZY 0408.03		280	4	8	3	30	20
A2610004083400	P2ZY 0408.03		400	4	8	3	30	20
A2610004083600	P2ZY 0408.03		600	4	8	3	30	20
A2610005103080	P2ZY 0510.03		80	5	10	3	30	20
A2610005103120	P2ZY 0510.03		120	5	10	3	30	20
A2610005103220	P2ZY 0510.03		220	5	10	3	30	20
A2610005103280	P2ZY 0510.03		280	5	10	3	30	20
A2610006103080	P2ZY 0610.03		80	6	10	3	30	20
A2610006103120	P2ZY 0610.03		120	6	10	3	30	20
A2610006103220	P2ZY 0610.03		220	6	10	3	30	20
A2610006103280	P2ZY 0610.03		280	6	10	3	30	20
A2610006103400	P2ZY 0610.03		400	6	10	3	30	20
A2610006103600	P2ZY 0610.03		600	6	10	3	30	20
A2610008103046	P2ZY 0810.03		46	8	10	3	30	20
A2610008103080	P2ZY 0810.03		80	8	10	3	30	20
A2610008103120	P2ZY 0810.03		120	8	10	3	30	20
A2610008103220	P2ZY 0810.03		220	8	10	3	30	20
A2610008103280	P2ZY 0810.03		280	8	10	3	30	20
A2610008103400	P2ZY 0810.03		400	8	10	3	30	20
A2610008103600	P2ZY 0810.03		600	8	10	3	30	20
A2610008166080	P2ZY 0816.06		80	8	16	6	30	10
A2610008166120	P2ZY 0816.06		120	8	16	6	30	10
A2610008166220	P2ZY 0816.06		220	8	16	6	30	10
A2610008166280	P2ZY 0816.06		280	8	16	6	30	10
A2610010103046	P2ZY 1010.03		46	10	10	3	30	20
A2610010103080	P2ZY 1010.03		80	10	10	3	30	20
A2610010103120	P2ZY 1010.03		120	10	10	3	30	20
A2610010103220	P2ZY 1010.03		220	10	10	3	30	20
A2610010103280	P2ZY 1010.03		280	10	10	3	30	20
A2610010206080	P2ZY 1020.06		80	10	20	6	40	10
A2610010206120	P2ZY 1020.06		120	10	20	6	40	10
A2610010206220	P2ZY 1020.06		220	10	20	6	40	10
A2610010206280	P2ZY 1020.06		280	10	20	6	40	10
A2610013133080	P2ZY 1313.03		80	13	13	3	40	20
A2610013133120	P2ZY 1313.03		120	13	13	3	40	20
A2610013133220	P2ZY 1313.03		220	13	13	3	40	20
A2610013133280	P2ZY 1313.03		280	13	13	3	40	20
A2610013163120	P2ZY 1316.03		120	13	16	3	40	20

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● PlasticGRINDING AND POLISHING  
(with bonded tools)

Product number	Description	Shape	Grit size	D mm	T mm	S mm	L <sub>2</sub> mm	Pack contains
A2610013206080	P2ZY 1320.06		80	13	20	6	40	10
A2610013206120	P2ZY 1320.06		120	13	20	6	40	10
A2610013206220	P2ZY 1320.06		220	13	20	6	40	10
A2610013206280	P2ZY 1320.06		280	13	20	6	40	10
A2610016163120	P2ZY 1616.03		120	16	16	3	40	20
A2610016206080	P2ZY 1620.06		80	16	20	6	40	10
A2610016206120	P2ZY 1620.06		120	16	20	6	40	10
A2610016206220	P2ZY 1620.06		220	16	20	6	40	10
A2610016206280	P2ZY 1620.06		280	16	20	6	40	10
<b>NEW</b> A2610016206400	P2ZY 1620.06		400	16	20	6	40	10
<b>NEW</b> A2610016206600	P2ZY 1620.06		600	16	20	6	40	10
A2610016326080	P2ZY 1632.06		80	16	32	6	40	10
A2610016326120	P2ZY 1632.06		120	16	32	6	40	10
A2610016326220	P2ZY 1632.06		220	16	32	6	40	10
A2610020206046	P2ZY 2020.06		46	20	20	6	40	10
A2610020206080	P2ZY 2020.06		80	20	20	6	40	10
A2610020206120	P2ZY 2020.06		120	20	20	6	40	10
A2610020206220	P2ZY 2020.06		220	20	20	6	40	10
A2610020206280	P2ZY 2020.06		280	20	20	6	40	10
A2610020326120	P2ZY 2032.06		120	20	32	6	40	10
A2610020326220	P2ZY 2032.06		220	20	32	6	40	10
A2610020326280	P2ZY 2032.06		280	20	32	6	40	10
A2610032206120	P2ZY 3220.06		120	32	20	6	40	10
A2610032326120	P2ZY 3232.06		120	32	32	6	40	10
A2610032326280	P2ZY 3232.06		280	32	32	6	40	10
A2610040206120	P2ZY 4020.06		120	40	20	6	40	10
A2611013206120	P2SP 1320.06		120	13	20	6	40	10
A2611020326220	P2SP 2032.06		220	20	32	6	40	10
A2615008083120	P2KU 0808.03		120	8	8	3	30	20
<b>NEW</b> A2615008083400	P2KU 0808.03		400	8	8	3	30	20
<b>NEW</b> A2615008083600	P2KU 0808.03		600	8	8	3	30	20
A2615010103120	P2KU 1010.03		120	10	10	3	30	20
A2615016166120	P2KU 1616.06		120	16	16	6	40	10
A2615016166220	P2KU 1616.06		220	16	16	6	40	10
A2617025106120	P2ZY 2510.06		120	25	10	6	40	10
A2617032106120	P2ZY 3210.06		120	32	10	6	40	10
A2617032106220	P2ZY 3210.06		220	32	10	6	40	10
A2617040106120	P2ZY 4010.06		120	40	10	6	40	10
A2618016326120	P2WR 1632.06		120	16	32	6	40	10
A2619010206080	P2KE 1020.06		80	10	20	6	40	10
A2619010206120	P2KE 1020.06		120	10	20	6	40	10

Recommended for:  Inox/Steel  Steel  Aluminium  Cast material  Titanium  Plastic

## POLISHING GROUP P3

## Excellent results all the way to a mirror finish



LUKAS felt polishing points are available in two qualities:

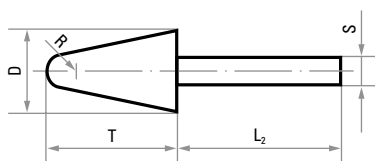
- H3 as per DIN 61200
- H3-S super hard and particularly effective when used in combination with diamond paste

**The ideal peripheral speed for LUKAS felt polishing points is 2 to 8 m/s.**

The LUKAS range of felt polishing tools reflects our many years of experience in this field and covers all the most common shapes and sizes. Thanks to their extreme flexibility, felt polishing points used together with LUKAS diamond paste are ideally suited for polishing highly complex shapes like pressure and injection moulds, drawing, press and cutting tools, dies, bearings, spindles, rolls, gauges, etc.



## P3 polishing point



★★☆

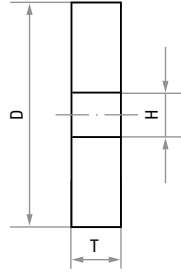
- perfect for polishing highly complex shapes
- manufactured as per DIN 69170

Product number	Description	Shape	Quality	D mm	T mm	S mm	L <sub>2</sub> mm	R mm	Pack contains
A3700006103	P3ZY 0610.03		H3	6	10	3	40	–	20
A3700008103	P3ZY 0810.03		H3	8	10	3	40	–	20
A3700010123	P3ZY 1012.03		H3	10	12	3	38	–	20
A3700010156	P3ZY 1015.06		H3	10	15	6	40	–	10
A3700012153	P3ZY 1215.03		H3	12	15	3	40	–	20
A3700012206	P3ZY 1220.06		H3	12	20	6	40	–	10
A3700016206	P3ZY 1620.06		H3	16	20	6	40	–	10
A3700020256	P3ZY 2025.06		H3	20	25	6	40	–	10
A3700025306	P3ZY 2530.06		H3	25	30	6	40	–	10
A3700030406	P3ZY 3040.06		H3	30	40	6	40	–	10
A3701006103	P3SP 0610.03		H3	6	10	3	40	–	20
A3701008103	P3SP 0810.03		H3	8	10	3	40	–	20
A3701010123	P3SP 1012.03		H3	10	12	3	40	–	20
A3701010156	P3SP 1015.06		H3	10	15	6	40	–	10
A3701012206	P3SP 1220.06		H3	12	20	6	40	–	10
A3701020256	P3SP 2025.06		H3	20	25	6	40	–	10
A3701025306	P3SP 2530.06		H3	25	30	6	40	–	10
A3701030406	P3SP 3040.06		H3	30	40	6	40	–	10
A3703006063	P3KU 0605.03		H3	6	5.5	3	39.5	–	20
A3703008083	P3KU 0807.03		H3	8	7.5	3	42.5	–	20
A3703010103	P3KU 1009.03		H3	10	9	3	41	–	20
A3703010106	P3KU 1009.06		H3	10	9	6	41	–	10
A3703012126	P3KU 1211.06		H3	12	11	6	39	–	10
A3703020206	P3KU 2019.06		H3	20	19	6	41	–	10
A3705010123	P3KE 1012.03		H3	10	12	3	38	2.5	20
A3705010156	P3KE 1015.06		H3	10	15	6	40	2.5	10
A3705020256	P3KE 2025.06		H3	20	25	6	40	3.5	10
A3705025306	P3KE 2530.06		H3	25	30	6	40	4.5	10
A3705030406	P3KE 3040.06		H3	30	40	6	40	6.5	10
A37000061030001	P3ZY 0610.03		H3-S	6	10	3	40	–	20
A37000081030001	P3ZY 0810.03		H3-S	8	10	3	40	–	20
A37000101230001	P3ZY 1012.03		H3-S	10	12	3	38	–	20
A37000101560001	P3ZY 1015.06		H3-S	10	15	6	40	–	10
A37000121530001	P3ZY 1215.03		H3-S	12	15	3	40	–	20
A37000122060001	P3ZY 1220.06		H3-S	12	20	6	40	–	10
A37000202560001	P3ZY 2025.06		H3-S	20	25	6	40	–	10

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



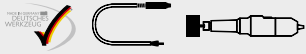
## Felt polishing wheel, shape S1



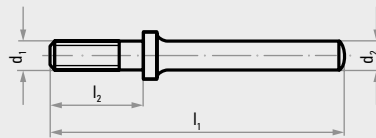
★★☆

Product number	Description	Quality	D mm	T mm	H mm	Pack contains
A3750040106	P3S1 4010.06	H3	40	10	6	10
A3750050106	P3S1 5010.06	H3	50	10	6	10
A3750050206	P3S1 5020.06	H3	50	20	6	10
A3750060106	P3S1 6010.06	H3	60	10	6	10
A3750060206	P3S1 6020.06	H3	60	20	6	10

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

 GRINDING AND POLISHING  
(with bonded tools)


## Arbors for felt polishing wheels



Delivery includes the following for each arbor:

- two washers, Ø 18 mm
  - two washers, Ø 30 mm
- and one hex nut.

★★☆

Product number	Description	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>1</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A1630780	ASB 780	M6	20	6	63	7,000	5
A1630781	ASB 781	M6	30	6	73	7,000	5

## Grinding pastes



- new and improved formula
- silicon carbide paste, oil-soluble, can be used with thinners, cleaned with oil, spirit or petrol
- for polishing pre-ground surfaces, particularly suited for hard metallic surfaces such as steel, iron, cast iron, bronze, brass and copper

★★★

Product number	Description	Quality	Grit size	Grain size in µm	Content ml	Pack contains
A3760120	SP-1	medium	SIC 120	88–125	250	1
A3760180	SP-2	fine	SIC 180	55–88	250	1
A3760320	SP-3	very fine	SIC 320	20–40	250	1

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

## FINE POLISH FOR HARD METALS

COUNTLESS CUTTING EDGES FOR A GREAT GLOSS FAST

### MORE CUTTING EDGES IN DIAMOND PASTES

The diamonds in the polycrystalline diamond pastes deliver a fast high-gloss polish. The reason for this lies in the manufacturing process of the polycrystalline diamonds, which creates a large number of predetermined breaking points. Under load the diamonds break at these points. This then constantly results in new cutting edges in the polycrystalline diamond paste during use for outstanding surface results with less paste consumption.

### FOR MACHINES AND ROBOTS

Polycrystalline pastes are used for steels and titanium with a hardness greater than 60 HRC. The high yield and the extremely high process reliability make the polycrystalline diamond pastes from LUKAS perfect for use on NC machines and robots. Thanks to their high temperature resistance of 130 °C and solubility in water, oil and alcohol, the polycrystalline paste can be used in a variety of ways in industrial processes. Polycrystalline diamond paste is also suitable for manual application.

## NEW Polycrystalline diamond pastes



★★★★

- for steel and titanium
- resists temperatures of up to 130 °C

Product number	Description	Quality	Grain size in µm	Colour	Content in g	Pack contains
A3410129110	EP-091	Super-EP	1	blue	10	1
A3410129210	EP-092	Super-EP	3	green	10	1
A3410129310	EP-093	Super-EP	6	yellow	10	1
A3410129410	EP-094	Super-EP	9	red	10	1
A3410129510	EP-095	Super-EP	15	light brown	10	1

Recommended for: ● Steel ● Cast material ● Titanium

# SUPER-E DIAMOND PASTE

GET THE GLOSS YOU WANT WITH JUST A TINY AMOUNT

Thanks to the high concentration of diamond grains, you can polish even the hardest materials quickly and efficiently. The optimal shape of the monocrystalline diamonds and the very narrow grain size distribution guarantee perfect polishing results. Because of

its agglomerate-free production and high viscosity – which can be gradually diluted with water, oil or alcohol – our diamond paste is also ideal for use in machines. The paste was specially developed for mould making.

## FEATURES

- high grain concentration
- perfect grain size
- free from agglomerates
- narrow grain size distribution
- monocrystalline
- high viscosity

## BENEFITS/USES

- polishes the hardest materials quickly and efficiently
- optimised for machine application
- highly effective
- ideal for mould making
- dilute with water, oil or alcohol



GRINDING AND POLISHING  
(with bonded tools)



## Monocrystalline diamond pastes



- highly versatile for both manual and machine polishing
- resists temperatures of up to 130 °C

★★☆

Product number	Description	Quality	Grain size in µm	Colour	Content g	Pack contains
A3410119105	E-091	Super-E	1	blue	5	1
A3410119110	E-091	Super-E	1	blue	10	1
A3410119205	E-092	Super-E	3	green	5	1
A3410119210	E-092	Super-E	3	green	10	1
A3410119305	E-093	Super-E	6	yellow	5	1
A3410119310	E-093	Super-E	6	yellow	10	1
A3410119405	E-094	Super-E	9	red	5	1
A3410119410	E-094	Super-E	9	red	10	1
A3410119505	E-095	Super-E	15	light brown	5	1
A3410119510	E-095	Super-E	15	light brown	10	1

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

## POLISHING GROUP P4

# LUKAS exclusive: flexible polishing sticks

The tools in this group are bonded with polyurethane (PU) and are manufactured in various hardnesses. They contain a mixture of abrasive grains (aluminium

oxide, silicon carbide) and fillers. The tools are colour-coded to visually differentiate between the different qualities. Products in this group have a relatively dense

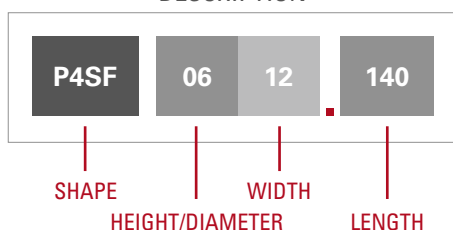
structure. They are available in several qualities from soft to hard and with various profiles. These polishing sticks are mainly used manually for mould-making.

## GET YOUR CUSTOM-MADE POLISHING STICK IN JUST TWO STEPS

## STEP 1

Select the required shape and size (see product tables)

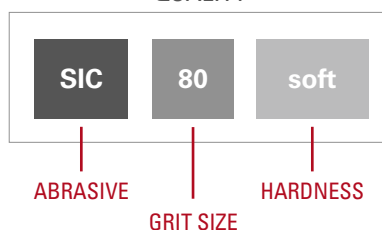
## DESCRIPTION



## STEP 2

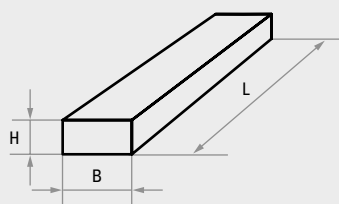
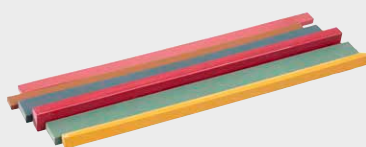
Choose the required quality

## QUALITY



Colour	Quality
pale grey	SIC 80 soft
grey	SIC 80 hard
pale blue	SIC 150 soft
blue	SIC 150 hard
pale green	SIC 240 soft
green	SIC 240 hard
beige	EKW 80 soft
dark beige	EKW 80 hard
pale red	EKW 150 soft
red	EKW 150 hard
light brown	EKW 240 soft
brown	EKW 240 hard

## Polishing sticks, flat



★★☆

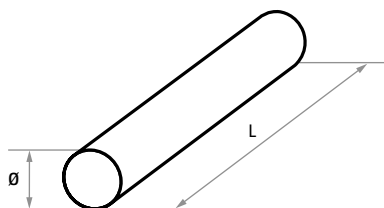
- perfect for manual polishing
- further sizes available on request

Description	H mm	B mm	L mm	Pack contains
P4SF 0612.070	6	12	70	10
P4SF 0612.140	6	12	140	10
P4SF 0816.070	8	16	70	10
P4SF 0816.140	8	16	140	10
P4SF 0816.210	8	16	210	10
P4SF 1020.070	10	20	70	10
P4SF 1020.140	10	20	140	10
P4SF 1020.210	10	20	210	10
P4SF 1020.280	10	20	280	10

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



## Polishing sticks, round



- perfect for manual polishing
- further sizes available on request

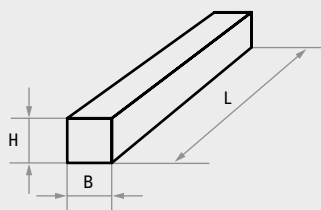
★★☆

Description	Diameter mm	L mm	Pack contains
P4SR 0006.070	6	70	10
P4SR 0006.140	6	140	10
P4SR 0010.070	10	70	10
P4SR 0010.140	10	140	10
P4SR 0010.210	10	210	10
P4SR 0012.070	12	70	10
P4SR 0012.140	12	140	10
P4SR 0012.210	12	210	10
P4SR 0012.280	12	280	10
P4SR 0015.070	15	70	10
P4SR 0015.140	15	140	10
P4SR 0015.210	15	210	10
P4SR 0015.280	15	280	10

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

 GRINDING AND POLISHING  
(with bonded tools)


## Polishing sticks, square



- perfect for manual polishing
- further sizes available on request

★★☆

Description	H mm	B mm	L mm	Pack contains
P4SV 0606.070	6	6	70	10
P4SV 0606.140	6	6	140	10
P4SV 1010.070	10	10	70	10
P4SV 1010.140	10	10	140	10
P4SV 1010.210	10	10	210	10
P4SV 1212.140	12	12	140	10
P4SV 1212.210	12	12	210	10
P4SV 1515.070	15	15	70	10
P4SV 1515.140	15	15	140	10
P4SV 1515.210	15	15	210	10
P4SV 1515.280	15	15	280	10

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



POLISHING GROUP P5

Fibre reinforced for wear resistance

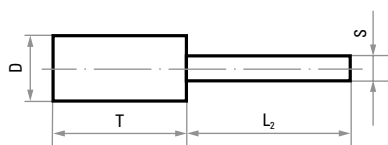
The polishing points in this group are characterised by their special fibre-reinforced structure and bonding. This makes them ideally suited for the fine finishing of aluminium and associated alloys, non-ferrous metals and low and high-alloyed steels. The fibre reinforcement gives these tools exceptional edge-fray resistance and stability. Polishing points in group P5 are available in the grit sizes shown below, and are identified with a red marking on the shank.

GRINDING AND POLISHING  
(with bonded tools)

Product image			
Colour	black	pale grey	red
Grit size	46	80	120



## P5 polishing points



- ideally suited for the fine finishing of non-ferrous metals and low- and high-alloyed steels

★★☆

Product number	Description	Shape	Grit size	D mm	T mm	S mm	L <sub>2</sub> mm	Pack contains
A2620004083080	P5ZY 0408.03		80	4	8	3	30	20
A2620004083120	P5ZY 0408.03		120	4	8	3	30	20
A2620005103080	P5ZY 0510.03		80	5	10	3	30	20
A2620005103120	P5ZY 0510.03		120	5	10	3	30	20
A2620006103080	P5ZY 0610.03		80	6	10	3	30	20
A2620006103120	P5ZY 0610.03		120	6	10	3	30	20
A2620008103080	P5ZY 0810.03		80	8	10	3	30	20
A2620008103120	P5ZY 0810.03		120	8	10	3	30	20
A2620008166046	P5ZY 0816.06		46	8	16	6	30	10
A2620008166080	P5ZY 0816.06		80	8	16	6	30	10
A2620008166120	P5ZY 0816.06		120	8	16	6	40	10
A2620010103080	P5ZY 1010.03		80	10	10	3	30	20
A2620010103120	P5ZY 1010.03		120	10	10	3	30	20
A2620010206046	P5ZY 1020.06		46	10	20	6	40	10
A2620010206080	P5ZY 1020.06		80	10	20	6	40	10
A2620010206120	P5ZY 1020.06		120	10	20	6	40	10
A2620013133120	P5ZY 1313.03		120	13	13	3	30	20
A2620013163080	P5ZY 1316.03		80	13	16	3	30	20
A2620013206080	P5ZY 1320.06		80	13	20	6	40	10
A2620013206120	P5ZY 1320.06		120	13	20	6	40	10
A2620016206080	P5ZY 1620.06		80	16	20	6	40	10
A2620016206120	P5ZY 1620.06		120	16	20	6	40	10
A2620016326046	P5ZY 1632.06		46	16	32	6	40	10
A2620016326080	P5ZY 1632.06		80	16	32	6	40	10
A2620032326080	P5ZY 3232.06		80	32	32	6	40	10
A2621020326080	P5SP 2032.06		80	20	32	6	40	10
A2625008083080	P5KU 0808.03		80	8	8	3	30	20

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

## POLISHING GROUP P6

## Polishing with polyurethane bonding

Products in group P6 are manufactured with a polyurethane bond (PU) in different hardnesses.

These tools:

- can be easily profiled
- quickly generate an excellent surface finish
- do not tend to clog
- require no dressing
- contain no softeners
- do not increase in hardness after long storage
- are ideal for both stationary and manual application

These polishing tools are used to improve the surface finish and dimensional accuracy of polishing and finishing steel, brass, precious metals, sintered metals and plastic, as well as for very fine and effect grinding. The spectrum ranges from polishing and marbling points to rolls for satin finishes and polishing wheels measuring 60 to 300 mm in diameter. They can be used for dry and wet grinding. Only use ph-neutral coolant for wet grinding. Use handstones (**page 94**) or diamond dressing tools for dressing.

Due to their long tool life and a good edge-fray resistance, the tools are ideally suited for automated processes such as cylindrical polishing of tubes or marbling of high-alloyed steel plates.

## RECOMMENDED FOR

# The right polishing tool for every job

Find the perfect tool for your application! Simply find your process and the corresponding material in the table to discover the perfect grit size for your LUKAS P6 polishing tool.

	Removing rust, cleaning, tarnish removal			Cylindrical and surface grinding			Sharpening, dressing		Marbling, dash-dot matting		Deburring, fettling, rounding off				Fine grinding				Pre-finishing				Polishing	
	MWP	MP	SHP CG	SHP	SHP CG	SHP+	SHP	SHP+	WP	MWP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP	MP	HP	WP	MWP
Gold, silver, nickel, aluminium, brass														410									400	400
																			240	240			800	
																	150		150				1,200	
																120	120							
													80	80	80		80							
Structural steel		150	120		120	36																		
	46		60		60	30																		
Stainless steel, titanium							400																400	400
							240													240	240		800	240
		150												150			150		150	150			1,200	
			120		120		120									120	120		120					
					60		80			80	80	80		80	80	80	80	80						
			60					36		46		46			46	46	46	46						
								30	24					24										
Hardened steel, tungsten carbide				240																		240	400	
				150														150					800	
				120	120													120					1,200	
				80	60	36		36			80													
						30		30			46													
Glass																			400					
																		100		240				
																		80		150				
											80							46						
Rubber			60															80						
Wood																	80							
Paint	46	150																						
Solder	240				120																			
Tin						36																		
						30											80							
Grit sizes																								

GRINDING AND POLISHING  
(with bonded tools)

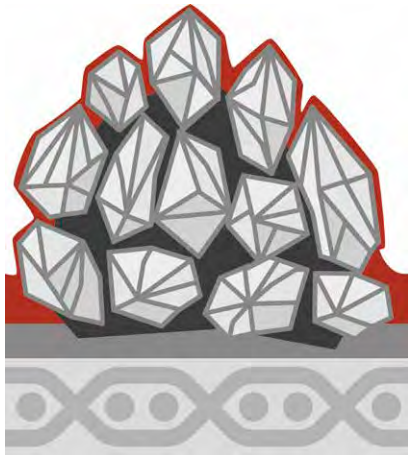
The following grades are available:

- WP** = soft, very flexible
- MWP** = medium to soft
- MP** = medium for general application
- HP** = hard and resilient, mainly for flat surfaces
- SHP** = super hard, for stationary applications
- SHP CG** = super hard, with compact grain
- SHP+** = super hard, for manual applications

The bonding is mixed with silicon carbide "SIC", aluminium oxide white "EKW" or aluminium oxide "A" as abrasive in the FEPA grit sizes 24 to 1,200.

## COMPACT GRAIN

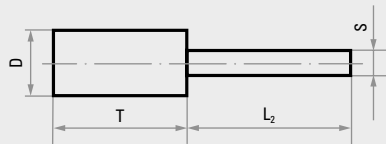
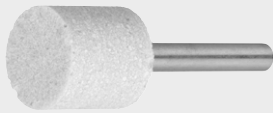
## Many cutting edges combined in one grain



The compact grain (CG) consists of many abrasive grains and reactive filler, which are bonded to each other before adding them to the tool. During grinding, individual worn particles break out of the compact grain, exposing the underlying abrasive particles with new, sharp cutting edges. As a result, tools with compact grain do not clog even with softer or smearing materials.

Due to the double adhesive bonding in the compact grain and abrasive layer, the grinding particles adhere better than with just a single adhesive bonding. This means a longer useful life without premature tool changes. The high density of the cutting edges within the compact grain guarantees the very high stock removal rate, while the filler ensures a cool cut.

## P6 CG polishing points



- cylindrical polishing point
- creates perfect surfaces on all metals
- long service life and excellent grain usage
- This polishing point is ideally suited to processing difficult-to-access areas on metal parts.
- the perfect addition to the polishing wheel

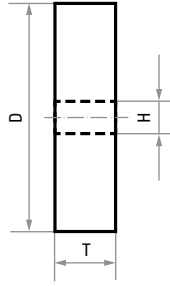
★★★

Product number	Description	Quality/grit size	Type/surface result	D mm	T mm	H mm	$n_{max}$ rpm	Pack contains
A29300130203B39	P6ZY 1320.03	EKW 60 SHP CG	extra coarse	13	20	3	117,500	10
A29300130203B59	P6ZY 1320.03	EKW 120 SHP CG	coarse	13	20	3	117,500	10
A29300160206B39	P6ZY 1620.06	EKW 60 SHP CG	extra coarse	16	20	6	95,400	10
A69300160206B59	P6ZY 1620.06	EKW 120 SHP CG	coarse	16	20	6	95,400	10
A69300200206B39	P6ZY 2020.06	EKW 60 SHP CG	extra coarse	20	20	6	76,300	10
A29300200206B59	P6ZY 2020.06	EKW 120 SHP CG	coarse	20	20	6	76,300	10
A29300300306B39	P6ZY 3030.06	EKW 60 SHP CG	extra coarse	30	30	6	50,900	10
A69300300306B59	P6ZY 3030.06	EKW 120 SHP CG	coarse	30	30	6	50,900	10

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



## Polishing wheel, shape SE1 CG



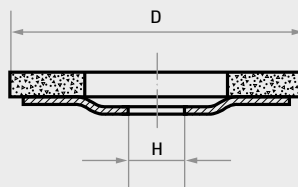
★★★

Product number	Description	Quality/grit size	Type/surface result	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
A29100800060B39	P6SE1 08006 B.06	EKW 60 SHP CG	extra coarse	80	6	6	19,000	20
A29100800060B59	P6SE1 08006 B.06	EKW 120 SHP CG	coarse	80	6	6	19,000	20
A29101500100B39	P6SE1 15010 B.25	EKW 60 SHP CG	extra coarse	150	10	25	10,100	10
A29101500100B59	P6SE1 15010 B.25	EKW 120 SHP CG	coarse	150	10	25	10,100	10
A29102000200B39	P6SE1 20020 B.25	EKW 60 SHP CG	extra coarse	200	20	25	7,600	10
A29102000200B59	P6SE1 20020 B.25	EKW 120 SHP CG	coarse	200	20	25	7,600	10

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

GRINDING AND POLISHING  
(with bonded tools)

## P6PT polishing disc, CG quality



★★★

- very hard PU bonding
- can be used on a variety of materials
- contains compact grain (CG)
- suitable for removing irregularities and defects before polishing
- produces good surfaces
- incredible tool life

Product number	Description	Quality/grit size	Type/surface result	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A671611506014	P6PT 115 (flat)	EKW 60 SHP CG	extra coarse	115	22.23	13,300	5
A671611512014	P6PT 115 (flat)	EKW 120 SHP CG	coarse	115	22.23	13,300	5
A671612506014	P6PT 125 (flat)	EKW 60 SHP CG	extra coarse	125	22.23	12,200	5
A671612512014	P6PT 125 (flat)	EKW 120 SHP CG	coarse	125	22.23	12,200	5

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

The new tools in the P6 Compact Grain series let you remove scratches and irregularities on workpieces, whilst also creating a good surface. This helps you save time and removes the need for annoying tool changes. Their incredible tool life is down to the very hard PU bonding and the compact grain technology. P6 CG tools are perfect for grinding before polishing with other P6 tools with hardness ranging from WP to HP.

Ideal for:

- cleaning surfaces
- removing scratches
- removing paint and undercoats
- preparing surfaces for polishing





## FROM COARSE TO FINE – THE PERFECT POLISHING SET

TEST THE LUKAS POLISHING DISCS NOW!

The P6PT polishing disc makes improving the surface quality and dimensional accuracy of your workpiece easy. This disc with silicon carbide grinds cool and generates few sparks, making it suitable for use in aerospace engineering. Even hard materials like stone, glass and high-alloyed materials can be processed efficiently. The hard and sharp abrasive grain ensures a long tool life. Whether it's cleaning, grinding or polishing – this LUKAS polishing disc takes care of any job with flying colours. It is perfectly suited for working with a standard controlled angle grinder.

The polishing disc can be used for both wet and dry grinding and requires no additional grinding paste.

Its light, stable and flexible design lets you achieve outstanding surface results. The glass fibre carrier plays no role here. The disc is highly resistant to breakage and generates little vibration when working. Combined with its easy handling, it is ideal for manual use. The P6 group of polishing discs are perfect for quickly processing large metal surfaces.

### THE LUKAS POLISHING DISC SET

Get the polishing result you want quickly with the polishing disc set from LUKAS. Simply use the various polishing discs in the set one after another. Go from rusty to a mirror finish quickly and easily with just a few tool changes and one machine.





## P6PT polishing disc set



- from rusty to a mirror finish with the LUKAS polishing disc set
- use these tools one after another to achieve the finish you want

★★☆

Product number	Description	Shape	Quality	D mm	H mm	n <sub>max</sub> rpm	n <sub>recom</sub> rpm	Contents 1 per pack	Pack contains
A6700023	P6PT 125 (flat) SET		P6PT	125	22.23	4,800	2,700	P150, 240, 400, 800	1
A6700024	P6PT 125 (dished) SET		P6PT	125	22.23	4,800	2,700	P150, 240, 400, 800	1

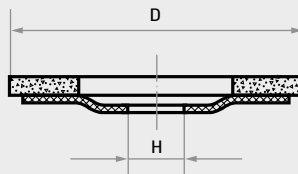
Recommended for: ● Inox/Steel ● Cast material ● Titanium ● Steel ● Aluminium

GRINDING AND POLISHING (with bonded tools)



## P6PT polishing discs

- polishing a wide range of surfaces
- cleaning and derusting
- removing paint and coatings
- replaces cloth discs, felt discs and polishing pastes
- for standard controlled angle grinders
- clean working conditions, as no grinding paste is required
- quicker work progress

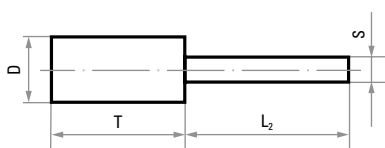
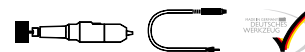


★★☆

Product number	Description	Shape overview	Quality	Type/ surface result	D mm	H mm	n <sub>max</sub> rpm	n <sub>recom</sub> rpm	Pack contains
A671612515014	P6PT 125 (flat)		SIC 150 MP	medium	125	22.23	4,800	2,700	5
A671612515014001	P6PT 125 (flat)		SIC 150 MWP	medium	125	22.23	4,800	2,700	5
A671612524014	P6PT 125 (flat)		SIC 240 MWP	fine	125	22.23	4,800	2,700	5
A671612540014	P6PT 125 (flat)		SIC 400 WP	very fine	125	22.23	4,800	2,700	5
A671612580014	P6PT 125 (flat)		SIC 800 WP	ultra-fine	125	22.23	4,800	2,700	5
A671712515014	P6PT 125 (dished)		SIC 150 MP	medium	125	22.23	4,800	2,700	5
A671712524014	P6PT 125 (dished)		SIC 240 MWP	fine	125	22.23	4,800	2,700	5
A671712540014	P6PT 125 (dished)		SIC 400 WP	very fine	125	22.23	4,800	2,700	5
A671712580014	P6PT 125 (dished)		SIC 800 WP	ultra-fine	125	22.23	4,800	2,700	5
A6717125120014	P6PT 125 (dished)		SIC 1200 WP	ultra-fine	125	22.23	4,800	2,700	5

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

## P6 polishing point



- cylindrical polishing point
- This polishing point is ideally suited to processing difficult-to-access areas on metal parts.
- perfect addition to the polishing wheel

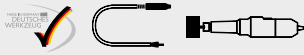
### ■ Application:

Bores, fillet welds, mould tools

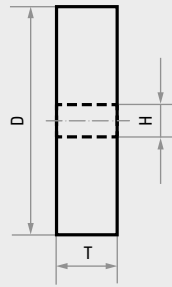
★★☆

Product number	Description	Quality/grit size	D mm	T mm	S mm	L <sub>2</sub> mm	n <sub>max</sub> rpm	Pack contains
A29300080103048	P6ZY 0810.03	SIC 80 HP	8	10	3	30	76,300	10
A29300080103068	P6ZY 0810.03	SIC 150 HP	8	10	3	30	76,300	10
A29300080103078	P6ZY 0810.03	SIC 240 HP	8	10	3	30	76,300	10
A29300080163048	P6ZY 0816.03	SIC 80 HP	8	16	3	30	76,300	10
A29300080163068	P6ZY 0816.03	SIC 150 HP	8	16	3	30	76,300	10
A29300080163078	P6ZY 0816.03	SIC 240 HP	8	16	3	30	76,300	10
A29300100103048	P6ZY 1010.03	SIC 80 HP	10	10	3	30	61,100	10
A29300100103068	P6ZY 1010.03	SIC 150 HP	10	10	3	30	61,100	10
A29300100103078	P6ZY 1010.03	SIC 240 HP	10	10	3	30	61,100	10
A29300100203048	P6ZY 1020.03	SIC 80 HP	10	20	3	30	61,100	10
A29300100203068	P6ZY 1020.03	SIC 150 HP	10	20	3	30	61,100	10
A29300100203078	P6ZY 1020.03	SIC 240 HP	10	20	3	30	61,100	10
A29300130203048	P6ZY 1320.03	SIC 80 HP	13	20	3	30	47,000	10
A29300160203028	P6ZY 1620.03	SIC 46 HP	16	20	3	30	38,100	10
A29300160203048	P6ZY 1620.03	SIC 80 HP	16	20	3	30	38,100	10
A29300160203068	P6ZY 1620.03	SIC 150 HP	16	20	3	30	38,100	10
A29300160203078	P6ZY 1620.03	SIC 240 HP	16	20	3	40	38,100	10
A69300160203094	P6ZY 1620.03	SIC 400 MP	16	20	3	40	29,800	10
A693001602030H0	P6ZY 1620.03	SIC 800 WP	16	20	3	40	19,000	10
A29300200206028	P6ZY 2020.06	SIC 46 HP	20	20	6	40	30,500	10
A29300200206068	P6ZY 2020.06	SIC 150 HP	20	20	6	40	30,500	10
A69300200306044	P6ZY 2030.06	SIC 80 MP	20	30	6	40	23,800	10
A29300250206048	P6ZY 2520.06	SIC 80 HP	25	20	6	40	24,400	10
A29300300306028	P6ZY 3030.06	SIC 46 HP	30	30	6	40	20,300	10
A29300300306068	P6ZY 3030.06	SIC 150 HP	30	30	6	40	20,300	10
A29300300306078	P6ZY 3030.06	SIC 240 HP	30	30	6	40	20,300	10
A69300400306078	P6ZY 4030.06	SIC 240 HP	40	30	6	40	15,200	10
A29300400406028	P6ZY 4040.06	SIC 46 HP	40	40	6	40	15,200	10
A69300400406048	P6ZY 4040.06	SIC 80 HP	40	40	6	40	15,200	10
A69300400406064	P6ZY 4040.06	SIC 150 MP	40	40	6	40	11,900	10
A29300400406068	P6ZY 4040.06	SIC 150 HP	40	40	6	40	15,200	10
A69300400406091	P6ZY 4040.06	SIC 400 MWP	40	40	6	40	9,500	10
A29300500406028	P6ZY 5040.06	SIC 46 HP	50	40	6	40	12,200	10
A29300500406068	P6ZY 5040.06	SIC 150 HP	50	40	6	40	12,200	10
A29300600406028	P6ZY 6040.06	SIC 46 HP	60	40	6	40	10,100	10
A29300600406068	P6ZY 6040.06	SIC 150 HP	60	40	6	40	10,100	10

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



## Polishing wheel, shape SE1



★★☆

These polishing wheels are available from stock with a soft to very hard bonding in grit sizes 46 to 400. Further qualities in grit sizes 8 to 1,200 are available as special tools.

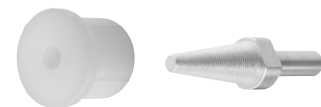
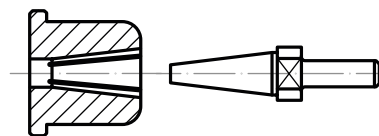
Product number	Description	Quality/grit size	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
A29100600060041	P6SE1 06006 B.06	SIC 80 MWP	60	6	6	6,300	1
A29100600060061	P6SE1 06006 B.06	SIC 150 MWP	60	6	6	6,300	1
A29101000100041	P6SE1 10010 B.25	SIC 80 MWP	100	10	25	3,800	1
A29101000200021	P6SE1 10020 B.25	SIC 46 MWP	100	20	25	3,800	1
A29101000200041	P6SE1 10020 B.25	SIC 80 MWP	100	20	25	3,800	1
A29101000200061	P6SE1 10020 B.25	SIC 150 MWP	100	20	25	3,800	1
A29101000200091	P6SE1 10020 B.25	SIC 400 MWP	100	20	25	3,800	1
A29101250100041	P6SE1 12510 B.25	SIC 80 MWP	125	10	25	3,000	1
A29101250100061	P6SE1 12510 B.25	SIC 150 MWP	125	10	25	3,000	1
A29101250200041	P6SE1 12520 B.25	SIC 80 MWP	125	20	25	3,000	1
A29101250200061	P6SE1 12520 B.25	SIC 150 MWP	125	20	25	3,000	1
A29101500100061	P6SE1 15010 B.25	SIC 150 MWP	150	10	25	2,500	1
A29101500100069	P6SE1 15010 B.25	SIC 150 SHP	150	10	25	4,000	1
A29101500150059	P6SE1 15015 B.20	SIC 120 SHP	150	15	20	4,000	1
A29101500200040	P6SE1 15020 B.25	SIC 80 WP	150	20	25	2,000	1
A29101500200041	P6SE1 15020 B.25	SIC 80 MWP	150	20	25	2,500	1
A29101500200061	P6SE1 15020 B.25	SIC 150 MWP	150	20	25	2,500	1
A29101500250021	P6SE1 15025 B.20	SIC 46 MWP	150	25	20	2,500	1
A29101500250040	P6SE1 15025 B.25	SIC 80 WP	150	25	25	2,000	1
A29101500250061	P6SE1 15025 B.25	SIC 150 MWP	150	25	25	2,500	1
A29101500250074	P6SE1 15025 B.20	SC 240 MP	150	25	20	3,100	1
A29102000250041	P6SE1 20025 B.25	SIC 80 MWP	200	25	25	1,900	1
A29102000250061	P6SE1 20025 B.25	SIC 150 MWP	200	25	25	1,900	1

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

 GRINDING AND POLISHING  
(with bonded tools)


## Mounting system for polishing wheels

The mounting system for SE1 polishing wheels is suitable for the sizes 10010 B.25 and 10020 B.25 only. Do not use this system to mount larger polishing wheels. The maximum cutting speed for this mounting system is 10 m/s. This corresponds to a maximum speed of 1,900 rpm for a wheel diameter of 100 mm.



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Product number	Description	Content	Pack contains
A6981008000	Mounting system MCA + K25	Plastic sleeve (MCA) and mounting mandrel with 8 mm shank (K25)	1



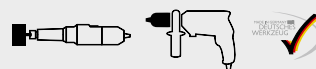
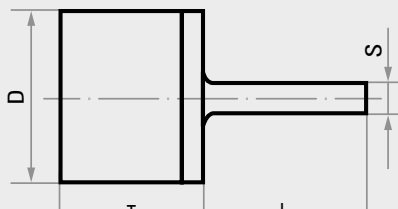
# MARBLING MADE EASY

CONSISTENTLY HIGH PERFORMANCE FROM START TO FINISH

## Marbling point



★★☆



- cylindrical marbling point
- LUKAS marbling points let you marble non-rusting steels, aluminium and non-ferrous metal (peacock eye, clouds). The marbling points do not clog with abrasive dust and their abrasive capability is retained all the way to the plastic cap.

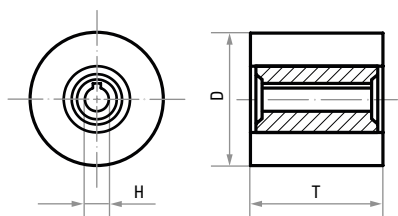
Product number	Description	Quality/grit size	D mm	T mm	S mm	L <sub>2</sub> mm	n <sub>max</sub> rpm	Pack contains
A29200200306021	P6MA ZY 2030.06	SIC 46 MWP	20	30	6	35	9,500	1
A29200300306021	P6MA ZY 3030.06	SIC 46 MWP	30	30	6	35	6,300	1
A29200400306046	P6MA ZY 4030.06	SIC 46 MWP	40	30	6	35	4,700	1
A29200500306046	P6MA ZY 5030.06	SIC 46 MWP	50	30	6	35	3,800	1
A29200500306034	P6MA ZY 5030.06	SIC 60 MP	50	30	6	35	3,800	1
A29200600306046	P6MA ZY 6030.06	SIC 46 MWP	60	30	6	35	3,100	1

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

## P6PW polishing roll



★★☆



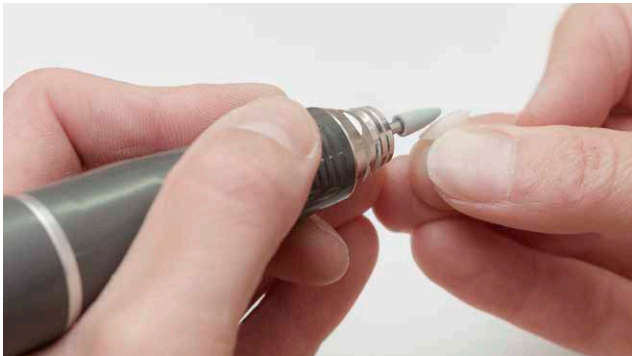
- P6PW polishing roll for the conditioning machine.
- for perfectly brushed or dash-dot matted surfaces
- ▶ You can find the right power tool (conditioning machine) on **page 312**.

Product number	Description	Quality/grit size	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
A29401000500041	P6PW 100050	SIC 80 MWP	100	50	19	3,000	1
A29401001000011	P6PW 100100	SIC 24 MWP	100	100	19	3,000	1
A29401001000020	P6PW 100100	SIC 46 WP	100	100	19	3,000	1
A29401001000021	P6PW 100100	SIC 46 MWP	100	100	19	3,000	1
A29401001000040	P6PW 100100	SIC 80 WP	100	100	19	3,000	1
A29401001000041	P6PW 100100	SIC 80 MWP	100	100	19	3,000	1

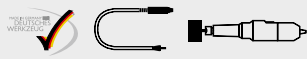
Recommended for: ● Inox/Steel ● Cast material ● Titanium ● Steel ● Aluminium

## POLISHING GROUP P7

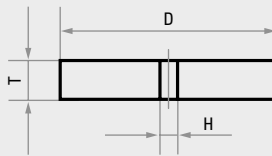
## Fine processing with no compromises



LUKAS polishing points, wheels and lenses are specially designed for fine mechanics and laboratory work. But with their soft elastomer bonding, these tools are also a valuable aid in other areas such as pattern construction or jewellery. Available in tiny sizes and a wide range of shapes, they make it possible to machine even the finest workpieces and textures.

GRINDING AND POLISHING  
(with bonded tools)

## Polishing wheel and lens made from soft elastomer



★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	Pack contains
A2950000101007	P7- R22	SICGR 240		22	3.5	1.8	100
A2950000105007	P7- L22	SICGR 240		22	3.4	1.8	100

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



## Assortment of small soft elastomer polishing points



- The small polishing points have a shank diameter of 2.35 mm.

★★☆

Product number	Description	Quality	Content	Shank mm	Pack contains
A29551301582077	P7Sort. 130-15	SICGR 240	12 parts	2.35	1
A29551301582071	P7Sort. 130-15	SICGR 400	12 parts	2.35	1

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



## CBN/DIAMOND TOOLS

# Let LUKAS experts develop your perfect precision tool

## GENERAL

Diamond is the hardest and cubic boron nitride (CBN) is among the hardest materials known to man. Their excellent hardness makes them highly effective abrasives that have become an essential part of modern precision machining. Diamond grains "D" are available as both natural and synthetic products, while grains made from CBN "B" are entirely synthetic.

Due to the complex syntheses and natural scarcity, diamond and CBN grains are much more expensive than conventional abrasives. But their incredible hardness makes them far superior and essential for many applications. Super-abrasive tools are particularly economical when used in large-scale series production and for the manufacture of premium individual workpieces. The diagram below shows a comparison of the micro-hardnesses of various abrasives.

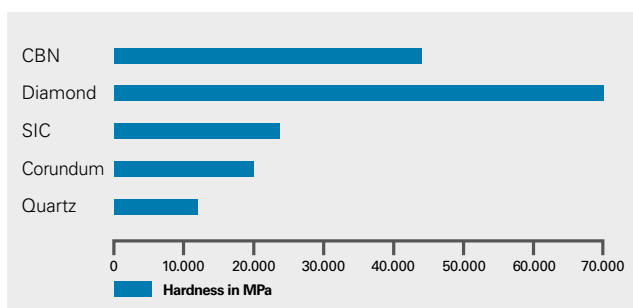
Diamond tools are suitable for processing a wide range of materials, including hard substances like carbides, ceramic, glass, carbon and glass-fibre-reinforced plastics (CFRP and GFRP), and even diamond itself. They can also be used to economically process several plastics and even rubber. CBN is used to process hardened steels. Our expert team will be happy to help find the abrasive that's right for you.

## HARDNESS

These ultra-hard abrasives are much more expensive than conventional products, but offer much greater performance in optimised production processes due to their extreme hardness. This helps to significantly reduce costs.

### Micro-hardness

The diagram below clearly shows the extreme differences in micro-hardness.



## BOND

We offer our customers ultra-hard grinding wheels in a range of bonds. We will be happy to help find the right bond for you.

### Vitrified bond

The abrasive grains in these tools are bonded using a ceramic matrix. These high-performance tools are ideal for achieving the best surface qualities. Their very low dressing rates and consistent abrasive coating give them a very long tool life, helping to keep production costs down. We produce these grinding wheels in a variety of sizes and structures, so that we can offer the right tool to every customer (more information on [page 125](#)).

### Electro-plated

On electro-plated tools, the abrasive grains are galvanically nickel plated to bind them to the surface of a metallic body. Tools produced in this way usually cost less and can be produced in a variety of special shapes and profiles. As both the body and bond are made from metal, they offer outstanding heat conductivity in grinding processes. Electro-plating is also possible with very coarse grains. These tools are suitable for manual use and dry grinding. We recommend using cutting fluids to extend the tool life, however. To help keep costs down, we can recoat worn tools for our customers. This is a particularly economical option when using large or complex tool bodies (suitable tools can be found on [pages 126–128](#)).

## VACUUM-BRAZED TOOLS

Alongside vacuum-brazed cutting discs, we offer our customers a wide range of special solutions and shapes on request to help them meet their specific requirements. This ultra-hard coating delivers extreme profile retention and long tool life.

## GRAIN

As well as physical and chemical properties, the design of the individual grain determines the type of grain to be used. Our expert team can choose the right abrasive grains to develop the right tool for your needs.

Unlike conventional abrasive particles, the grain size for diamond and CBN is indicated in micrometres rather than US Standard Mesh, as per ISO 6106 and FEPA.

Therefore, always remember: **the smaller the number, the finer the grain size – the larger the number, the coarser the grain size.**

The adjacent table shows a comparison of the various sizes measurements.

When selecting the grain size, always bear in mind that ultra-hard abrasives always achieve a higher surface roughness than conventional abrasives due to their extremely low grain wear.

Grain size ranges as per ISO 6106/  
FEPA and US standard

CBN	Diamond	Grain size µm	US Standard Mesh
B 46	D 46	38–45	325/400
B 54	D 54	45–53	270/325
B 64	D 64	53–63	230/270
B 76	D 76	63–75	200/230
B 91	D 91	75–90	170/200
B 107	D 107	90–106	140/170
B 126	D 126	106–125	120/140
B 151	D 151	125–150	100/120
B 181	D 181	150–180	80/100
B 213	D 213	180–212	70/80
B 251	D 251	212–250	60/70

## VITRIFIED-BONDED CBN/DIAMOND TOOLS

# Reliable tool solutions

## QUALITIES

Vitrified-bonded tools are perfect for use in machine-aided large series production processes. They can achieve good and reproducible surface qualities reliably. Thanks to their extreme tool life and low dressing rates, these tools allow users to extend service intervals and save production costs. Our vitrified-bonded diamond and CBN precision tools are defined through a range of parameters, including the choice of abrasive particle, the vitrified bond and its porosity, as well as the suitable shanks. Our expert team will be happy to advise you and help develop the perfect solution for your needs, making use of our years of experience in developing abrasives and in supporting large series production processes.

## SHANKS

We recommend carbide shanks for our range of diamond and CBN mounted points with vitrified bond, as the elasticity module (E-module) of carbide is three times higher than that of steel. This elasticity module determines how much a body deforms under force. As the carbide shank has a higher E-module value, the tool deformation is kept to a minimum when it is exposed to grinding forces.



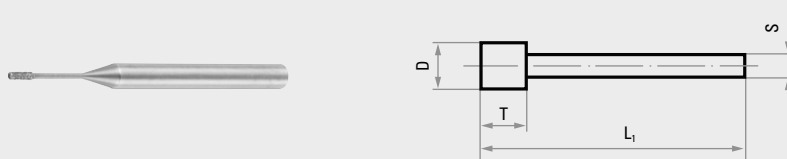
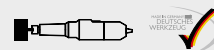
## QUALITY SELECTION

All vitrified-bonded diamond tools have a LUKAS quality code that determines the entire composition. Only after analysing the application data can our specialists recommend the correct tool.

The choice of quality is the decisive step to achieving the perfect result. Varying the quality allows users to influence the hardness and porosity of the grinding wheel. This has a direct impact on process parameters such as removal speed, tool life and surface quality.

**We will be happy to advise you to help you find the right quality.**

## Diamond mounted point, electro-plated

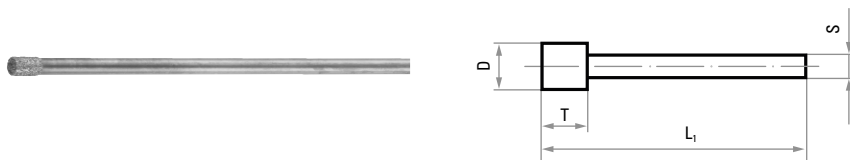
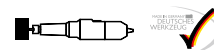


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Product number	Description	Shapes	Grain size	D mm	T mm	S mm	L <sub>1</sub> mm	Pack contains
A34013050126	DS 01003		D 126	1	3	3	40	1
A34013051126	DS 01503		D 126	1.5	3	3	40	1
A34013052126	DS 02005		D 126	2	5	3	40	1
A34013053126	DS 02505		D 126	2.5	5	3	40	1
A34013054126	DS 03005		D 126	3	5	3	40	1
A3401305412601	DS 03505		D 126	3.5	5	3	40	1
A34013055126	DS 04005		D 126	4	5	3	40	1
A3401305512601	DS 04505		D 126	4.5	5	3	40	1
A34013056126	DS 05006		D 126	5	6	3	40	1
A34013057126	DS 06007		D 126	6	7	3	40	1
A34013058126	DS 08010		D 126	8	10	6	60	1
A34013059126	DS 10010		D 126	10	10	6	60	1
A34013060126	DS 12015		D 126	12	15	6	60	1
A34013090126	DSK 02020		D 126	2	–	3	40	1
A34013091126	DSK 03030		D 126	3	–	3	40	1
A34013092126	DSK 04040		D 126	4	–	3	40	1
A34013093126	DSK 05050		D 126	5	–	3	40	1
A34013094126	DSK 06060		D 126	6	–	3	40	1
A34013095126	DSK 08080		D 126	8	–	6	60	1

Recommended for: ● Stone/Construction material ● Cast material ● Plastic/Wood ● Inox/Steel ● Titanium

## Full-carbide diamond mounted point, electro-plated



★★☆

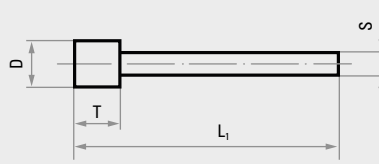
■ Cylindrical diamond mounted point

Product number	Description	Grain size	D mm	T mm	S mm	L <sub>1</sub> mm	Pack contains
A340202305126	DSH 02303	D 126	2.3	3	2	75	1
A340203303126	DSH 03304	D 126	3.3	4	3	75	1
A340204305126	DSH 04305	D 126	4.3	5	4	75	1
A340206307126	DSH 06307	D 126	6.3	7	6	75	1
A340208310126	DSH 08310	D 126	8.3	10	8	75	1
A340210310126	DSH 10310	D 126	10.3	10	10	75	1

Recommended for: ● Stone/Construction material ● Cast material ● Plastic/Wood ● Inox/Steel ● Titanium



## CBN mounted point, electro-plated



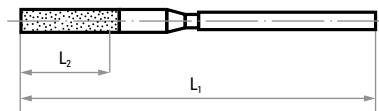
★★☆

Product number	Description	Shape	Grain size	D mm	T mm	S mm	L <sub>1</sub> mm	Pack contains
A34033050126	CS 01003		B 126	1	3	3	40	1
A34033051126	CS 01503		B 126	1.5	3	3	40	1
A34033052126	CS 02005		B 126	2	5	3	40	1
A34033053126	CS 02505		B 126	2.5	5	3	40	1
A34033054126	CS 03005		B 126	3	5	3	40	1
A3403305412601	CS 03505		B 126	3.5	5	3	40	1
A34033055126	CS 04005		B 126	4	5	3	40	1
A3403305512601	CS 04505		B 126	4.5	5	3	40	1
A34033056126	CS 05006		B 126	5	6	3	40	1
A34033057126	CS 06007		B 126	6	7	3	40	1
A34033058126	CS 08010		B 126	8	10	6	60	1
A34033059126	CS 10010		B 126	10	10	6	60	1
A34033060126	CS 12015		B 126	12	15	6	60	1
A34033090126	CSK 0202		B 126	2	–	3	40	1
A34033091126	CSK 0303		B 126	3	–	3	40	1
A34033092126	CSK 0404		B 126	4	–	3	40	1
A34033093126	CSK 0505		B 126	5	–	3	40	1
A34033094126	CSK 0606		B 126	6	–	3	40	1
A34033095126	CSK 0808		B 126	8	–	6	60	1

Recommended for: ● Steel ● Inox/Steel ● Plastic/Wood

GRINDING AND POLISHING  
(with bonded tools)

## Diamond file for manual filing machines, electro-plated



★★☆

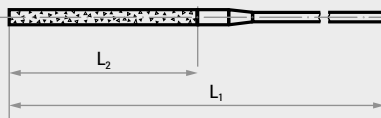
Product number	Description	Shapes	Shape	Grain size	Cross section mm	L <sub>2</sub> mm	L <sub>1</sub> mm	Pack contains
A34003122126	DF 3122		flat	D 126	4 x 1	15	50	1
A34003130126	DF 3130		round	D 126	4	15	50	1

Recommended for: ● Stone/Construction material ● Plastic/Wood ● Titanium ● Inox/Steel ● Cast material

# PERFORM FINE WORK PRECISELY

PERFECT EVERY DETAIL WITH LUKAS DIAMOND FILES

## Diamond needle file, electro-plated

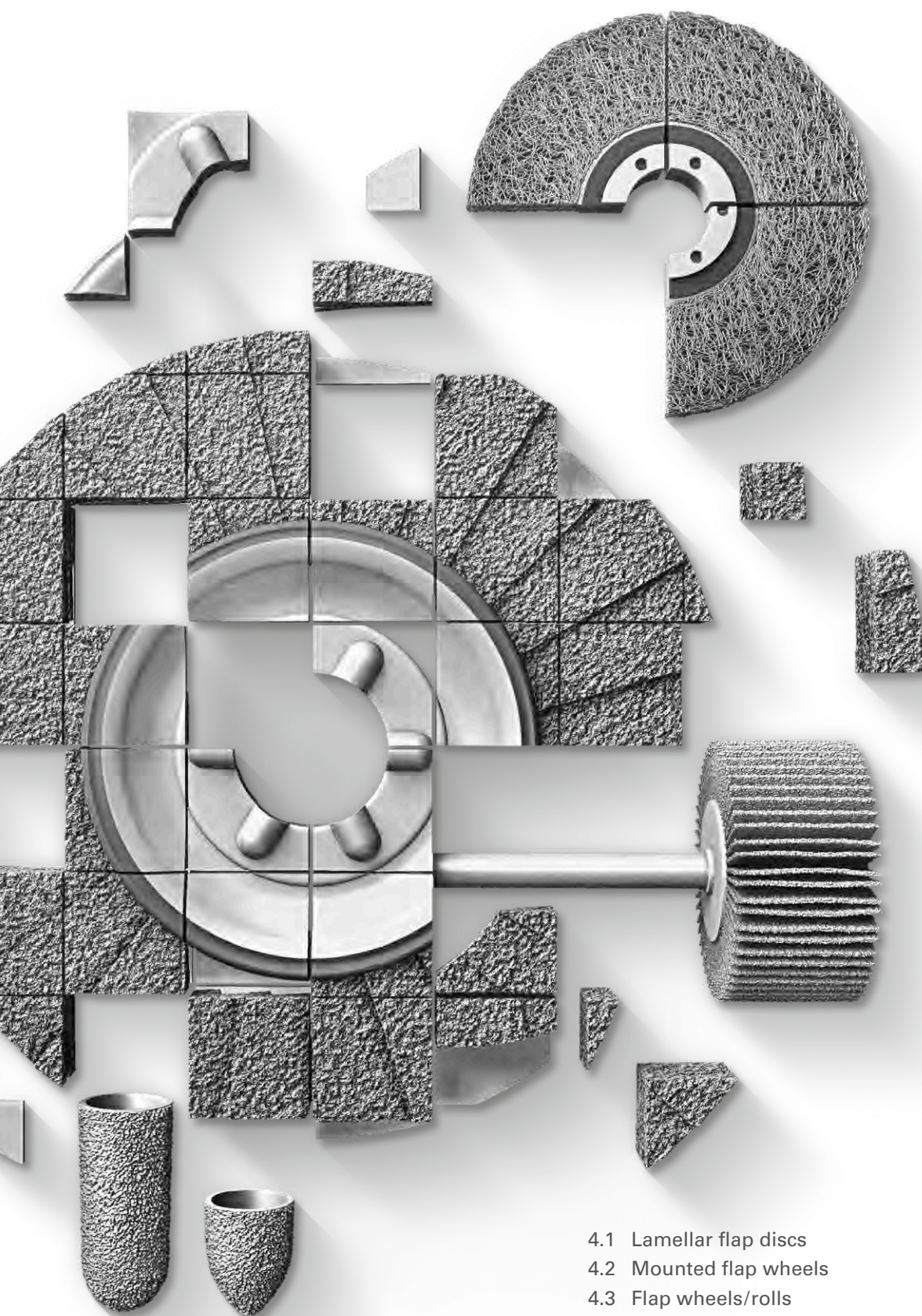


★★☆

Product number	Description	Shapes	Shape	Grain size	Cross section mm	L <sub>2</sub> mm	L <sub>1</sub> mm	Pack contains
A34003140091	DF 3140		flat	D 91	5.0 x 1.4	70	140	1
A34003140126	DF 3140		flat	D 126	5.0 x 1.4	70	140	1
A34003142091	DF 3142		triangular	D 91	3.5 x 3.5	70	140	1
A34003142126	DF 3142		triangular	D 126	3.5 x 3.5	70	140	1
A34003143126	DF 3143		square	D 126	2.5 x 2.5	70	140	1
A34003144126	DF 3144		half-round	D 126	5.2 x 1.9	70	140	1
A34003145126	DF 3145		round	D 126	3	70	140	1
A34003146126	DF 3146		knife	D 126	5.0 x 1.4	70	140	1

Recommended for: ● Stone/Construction material ● Plastic/Wood ● Inox/Steel ● Cast material ● Titanium





# GRINDING AND POLISHING

(with flexible tools)

4.1 Lamellar flap discs	133–162
4.2 Mounted flap wheels	163–180
4.3 Flap wheels/rolls	181–194
4.4 Abrasive bands and mandrels	195–205
4.5 Abrasive rolls and mandrels	206–208
4.6 Abrasive caps and mandrels	209–215
4.7 Abrasive discs and carriers	216–235
4.8 Fibre discs, backing pads, etc.	236–241



## TECHNICAL INFORMATION

# The most important product information at a glance

## GENERAL

Our flexible grinding and polishing tools are made of high quality abrasive cloth and abrasive fleece. They consist of a flexible backing coated with abrasive grain (see pages 131 to 132).

### ▪ Backings used:

cloth, polyester, fleece, fibre

### ▪ Grain types used:

regular aluminium oxide (NK), silicon carbide (SIC),  
zirconia alumina (ZK), ceramic (Ceramic)

Our flexible grinding and polishing tools are available in many different shapes and dimensions. Applications range from high chip removal through to achieving an extremely fine surface finish.

## SAFETY ADVICE

Please note our recommended operating speeds. Pay attention to the safety and accident prevention regulations, including the FEPA safety recommendations, when using and storing flexible grinding and polishing tools. The tools are marked with the appropriate pictograms for correct usage.

## APPLICATION RECOMMENDATIONS

**At high speed coarse grain produces a finer finish, while at low speed a fine grain produces a coarser finish.**

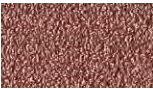

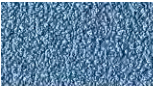




Do not apply too much pressure when using LUKAS grinding tools: excessive pressure does not improve the performance, and will instead result in premature wear. Even if the chip removal is unsatisfactory, you do not apply more pressure. Use a coarser grain instead to prevent unnecessary tool wear and effort. Using grinding additives can also improve efficiency.






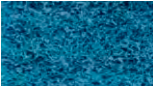




## QUALITY AND APPLICATIONS

# The right abrasive for every application

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high quality abrasives from LUKAS are ideal for many industries, areas and requirements, and therefore offer you a very wide choice.

The overview below lists all abrasives for use with flexible grinding and polishing tools. Read through the properties and application areas for various workpiece materials to establish the most suitable abrasive grain type and tools to meet your requirements.

Quality	Properties	Application areas/ machining	available as	Page
	<b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	forged steel, malleable iron, grey cast iron, carbon steel, deep-drawn steel, steel band, zinc die castings, non-ferrous metals, wood	Lamellar flap discs 156 161 Mounted flap wheels 165 – 170 172 – 174 Flap wheels 182/183 Flap rolls 190 Abrasive bands 198/199 201 – 204 Abrasive rolls 207/208 Abrasive sleeves 205 Abrasive discs 220 229 Fibre discs 231 – 233 238/239
	<b>NKE</b> Abrasive cloth Regular aluminium oxide with active abrasive surface layer	very tough abrasive, high resilience	chrome-nickel and other non-rusting steels, deep-drawn steel, titanium and titanium alloys, heat-resistant steel	Mounted flap wheels 170 Abrasive discs 221
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs 137, 141 144, 146 151/152 154/155 157/158 226 197 Abrasive bands 219, 224 Abrasive discs 237 Fibre discs
	<b>Z Power</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent removal rate, with long tool life	stainless steel	Lamellar flap discs 140 146 Abrasive bands 196 Abrasive discs 219
	<b>ZKS</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	with M-bonding on polyester backing for excellent removal rate with long tool life	forged steel, metals that are difficult to machine and with extremely hard surfaces (overlay welding), titanium and titanium alloys, heat-resistant steel	Lamellar flap discs 150 – 152 160
	<b>NKS</b> Abrasive cloth Regular aluminium oxide with active abrasive surface layer	excellent removal rate with long tool life	corrosion and heat-resistant steels, plastics, aluminium and non-ferrous metals	Abrasive caps 212/213
	<b>SIC</b> Abrasive cloth Silicon carbide	minimum heat generation, special quality for the aerospace industry	aluminium and alloys, titanium materials, glass, ceramic, heat-resistant steel, plastic	Lamellar flap discs 147 Mounted flap wheels 171 Abrasive discs 223, 228

Quality	Properties	Application areas/ machining	available as	Page
	<b>Ceramic</b> Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	non-rusting steels, nickel alloys	Lamellar flap discs Mounted flap wheel of abrasive cloth Abrasive bands Abrasive rolls Abrasive caps Abrasive discs Fibre discs 140 145 150 164 196 206 209 218 236
	<b>Ceramic4x</b> Abrasive cloth Ceramic grain	excellent removal rate without grain shredding, particularly stable thanks to reinforced backing, cool cutting	steel, rust- and acid-resistant steel	Lamellar flap discs 141 144 153
	<b>PG</b> Reinforced abrasive cloth with ceramic grain	maximum removal rate and tool life thanks to self-sharpening ceramic grain	inox, steel, hardened/coated surfaces	Compact grinding discs Lamellar flap discs 135 136
	<b>NK</b> Abrasive fleece Regular aluminium oxide	polishing effect with the fibre structure, consistent results thanks to contin- uous exposure of new abrasive particles	chrome-nickel alloys and other non-rusting steels, zinc die castings, non- ferrous metals, wood	Mounted flap wheels Mounted flap wheels Flap rolls Flap rolls 176/177 179 184–187 188 191
	<b>SIC</b> Abrasive fleece Silicon carbide	polishing effect with the fibre structure, consistent results thanks to contin- uous exposure of new abrasive particles	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Mounted flap wheels Mounted flap wheels Flap rolls Semi-flexible grinding disc 177 161 184–186 193 240
	<b>Z</b> Abrasive fleece Zirconia alumina	polishing effect with the fibre structure, improved aggressiveness	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals	Mounted flap wheels 175
	<b>TF</b> Abrasive fleece/cloth Regular aluminium oxide reinforced fleece	with the combination mounted flap wheels, the abrasive cloth and fleece flaps wear more evenly, improved removal rate	ideal for surface finishing of sheet metal products made from non-rusting steel such as stainless steel sinks and containers	Mounted flap wheels Flap rolls 178 192
	<b>A</b> Mounted flap wheels Flap rolls	the combination with abrasive cloth enhances the grinding effect	chrome-nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	Lamellar flap discs Mounted flap wheels Mounted flap wheels Flap rolls 161 179 187 192/193
	<b>C</b> Abrasive fleece/cloth Silicon carbide	the combination with abrasive cloth enhances the grinding effect	titanium and titanium alloys, silver and silver plating, aluminium and aluminium alloys, plastics	Lamellar flap discs Mounted flap wheels Mounted flap wheels 161 180 187
	<b>AS</b> Polyamide fleece	impregnated with aggressive abrasive grain	removal of paint and adhesives, cement and concrete resithankss, derusting, cleaning and polishing a wide variety of surfaces, graining and cleaning of wood	Flap disc Grinding wheel 227, 287 288

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS lamellar flap discs – from coarse cutting through to surface finishing

## GENERAL

We offer lamellar flap discs for practically every requirement. These tools are manufactured with a wide selection of backing materials (e.g. glass fabric, plastic, metal, as well as renewable raw materials) to suit every application. The large selection of available grit sizes covers coarse grinding applications (from grit size 36) through to finishing (grit size 240).

## ERGONOMICS

Using lamellar flap discs brings clear advantages in terms of ergonomics compared to conventional grinding discs. Noise levels during grinding are halved and vibrations are also significantly reduced. The tools are also lighter so less pressure needs to be applied. These advantages create a healthy and fatigue-free working environment.

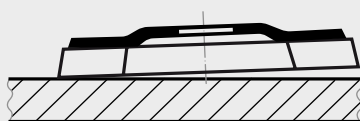
The lamellar flap discs are available in the diameters 100 mm (with 16 mm bore), 115 mm, 125 mm, 150 mm, 178 mm (22.23 mm bore) and 230 mm for use with commercially available angle grinders.

## APPLICATION

You can choose between the flat or angled version depending on the job in hand.

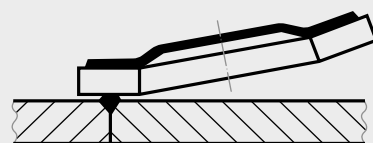
### Application examples:

- deburring
- fettling
- derusting
- smoothening
- weld seam removal



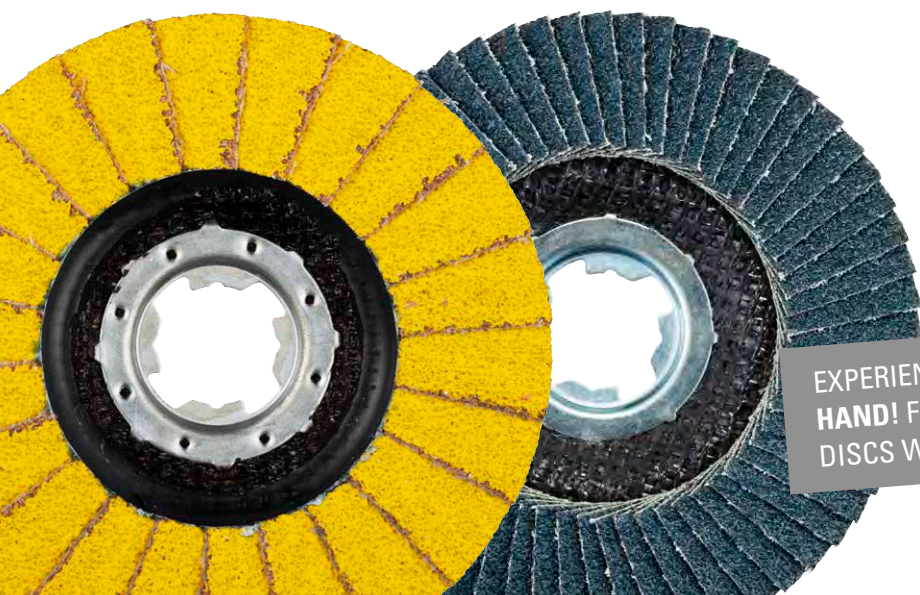
### Using the flat version

Use this version for grinding edges and flat surfaces with a working angle of 0 – 15°



### Using the angled version for spot grinding

e.g. a weld, with the ideal working angle of 15 – 25°



EXPERIENCE THIS TIME-SAVING INNOVATION AT FIRST HAND! FIND OUT MORE ABOUT OUR LAMELLAR FLAP DISCS WITH X-LOCK SYSTEM ON **PAGES 144 AND 154**



## iQ SERIES FROM LUKAS

## Developed for high-performance applications

Our high-performance tools are grouped together in our iQ series. Among them are the lamellar flap discs, which have a patented flap shape and arrangement for ultimate grinding performance.



## Purple Grain

## Powerful tools for heavy-duty applications

## AGGRESSIVE. DURABLE. ERGONOMIC.

- high stability and durability
- integrated backing pad in recycled fibre
- even wearing without overheating, becoming brittle or shredding of the grain
- innovative ceramic grain: sharp to the end



**innovative**  
Ceramic grain



**operating**  
angle < 10°



**no backing**  
pad required



**low**  
vibration

## WITH THE SELF-SHARPENING EFFECT

The self-sharpening ceramic grain ensures sustained cool grinding even at low grinding pressure. The tools retain their sharpness down to the last grain.



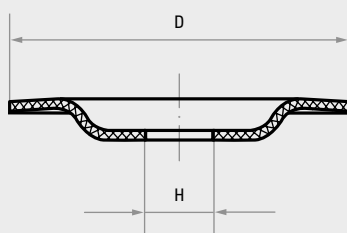


# THE DYNAMIC ALL-ROUNDER WITH A LONG TOOL LIFE

PURPLE GRAIN SINGLE AND PURPLE GRAIN MULTI WITH THREE LAYERS



Even with a minimum effort, "Purple Grain Single" achieves stunning removal rates. The integrated backing pad made of eco-friendly recycled fibre assures high stability and durability. The innovative design provides for even wear without overheating, becoming brittle or shredding of the grain. The deep recess allows you to work at a flat angle. Thanks to its special tool geometry, the "Purple Grain Single" can also reach inaccessible areas, which offers more application possibilities than a conventional tool.



## Purple Grain Single compact grinding disc



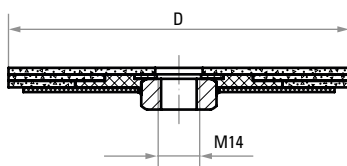
★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27601150361547	Purple Grain Single 115	Ceramic 36	115	22.23	13,300	10
A27601250361547	Purple Grain Single 125	Ceramic 36	125	22.23	12,200	10

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



With its unique multi-layer design, the powerful "Purple Grain Multi" achieves a maximum tool life. Wearing of the three grinding layers is controlled from start to finish, which is reflected in the tangible cost savings compared to conventional tools. The integrated M14 threaded holder ensures ultra-fast tool changing with no annoying clamping nuts. With its flat tool geometry, the "Purple Grain Multi" creates very good surface finishes, thus avoiding the need for reworking.



## Purple Grain Multi compact grinding disc



★★★

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A27621150361547	Purple Grain Multi 115	Ceramic 36	115	M14	13,300	10
A27621250361547	Purple Grain Multi 125	Ceramic 36	125	M14	12,200	10

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



# EXCEPTIONAL GRINDING PERFORMANCE IN INDUSTRIAL APPLICATIONS

## V4 PURPLE POWER – FOR ROBOTIC APPLICATIONS

GRINDING AND POLISHING  
(with flexible tools)

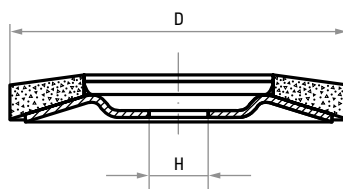


As a highly aggressive grinding tool, the V4 Purple Power is designed to be used on powerful angle grinders. On robots and automatic grinders, this grinding disc shows what it's capable of. It achieves unique performance values, combined with a long tool life for impressive efficiency.

The V4 Purple Power is equipped with a high-performance ceramic abrasive coating for outstanding results. In addition,

the flap shape is optimised for high stock removal. This lamellar flap disc effortlessly grinds steel, inox, cast material and titanium. The V4 Purple Power can convert up to 20 kg of structural steel into fine chips during grinding process. The chip removal rate is up to 250 % greater than conventional tools. With a tool life of approximately 3.5 hours, this grinding tool when used on robots also exceeds all expectations.

## V4 Purple Power



- exceptional grinding performance in industrial applications
- ideal for use with robots, grinding machines and heavy duty machine tools
- exceptional removal rate
- removes more than 20 kg of structural steel when used with a robot
- fewer tool changes
- extremely ergonomic

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A274812503600475	V4 Purple Power 125	Ceramic 36	125	22.23	12,200	5
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkgrey;">●</span> Titanium <span style="color: red;">●</span> Cast material						

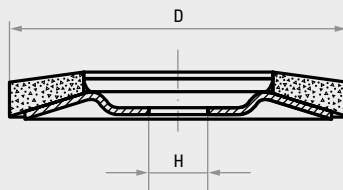
# POWER FOR METALWORKERS

HIGHLY AGGRESSIVE AND DURABLE  
FOR UNCOMPROMISING GRINDING

The V4 Master mounted on an angle grinder is used when high stock removal is required. This lamellar flap disc displays its enduring removal performance in rounding off sharp edges and finishing weld seams and thermal cuts. With its powerful cutting performance, it ensures this kind of challenging work can be performed quickly and effortlessly.

LUKAS has developed this grinding tool for various industries: steel and vessel construction, shipyards and offshore, machine and plant engineering, i.e. for any industry that removes a great deal of material from sheet metal and steel. The V4 Master is an excellent choice in this instance. The low force applied, the deep recess around the bore and the low noise and vibration levels when grinding makes for an easy application.

GRINDING AND POLISHING  
(with flexible tools)



- exceptional cutting performance
- high edge retention
- deep recess
- long tool life
- low noise and vibrations
- ergonomic handling requiring minimum force
- free of iron, sulphur and chlorine

## V4 Master



★★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27471150401465	V4 Master 115	ZK 40	115	22.23	13,300	10
A27471150601465	V4 Master 115	ZK 60	115	22.23	13,300	10
A27471250401465	V4 Master 125	ZK 40	125	22.23	12,200	10
A27471250601465	V4 Master 125	ZK 60	125	22.23	12,200	10
A27471780401465	V4 Master 178	ZK 40	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium





## SLTT – FOR THE TOUGHEST GRINDING REQUIREMENTS

COMPARE THE EFFICIENCY AGAINST GRINDING DISCS  
OR CONVENTIONAL LAMELLAR FLAP DISCS

# 70%

OF THE ABRASIVE MATERIAL IS  
LOCATED ON THE OUTER AREA OF  
THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE  
WITH ITS INNOVATIVE FLAP ARRANGEMENT

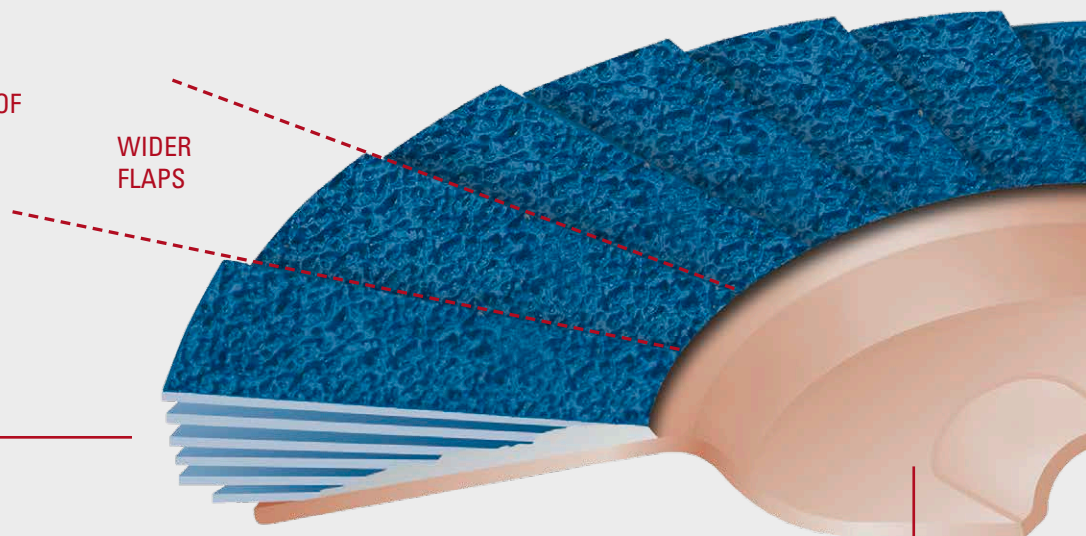
WIDER  
FLAPS

UP TO

# 6

ABRASIVE LAYERS

ROBUST  
STEEL BACKING PLATE





The efficient, high-performance SLTT lamellar flap discs from LUKAS are a better alternative to grinding discs and conventional lamellar flap discs.

Compared to grinding discs, the LUKAS patented flap shape and arrangement provides for 50 % lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.



**Patented LUKAS flap shape and arrangement** with more abrasive grains than the norm

A particularly large concentration of abrasive grain on the outer perimeter of these tools results in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.



#### PROPERTIES

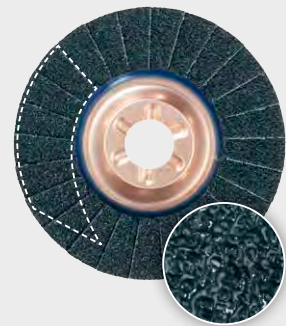
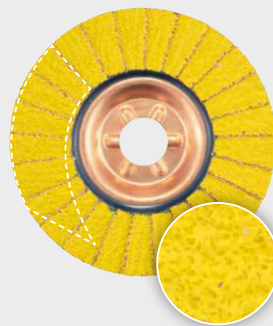
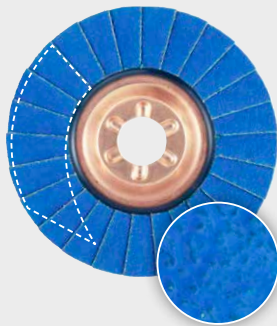
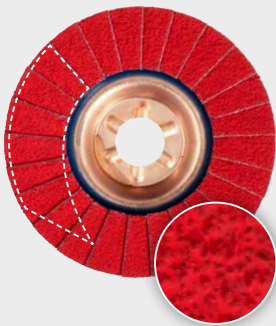
- outstanding cutting performance
- exceptional tool life
- robust steel back plate
- low noise and vibration levels

#### APPLICATION

Ideal for machining welds, deburring, derusting, fettling and smoothing. Thanks to its 22.23 mm bore, it fits onto all commonly used angle grinders.

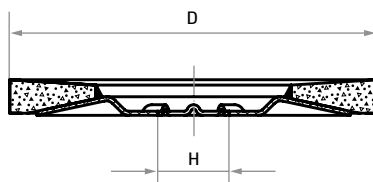
GRINDING AND POLISHING  
(with flexible tools)

#### THE FOUR SLTT VERSIONS



Heavy Duty Ceramic abrasive cloth	Inox Z Power abrasive cloth	HybridPerfection Ceramic4x abrasive cloth	Steel ZK abrasive cloth
<ul style="list-style-type: none"> <li>■ developed for the most demanding and toughest grinding applications</li> <li>■ especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ innovative development for grinding stainless steel</li> <li>■ no glazing or heating of the flaps thanks to the active abrasive surface layer</li> <li>■ equally efficient for edge and surface applications</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ the professional tool for the toughest jobs involving steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium</li> <li>■ achieves impressively high stock removal rates when rough grinding steel, edging and removal of welds</li> <li>■ with additional active abrasive layer for stainless steel</li> </ul>	<ul style="list-style-type: none"> <li>■ optimised for universal use on a wide variety of steels and aluminium</li> <li>■ exceptionally tough grain and resistant to high pressure</li> </ul>

## SLTT Heavy Duty lamellar flap discs



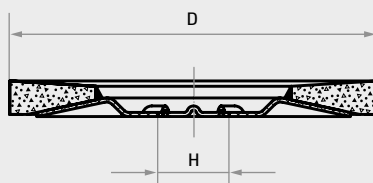
- developed for the most demanding and toughest grinding applications
- especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400050	SLTT 115	Ceramic 40	115	22.23	13,300	10
A27201150600050	SLTT 115	Ceramic 60	115	22.23	13,300	10
A27201250400050A	SLTT 125	Ceramic 40	125	22.23	12,200	10
A27201250600050	SLTT 125	Ceramic 60	125	22.23	12,200	10
A27201500400050	SLTT 150	Ceramic 40	150	22.23	10,200	10
A27201780400050	SLTT 178	Ceramic 40	178	22.23	8,500	10
A27201780600050	SLTT 178	Ceramic 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material ● Plastic/Wood

## SLTT Inox lamellar flap discs



- turbo back plate for machining stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

★★★

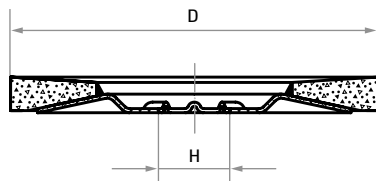
Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400045	SLTT 115	Z-Power 40	115	22.23	13,300	10
A27201150600045	SLTT 115	Z-Power 60	115	22.23	13,300	10
A27201250400045A	SLTT 125	Z-Power 40	125	22.23	12,200	10
A27201250600045	SLTT 125	Z-Power 60	125	22.23	12,200	10
A27201500400045	SLTT 150	Z-Power 40	150	22.23	10,200	10
A27201780400045	SLTT 178	Z-Power 40	178	22.23	8,500	10
A27201780600045	SLTT 178	Z-Power 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel



## SLTT HybridPerfection<sup>Ceramic4x</sup> lamellar flap discs **NEW**

- the professional tool for the toughest jobs on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves impressively high stock removal rates when rough grinding steel, edging and removal of welds
- with additional active abrasive layer for stainless steel
- designed for endurance
- outstanding price-to-performance ratio



★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400044	HybridPerfection 115	Ceramic4x 40	115	22.23	13,300	10
A27201150600044	HybridPerfection 115	Ceramic4x 60	115	22.23	13,300	10
A27201250400044	HybridPerfection 125	Ceramic4x 40	125	22.23	12,200	10
A27201250600044	HybridPerfection 125	Ceramic4x 60	125	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood

### UNBEATABLE ON STEEL: THE NEW LUKAS HYBRIDPERFECTION

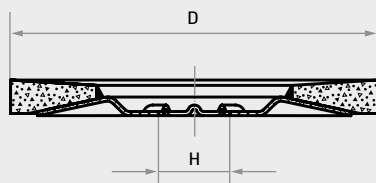
Thanks to its innovative Ceramic4x abrasive cloth and patented flaps, this lamellar flap disc quickly achieves exceptionally high stock removal rates on steel.

EXPERIENCE AT FIRST HAND THE **IMPRESSIVE PERFORMANCE** OF THE NEW HYBRID PERFECTION AND TEST IT NOW FOR YOURSELF.

GRINDING AND POLISHING  
(with flexible tools)



## SLTT steel lamellar flap discs



★★★

- optimised for steel
- exceptionally tough grain and resistant to high pressure

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27201150400065	SLTT 115	ZK 40	115	22.23	13,300	10
A27201150600065	SLTT 115	ZK 60	115	22.23	13,300	10
A27201250400065A	SLTT 125	ZK 40	125	22.23	12,200	10
A27201250600065	SLTT 125	ZK 60	125	22.23	12,200	10
A27201500400065	SLTT 150	ZK 40	150	22.23	10,200	10
A27201500600065	SLTT 150	ZK 60	150	22.23	10,200	10
A27201780400065	SLTT 178	ZK 40	178	22.23	8,500	10
A27201780600065	SLTT 178	ZK 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium





## THE V2 POWER – FOR UNIVERSAL USE

EXPERIENCE THE EFFICIENCY COMPARED TO CONVENTIONAL LAMELLAR FLAP DISCS

# 70%

OF THE ABRASIVE MATERIAL IS  
LOCATED ON THE OUTER AREA  
OF THE BACKING PLATE

IMPROVED GRINDING PERFORMANCE  
THANKS TO THE SPECIAL FLAP CONFIGURATION

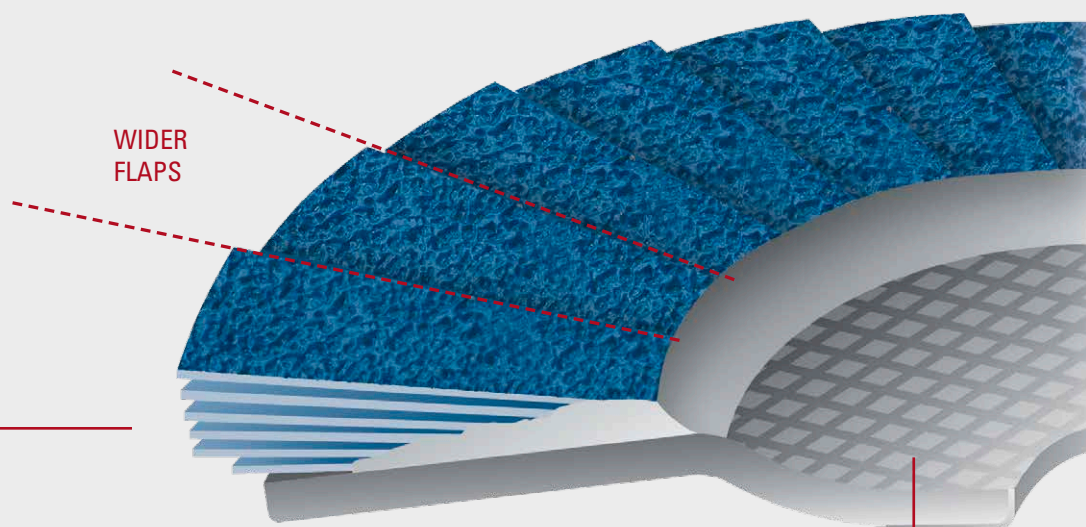
WIDER  
FLAPS

UP TO

# 6

ABRASIVE LAYERS

GLASS FIBRE  
BACKING PLATE





The efficient, high-performance LUKAS V2 Power lamellar flap discs with a glass fibre backing are a better alternative to grinding discs and conventional lamellar flap discs.



**innovative patented LUKAS flap shape and arrangement**  
with more abrasive grains than usual

The flexibility, light weight and stability of the elastic glass fibre backing result in an exceptional surface finish. The high resistance to shredding and minimal vibration during operation, not to mention its easy handling, perfectly round off the characteristics of the V2 Power lamellar flap disc.

Compared to grinding discs, the LUKAS patented flap shape and arrangement gives 50% lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

A particularly large concentration of abrasive grains on the outer perimeter results

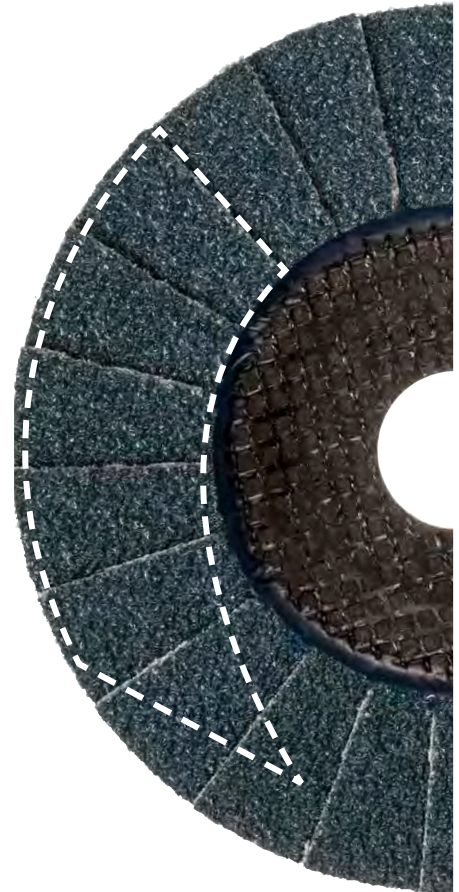
in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs additionally remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.

#### PROPERTIES

- exceptional grinding performance
- long tool life
- robust glass fibre backing

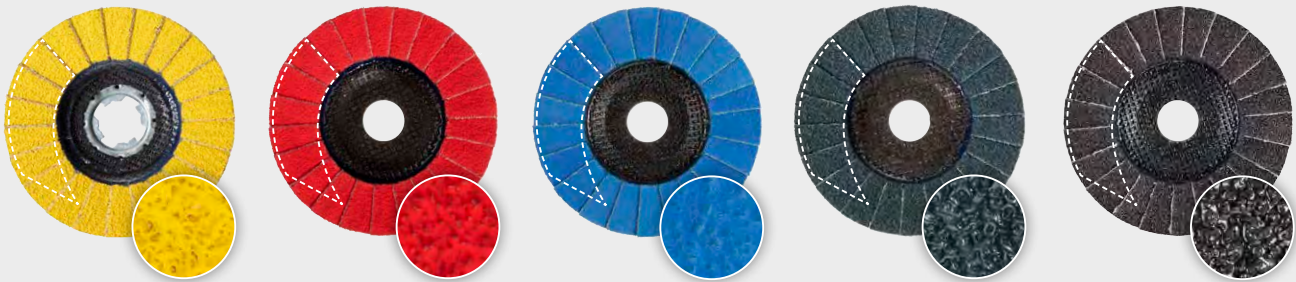
#### APPLICATION

Ideal for machining weld seams, deburring, derusting, fettling and smoothing.



GRINDING AND POLISHING  
(with flexible tools)

### THE FIVE V2 POWER VERSIONS



X-LOCK Ceramic4x abrasive cloth	Heavy Duty Ceramic abrasive cloth	Inox Z Power abrasive cloth	Steel ZK abrasive cloth	ALU SiC abrasive cloth
<ul style="list-style-type: none"> <li>■ perform the toughest machining jobs and quick tool changing</li> <li>■ all the benefits of the efficient LUKAS V2 Power lamellar flap disc coupled with the latest mounting system</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ developed for the most demanding and toughest grinding applications</li> <li>■ especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ developed for grinding stainless steel</li> <li>■ no glazing or heating of the flaps thanks to the active abrasive surface layer</li> <li>■ equally efficient for edge and surface applications</li> <li>■ free of iron, sulphur and chlorine</li> </ul>	<ul style="list-style-type: none"> <li>■ optimised for universal application on a wide variety of steels and aluminium</li> <li>■ exceptionally tough grain and resistant to high pressure</li> </ul>	<ul style="list-style-type: none"> <li>■ particularly suitable for preparing welds and finishing aluminium</li> <li>■ also ideal for fibre-reinforced materials such as CFRP and GFRP</li> </ul>

## V2 POWER WITH X-LOCK MOUNTING SYSTEM

THE HIGH-PERFORMANCE LAMELLAR FLAP DISC  
WITH THE INNOVATIVE MOUNTING SYSTEM

### MOUNTING GRINDING DISCS HAS NEVER BEEN SO EASY

The high-power V2 Power lamellar flap disc is the first tool from LUKAS equipped with the new X-LOCK mounting system. As a result, the outstanding grinding performance is combined with changing the tool in just seconds.

With the new X-LOCK system, you position the flap disc on the mounting fixture and allow it to engage – and you're done. A "click" noise indicates that the disc is firmly mounted. The potential of losing clamping nuts and keys is implemented. As a result, the tool change is fast and easy.

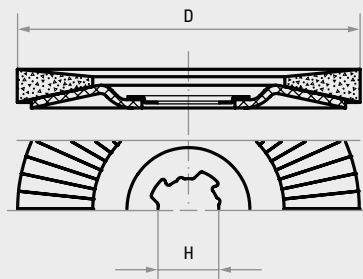


Photo: Bosch

### NEW V2 Power X-LOCK lamellar flap disc



★★★



- the professional tool for the toughest jobs on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves impressively high stock removal rates when rough grinding steel, edging and removing of welds
- keyless tool changing in no time at all
- all the benefits of the efficient LUKAS V2 Power lamellar flap disc coupled with the latest mounting system
- free of iron, sulphur and chlorine

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A67441250401844	V2 Power 125	Ceramic4x 40	125	X-LOCK/22.23	12,200	10
A67441250601844	V2 Power 125	Ceramic4x 60	125	X-LOCK/22.23	12,200	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: darkgrey;">●</span> Titanium <span style="color: yellow;">●</span> Plastic/Wood						
A67441250401865	V2 Power 125	ZK 40	125	X-LOCK/22.23	12,200	10
A67441250601865	V2 Power 125	ZK 60	125	X-LOCK/22.23	12,200	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material						





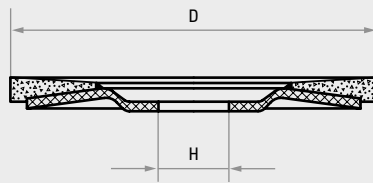
## HEAVY DUTY FOR HANDLING THE TOUGHEST JOBS

FOR THE MOST DEMANDING MACHINING REQUIREMENTS FOR UNIVERSAL USE

GRINDING AND POLISHING  
(with flexible tools)



### V2 Power Heavy Duty lamellar flap disc



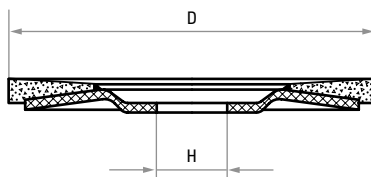
- especially robust for edge grinding, quenched and tempered steels, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27441150401450	V2 Power 115	Ceramic 40	115	22.23	13,300	10
A27441150601450	V2 Power 115	Ceramic 60	115	22.23	13,300	10
A27441250401450	V2 Power 125	Ceramic 40	125	22.23	12,200	10
A27441250601450	V2 Power 125	Ceramic 60	125	22.23	12,200	10
A27441780401450	V2 Power 178	Ceramic 40	178	22.23	8,500	10
A27441780601450	V2 Power 178	Ceramic 60	178	22.23	8,500	10
A27442300401428	V2 Power 230	Ceramic 40	230	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material ● Plastic/Wood

## V2 Power Inox lamellar flap disc



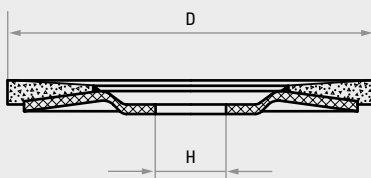
- optimised for grinding stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27441150401445	V2 Power 115	Z-Power 40	115	22.23	13,300	10
A27441150601445	V2 Power 115	Z-Power 60	115	22.23	13,300	10
A27441250401445	V2 Power 125	Z-Power 40	125	22.23	12,200	10
A27441250601445	V2 Power 125	Z-Power 60	125	22.23	12,200	10
A27441780401445	V2 Power 178	Z-Power 40	178	22.23	8,500	10
A27441780601445	V2 Power 178	Z-Power 60	178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel

## V2 Power Steel lamellar flap disc

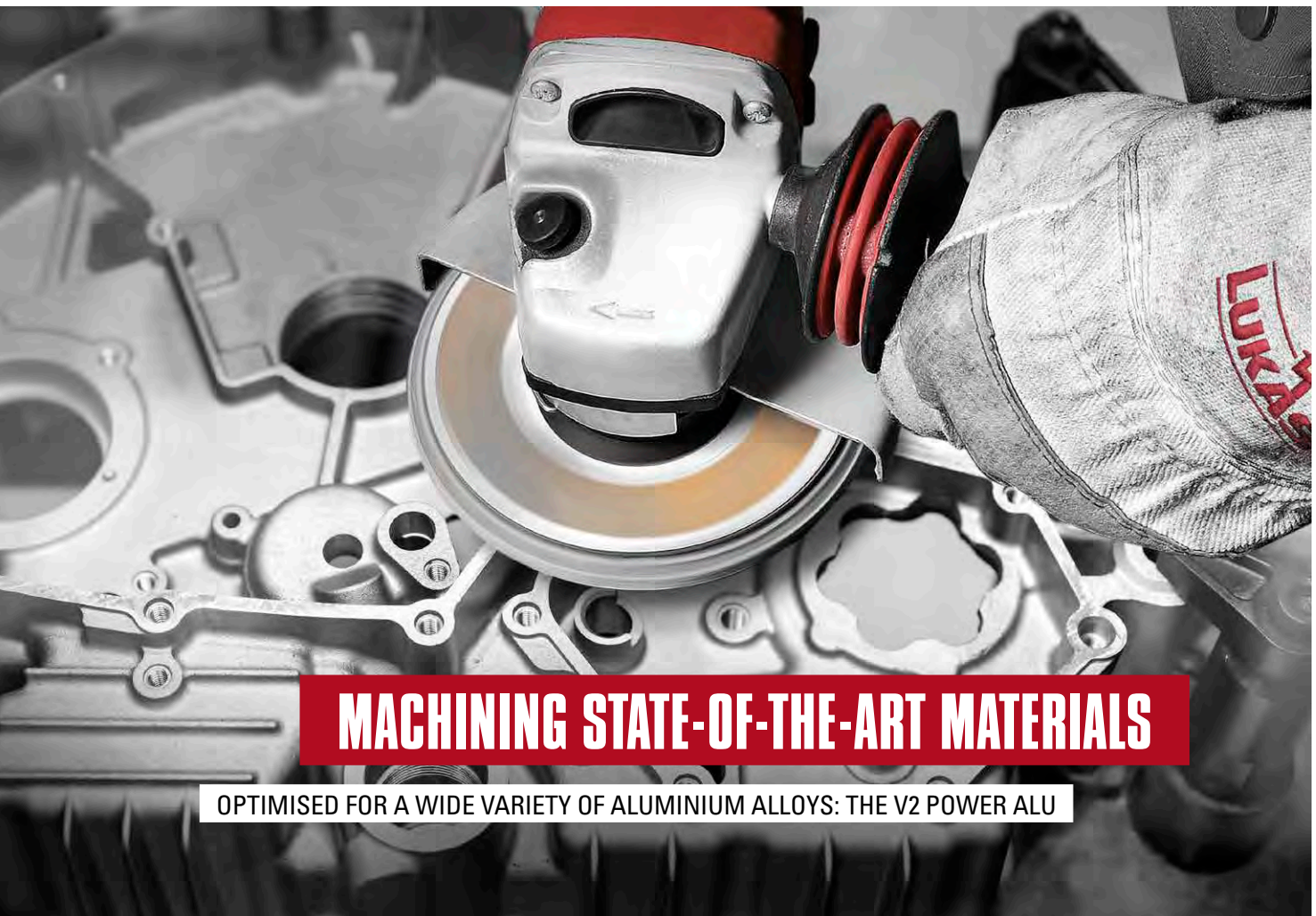


- ideally suited for universal use on steel
- exceptionally tough grain and resistant to high pressure

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27441000401465	V2 Power 100	ZK 40	100	16.00	15,300	10
A27441000601465	V2 Power 100	ZK 60	100	16.00	15,300	10
A27441150401465	V2 Power 115	ZK 40	115	22.23	13,300	10
A27441150601465	V2 Power 115	ZK 60	115	22.23	13,300	10
A27441250401465A	V2 Power 125	ZK 40	125	22.23	12,200	10
A27441250601465	V2 Power 125	ZK 60	125	22.23	12,200	10
A27441780401465	V2 Power 178	ZK 40	178	22.23	8,500	10
A27441780601465	V2 Power 178	ZK 60	178	22.23	8,500	10
A27442300401418	V2 Power 230	ZKS 40	230	22.23	6,600	5

Recommended for: ● Steel ● Inox/Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



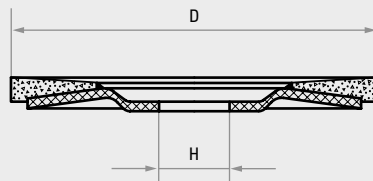
## MACHINING STATE-OF-THE-ART MATERIALS

OPTIMISED FOR A WIDE VARIETY OF ALUMINIUM ALLOYS: THE V2 POWER ALU

GRINDING AND POLISHING  
(with flexible tools)



### V2 Power Alu lamellar flap disc



★★★

- Silicon carbide (SiC) is ideally suited for the preparation and finishing of welds of various aluminium alloys.
- Silicon carbide (SiC) is also very suitable for machining modern materials such as CFRP and GFRP.

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27441150401434	V2 Power 115	SIC 40	115	22.23	13,300	10
A27441250361434	V2 Power 125	SIC 36	125	22.23	12,200	10
A27441250401434	V2 Power 125	SIC 40	125	22.23	12,200	10
A27441780241434	V2 Power 178	SIC 24	178	22.23	8,500	10
A27441780361434	V2 Power 178	SIC 36	178	22.23	8,500	10

Recommended for: ● Aluminium ● Titanium ● Plastic/Wood



## SLTflex – FOR MACHINING INACCESSIBLE AREAS

EXPERIENCE THE EFFICIENCY COMPARED TO FIBRE,  
GRINDING OR CONVENTIONAL LAMELLAR FLAP STOCK DISCS



The flexible SLTflex flap discs from LUKAS for machining hard-to-reach areas are the improved alternative to grinding discs or conventional lamellar flap discs.

The small resin core of the backing plate and its practical M14 thread allows for a larger flap projection. This makes the disc flexible, it can adapt itself to uneven surfaces, and requires little effort in use. With its long tool life, it is ideally suitable for fillet weld grinding. There is no risk of the workpiece being damaged by the back plate.

Compared to grinding discs, the LUKAS patented flap shape and arrangement gives 50 % lower noise levels, less vibration, faster operation, greater efficiency and better surface results. The flat orientation of the abrasive flaps not only makes for safer working, but also reduces tool wear.

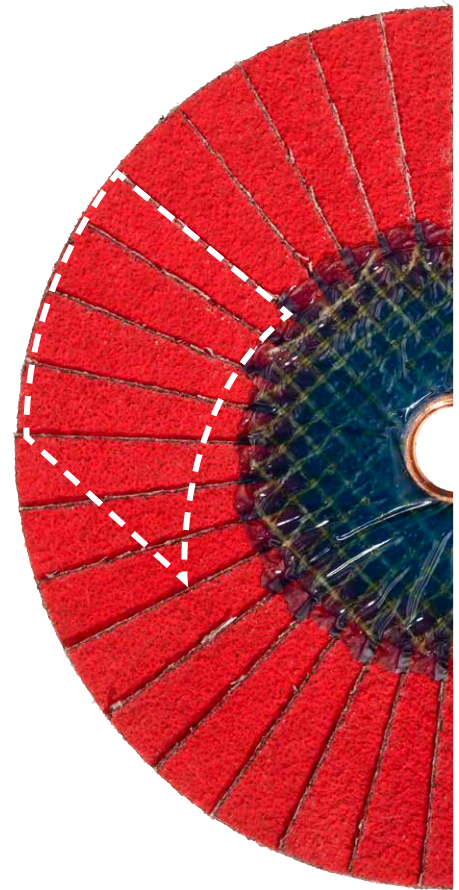
A particularly large concentration of abrasive grains on the outer perimeter results in an exceptionally high stock removal rate per minute. Thanks to the multi-layer abrasive coating, these lamellar flap discs remain sharp throughout the tool life. As the flaps wear, the fresh abrasive coating of the flaps underneath is exposed. Consequently, they achieve a long tool life with consistent results.

#### PROPERTIES

- high flexibility thanks to the wide flap projection
- exceptionally long tool life
- easy tool changing

#### APPLICATION

ideal for machining weld seams, deburring, derusting, fettling and smoothing

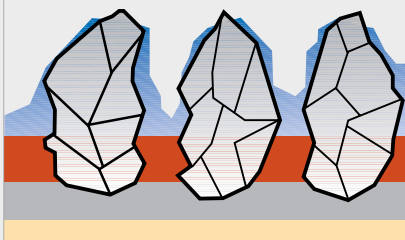


GRINDING AND POLISHING  
(with flexible tools)

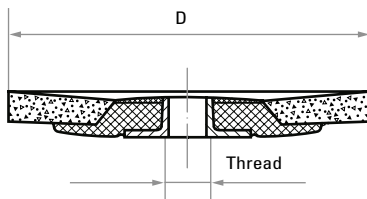
#### FLEXIBLE FLAP ARRANGEMENT

##### ABRASIVE CLOTH

Using high-performance abrasive cloth (with additional abrasive surface layer)



## SLTflex Ceramic lamellar flap disc



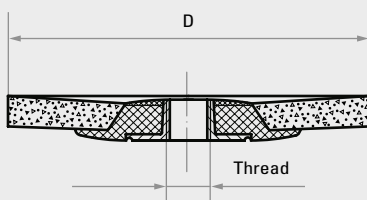
- The efficient grinding tools for radii and fillet welds
- high flexibility thanks to the wide flap projection (no interference from backing plate)
- easy tool changing (backing pad and clamping nut are not required)
- exceptionally long tool life

★★★

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A272711504070	SLTflex 115	Ceramic 40	115	M14	13,300	10
A272711506070	SLTflex 115	Ceramic 60	115	M14	13,300	10
A272712504070	SLTflex 125	Ceramic 40	125	M14	12,200	10
A272712506070	SLTflex 125	Ceramic 60	125	M14	12,200	10

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

## SLTsflex super flexible lamellar flap disc



- even greater flap projection
- even more flexibility
- M14 quick-clamping thread
- super-soft grinding action
- for perfect surface finishes
- fast tool change
- no backing pad and mounting nut required

★★★

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A272910004018	SLTs-flex 100	ZKS 40	100	M10	12,100	10
A272910006018	SLTs-flex 100	ZKS 60	100	M10	12,100	10
A272910008018	SLTs-flex 100	ZKS 80	100	M10	12,100	10
A672911504018	SLTs-flex 115	ZKS 40	115	M14	13,300	10
A672911506018	SLTs-flex 115	ZKS 60	115	M14	13,300	10
A672911508018	SLTs-flex 115	ZKS 80	115	M14	13,300	10
A672912504018	SLTs-flex 125	ZKS 40	125	M14	12,200	10
A672912506018	SLTs-flex 125	ZKS 60	125	M14	12,200	10
A672912508018	SLTs-flex 125	ZKS 80	125	M14	12,200	10
A272917804018	SLTs-flex 178	ZKS 40	178	M14	8,500	10
A272917806018	SLTs-flex 178	ZKS 60	178	M14	8,500	10
A272917808018	SLTs-flex 178	ZKS 80	178	M14	8,500	10

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



# MAXIMUM FLEXIBILITY THANKS TO LARGE FLAP PROJECTION

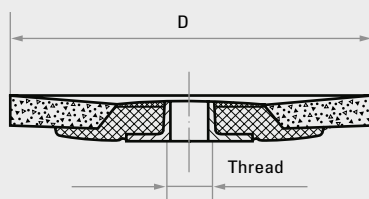
EASY MACHINING OF RADII AND FILLET WELDS



## SLTflex lamellar flap disc



- for machining radii and fillet welds
- high flexibility thanks to the large flap projection (no interference from backing plate)
- easy tool changing (backing pad and clamping nut are not required)
- long tool life

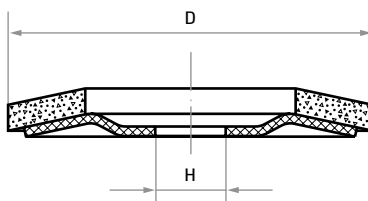
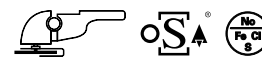


★★★

Product number	Description	Grit	D mm	Thread	$n_{max}$ rpm	Pack contains
A272711504018	SLTflex 115	ZKS 40	115	M14	13,300	10
A272811504018	SLTflex 115	ZKS 40	115	5/8"	13,300	10
A272711506018	SLTflex 115	ZKS 60	115	M14	13,300	10
A272811506018	SLTflex 115	ZKS 60	115	5/8"	13,300	10
A272711508016	SLTflex 115	ZK 80	115	M14	13,300	10
A272811508018	SLTflex 115	ZK 80	115	5/8"	13,300	10
A272711512016	SLTflex 115	ZK 120	115	M14	13,300	10
A272811512018	SLTflex 115	ZK 120	115	5/8"	13,300	10
A272712504018	SLTflex 125	ZKS 40	125	M14	12,200	10
A272812504018	SLTflex 125	ZKS 40	125	5/8"	12,200	10
A272712506018	SLTflex 125	ZKS 60	125	M14	12,200	10
A272812506018	SLTflex 125	ZKS 60	125	5/8"	12,200	10
A272712508016	SLTflex 125	ZK 80	125	M14	12,200	10
A272812508018	SLTflex 125	ZK 80	125	5/8"	12,200	10
A272712512016	SLTflex 125	ZK 120	125	M14	12,200	10
A272812512018	SLTflex 125	ZK 120	125	5/8"	12,200	10

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

## SLTR Control lamellar flap disc



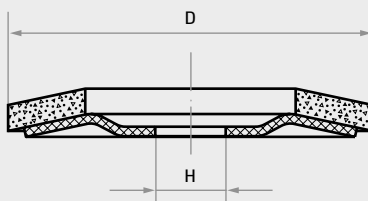
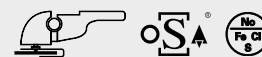
- grinding tool with apertures:  
keep a constant check on how  
your work is progressing
- protect sensitive surfaces against  
damage during grinding

★★★

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27461150401406	SLTR 115 Control	ZK 40 INOX	115	22.23	13,300	10
A27461150601406	SLTR 115 Control	ZK 60 INOX	115	22.23	13,300	10
A27461150801406	SLTR 115 Control	ZK 80 INOX	115	22.23	13,300	10
A27461250401406	SLTR 125 Control	ZK 40 INOX	125	22.23	12,200	10
A27461250601406	SLTR 125 Control	ZK 60 INOX	125	22.23	12,200	10
A27461250801406	SLTR 125 Control	ZK 80 INOX	125	22.23	12,200	10

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

## SLTZ lamellar flap disc



- lamellar flap disc with active  
grinding additives
- outstanding grinding performance
- best results with the special formulation
- outstanding tool life
- suitable for most material
- suitable for deburring, fettling,  
derusting and smoothening
- **Application:** Shipbuilding, steel  
construction, VA stainless steel and  
many other applications

★★★

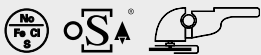
Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27261150401418	SLTZ 115	ZKS 40	115	22.23	13,300	10
A27261150601418	SLTZ 115	ZKS 60	115	22.23	13,300	10
A27261150801418	SLTZ 115	ZKS 80	115	22.23	13,300	10
A27261250401418	SLTZ 125	ZKS 40	125	22.23	12,200	10
A27261250601418	SLTZ 125	ZKS 60	125	22.23	12,200	10
A27261250801418	SLTZ 125	ZKS 80	125	22.23	12,200	10

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



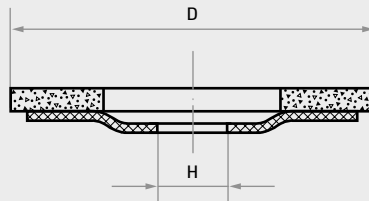
# IMPRESSIVE TOOL LIFE WITH HIGH ERGONOMICS

HIGH-PERFORMANCE LUKAS LAMELLAR FLAP DISCS WITH RECTANGULAR FLAPS



**SLTO<sup>Ceramic4x</sup> / SLTR<sup>Ceramic4x</sup> lamellar flap disc** **NEW**

- ideal for deburring, fettling, derusting, smoothening and weld seam machining
- for use on steel, ship's steel plate, Hardox steel, nickel-based alloys and titanium
- achieves high removal stock rates when rough grinding steel
- with self-sharpening effect thanks to innovative Ceramic4x abrasive grain
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- Glass fibre backing
- the perfect alternative to grinding discs



★★★

Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27251150401444	SLTO 115	Ceramic4x 40		115	22.23	13,300	10
A27251250401444	SLTO 125	Ceramic4x 40		125	22.23	12,200	10
A27251250601444	SLTO 125	Ceramic4x 60		125	22.23	12,200	10
A27251250801444	SLTO 125	Ceramic4x 80		125	22.23	12,200	10
A27231150401544	SLTR 115	Ceramic4x 40		115	22.23	13,300	10
A27231150601444	SLTR 115	Ceramic4x 60		115	22.23	13,300	10
A27231150801444	SLTR 115	Ceramic4x 80		115	22.23	13,300	10
A27231250401544	SLTR 125	Ceramic4x 40		125	22.23	13,300	10
A27231250601544	SLTR 125	Ceramic4x 60		125	22.23	12,200	10
A27231250801544	SLTR 125	Ceramic4x 80		125	22.23	12,200	10
A27231780401544	SLTR 178	Ceramic4x 40		178	22.23	8,500	10
A27231780601444	SLTR 178	Ceramic4x 60		178	22.23	8,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium ● Plastic/Wood



TOOL CHANGING IN NO TIME AT ALL

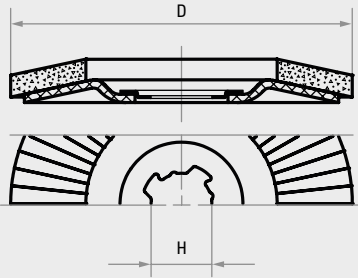
ALL THE BENEFITS OF THE SLTR LAMELLAR FLAP DISC WITH THE INNOVATIVE X-LOCK MOUNTING SYSTEM

Photo: Bosch

**NEW** SLTR X-LOCK lamellar flap disc



★★★



- keyless tool changing in no time at all
- ideal for deburring, fettling, derusting, smoothing and weld seam machining
- always remains sharp throughout the tool life thanks to the multi-layer coating
- good price-to-performance ratio thanks to the rectangular flaps

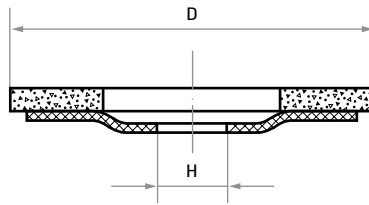
Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A67181250401865	SLTR 125	ZK 40	125	X-LOCK/22.23	12,200	10
A67181250601865	SLTR 125	ZK 60	125	X-LOCK/22.23	12,200	10
A67181250801865	SLTR 125	ZK 80	125	X-LOCK/22.23	12,200	10

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



## SLTO/SLTR lamellar flap disc, zirconia alumina

- achieves high removal rates on hard and tough materials and a long tool life
- for deburring, fettling, derusting, smoothening and weld seam machining
- very good price-to-performance thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing
- the efficient alternative to grinding discs



★★☆

Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27151150401406	SLTO 115	ZK 40		115	22.23	13,300	10
A27151150601406	SLTO 115	ZK 60		115	22.23	13,300	10
A27151150801406	SLTO 115	ZK 80		115	22.23	13,300	10
A27151250401406	SLTO 125	ZK 40		125	22.23	12,200	10
A27151250601406	SLTO 125	ZK 60		125	22.23	12,200	10
A27151250801406	SLTO 125	ZK 80		125	22.23	12,200	10
A27151780361401	SLTO 178	ZK 36		178	22.23	8,500	10
A27151780401401	SLTO 178	ZK 40		178	22.23	8,500	10
A27151781201401	SLTO 178	ZK 120		178	22.23	8,500	10
A27181000401423	SLTR 100	ZK 40		100	16.00	15,300	10
A27181000601423	SLTR 100	ZK 60		100	16.00	15,300	10
A27181000801423	SLTR 100	ZK 80		100	16.00	15300	10
A27181150361406	SLTR 115	ZK 36		115	22.23	13,300	10
A27181150401406	SLTR 115	ZK 40		115	22.23	13,300	10
A27181150601406	SLTR 115	ZK 60		115	22.23	13,300	10
A27181150801406	SLTR 115	ZK 80		115	22.23	13,300	10
A27181151201406	SLTR 115	ZK 120		115	22.23	13,300	10
A27181250361406	SLTR 125	ZK 36		125	22.23	12,200	10
A27181250401406	SLTR 125	ZK 40		125	22.23	12,200	10
A27181250601406	SLTR 125	ZK 60		125	22.23	12,200	10
A27181250801406	SLTR 125	ZK 80		125	22.23	12,200	10
A27181251201406	SLTR 125	ZK 120		125	22.23	12,200	10
A27181500401416	SLTR 150	ZK 40		150	22.23	10,200	10
A27181500601416	SLTR 150	ZK 60		150	22.23	10,200	10
A27181500801416	SLTR 150	ZK 80		150	22.23	10,200	10
A27181780361401	SLTR 178	ZK 36		178	22.23	8,500	10
A27181780401401	SLTR 178	ZK 40		178	22.23	8,500	10
A27181780601401	SLTR 178	ZK 60		178	22.23	8,500	10
A27181780801401	SLTR 178	ZK 80		178	22.23	8,500	10

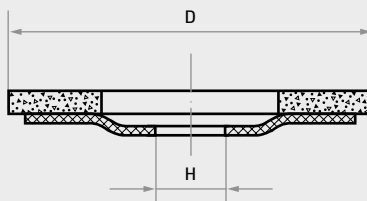
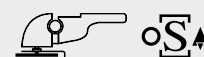
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium



# EFFICIENTLY MACHINE WELD SEAMS WITH REGULAR ALUMINIUM OXIDE

EASY TO USE, MINIMUM VIBRATION AND HIGH CRACK RESISTANCE

## SLTO/SLTR lamellar flap disc, regular aluminium oxide



- the good alternative to grinding discs
- for deburring, fettling, derusting, smoothing and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing

★★★

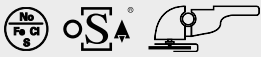
Product number	Description	Grit	Drawing	D mm	H mm	$n_{max}$ rpm	Pack contains
A27151150601400	SLTO 115	NK 60		115	22.23	13,300	10
A27151150801400	SLTO 115	NK 80		115	22.23	13,300	10
A27181150401400	SLTR 115	NK 40		115	22.23	13,300	10
A27181150601400	SLTR 115	NK 60		115	22.23	13,300	10
A27181150801400	SLTR 115	NK 80		115	22.23	13,300	10
A27181151201400	SLTR 115	NK 120		115	22.23	13,300	10
A27181250401400	SLTR 125	NK 40		125	22.23	12,200	10
A27181250601400	SLTR 125	NK 60		125	22.23	12,200	10
A27181250801400	SLTR 125	NK 80		125	22.23	12,200	10
A27181251201400	SLTR 125	NK 120		125	22.23	12,200	10

Recommended for: ● Steel ● Cast material ● Plastic/Wood



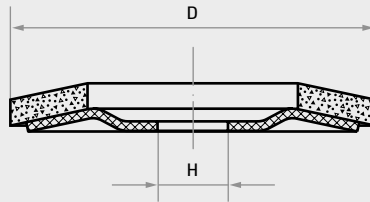
## THE ECONOMICAL BASE-X

ACHIEVE HIGH REMOVAL RATES WITH HARD AND SHARP ZIRCONIA ALUMINA



### SLTO/SLTR BASE-X lamellar flap disc **NEW**

- the economical alternative to grinding discs
- for deburring, fettling, derusting, smoothing and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating
- glass fibre backing



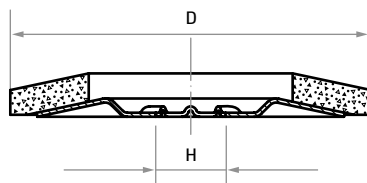
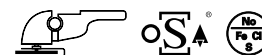
☆☆☆

Product number	Description	Grit	Drawing	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27151150401535	SLTO 115 BASE-X	ZK 40		115	22.23	13,300	10
A27151150601535	SLTO 115 BASE-X	ZK 60		115	22.23	13,300	10
A27151150801535	SLTO 115 BASE-X	ZK 80		115	22.23	13,300	10
A27151151201535	SLTO 115 BASE-X	ZK 120		115	22.23	13,300	10
A27151250401535	SLTO 125 BASE-X	ZK 40		125	22.23	12,200	10
A27151250601535	SLTO 125 BASE-X	ZK 60		125	22.23	12,200	10
A27151250801535	SLTO 125 BASE-X	ZK 80		125	22.23	12,200	10
A27151250801535	SLTO 125 BASE-X	ZK 80		125	22.23	12,200	10
A27181150401535	SLTR 115 BASE-X	ZK 40		115	22.23	13,300	10
A27181150601535	SLTR 115 BASE-X	ZK 60		115	22.23	13,300	10
A27181150801535	SLTR 115 BASE-X	ZK 80		115	22.23	13,300	10
A27181151201535	SLTR 115 BASE-X	ZK 120		115	22.23	13,300	10
A27181250401535	SLTR 125 BASE-X	ZK 40		125	22.23	12,200	10
A27181250601535	SLTR 125 BASE-X	ZK 60		125	22.23	12,200	10
A27181250801535	SLTR 125 BASE-X	ZK 80		125	22.23	12,200	10
A27181251201535	SLTR 125 BASE-X	ZK 120		125	22.23	12,200	10
A27181780401535	SLTR 178 BASE-X	ZK 40		178	22.23	8,500	10
A27181780601535	SLTR 178 BASE-X	ZK 60		178	22.23	8,500	10
A27181780801535	SLTR 178 BASE-X	ZK 80		178	22.23	8,500	10
A27181781201535	SLTR 178 BASE-X	ZK 120		178	22.23	8,500	10

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



## SLTB lamellar flap disc



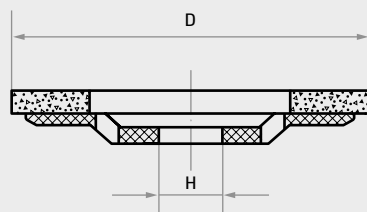
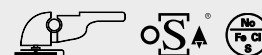
- especially robust lamellar flap disc thanks to the steel backing plate
- well suited for deburring, fettling, derusting, smoothening and weld seam machining
- good heat dissipation for cool grinding
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

★★☆

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A2250115040	SLTB 115	ZK 40	115	22.23	13,300	10
A2250115060	SLTB 115	ZK 60	115	22.23	13,300	10
A2250115080	SLTB 115	ZK 80	115	22.23	13,300	10
A2250125040	SLTB 125	ZK 40	125	22.23	12,200	10
A2250125060	SLTB 125	ZK 60	125	22.23	12,200	10
A2250125080	SLTB 125	ZK 80	125	22.23	12,200	10
A2250178040	SLTB 178	ZK 40	178	22.23	8,500	10
A2250178060	SLTB 178	ZK 60	178	22.23	8,500	10

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

## SLTK lamellar flap disc



- no marking on the workpiece thanks to the practical plastic backing plate
- with integrated cooling slots for cool grinding and minimum reworking
- well suited for deburring, fettling, derusting, smoothening and weld seam machining
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

★★☆

Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27111150401623	SLTK 115	ZK 40	115	22.23	13,300	10
A27111150601623	SLTK 115	ZK 60	115	22.23	13,300	10
A271111250401623	SLTK 125	ZK 40	125	22.23	12,200	10
A271111250601623	SLTK 125	ZK 60	125	22.23	12,200	10

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

# COOLING AND QUICK-CLAMPING THREAD

SLTK LAMELLAR FLAP DISC WITH PRACTICAL PLASTIC BACKING PLATE

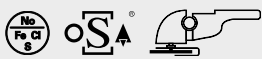
## MINI LAMELLAR FLAP DISC WITH PLASTIC THREAD – TEST IT NOW!

Self-clamping, mini lamellar flap disc for pneumatic angle grinders: all the benefits of LUKAS lamellar flap discs combined with fast, accessory-free tool changing. Also ideal for use with robotics!

FIND OUT ABOUT OUR SELF-CLAMPING MINI LAMELLAR FLAP DISCS ON **PAGE 226**

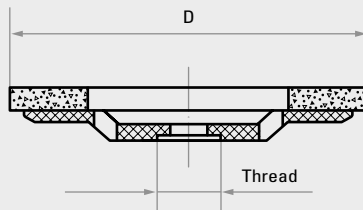


GRINDING AND POLISHING  
(with flexible tools)



## SLTK lamellar flap disc with quick-clamping thread

- with integrated M14 thread for easy mounting on the angle grinder
- no marking on the workpiece thanks to the practical plastic backing plate
- with integrated cooling slots for cool grinding and minimum reworking
- well suited for deburring, fettling, derusting, smoothening and weld seam machining
- very good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating



★★☆

Product number	Description	Grit	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A27111150401723	SLTK 115	ZK 40	115	M14	13,300	10
A27111150601723	SLTK 115	ZK 60	115	M14	13,300	10
A27111250401723	SLTK 125	ZK 40	125	M14	12,200	10
A27111250601723	SLTK 125	ZK 60	125	M14	12,200	10

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

# ALWAYS WITH THE ENVIRONMENT IN MIND

LUKAS HAS BEEN PIONEERING THE USE OF RENEWABLE

RAW MATERIALS FOR MANUFACTURING TOOLS FOR 30 YEARS.



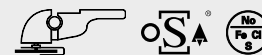
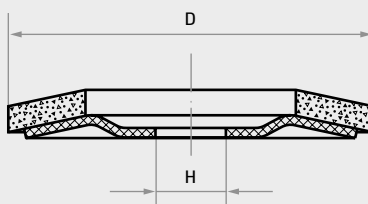
LUKAS NAWAROFLEX® lamellar flap discs have a backing plate made of renewable raw materials. Although made of paper, these special eco-friendly backing plates are nevertheless very sturdy and offer enough stability for hard grinding applications.

As a pioneer in the tool industry in the use of this technology, LUKAS has been relying on NAWAROFLEX® for 30 years, and currently offers three different tools made with renewable raw materials. You can use LUKAS tools with NAWAROFLEX® for deburring, weld seam machining, refining surfaces or for fine grinding, and in doing so work in an environmentally conscious manner.

## SLTC NAWAROFLEX® lamellar flap disc



★★★



- with special zirconia alumina (polyester-based) and active abrasive surface layer
- ideal for machining stainless steel
- for deburring, fettling, derusting, smoothing and weld seam machining
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials
- good price-to-performance ratio thanks to the rectangular flaps
- always remains sharp throughout the tool life thanks to the multi-layer coating

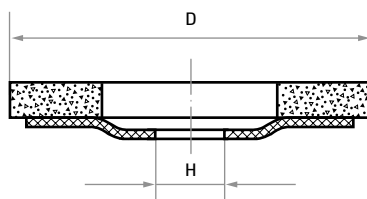
Product number	Description	Grit	D mm	H mm	$n_{max}$ rpm	Pack contains
A27031150360127	SLTC 115	ZKS 36	115	22.23	13,300	10
A27031150400127	SLTC 115	ZKS 40	115	22.23	13,300	10
A27031150500127	SLTC 115	ZKS 50	115	22.23	13,300	10
A27031150600127	SLTC 115	ZKS 60	115	22.23	13,300	10
A27031150800127	SLTC 115	ZKS 80	115	22.23	13,300	10
A27031250400127	SLTC 125	ZKS 40	125	22.23	12,200	10
A27031250600127	SLTC 125	ZKS 60	125	22.23	12,200	10
A27031250800127	SLTC 125	ZKS 80	125	22.23	12,200	10

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



## SLTM NAWAROFLEX® lamellar flap disc

- made from an abrasive cloth and fleece mix for surface enhancement
- can be used without a backing pad on adjustable or low-speed angle grinders
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials



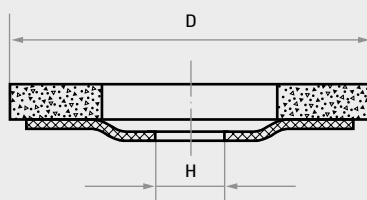
★★☆

Product number	Description	Quality	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27131151040140	SLTM 115	A104/80	NK 100/80	115	22.23	5,300	10
A27131151060140	SLTM 115	A106/150	NK 180/150	115	22.23	5,300	10
A27131151070140	SLTM 115	A107/240	NK 280/240	115	22.23	5,300	10
Recommended use for A qualities: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium							
A27131152040141	SLTM 115	C204/80	SIC 100/80	115	22.23	5,300	10
A27131152060141	SLTM 115	C206/150	SIC 180/150	115	22.23	5,300	10
A27131152070141	SLTM 115	C207/240	SIC 280/240	115	22.23	5,300	10
Recommended use for C qualities: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material							



## SLTV NAWAROFLEX® lamellar flap disc

- made of abrasive fleece for fine grinding, e.g. before polishing
- can be used without a backing pad on adjustable or low-speed angle grinders
- eco-friendly NAWAROFLEX®: backing made of renewable raw materials



★★☆

Product number	Description	Quality	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A27221151040130	SLTV 115	A104	NK 100	115	22.23	5,300	10
A27221151060130	SLTV 115	A106	NK 180	115	22.23	5,300	10
A27221151070130	SLTV 115	A107	NK 280	115	22.23	5,300	10
Recommended use for A qualities: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium							
A27221152060130	SLTV 115	C206	SIC 180	115	22.23	5,300	10
A27221152070130	SLTV 115	C207	SIC 280	115	22.23	5,300	10
A27221153061530	SLTV 115	Z306	ZK 180	115	22.23	5,300	10
A27221153071530	SLTV 115	Z307	ZK 280	115	22.23	5,300	10
Recommended use for C qualities: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material							

NEW

NEW



# FROM FINE GRINDING TO POLISHING

## A SMOOTH TRANSITION WITH LUKAS TOOLS

After the fine grinding, is polishing your next job? LUKAS offers a wide assortment of polishing tools especially designed for fine surface treatment and polishing work. Made of high quality raw materials, LUKAS polishing points, discs, sticks and rolls are precisely tailored to achieve the required degree of polishing for each individual application – through to shiny and mirror-like polishing. LUKAS polishing tools are divided into the groups P1 to P7 according to the respective intended use. You can find further information and the products **from page 97**.

The LUKAS polishing tool range with its huge variety of different shapes allows you to choose the most suitable polishing tools for your specific fine machining (fine and ultra-fine grinding) or polishing requirements. This means that with our tools you can work in an extremely economical and especially effective manner.

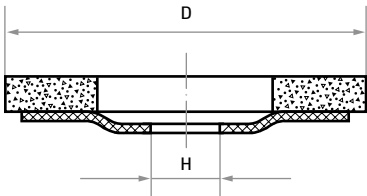
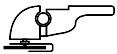
### THE LUKAS POLISHING DISC SET

After fine grinding your surfaces with an angle grinder, you can then easily achieve your desired polishing results with the LUKAS polishing disc set. Just use the different polishing discs from the LUKAS polishing set in sequence. Easily and quickly achieve everything from removing rust to a mirror finish with just a few tool changes and without switching machines. The practical LUKAS polishing disc sets can be found on **pages 118 and 119!**



GRINDING AND POLISHING  
(with flexible tools)

### SLTP polishing disc



- cooler – very efficient for light deburring, cleaning Inox weld seams and surface enhancement
- The fleece fibre design prevents overheating and clogging on the tool.
- minimum edge abrasion for improved productivity
- can be used without a backing pad on adjustable or low-speed angle grinders

★★☆

Product number	Description	D mm	H mm	Type/hardness	n <sub>max</sub> rpm	Pack contains
A271611523	SLTP 115 M	115	22.23	medium	8,300	5
A271611513	SLTP 115 W	115	22.23	soft	8,300	5

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Mounted flap wheels made of abrasive cloth, abrasive fleece and a combination of both

## SFL, MOUNTED FLAP WHEEL MADE OF ABRASIVE CLOTH

These tools comprise individual flaps which are radially fixed around the axis of the tool. They are mainly used on handheld power tools. We offer our mounted flap wheels made of abrasive cloth in the qualities Ceramic, NK, NKE and SIC.

## SFB, SLOTTED FLAP WHEEL

The slits around the circumference of the flaps add greater flexibility compared to a regular mounted flap wheel. This allows the slotted flap wheel to adapt itself even better to the contour of the workpiece.

## SFT, MOUNTED FLAP WHEEL WITH RECESS

These tools are suitable for both face and peripheral grinding.

## SFI AND SFA, MOUNTED FLAP WHEELS MADE OF ABRASIVE CLOTH WITH INTERNAL OR EXTERNAL THREAD INCL. TOOL ADAPTERS

In contrast to the SFL, these mounted flap wheels also have a thread. With the appropriate adapter, the tool can be changed quickly without removing the tool adapter from the power tool. The adapter extends the shaft and optimises set-up time.

## SFV, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE

These tools comprise single fleece flaps fixed radially around the axis of the tool; they are available in regular aluminium oxide (A), silicon carbide (C) and zirconia aluminium oxide (Z). SFV are mainly used on handheld power tools.

## SFR, MOUNTED FLAP WHEEL MADE OF ABRASIVE FLEECE DISCS

These special tools are comprised of individual elastic fleece discs staked one upon the other. This makes them particularly suitable for machining profiled workpieces.

## SFM, MOUNTED FLAP WHEEL MADE OF COMBINED ABRASIVE FLEECE AND CLOTH

These tools comprise single fleece and cloth flaps radially fixed around the axis of the tool; they are available in regular aluminium oxide (A) and silicon carbide (C). The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared with type SFV. SFM are mainly used on handheld power tools.

## SFM, MOUNTED FLAP WHEEL MADE OF TF MATERIAL

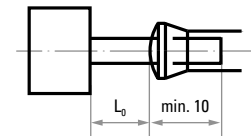
These tools are specially designed for use with non-rusting materials. The abrasive fleece with its reinforced backing guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotating direction of the tool!

### Application examples:

- Smoothing
- Derusting
- Fettling
- Deburring
- Surface grinding
- Texturing
- Beveling

### SPEED

The stated maximum permissible speeds apply for a maximum open shank length  $L_0$  of 20 mm.



### Application examples:

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

### Application examples:

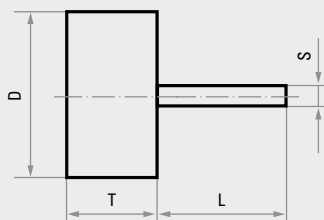
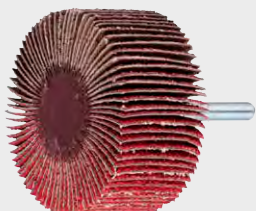
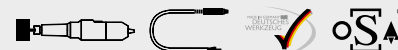
- Cleaning
- Derusting
- Pre-grinding
- Texturing
- Roughing

Quality	Abrasive particles	Grit	Surface
A104	Regular aluminium oxide	NK 100	medium
A106	Regular aluminium oxide	NK 180	fine
A107	Regular aluminium oxide	NK 280	very fine
C204	Silicon carbide	SIC 100	medium
C206	Silicon carbide	SIC 180	fine
C207	Silicon carbide	SIC 280	very fine
C208	Silicon carbide	SIC 400	ultra-fine
Z304	Zirconia alumina	ZK 100	medium
Z306	Zirconia alumina	ZK 180	fine
Z307	Zirconia alumina	ZK 280	very fine

# CERAMIC MOUNTED FLAP WHEELS FROM LUKAS FOR THE MOST PRECISE APPLICATIONS

EFFICIENT SURFACE GRINDING WITH SELF-SHARPENING EFFECT AND EXCEPTIONAL TOOL LIFE

## SFL Ceramic mounted flap wheel



- especially high stock removal thanks to self-sharpening ceramic grain
- robust design for a long tool life
- used as a handheld tool, ideal for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling

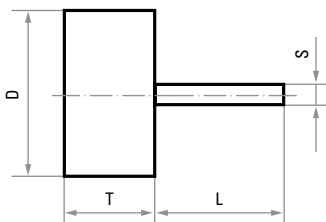
★★★

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2214020206080	SFL 02020.06	Ceramic 80	20	20	6	40	20,000	38,200	10
A2214020206120	SFL 02020.06	Ceramic 120	20	20	6	40	20,000	38,200	10
A2214030106060	SFL 03010.06	Ceramic 60	30	10	6	40	16,000	25,400	10
A2214030106080	SFL 03010.06	Ceramic 80	30	10	6	40	16,000	25,400	10
A2214030106120	SFL 03010.06	Ceramic 120	30	10	6	40	16,000	25,400	10
A2214040206060	SFL 04020.06	Ceramic 60	40	20	6	40	12,000	19,100	10
A2214040206080	SFL 04020.06	Ceramic 80	40	20	6	40	12,000	19,100	10
A2214040206120	SFL 04020.06	Ceramic 120	40	20	6	40	12,000	19,100	10
A2214060156080	SFL 06015.06	Ceramic 80	60	15	6	40	8,000	12,700	10
A2214060156120	SFL 06015.06	Ceramic 120	60	15	6	40	8,000	12,700	10
A2214060306060	SFL 06030.06	Ceramic 60	60	30	6	40	8,000	12,700	10
A2214060306080	SFL 06030.06	Ceramic 80	60	30	6	40	8,000	12,700	10
A2214060306120	SFL 06030.06	Ceramic 120	60	30	6	40	8,000	12,700	10

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



- good tool life on different materials for rough and fine grinding
- regular aluminium oxide for cost-effective applications
- used as a handheld tool, ideal for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling



## SFL mounted flap wheel



Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200010103080	SFL 01010.03	NK 80	10	10	3	40	26,000	35,000	10
A2200010103120	SFL 01010.03	NK 120	10	10	3	40	26,000	35,000	10
A2200010103150	SFL 01010.03	NK 150	10	10	3	40	26,000	35,000	10
A2200010103240	SFL 01010.03	NK 240	10	10	3	40	26,000	35,000	10
A2200010153080	SFL 01015.03	NK 80	10	15	3	40	24,000	35,000	10
A2200015103080	SFL 01510.03	NK 80	15	10	3	40	24,000	35,000	10
A2200015103150	SFL 01510.03	NK 150	15	10	3	40	24,000	35,000	10
A2200015106080	SFL 01510.06	NK 80	15	10	6	40	24,000	35,000	10
A2200015153080	SFL 01515.03	NK 80	15	15	3	40	24,000	35,000	10
A2200015153120	SFL 01515.03	NK 120	15	15	3	40	24,000	35,000	10
A2200015153150	SFL 01515.03	NK 150	15	15	3	40	24,000	35,000	10
A2200020056120	SFL 02005.06	NK 120	20	5	6	40	20,000	38,200	10
A2200020103080	SFL 02010.03	NK 80	20	10	3	40	20,000	28,000	10
A2200020103120	SFL 02010.03	NK 120	20	10	3	40	20,000	28,000	10
A2200020103150	SFL 02010.03	NK 150	20	10	3	40	20,000	28,000	10
A2200020103320	SFL 02010.03	NK 320	20	10	3	40	20,000	28,000	10
A2200020106080	SFL 02010.06	NK 80	20	10	6	40	20,000	38,200	10
A2200020106120	SFL 02010.06	NK 120	20	10	6	40	20,000	38,200	10
A2200020156060	SFL 02015.06	NK 60	20	15	6	40	20,000	38,200	10
A2200020156080	SFL 02015.06	NK 80	20	15	6	40	20,000	38,200	10
A2200020156120	SFL 02015.06	NK 120	20	15	6	40	20,000	38,200	10
A2200020156150	SFL 02015.06	NK 150	20	15	6	40	20,000	38,200	10
A2200020156240	SFL 02015.06	NK 240	20	15	6	40	20,000	38,200	10
A2200020206060	SFL 02020.06	NK 60	20	20	6	40	20,000	38,200	10
A2200020206080	SFL 02020.06	NK 80	20	20	6	40	20,000	38,200	10
A2200025053120	SFL 02505.03	NK 120	25	5	3	40	16,000	18,000	10
A2200025103080	SFL 02510.03	NK 80	25	10	3	40	16,000	18,000	10
A2200025103120	SFL 02510.03	NK 120	25	10	3	40	16,000	18,000	10
A2200025103150	SFL 02510.03	NK 150	25	10	3	40	16,000	18,000	10
A2200025106080	SFL 02510.06	NK 80	25	10	6	40	16,000	30,600	10
A2200025106120	SFL 02510.06	NK 120	25	10	6	40	16,000	30,600	10
A2200025156080	SFL 02515.06	NK 80	25	15	6	40	16,000	30,600	10
A2200025156120	SFL 02515.06	NK 120	25	15	6	40	16,000	30,600	10
A2200025156150	SFL 02515.06	NK 150	25	15	6	40	16,000	30,600	10
A2200025206080	SFL 02520.06	NK 80	25	20	6	40	16,000	30,600	10
A2200025206120	SFL 02520.06	NK 120	25	20	6	40	16,000	30,600	10
A2200025256080	SFL 02525.06	NK 80	25	25	6	40	16,000	30,600	10
A2200025256150	SFL 02525.06	NK 150	25	25	6	40	16,000	30,600	10
A2200030053060	SFL 03005.03	NK 60	30	5	3	40	16,000	18,000	10
A2200030053080	SFL 03005.03	NK 80	30	5	3	40	16,000	18,000	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium									

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200030053120	SFL 03005.03	NK 120	30	5	3	40	16,000	18,000	10
A2200030053150	SFL 03005.03	NK 150	30	5	3	40	16,000	18,000	10
A2200030053240	SFL 03005.03	NK 240	30	5	3	40	16,000	18,000	10
A2200030053320	SFL 03005.03	NK 320	30	5	3	40	16,000	18,000	10
A2200030056060	SFL 03005.06	NK 60	30	5	6	40	16,000	25,400	10
A2200030056080	SFL 03005.06	NK 80	30	5	6	40	16,000	25,400	10
A2200030056100	SFL 03005.06	NK 100	30	5	6	40	16,000	25,400	10
A2200030056120	SFL 03005.06	NK 120	30	5	6	40	16,000	25,400	10
A2200030056150	SFL 03005.06	NK 150	30	5	6	40	16,000	25,400	10
A2200030056180	SFL 03005.06	NK 180	30	5	6	40	16,000	25,400	10
A2200030056240	SFL 03005.06	NK 240	30	5	6	40	16,000	25,400	10
A2200030056320	SFL 03005.06	NK 320	30	5	6	40	16,000	25,400	10
A2200030103060	SFL 03010.03	NK 60	30	10	3	40	16,000	18,000	10
A2200030103080	SFL 03010.03	NK 80	30	10	3	40	16,000	18,000	10
A2200030103120	SFL 03010.03	NK 120	30	10	3	40	16,000	18,000	10
A2200030103150	SFL 03010.03	NK 150	30	10	3	40	16,000	18,000	10
A2200030103240	SFL 03010.03	NK 240	30	10	3	40	16,000	18,000	10
A2200030103320	SFL 03010.03	NK 320	30	10	3	40	16,000	18,000	10
A2200030106060	SFL 03010.06	NK 60	30	10	6	40	16,000	25,400	10
A2200030106080	SFL 03010.06	NK 80	30	10	6	40	16,000	25,400	10
A2200030106120	SFL 03010.06	NK 120	30	10	6	40	16,000	25,400	10
A2200030106150	SFL 03010.06	NK 150	30	10	6	40	16,000	25,400	10
A2200030106240	SFL 03010.06	NK 240	30	10	6	40	16,000	25,400	10
A2200030106320	SFL 03010.06	NK 320	30	10	6	40	16,000	25,400	10
A2200030156060	SFL 03015.06	NK 60	30	15	6	40	16,000	25,400	10
A2200030156080	SFL 03015.06	NK 80	30	15	6	40	16,000	25,400	10
A2200030156120	SFL 03015.06	NK 120	30	15	6	40	16,000	25,400	10
A2200030156150	SFL 03015.06	NK 150	30	15	6	40	16,000	25,400	10
A2200030206040	SFL 03020.06	NK 40	30	20	6	40	16,000	25,400	10
A2200030206060	SFL 03020.06	NK 60	30	20	6	40	16,000	25,400	10
A2200030206080	SFL 03020.06	NK 80	30	20	6	40	16,000	25,400	10
A2200030206120	SFL 03020.06	NK 120	30	20	6	40	16,000	25,400	10
A2200040056100	SFL 04005.06	NK 100	40	5	6	40	12,200	19,100	10
A2200040103080	SFL 04010.03	NK 80	40	10	3	40	12,000	14,000	10
A2200040103150	SFL 04010.03	NK 150	40	10	3	40	12,000	14,000	10
A2200040106060	SFL 04010.06	NK 60	40	10	6	40	12,000	19,100	10
A2200040106080	SFL 04010.06	NK 80	40	10	6	40	12,000	19,100	10
A2200040106120	SFL 04010.06	NK 120	40	10	6	40	12,000	19,100	10
A2200040106150	SFL 04010.06	NK 150	40	10	6	40	12,000	19,100	10
A2200040106180	SFL 04010.06	NK 180	40	10	6	40	12,000	19,100	10
A2200040106240	SFL 04010.06	NK 240	40	10	6	40	12,000	19,100	10
A2200040106320	SFL 04010.06	NK 320	40	10	6	40	12,000	19,100	10
A2200040156040	SFL 04015.06	NK 40	40	15	6	40	12,000	19,100	10
A2200040156060	SFL 04015.06	NK 60	40	15	6	40	12,000	19,100	10
A2200040156080	SFL 04015.06	NK 80	40	15	6	40	12,000	19,100	10
A2200040156120	SFL 04015.06	NK 120	40	15	6	40	12,000	19,100	10
A2200040156150	SFL 04015.06	NK 150	40	15	6	40	12,000	19,100	10
A2200040156240	SFL 04015.06	NK 240	40	15	6	40	12,000	19,100	10
A2200040156320	SFL 04015.06	NK 320	40	15	6	40	12,000	19,100	10
Recommended for: <span style="color: #0070C0;">●</span> Inox/Steel <span style="color: #808080;">●</span> Steel <span style="color: #FF8C00;">●</span> Aluminium <span style="color: #8B0000;">●</span> Cast material <span style="color: #FFD700;">●</span> Plastic/Wood <span style="color: #4682B4;">●</span> Titanium									



Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200040206040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	10
A2200040206060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	10
A2200040206080	SFL 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A2200040206120	SFL 04020.06	NK 120	40	20	6	40	12,000	19,100	10
A2200040206150	SFL 04020.06	NK 150	40	20	6	40	12,000	19,100	10
A2200040206240	SFL 04020.06	NK 240	40	20	6	40	12,000	19,100	10
A2200040206320	SFL 04020.06	NK 320	40	20	6	40	12,000	19,100	10
A2200040306040	SFL 04030.06	NK 40	40	30	6	40	12,000	19,100	10
A2200040306060	SFL 04030.06	NK 60	40	30	6	40	12,000	19,100	10
A2200040306080	SFL 04030.06	NK 80	40	30	6	40	12,000	19,100	10
A2200050106060	SFL 05010.06	NK 60	50	10	6	40	9,000	15,300	10
A2200050106080	SFL 05010.06	NK 80	50	10	6	40	9,000	15,300	10
A2200050106100	SFL 05010.06	NK 100	50	10	6	40	9,000	15,300	10
A2200050106120	SFL 05010.06	NK 120	50	10	6	40	9,000	15,300	10
A2200050106150	SFL 05010.06	NK 150	50	10	6	40	9,000	15,300	10
A2200050106240	SFL 05010.06	NK 240	50	10	6	40	9,000	15,300	10
A2200050156040	SFL 05015.06	NK 40	50	15	6	40	9,000	15,300	10
A2200050156060	SFL 05015.06	NK 60	50	15	6	40	9,000	15,300	10
A2200050156080	SFL 05015.06	NK 80	50	15	6	40	9,000	15,300	10
A2200050156120	SFL 05015.06	NK 120	50	15	6	40	9,000	15,300	10
A2200050156150	SFL 05015.06	NK 150	50	15	6	40	9,000	15,300	10
A2200050156240	SFL 05015.06	NK 240	50	15	6	40	9,000	15,300	10
A2200050156320	SFL 05015.06	NK 320	50	15	6	40	9,000	15,300	10
A2200050206040	SFL 05020.06	NK 40	50	20	6	40	9,000	15,300	10
A2200050206060	SFL 05020.06	NK 60	50	20	6	40	9,000	15,300	10
A2200050206080	SFL 05020.06	NK 80	50	20	6	40	9,000	15,300	10
A2200050206120	SFL 05020.06	NK 120	50	20	6	40	9,000	15,300	10
A2200050206150	SFL 05020.06	NK 150	50	20	6	40	9,000	15,300	10
A2200050206240	SFL 05020.06	NK 240	50	20	6	40	9,000	15,300	10
A2200050206320	SFL 05020.06	NK 320	50	20	6	40	9,000	15,300	10
A2200050306040	SFL 05030.06	NK 40	50	30	6	40	9,000	15,300	10
A2200050306060	SFL 05030.06	NK 60	50	30	6	40	9,000	15,300	10
A2200050306080	SFL 05030.06	NK 80	50	30	6	40	9,000	15,300	10
A2200050306120	SFL 05030.06	NK 120	50	30	6	40	9,000	15,300	10
A2200050306150	SFL 05030.06	NK 150	50	30	6	40	9,000	15,300	10
A2200050306320	SFL 05030.06	NK 320	50	30	6	40	9,000	15,300	10
A2200060106060	SFL 06010.06	NK 60	60	10	6	40	8,000	12,700	10
A2200060106080	SFL 06010.06	NK 80	60	10	6	40	8,000	12,700	10
A2200060106100	SFL 06010.06	NK 100	60	10	6	40	8,000	12,700	10
A2200060156040	SFL 06015.06	NK 40	60	15	6	40	8,000	12,700	10
A2200060156060	SFL 06015.06	NK 60	60	15	6	40	8,000	12,700	10
A2200060156080	SFL 06015.06	NK 80	60	15	6	40	8,000	12,700	10
A2200060156120	SFL 06015.06	NK 120	60	15	6	40	8,000	12,700	10
A2200060156150	SFL 06015.06	NK 150	60	15	6	40	8,000	12,700	10
A2200060156240	SFL 06015.06	NK 240	60	15	6	40	8,000	12,700	10
A2200060156320	SFL 06015.06	NK 320	60	15	6	40	8,000	12,700	10
A2200060206040	SFL 06020.06	NK 40	60	20	6	40	8,000	12,700	10
A2200060206060	SFL 06020.06	NK 60	60	20	6	40	8,000	12,700	10
A2200060206080	SFL 06020.06	NK 80	60	20	6	40	8,000	12,700	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● TitaniumGRINDING AND POLISHING  
(with flexible tools)



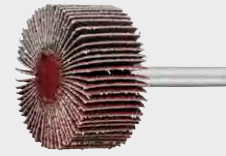
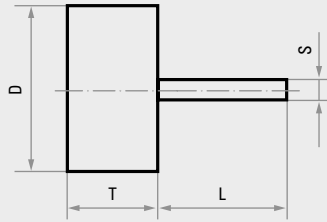
Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200060206120	SFL 06020.06	NK 120	60	20	6	40	8,000	12,700	10
A2200060206150	SFL 06020.06	NK 150	60	20	6	40	8,000	12,700	10
A2200060206240	SFL 06020.06	NK 240	60	20	6	40	8,000	12,700	10
A2200060206320	SFL 06020.06	NK 320	60	20	6	40	8,000	12,700	10
A2200060306040	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	10
A2200060306060	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	10
A2200060306080	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	10
A2200060306100	SFL 06030.06	NK 100	60	30	6	40	8,000	12,700	10
A2200060306120	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	10
A2200060306150	SFL 06030.06	NK 150	60	30	6	40	8,000	12,700	10
A2200060306240	SFL 06030.06	NK 240	60	30	6	40	8,000	12,700	10
A2200060306320	SFL 06030.06	NK 320	60	30	6	40	8,000	12,700	10
A2200060406040	SFL 06040.06	NK 40	60	40	6	40	8,000	12,700	10
A2200060406060	SFL 06040.06	NK 60	60	40	6	40	8,000	12,700	10
A2200060406080	SFL 06040.06	NK 80	60	40	6	40	8,000	12,700	10
A2200060406120	SFL 06040.06	NK 120	60	40	6	40	8,000	12,700	10
A2200060406150	SFL 06040.06	NK 150	60	40	6	40	8,000	12,700	10
A2200060406240	SFL 06040.06	NK 240	60	40	6	40	8,000	12,700	10
A2200060406320	SFL 06040.06	NK 320	60	40	6	40	8,000	12,700	10
A2200060506040	SFL 06050.06	NK 40	60	50	6	40	8,000	8,500	10
A2200060506060	SFL 06050.06	NK 60	60	50	6	40	8,000	8,500	10
A2200060506080	SFL 06050.06	NK 80	60	50	6	40	8,000	8,500	10
A2200060506120	SFL 06050.06	NK 120	60	50	6	40	8,000	8,500	10
A2200060506150	SFL 06050.06	NK 150	60	50	6	40	8,000	8,500	10
A2200060506240	SFL 06050.06	NK 240	60	50	6	40	8,000	8,500	10
A2200080156060	SFL 08015.06	NK 60	80	15	6	40	6,000	9,500	10
A2200080156080	SFL 08015.06	NK 80	80	15	6	40	6,000	9,500	10
A2200080156120	SFL 08015.06	NK 120	80	15	6	40	6,000	9,500	10
A2200080156240	SFL 08015.06	NK 240	80	15	6	40	6,000	9,500	10
A2200080156320	SFL 08015.06	NK 320	80	15	6	40	6,000	9,500	10
A2200080206060	SFL 08020.06	NK 60	80	20	6	40	6,000	9,500	10
A2200080206080	SFL 08020.06	NK 80	80	20	6	40	6,000	9,500	10
A2200080306040	SFL 08030.06	NK 40	80	30	6	40	6,000	9,500	10
A2200080306060	SFL 08030.06	NK 60	80	30	6	40	6,000	9,500	10
A2200080306080	SFL 08030.06	NK 80	80	30	6	40	6,000	9,500	10
A2200080306120	SFL 08030.06	NK 120	80	30	6	40	6,000	9,500	10
A2200080306150	SFL 08030.06	NK 150	80	30	6	40	6,000	9,500	10
A2200080306320	SFL 08030.06	NK 320	80	30	6	40	6,000	9,500	10
A2200080406060	SFL 08040.06	NK 60	80	40	6	40	6,000	9,500	10
A2200080406080	SFL 08040.06	NK 80	80	40	6	40	6,000	9,500	10
A2200080506040	SFL 08050.06	NK 40	80	50	6	40	6,000	7,500	10
A2200080506060	SFL 08050.06	NK 60	80	50	6	40	6,000	7,500	10
A2200080506080	SFL 08050.06	NK 80	80	50	6	40	6,000	7,500	10
A2200080506120	SFL 08050.06	NK 120	80	50	6	40	6,000	7,500	10
A2200080506150	SFL 08050.06	NK 150	80	50	6	40	6,000	7,500	10
A2200080506240	SFL 08050.06	NK 240	80	50	6	40	6,000	7,500	10
A2200080506320	SFL 08050.06	NK 320	80	50	6	40	6,000	7,500	10
A2200100408040	SFL 10040.08	NK 40	100	40	8	40	5,000	7,500	10
A2200100508080	SFL 10050.08	NK 80	100	50	8	40	5,000	7,500	10
A2200100508150	SFL 10050.08	NK 150	100	50	8	40	5,000	7,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



## SFL Base-X mounted flap wheel

- for rough and fine grinding of many different materials
- used as a handheld tool, good for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- good price-to-performance ratio with regular aluminium oxide



★☆☆

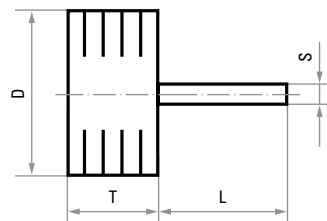
Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2230030106060	SFL 03010.06	NK 60	30	10	6	40	16,000	18,000	20
A2230030106080	SFL 03010.06	NK 80	30	10	6	40	16,000	18,000	20
A2230030106120	SFL 03010.06	NK 120	30	10	6	40	16,000	18,000	20
A2230030106150	SFL 03010.06	NK 150	30	10	6	40	16,000	18,000	20
A2230040156080	SFL 04015.06	NK 80	40	15	6	40	12,000	19,100	20
A2230040156120	SFL 04015.06	NK 120	40	15	6	40	12,000	19,100	20
A2230040156150	SFL 04015.06	NK 150	40	15	6	40	12,000	19,100	20
A2230040206040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	20
A2230040206060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	20
A2230050106060	SFL 05010.06	NK 60	50	10	6	40	9,000	15,300	20
A2230050106080	SFL 05010.06	NK 80	50	10	6	40	9,000	15,300	20
A2230050106120	SFL 05010.06	NK 120	50	10	6	40	9,000	15,300	20
A2230050106150	SFL 05010.06	NK 150	50	10	6	40	9,000	15,300	20
A2230050206060	SFL 05020.06	NK 60	50	20	6	40	9,000	15,300	20
A2230050206080	SFL 05020.06	NK 80	50	20	6	40	9,000	15,300	20
A2230060306040	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	20
A2230060306060	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	20
A2230060306080	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	20
A2230060306120	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	20
A2230060306150	SFL 06030.06	NK 150	60	30	6	40	8,000	12,700	20

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

GRINDING AND POLISHING  
(with flexible tools)

## SFB slotted flap wheel

- slitted flaps for greater flexibility
- adapts itself perfectly to the contours of the workpiece
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling

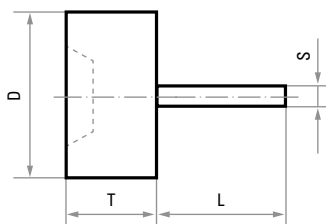


★★★

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2220040206080	SFB 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A2220050206080	SFB 05020.06	NK 80	50	20	6	40	9,000	15,300	10
A2220050306120	SFB 05030.06	NK 120	50	30	6	40	9,000	15,300	10
A2220060306080	SFB 06030.06	NK 80	60	30	6	40	8,000	12,700	10
A2220060306120	SFB 06030.06	NK 120	60	30	6	40	8,000	12,700	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

## SFT mounted flap wheel with recess



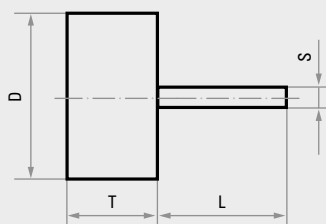
- mounted flap wheels with recess: optimised for face and peripheral grinding
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials

★★★

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A3100040306060	SFT 04030.06	NK 60	40	30	6	40	12,000	19,100	10
A3100040306080	SFT 04030.06	NK 80	40	30	6	40	12,000	19,100	10
A3100040306150	SFT 04030.06	NK 150	40	30	6	40	12,000	19,100	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

## SFT mounted flap wheel for stainless steel



- regular aluminium oxide with active abrasive surface layer
- optimised for use on stainless steel
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling

★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2201030103120	SFE 03010.03	NKE 120	30	10	3	40	16,000	18,000	10
A2201030106060	SFE 03010.06	NKE 60	30	10	6	40	16,000	25,400	10
A2201030106080	SFE 03010.06	NKE 80	30	10	6	40	16,000	25,400	10
A2201030106150	SFE 03010.06	NKE 150	30	10	6	40	16,000	25,400	10
A2201040156060	SFE 04015.06	NKE 60	40	15	6	40	12,000	19,100	10
A2201040156080	SFE 04015.06	NKE 80	40	15	6	40	12,000	19,100	10
A2201040156120	SFE 04015.06	NKE 120	40	15	6	40	12,000	19,100	10
A2201060206080	SFE 06020.06	NKE 80	60	20	6	40	8,000	12,700	10
A2201060306060	SFE 06030.06	NKE 60	60	30	6	40	8,000	12,700	10
A2201060306120	SFE 06030.06	NKE 120	60	30	6	40	8,000	12,700	10
A2201080306080	SFE 08030.06	NKE 80	80	30	6	40	6,000	9,500	10
A2201080506080	SFE 08050.06	NKE 80	80	50	6	40	6,000	7,500	10

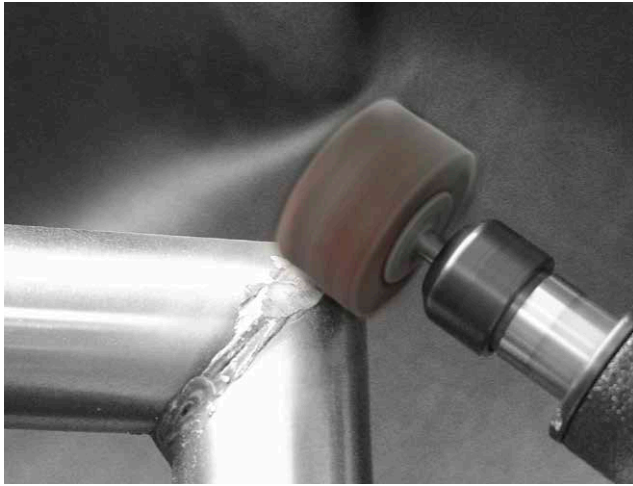
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

# INNOVATIVE TOOLS FOR THE AEROSPACE INDUSTRY

## PRECISION TOOLS FOR THE MOST DEMANDING REQUIREMENTS

LUKAS has been following the developments in the aerospace industry for some considerable time. Today, we are the internationally acknowledged specialist for innovative solutions and the manufacture of high-performance tools for the aerospace industry. We are familiar with the industry's special

requirements, and have developed highly specialised tool solutions. 10,000 special solutions and numerous innovations are in use worldwide – not only our own, but above all your products will always be ready for whatever the future holds.



### HIGH-TECH TOOLS

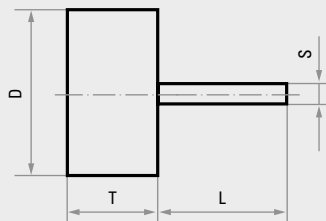
Machining high-tech materials used in the aerospace industry, such as aluminium, titanium, nickel-based alloys or composite materials, requires high-tech tools of the utmost reliability. LUKAS tools for the aerospace industry, e.g. with silicon carbide, can handle the most demanding requirements for reliability, durability and efficiency.

It all comes down to ongoing optimisation of their quality and economic efficiency. The cost-saving potential from selecting the right tool, one that is perfectly suited for the high-tech materials which require processing, also plays a key role. Our goal: the best performance for you!

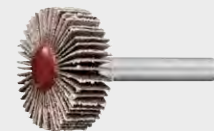
Discover more tools with silicon carbide for the aerospace industry in all the LUKAS product range.



- special quality, e.g. for the aerospace industry
- ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- used as a handheld tool, suitable for smoothening, derusting, fettling, deburring, surface grinding, texturing and bevelling



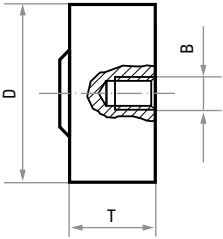
### SFC mounted flap wheel, silicon carbide



★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2202030106080	SFC 03010.06	SIC 80	30	10	6	40	16,000	25,400	10
A2202030106150	SFC 03010.06	SIC 150	30	10	6	40	16,000	25,400	10
A2202040156080	SFC 04015.06	SIC 80	40	15	6	40	12,000	19,100	10
A2202060206080	SFC 06020.06	SIC 80	60	20	6	40	8,000	12,700	10
A2202060206120	SFC 06020.06	SIC 120	60	20	6	40	8,000	12,700	10
A2202060306120	SFC 06030.06	SIC 120	60	30	6	40	8,000	12,700	10
Recommended for: <span style="color: orange;">●</span> Aluminium <span style="color: green;">●</span> Stone/Construction material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: grey;">●</span> Titanium <span style="color: blue;">●</span> Inox/Steel <span style="color: lightgrey;">●</span> Steel <span style="color: red;">●</span> Cast material									

SFI mounted flap wheel with internal thread



★★☆

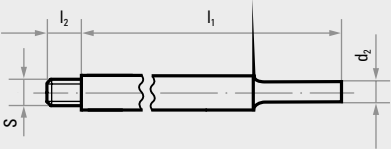
- machine difficult-to-reach areas with the suitable long shank
- thread connection for fast tool changing
- used as a handheld tool, suitable for smoothing, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adapter (see below).

Product number	Description	Grit	D mm	T mm	B Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	matching tool adapter	Pack contains
A2207030050120	SFI 03005.M4	NK 120	30	5	M4	16,000	18,000	WADI 0404	10
A2207030100120	SFI 03010.M4	NK 120	30	10	M4	16,000	18,000	WADI 0407	10
A2207030100150	SFI 03010.M4	NK 150	30	10	M4	16,000	18,000	WADI 0407	10
A2207040150080	SFI 04015.M6	NK 80	40	15	M6	10,000	10,000	WADI 0609	10
A2207040150120	SFI 04015.M6	NK 120	40	15	M6	10,000	10,000	WADI 0609	10
A2207050200080	SFI 05020.M6	NK 80	50	20	M6	7,500	7,500	WADI 0612	10

Recommended for: Inox/Steel Steel Aluminium Cast material Plastic/Wood Titanium

GRINDING AND POLISHING (with flexible tools)

Tool adapters for SFI mounted flap wheels



★★☆

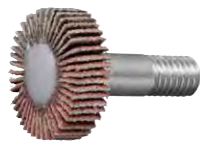
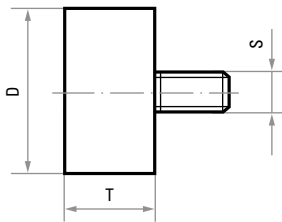
Product number	Description	d <sub>1</sub> mm	l <sub>1</sub> mm	S Thread	l <sub>2</sub> mm	Pack contains
A36300404	WADI 0404	6	80	M4	4	1
A36300407	WADI 0407	6	80	M4	7	1
A36300609	WADI 0609	6	100	M6	9	1
A36300612	WADI 0612	6	100	M6	12	1





SFA mounted flap wheel with external thread

- machine difficult-to-reach areas with the suitable long shank
- thread connection for fast tool changing
- used as a handheld tool, suitable for smoothening, derusting, fettling, deburring, surface grinding, texturing and bevelling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adapter (see below).

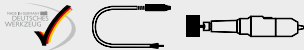


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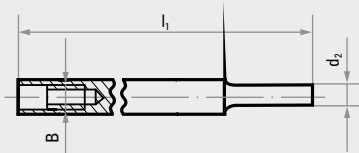
Product number	Description	Grit	D mm	T mm	S Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200015055150	SFA 01505.M5	NK 150	15	5	M5	16,000	18,000	10
A2200015055240	SFA 01505.M5	NK 240	15	5	M5	16,000	18,000	10
A2200020055150	SFA 02005.M5	NK 150	20	5	M5	16,000	18,000	10
A2200020055240	SFA 02005.M5	NK 240	20	5	M5	16,000	18,000	10
A2200030055120	SFA 03005.M5	NK 120	30	5	M5	16,000	18,000	10
A2200030055150	SFA 03005.M5	NK 150	30	5	M5	16,000	18,000	10
A2200030055240	SFA 03005.M5	NK 240	30	5	M5	16,000	18,000	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

GRINDING AND POLISHING  
(with flexible tools)



Tool adapter for SFA mounted flap wheels



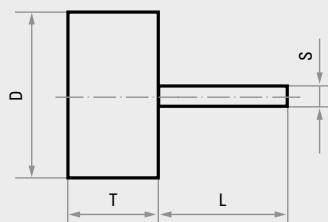
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Product number	Description	d <sub>2</sub> mm	l <sub>1</sub> mm	B Thread	Pack contains
A36300518	WADA 05	6	100	M5	1

# DEBURR EVEN THE SMALLEST BORES

LUKAS MINI FLAP WHEELS FOR FLEXIBLE AND FINE WORK

## MFS mini flap wheel



- deburring bores
- manufacturing and cleaning of glass products
- internal pipe machining
- machining aluminium tyre rims
- machining bores in turbine blades
- versatile special applications

★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2205015106150	MFS 01510.06	NK 150	15	10	6	40	18,000	10
A2205015106150001	MFS 01510.06	NK 150	15	10	6	100	18,000	10
A2205015306150	MFS 01530.06	NK 150	15	30	6	40	18,000	10
A2205015306150001	MFS 01530.06	NK 150	15	30	6	100	18,000	10
A2205020106150	MFS 02010.06	NK 150	20	10	6	40	18,000	10
A2205020106150001	MFS 02010.06	NK 150	20	10	6	100	18,000	10
A2205020306150	MFS 02030.06	NK 150	20	30	6	40	18,000	10
A2205020306150001	MFS 02030.06	NK 150	20	30	6	100	18,000	10
A2205025106150	MFS 02510.06	NK 150	25	10	6	40	18,000	10
A2205025106150001	MFS 02510.06	NK 150	25	10	6	100	18,000	10
A2205025306150	MFS 02530.06	NK 150	25	30	6	40	18,000	10
A2205025306150001	MFS 02530.06	NK 150	25	30	6	100	18,000	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								



### SAFETY INFORMATION

To safely use mini flap wheels with a long shan, they must be placed against the workpiece or inserted into bores or channels

before starting up the power tool. Contact with the workpiece must be assured until the power tool is switched off.

# LUKAS MOUNTED FLAP WHEELS MADE OF ABRASIVE FLEECE

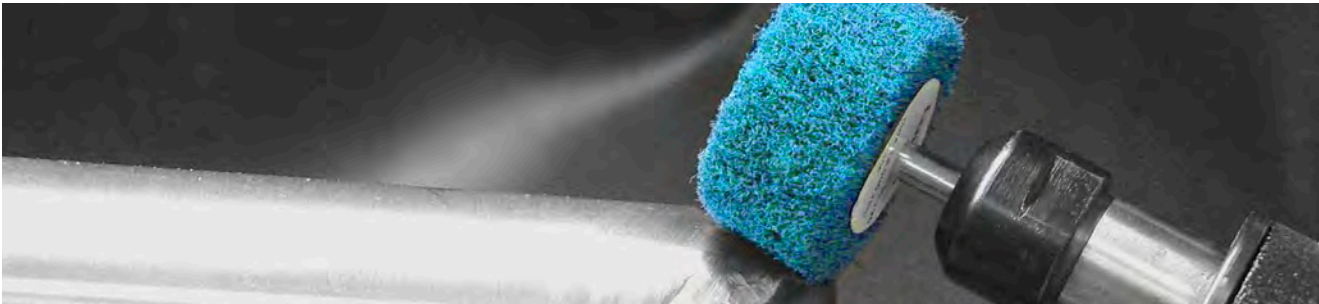
READY FOR EVERY WORK SCENARIO

The fleece flaps or discs of the LUKAS mounted flap wheels with abrasive fleece are made with regular aluminium oxide, zirconia alumina or silicon carbide. This means that LUKAS can cover a broad spectrum of machining materials from steel and titanium through to ceramics and tungsten carbide. Different designs allow you to specify the application even further.

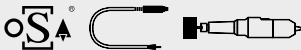
Abrasive fleece is probably the most flexible of all abrasives and can be used for many different jobs. Its wide variety of designs enables LUKAS to offer you a broad spectrum of machining

options: matt finishing, satin-matt finishing, polishing, smoothing and final surface finishing – with LUKAS mounted flap wheels made of abrasive fleece, you can master any scenario.

LUKAS mounted flap wheels made of abrasive fleece comprise individual flaps, which are fixed radially fixed around the axis of the tool. Thanks to the use of polyamide, the abrasive fleece also adapts itself perfectly to uneven surfaces. You need less effort and time for your work, and yet still achieve perfect surface results.

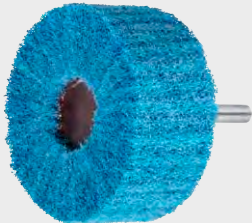
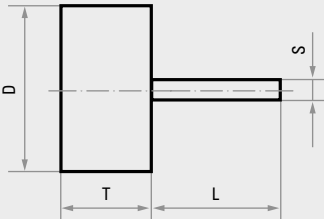


GRINDING AND POLISHING  
(with flexible tools)



## SFV mounted flap wheel, zirconia alumina

- achieves especially high stock removal rates on hard and tough materials such as stainless steel and a long tool life
- manufactured with zirconia alumina for extreme hardness and sharpness
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working

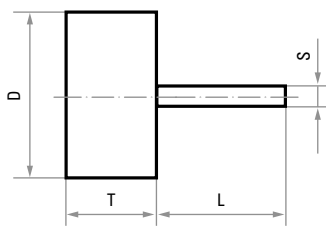
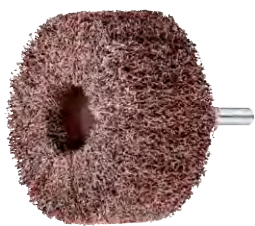
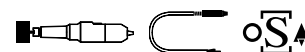


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Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2203030106306	SFV 03010.06	Z306	ZK 180	30	10	6	40	10,000	14,000	10
A2203040206306	SFV 04020.06	Z306	ZK 180	40	20	6	40	7,500	14,000	10
A2203050106306	SFV 05010.06	Z306	ZK 180	50	10	6	40	6,000	11,000	10
A2203060306306	SFV 06030.06	Z306	ZK 180	60	30	6	40	5,000	9,000	10
A2203080506306	SFV 08050.06	Z306	ZK 180	80	50	6	40	4,000	7,000	10

Recommended for: 
 ● Inox/Steel 
 ● Steel 
 ● Aluminium 
 ● Cast material 
 ● Plastic/Wood 
 ● Titanium

## SFV mounted flap wheel, regular aluminium oxide

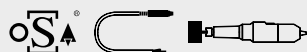


- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working

★★☆

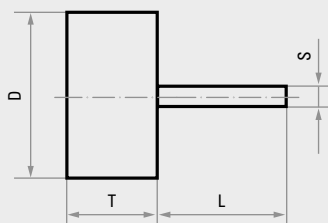
Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2203030206106	SFV 03020.06	A106	NK 180	30	20	6	40	10,000	14,000	10
A2203030406107	SFV 03040.06	A107	NK 280	30	40	6	40	10,000	14,000	10
A2203040206104	SFV 04020.06	A104	NK 100	40	20	6	40	7,500	14,000	10
A2203040206106	SFV 04020.06	A106	NK 180	40	20	6	40	7,500	14,000	10
A2203040206107	SFV 04020.06	A107	NK 280	40	20	6	40	7,500	14,000	10
A2203040306104	SFV 04030.06	A104	NK 100	40	30	6	40	7,500	14,000	10
A2203040306106	SFV 04030.06	A106	NK 180	40	30	6	40	7,500	14,000	10
A2203040306107	SFV 04030.06	A107	NK 280	40	30	6	40	7,500	14,000	10
A2203050106106	SFV 05010.06	A106	NK 180	50	10	6	40	6,000	11,000	10
A2203050206104	SFV 05020.06	A104	NK 100	50	20	6	40	6,000	11,000	10
A2203050206106	SFV 05020.06	A106	NK 180	50	20	6	40	6,000	11,000	10
A2203050306104	SFV 05030.06	A104	NK 100	50	30	6	40	6,000	11,000	10
A2203050306106	SFV 05030.06	A106	NK 180	50	30	6	40	6,000	11,000	10
A2203050306107	SFV 05030.06	A107	NK 280	50	30	6	40	6,000	11,000	10
A2203050406104	SFV 05040.06	A104	NK 100	50	40	6	40	6,000	11,000	10
A2203050406106	SFV 05040.06	A106	NK 180	50	40	6	40	6,000	11,000	10
A2203050406107	SFV 05040.06	A107	NK 280	50	40	6	40	6,000	11,000	10
A2203060306104	SFV 06030.06	A104	NK 100	60	30	6	40	5,000	9,000	10
A2203060306106	SFV 06030.06	A106	NK 180	60	30	6	40	5,000	9,000	10
A2203060306107	SFV 06030.06	A107	NK 280	60	30	6	40	5,000	9,000	10
A2203060406104	SFV 06040.06	A104	NK 100	60	40	6	40	5,000	9,000	10
A2203060406106	SFV 06040.06	A106	NK 180	60	40	6	40	5,000	9,000	10
A2203060406107	SFV 06040.06	A107	NK 280	60	40	6	40	5,000	9,000	10
A2203060506104	SFV 06050.06	A104	NK 100	60	50	6	40	5,000	9,000	10
A2203060506106	SFV 06050.06	A106	NK 180	60	50	6	40	5,000	9,000	10
A2203060506107	SFV 06050.06	A107	NK 280	60	50	6	40	5,000	9,000	10
A2203080406104	SFV 08040.06	A104	NK 100	80	40	6	40	4,000	7,000	10
A2203080406106	SFV 08040.06	A106	NK 180	80	40	6	40	4,000	7,000	10
A2203080506104	SFV 08050.06	A104	NK 100	80	50	6	40	4,000	7,000	10
A2203080506106	SFV 08050.06	A106	NK 180	80	50	6	40	4,000	7,000	10
A2203080506107	SFV 08050.06	A107	NK 280	80	50	6	40	4,000	7,000	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



## SFV mounted flap wheel, silicon carbide

- mounted flap wheels with silicon carbide: ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- special quality, e.g. for the aerospace industry
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



★★☆

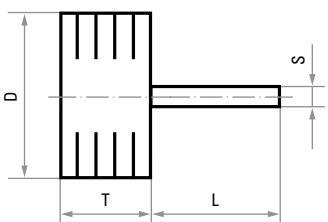
Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2203020153207	SFV 02015.03	C207	SIC 280	20	15	3	40	10,000	14,000	10
A2203040206206	SFV 04020.06	C206	SIC 180	40	20	6	40	7,500	14,000	10
A2203040206207	SFV 04020.06	C207	SIC 280	40	20	6	40	7,500	14,000	10
A2203040306207	SFV 04030.06	C207	SIC 280	40	30	6	40	7,500	14,000	10
A2203050206204	SFV 05020.06	C204	SIC 100	50	20	6	40	6,000	11,000	10
A2203050206206	SFV 05020.06	C206	SIC 180	50	20	6	40	6,000	11,000	10
A2203050206207	SFV 05020.06	C207	SIC 280	50	20	6	40	6,000	11,000	10
A2203050306207	SFV 05030.06	C207	SIC 280	50	30	6	40	6,000	11,000	10
A2203050406207	SFV 05040.06	C207	SIC 280	50	40	6	40	6,000	11,000	10
A2203060306204	SFV 06030.06	C204	SIC 100	60	30	6	40	5,000	9,000	10
A2203060306206	SFV 06030.06	C206	SIC 180	60	30	6	40	5,000	9,000	10
A2203060306207	SFV 06030.06	C207	SIC 280	60	30	6	40	5,000	9,000	10
A2203060406204	SFV 06040.06	C204	SIC 100	60	40	6	40	5,000	9,000	10
A2203060406207	SFV 06040.06	C207	SIC 280	60	40	6	40	5,000	9,000	10
A2203080406204	SFV 08040.06	C204	SIC 100	80	40	6	40	4,000	7,000	10
A2203080406206	SFV 08040.06	C206	SIC 180	80	40	6	40	4,000	7,000	10
A2203080406207	SFV 08040.06	C207	SIC 280	80	40	6	40	4,000	7,000	10
A2203080506204	SFV 08050.06	C204	SIC 100	80	50	6	40	4,000	7,000	10
A2203080506206	SFV 08050.06	C206	SIC 180	80	50	6	40	4,000	7,000	10
A2203080506207	SFV 08050.06	C207	SIC 280	80	50	6	40	4,000	7,000	10

Recommended for: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material

GRINDING AND POLISHING  
(with flexible tools)

## SFR mounted fleece discs

- manufactured from abrasive fleece discs
- used as a handheld tool, ideal for matt finishing, satin-matt finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2223060506104	SFR 06050.06	A104	NK 100	60	50	6	40	5,000	9,000	10
A2223060506106	SFR 06050.06	A106	NK 180	60	50	6	40	5,000	9,000	10
A2223060506107	SFR 06050.06	A107	NK 280	60	50	6	40	5,000	9,000	10
A2223080506104	SFR 08050.06	A104	NK 100	80	50	6	40	4,000	7,000	10
A2223080506106	SFR 08050.06	A106	NK 180	80	50	6	40	4,000	7,000	10
A2223080506107	SFR 08050.06	A107	NK 280	80	50	6	40	4,000	7,000	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



# COMBINATION OF ABRASIVE FLEECE AND ABRASIVE CLOTH

## GREATER STABILITY FOR SUSTAINED USAGE

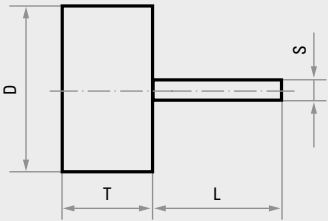
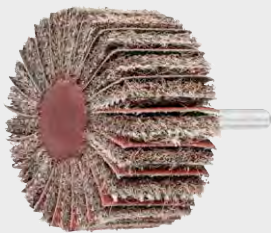


These LUKAS grinding tools feature a combination of abrasive fleece and abrasive cloth. During the production, the fleece and cloth flaps are fastened alternately and radially to the tool axis.

The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate than can be achieved compared to mounted flap wheels without the cloth. These optimised mounted flap wheels are mainly used on handheld power tools and, thanks to their stability, are ideally suited for cleaning, derusting, surface preparation, texturing and rough grinding.

GRINDING AND POLISHING  
(with flexible tools)

## SFM mounted flap wheel, combined abrasive fleece TF and cloth



- due to its especially stable abrasive fleece made of TF material, this mounted flap wheel wears evenly
- perfect for continuous working
- specially designed for use on non-rusting materials
- used as a handheld tool, ideal for the cleaning, derusting, surface preparation, texturing and rough grinding of workpiece surfaces

★★★

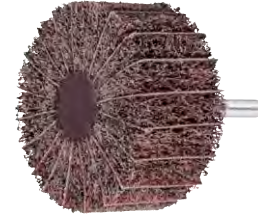
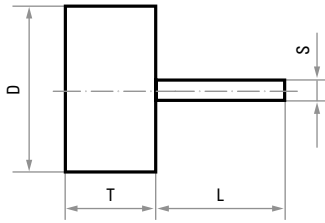
Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2204040206120	SFM 04020.06	TF 120/80	40	20	6	40	7,500	14,000	10
A2204060306120	SFM 06030.06	TF 120/80	60	30	6	40	5,000	9,000	10
A2204080506120	SFM 08050.06	TF 120/80	80	50	6	40	4,000	7,000	10
A2204080406120	SFM 08040.06	TF 120/150	80	40	6	40	4,000	7,000	10

Recommended for: Inox/Steel Steel Aluminium Cast material Plastic/Wood Titanium



## SFM mounted flap wheel, combined abrasive fleece and cloth, regular aluminium oxide

- for continuous working
- used as a handheld tool, ideal for the cleaning, derusting, surface preparation, texturing and roughening of workpiece surfaces



Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2204030306104	SFM 03030.06	A104/80	NK 100/80	30	30	6	40	10,000	14,000	10
A2204040206104	SFM 04020.06	A104/80	NK 100/80	40	20	6	40	7,500	14,000	10
A2204040206106	SFM 04020.06	A106/150	NK 180/150	40	20	6	40	7,500	14,000	10
A2204040206107	SFM 04020.06	A107/240	NK 280/240	40	20	6	40	7,500	14,000	10
A2204040306104	SFM 04030.06	A104/80	NK 100/80	40	30	6	40	7,500	14,000	10
A2204040306106	SFM 04030.06	A106/150	NK 180/150	40	30	6	40	7,500	14,000	10
A2204040306107	SFM 04030.06	A107/240	NK 280/240	40	30	6	40	7,500	14,000	10
A2204050206104	SFM 05020.06	A104/80	NK 100/80	50	20	6	40	6,000	11,000	10
A2204050206106	SFM 05020.06	A106/150	NK 180/150	50	20	6	40	6,000	11,000	10
A2204050306106	SFM 05030.06	A106/150	NK 180/150	50	30	6	40	6,000	11,000	10
A2204050306107	SFM 05030.06	A107/240	NK 280/240	50	30	6	40	6,000	11,000	10
A2204050406104	SFM 05040.06	A104/80	NK 100/80	50	40	6	40	6,000	11,000	10
A2204050406106	SFM 05040.06	A106/150	NK 180/150	50	40	6	40	6,000	11,000	10
A2204060306104	SFM 06030.06	A104/80	NK 100/80	60	30	6	40	5,000	9,000	10
A2204060306106	SFM 06030.06	A106/150	NK 180/150	60	30	6	40	5,000	9,000	10
A2204060306107	SFM 06030.06	A107/240	NK 280/240	60	30	6	40	5,000	9,000	10
A2204060406104	SFM 06040.06	A104/80	NK 100/80	60	40	6	40	5,000	9,000	10
A2204060406106	SFM 06040.06	A106/150	NK 180/150	60	40	6	40	5,000	9,000	10
A2204060406107	SFM 06040.06	A107/240	NK 280/240	60	40	6	40	5,000	9,000	10
A2204060506104	SFM 06050.06	A104/80	NK 100/80	60	50	6	40	5,000	9,000	10
A2204060506106	SFM 06050.06	A106/150	NK 180/150	60	50	6	40	5,000	9,000	10
A2204080406104	SFM 08040.06	A104/80	NK 100/80	80	40	6	40	4,000	7,000	10
A2204080406106	SFM 08040.06	A106/150	NK 180/150	80	40	6	40	4,000	7,000	10
A2204080406107	SFM 08040.06	A107/240	NK 280/240	80	40	6	40	4,000	7,000	10
A2204080506104	SFM 08050.06	A104/80	NK 100/80	80	50	6	40	4,000	7,000	10
A2204080506106	SFM 08050.06	A106/150	NK 180/150	80	50	6	40	4,000	7,000	10
A2204080506107	SFM 08050.06	A107/240	NK 280/240	80	50	6	40	4,000	7,000	10

Recommended for:

● Inox/Steel

● Steel

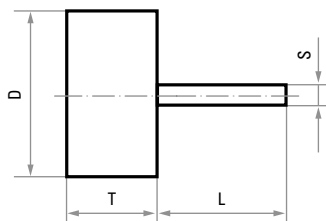
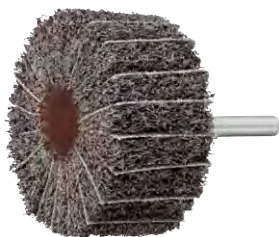
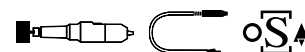
● Aluminium

● Cast material

● Plastic/Wood

● Titanium

## SFM mounted flap wheel, combined abrasive fleece and cloth, silicon carbide



★★☆

- for continuous working
- mounted flap wheels with silicon carbide: ideally suited for machining aluminium and aluminium alloys, titanium materials, glass, ceramic, high-temperature steels and plastics
- special quality, e.g. for the aerospace industry
- used as a handheld tool, ideal for cleaning, derusting, preparation, texturing and rough of workpiece surfaces

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2204040206204	SFM 04020.06	C204/80	SIC 100/80	40	20	6	40	7,500	14,000	10
A2204040206206	SFM 04020.06	C206/150	SIC 180/150	40	20	6	40	7,500	14,000	10
A2204040306204	SFM 04030.06	C204/80	SIC 100/80	40	30	6	40	7,500	14,000	10
A2204040306206	SFM 04030.06	C206/150	SIC 180/150	40	30	6	40	7,500	14,000	10
A2204040306207	SFM 04030.06	C207/240	SIC 280/240	40	30	6	40	7,500	14,000	10
A2204050206204	SFM 05020.06	C204/80	SIC 100/80	50	20	6	40	6,000	11,000	10
A2204050206206	SFM 05020.06	C206/150	SIC 180/150	50	20	6	40	6,000	11,000	10
A2204060306204	SFM 06030.06	C204/80	SIC 100/80	60	30	6	40	5,000	9,000	10
A2204060306206	SFM 06030.06	C206/150	SIC 180/150	60	30	6	40	5,000	9,000	10
A2204060306207	SFM 06030.06	C207/240	SIC 280/240	60	30	6	40	5,000	9,000	10
A2204080506204	SFM 08050.06	C204/80	SIC 100/80	80	50	6	40	4,000	7,000	10
A2204080506206	SFM 08050.06	C206/150	SIC 180/150	80	50	6	40	4,000	7,000	10

Recommended for: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## Flap wheels from LUKAS

### LSL, FLAP WHEELS OF ABRASIVE CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSL consists of single flaps which are embedded radially to the axis in a solid plastic core. Please pay attention to the rotational direction of the tool!

#### Application examples:

- Cleaning
- Deburring
- Derusting
- Surface preparation
- Texturing
- Roughening

### LSV, FLAP WHEELS OF ABRASIVE FLEECE, CUSTOMER SOLUTIONS

These wheels, which are available with different bore sizes, are designed to be used with both handheld and stationary machines. The LSV consist of abrasive fleece flaps. The use of fibre fleece makes the tool elastic and allows it to adapt itself to the shape of the workpiece.

#### Application examples:

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

### LSM, FLAP WHEELS MADE BY COMBINING ABRASIVE FLEECE AND CLOTH, CUSTOMER SOLUTIONS

These wheels, which are available with different bore size, are designed to be used with both handheld and stationary machines. The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LSV. Please pay attention to the rotational direction of the tool!

#### Application examples:

- Cleaning
- Derusting
- Surface preparation
- Texturing
- Roughening

## SAMPLE ORDER

## Customised solutions adapted to handle your challenge

We manufacture LUKAS LSL, LSV and LSM flap wheels as well as LUKAS FRV mops according to your specific requirements as individual custom solutions. For this reason, the product tables on **pages 183–188** contain a description together with additional information instead of the usual article numbers.

After you have selected the right tool for your application, add the required grit size and bore to the designation (see example on the right). Please state this information in your order. This enables us to provide you with a tool that is precisely tailored to your needs.

**If you have any questions, please contact your LUKAS representative or send an email to [le@lukas-erzett.de](mailto:le@lukas-erzett.de)**

**Please give the following details when placing your order:**

LSL 125025

DESCRIPTION

NK 60

GRIT

Bore 13

BORE (H)

# FLAP WHEELS FOR ANGLE GRINDERS

FOR DERUSTING, PAINT STRIPPING, WELD SEAM MACHINING AND MANY OTHER USES

Each flap of this wheel of abrasive cloth is embedded radially to the axis in a solid plastic core. Used with a handheld tool, it is therefore ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities.

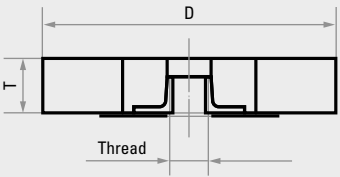
The regular aluminium oxide used for this wheel boasts an impressive tool life on many materials and allows you to work in a cost-effective manner.

The integrated M14 thread means that no additional tool is required for fast and easy mounting of the flap wheel.



GRINDING AND POLISHING  
(with flexible tools)

## LSL, flap wheel of abrasive cloth with thread



★★☆

- fits on commercially available angle grinders and is used in place of mounted flap wheels with shanks
- can be used without a clamping nut
- ideal for reworking weld seams on stainless steels
- ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work in container and railing construction, as well as in assembly facilities
- grinding is only permitted with the peripheral surface

Product number	Description	Grit	D mm	T mm	Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2280125200040	LSL 125020	NK 40	125	20	M14	9,600	12,200	5
A2280125200040001	LSL 125020	NK 40	125	20	5/8"	9,600	12,200	5
A2280125200060	LSL 125020	NK 60	125	20	M14	9,600	12,200	5
A2280125200060001	LSL 125020	NK 60	125	20	5/8"	9,600	12,200	5
A2280125200080	LSL 125020	NK 80	125	20	M14	9,600	12,200	5
A2280125200080001	LSL 125020	NK 80	125	20	5/8"	9,600	12,200	5
A2280125200120	LSL 125020	NK 120	125	20	M14	9,600	12,200	5
A2280125200120001	LSL 125020	NK 120	125	20	5/8"	9,600	12,200	5

Recommended for: Inox/Steel Steel Aluminium Cast material Plastic/Wood Titanium

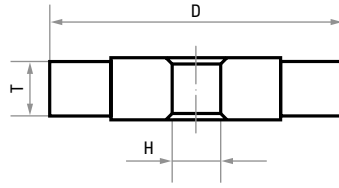




## LSL, flap wheel of abrasive cloth

### INDIVIDUAL CUSTOMER SOLUTIONS

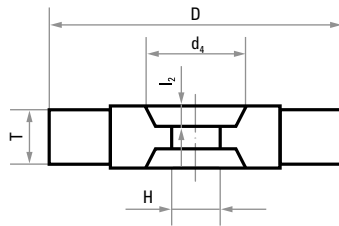
- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- Other dimensions, bores or qualities are available on request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on **page 181**.
- $v_{\text{recom}}$  30 m/s in handheld use
- $v_{\text{max}}$  50 m/s in stationary use
- $n_{\text{max}}$  (rpm) applies for stationary use



Description	Grit	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
LSL 125025	NK 60	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 80	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 120	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 150	125	25	13-16-20	4,500	7,600	25
LSL 125025	NK 240	125	25	13-16-20	4,500	7,600	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

\*minimum order quantity



Description	Grit	D mm	T mm	H mm	recess on both sides $d_4$ mm	recess on both sides $l_2$ mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
LSL 150050	NK 60	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 80	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 120	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 150	150	50	13-16-20	47	18	3,800	6,300	25
LSL 150050	NK 240	150	50	13-16-20	47	18	3,800	6,300	25
LSL 165050	NK 60	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 80	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 120	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 150	165	50	13-16-20	47	18	3,400	5,700	25
LSL 165050	NK 240	165	50	13-16-20	47	18	3,400	5,700	25
LSL 200025	NK 60	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 80	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 120	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 150	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200025	NK 240	200	25	20-25-32	71	10	2,800	4,700	25
LSL 200050	NK 60	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 80	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 120	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 150	200	50	20-25-32	71	18	2,800	4,700	25
LSL 200050	NK 240	200	50	20-25-32	71	18	2,800	4,700	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

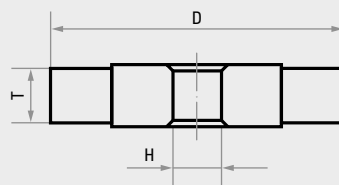
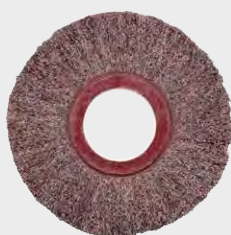
\*minimum order quantity

# LUKAS FLAP WHEEL MADE OF ABRASIVE FLEECE

ADAPTED TO HANDLE YOUR SPECIFIC CHALLENGES

## LSV, flap wheel of abrasive fleece

INDIVIDUAL CUSTOMER SOLUTIONS



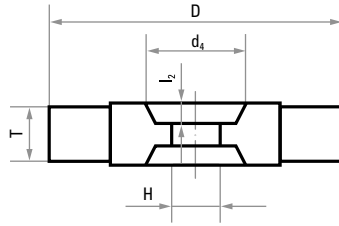
- for matt finishing, satin finishing, polishing, smoothening and final surface finishing
- Other dimensions, bores or qualities (e.g. "very hard" version or impregnated with polyurethane) are available upon request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on **page 181**.
- $v_{\max}$  35 m/s

★★☆

Description	Quality	Grit	Type	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
LSV 100050	A104 W	NK 100	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 W	NK 180	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 W	NK 280	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 W	SIC 100	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 W	SIC 180	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 W	SIC 280	soft	100	50	13-16-20	3,000	6,000	25
LSV 100050	A104 M	NK 100	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 M	NK 180	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 M	NK 280	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 M	SIC 100	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 M	SIC 180	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 M	SIC 280	medium	100	50	13-16-20	3,000	6,000	25
LSV 100050	A104 H	NK 100	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	A106 H	NK 180	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	A107 H	NK 280	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C204 H	SIC 100	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C206 H	SIC 180	hard	100	50	13-16-20	3,000	6,000	25
LSV 100050	C207 H	SIC 280	hard	100	50	13-16-20	3,000	6,000	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/ Wood ● Titanium

\*minimum order quantity



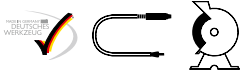
Description	Quality	Grit	Type	D mm	T mm	H mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	MOQ* pcs.
LSV 150050	A104 W	NK 100	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 W	NK 180	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 W	NK 280	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 W	SIC 100	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 W	SIC 180	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 W	SIC 280	soft	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A104 M	NK 100	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 M	NK 180	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 M	NK 280	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 M	SIC 100	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 M	SIC 180	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 M	SIC 280	medium	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A104 H	NK 100	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A106 H	NK 180	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	A107 H	NK 280	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C204 H	SIC 100	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C206 H	SIC 180	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 150050	C207 H	SIC 280	hard	150	50	13-16-20	47	18	2,000	4,000	25
LSV 160050	A104 W	NK 100	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 W	NK 180	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 W	NK 280	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 W	SIC 100	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 W	SIC 180	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 W	SIC 280	soft	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A104 M	NK 100	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 M	NK 180	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 M	NK 280	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 M	SIC 100	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 M	SIC 180	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 M	SIC 280	medium	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A104 H	NK 100	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A106 H	NK 180	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	A107 H	NK 280	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C204 H	SIC 100	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C206 H	SIC 180	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 160050	C207 H	SIC 280	hard	160	50	13-16-20	47	18	1,900	3,800	25
LSV 200025	A104 W	NK 100	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 W	NK 180	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 W	NK 280	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 W	SIC 100	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 W	SIC 180	soft	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 W	SIC 280	soft	200	25	20-25-32	71	10	1,500	3,000	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

\*minimum order quantity

Description	Quality	Grit	Type	D mm	T mm	H mm	recess on both sides d <sub>4</sub> mm	recess on both sides l <sub>2</sub> mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	MOQ* pcs.
LSV 200025	A104 M	NK 100	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 M	NK 180	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 M	NK 280	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 M	SIC 100	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 M	SIC 180	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 M	SIC 280	medium	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A104 H	NK 100	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 H	NK 180	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 H	NK 280	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 H	SIC 100	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 H	SIC 180	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 H	SIC 280	hard	200	25	20-25-32	71	10	1,500	3,000	25
LSV 200050	A104 W	NK 100	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 W	NK 180	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 W	NK 280	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 W	SIC 100	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 W	SIC 180	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 W	SIC 280	soft	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A104 M	NK 100	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 M	NK 180	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 M	NK 280	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 M	SIC 100	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 M	SIC 180	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 M	SIC 280	medium	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A104 H	NK 100	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A106 H	NK 180	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	A107 H	NK 280	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C204 H	SIC 100	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C206 H	SIC 180	hard	200	50	20-25-32	71	18	1,500	3,000	25
LSV 200050	C207 H	SIC 280	hard	200	50	20-25-32	71	18	1,500	3,000	25
Recommended for: <span style="color: #0070C0;">●</span> Inox/Steel <span style="color: #808080;">●</span> Steel <span style="color: #FF8C00;">●</span> Aluminium <span style="color: #8B0000;">●</span> Cast material <span style="color: #FFD700;">●</span> Plastic/ Wood <span style="color: #404040;">●</span> Titanium											

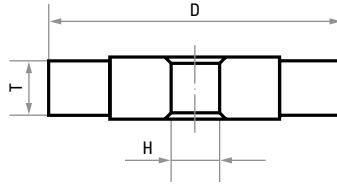
\*minimum order quantity



## LSM, flap wheel of abrasive fleece and cloth in combination

INDIVIDUAL CUSTOMER SOLUTIONS

- for cleaning, derusting, surface preparation, texturing and roughening
- Other dimensions, bores or qualities are available on request. Available diameters 80 mm to max. 400 mm.
- A sample order for this LUKAS custom solution can be found on **page 181**.
- $v_{max}$  35 m/s

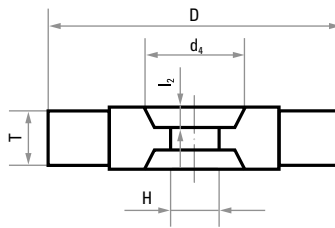


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Description	Quality	Grit	D mm	T mm	H mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSM 080050	A104/80	NK 100/80	80	50	10-13-16	3,800	7,600	25
LSM 080050	A106/150	NK 180/150	80	50	10-13-16	3,800	7,600	25
LSM 080050	A107/240	NK 280/240	80	50	10-13-16	3,800	7,600	25
LSM 080050	C204/80	SIC 100/80	80	50	10-13-16	3,800	7,600	25
LSM 080050	C206/150	SIC 180/150	80	50	10-13-16	3,800	7,600	25
LSM 080050	C207/240	SIC 280/240	80	50	10-13-16	3,800	7,600	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

\*minimum order quantity



Description	Quality	Grit	D mm	T mm	H mm	recess on both sides $d_4$ mm	recess on both sides $l_2$ mm	$n_{recom}$ rpm	$n_{max}$ rpm	MOQ* pcs.
LSM 150050	A104/80	NK 100/80	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	A106/150	NK 180/150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	A107/240	NK 280/240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C204/80	SIC 100/80	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C206/150	SIC 180/150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 150050	C207/240	SIC 280/240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 160050	A104/80	NK 100/80	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	A106/150	NK 180/150	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	A107/240	NK 280/240	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C204/80	SIC 100/80	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C206/150	SIC 180/150	160	50	13-16-20	47	18	1,900	3,800	25
LSM 160050	C207/240	SIC 280/240	160	50	13-16-20	47	18	1,900	3,800	25
LSM 200050	A104/80	NK 100/80	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	A106/150	NK 180/150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	A107/240	NK 280/240	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C204/80	SIC 100/80	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C206/150	SIC 180/150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 200050	C207/240	SIC 280/240	200	50	20-25-32	71	18	1,500	3,000	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

\*minimum order quantity



# SILKY LUSTRE MATT FINISHING ON STAINLESS STEEL

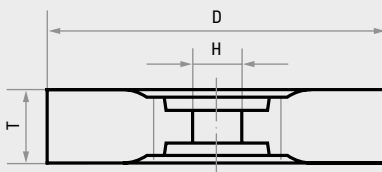
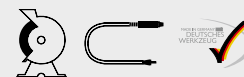
## LUKAS MOPS FOR YOUR APPLICATION



LUKAS mops of abrasive fleece are packed together on a shaft to create rolls of different widths. By adding water or low-viscosity oil, you can further boost the service life of this tool: Water produces matt surfaces on almost all metals and very matt surfaces on aluminium, while oils give a silky lustre finish.

### FRV, mops of abrasive fleece

INDIVIDUAL CUSTOMER SOLUTIONS



- for silky lustre matt finishing on stainless steel, chrome, nickel and non-ferrous metals
- can also be used for cleaning and smoothing primer coatings and soiled paint surfaces in the wood and plastics industries
- The best cutting speed is between 10 – 20 m/s, applying only slight contact pressure.
- A sample order for this LUKAS custom solution can be found on **page 181**.

★★☆

Description	Quality	Grit	Surface	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	MOQ* pcs.
FRV 200050	A104	NK 100	medium	200	50	20-25-32	1,400	1,900	25
FRV 200050	A106	NK 180	fine	200	50	20-25-32	1,400	1,900	25
FRV 200050	A107	NK 280	very fine	200	50	20-25-32	1,400	1,900	25
FRV 250050	A104	NK 100	medium	250	50	20-25-32	1,100	1,500	25
FRV 250050	A106	NK 180	fine	250	50	20-25-32	1,100	1,500	25
FRV 250050	A107	NK 280	very fine	250	50	20-25-32	1,100	1,500	25
FRV 300060	A104	NK 100	medium	300	60	20-25-32	900	1,200	25
FRV 300060	A106	NK 180	fine	300	60	20-25-32	900	1,200	25
FRV 300060	A107	NK 280	very fine	300	60	20-25-32	900	1,200	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

\*minimum order quantity

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

**LUKAS flap rolls**

These rolls have a 19 mm bore and four keyways for use on handheld surface grinding machines (burnishing machines).

**LWL, FLAP ROLLS MADE OF ABRASIVE CLOTH FOR BURNISHING MACHINES**

These tools are comprised of single flaps that are radially fixed around the axis in a plastic core. Please pay attention to the rotational direction of the tool! **Page 190**

**Application examples:**

- Cleaning
- Deburring
- Derusting
- Preparation
- Texturing
- Roughening

**LWV, FLAP ROLLS MADE OF ABRASIVE FLEECE FOR BURNISHING MACHINES**

This design is comprised of abrasive fleece flaps. The use of fibre fleece makes the tool elastic and allows it to adapt itself to the shape of the workpiece. **Page 191**

**Application examples:**

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

**LWM, FLAP ROLLS MADE OF TF MATERIAL**

These rolls with a 19 mm bore and four keyways are specially designed for use on non-rusting materials. The abrasive fleece, with its reinforced backing, guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotational direction of the tool! **Page 192**

**LWM, FLAP ROLLS FOR BURNISHING MACHINES MADE OF ABRASIVE FLEECE/CLOTH IN COMBINATION**

The combination of abrasive cloth and abrasive fleece results in a higher stock removal rate compared to type LWV. Please pay attention to the rotational direction of the tool! **Pages 192 / 193**

**Application examples:**

- Cleaning
- Derusting
- surface preparation
- Texturing
- Roughening

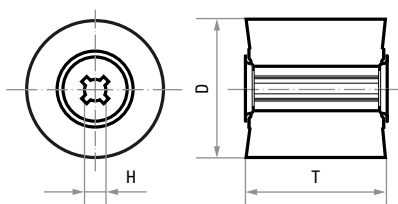
**LWF, SINUS ABRASIVE ROLL MADE OF ABRASIVE FLEECE FOR CONDITIONING MACHINES**

These tools consist of abrasive fleece webs that are wound around the core in a wave pattern. This wave arrangement enables matt finishing of surfaces without visible transitions. The use of fibre fleece makes the LWF elastic and allows it to adapt itself to the shape of the workpiece. **Page 193**

**Application examples:**

- Matt finishing
- Satin-matt finishing
- Polishing
- Smoothing
- Final finishing of the workpiece surfaces

## LWL, flap roll made of abrasive cloth

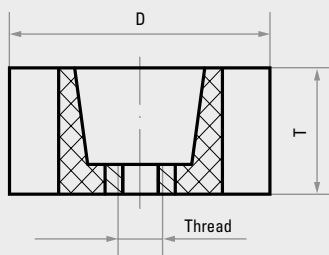
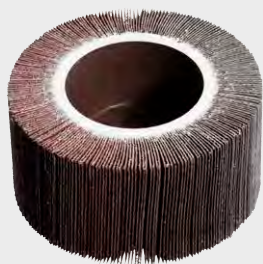


★★☆

- for cleaning, deburring, derusting, surface preparation, texturing and roughening
- for conditioning machines

Product number	Description	Grit	D mm	T mm	H mm	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2280100500040	LWL 100050	NK 40	100	50	19	3,700	6,000	2
A2280100500060	LWL 100050	NK 60	100	50	19	3,700	6,000	2
A2280100500080	LWL 100050	NK 80	100	50	19	3,700	6,000	2
A22801001000040	LWL 100100	NK 40	100	100	19	3,700	6,000	1
A22801001000060	LWL 100100	NK 60	100	100	19	3,700	6,000	1
A22801001000080	LWL 100100	NK 80	100	100	19	3,700	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: gray;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								

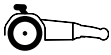
## LWL, flap roll made of abrasive cloth with thread



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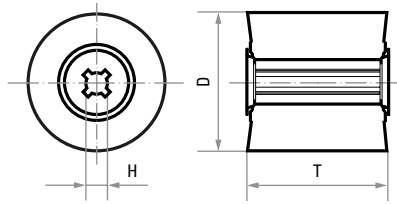
- fits on commercially available angle grinders
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

Product number	Description	Grit	D mm	T mm	Thread	$n_{\text{recom}}$ rpm	$n_{\text{max}}$ rpm	Pack contains
A2280100501060	LWL 100050	NK 60	100	50	M14	3,700	6,000	2
A2280100501080	LWL 100050	NK 80	100	50	M14	3,700	6,000	2
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: gray;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								



## LWV, flap roll made of abrasive fleece

- for conditioning machines
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces



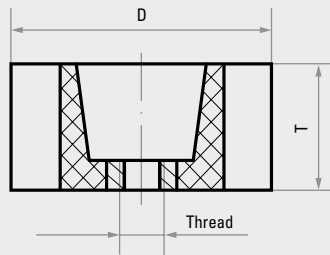
★★☆

Product number	Description	Quality	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2286100500104	LWV 100050	A104	NK 100	100	50	19	2,800	6,000	2
A2286100500106	LWV 100050	A106	NK 180	100	50	19	2,800	6,000	2
A2286100500107	LWV 100050	A107	NK 280	100	50	19	2,800	6,000	2
A22861001000104	LWV 100100	A104	NK 100	100	100	19	2,800	6,000	1
A22861001000106	LWV 100100	A106	NK 180	100	100	19	2,800	6,000	1
A22861001000107	LWV 100100	A107	NK 280	100	100	19	2,800	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium									



## LWV, flap roll made of abrasive fleece with thread

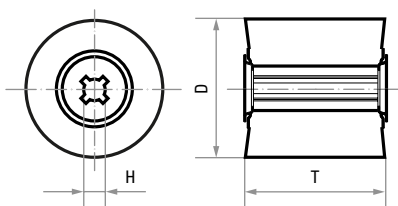
- fits on commercially available angle grinders
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces



★★☆

Product number	Description	Grit	D mm	T mm	Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2286100501104	LWV 100050	A 104	100	50	M14	2,800	6,000	2
A2286100501106	LWV 100050	A 106	100	50	M14	2,800	6,000	2
A2286100501107	LWV 100050	A 107	100	50	M14	2,800	6,000	2
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								

## LWM, flap roll made of abrasive fleece TF and cloth in combination

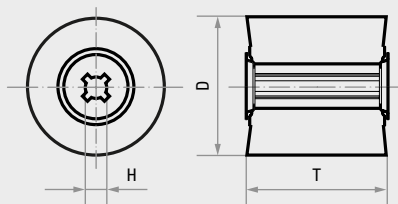


- for conditioning machines
- Due to its highly robust abrasive fleece made of TF material, this mounted flap wheel wears evenly.
- perfect for continuous working
- ideal for machining the surfaces of sheet metal products made from stainless steel such as sinks and containers
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

★★★

Product number	Description	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A22881001000120	LWM 100100	TF 120/80	100	100	19	2,800	6,000	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: gray;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: black;">●</span> Titanium								

## LWM, flap roll made of abrasive fleece and cloth in combination



- for conditioning machines
- for continuous working
- better stock removal performance than flap rolls made solely with abrasive fleece
- for cleaning, deburring, derusting, surface preparation, texturing and roughening

★★☆

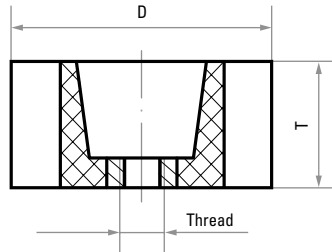
Product number	Description	Quality	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2288100500104	LWM 100050	A104/80	NK 100/80	100	50	19	2,800	6,000	2
A2288100500106	LWM 100050	A106/150	NK 180/150	100	50	19	2,800	6,000	2
A2288100500107	LWM 100050	A107/240	NK 280/240	100	50	19	2,800	6,000	2
A22881001000104	LWM 100100	A104/80	NK 100/80	100	100	19	2,800	6,000	1
A22881001000106	LWM 100100	A106/150	NK 180/150	100	100	19	2,800	6,000	1
A22881001000107	LWM 100100	A107/240	NK 280/240	100	100	19	2,800	6,000	1
Recommended for: <div><div></div> Inox/Steel</div> <div><div></div> Steel</div> <div><div></div> Aluminium</div> <div><div></div> Cast material</div> <div><div></div> Plastic/ Wood</div> <div><div></div> Titanium</div>									





## LWM, flap rolls made of combined abrasive fleece and cloth with thread

- fits on commercially available angle grinders
- for continuous working
- better stock removal performance than flap rolls made solely with abrasive fleece
- for cleaning, deburring, derusting, surface preparation, texturing and roughening



★★☆

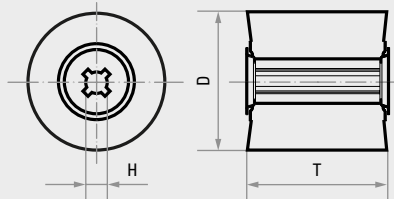
Product number	Description	Quality	Grit	D mm	T mm	Thread	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2288100501104	LWM 100050	A104/80	NK 100/80	100	50	M14	2,800	6,000	2
A2288100501106	LWM 100050	A106/150	NK 180/150	100	50	M14	2,800	6,000	2

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/ Wood ● Titanium



## LWF, sinus abrasive roll with abrasive fleece

- fits on commercially available angle grinders
- The wave arrangement enables matt finishing of surfaces without visible imperfections.
- use of fibre fleece makes it elastic
- adapts itself to the shape of the workpiece
- for matt finishing, satin-matt finishing, polishing, smoothening and final finishing of workpiece surfaces



★★☆

Product number	Description	Quality	Grit	D mm	T mm	H mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A22811001000104	LWF 100100	A104	NK 100	100	100	19	2,800	3,800	1
A22811001000106	LWF 100100	A106	NK 180	100	100	19	2,800	3,800	1

Recommended use for A quality: ● Inox/Steel ● Steel ● Cast material ● Plastic/ Wood ● Aluminium ● Titanium

A2281100500208	LWF 100050	C208	SIC 400	100	50	19	2,800	3,800	2
A22811001000208	LWF 100100	C208	SIC 400	100	100	19	2,800	3,800	1

Recommended use for C quality: ● Aluminium ● Plastic/ Wood ● Titanium ● Inox/Steel ● Steel ● Cast material

# LUKAS CONDITIONING MACHINES

THE MATCHING POWER TOOL FOR YOUR CONDITIONING ROLLS

## Conditioning machine



### Technical details:

- weight: approx. 2.8 kg
- electronic control with soft start, variable speed control, temperature and overload cut-off

► Further technical details can be found on page 301.

### Properties:

- heavy-duty motor (durable)
- double gear reduction (long service life)
- dust-protected bearings (low wear)
- Combined with the perfect tool, you can achieve shadow-free metal, wood or plastic surfaces without transitions.

### With the appropriate tool perfect for:

- satin-matt finishing
- texturing
- polishing
- brushing
- smoothening
- deburring
- matt finishing



Product number	Description	Idle speed rpm	Power consumption W	Tool max. Ø mm	Tool width mm	Tool holder mm	Pack contains
A3995ESM1310	ESM 1310	1,300 – 3,050	1,300	120	100	19	1

For use with LUKAS tools			Dimensions	Catalogue page
ESM 1310	P6 polishing roll		100 x 50 mm, 100 x 100 mm	122
	SBZY abrasive band rolls		100 x 100 mm	203
	LWL/LWV/LWM/LWF abrasive flap rolls		100 x 50 mm, 100 x 100 mm	190–193



Please pay attention to the respective speed specifications on our tool packaging.

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# Abrasive bands and mandrels from LUKAS

## SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE

We offer a large selection of abrasive bands and matching mandrels. They are available in many different dimensions and qualities. Abrasive bands are made of abrasive cloth which is spirally wound onto a fabric with a backing. Mounted on matching mandrels, they are used with handheld machines (straight grinders or machines with a flexible shaft). **Pages 196–199**

### Application examples:

- Cleaning
- Light deburring
- Refining
- Surface and contour grinding
- Fine grinding

## STZY ABRASIVE BAND MANDRELS, CYLINDRICAL SHAPE

Our mandrels are used solely for mounting our cylindrical abrasive bands. Due to the special slots in the mandrel, the abrasive bands are firmly secured as speed increases. **Page 200**

## SBZY ABRASIVE BANDS, CYLINDRICAL SHAPE WITHOUT LINING

These particularly flexible abrasive bands are made of abrasive cloth. They are used on handheld machines (straight grinders or machines with flexible shafts) and are mounted on matching soft mandrels. **Page 201**

## SBKE ABRASIVE BANDS, CONICAL SHAPE

Conical abrasive bands are comparable in their design and usage with the cylindrical version. The taper (sleeve shape) allows the grinding of workpieces with hard-to-reach areas. **Page 203**

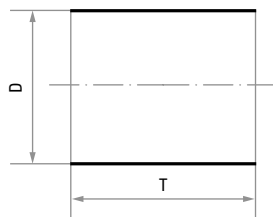
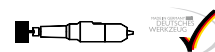
## STKE ABRASIVE BAND MANDRELS, CONICAL SHAPE

Our mandrels are used solely for mounting our conical abrasive bands. Due to the special slot design, the abrasive bands are firmly secured as speed increases. **Page 203**

## STWS ABRASIVE BAND MANDRELS FOR ABRASIVE BAND ROLLS

These especially soft mandrels are provided with a 19 mm bore and four keyways in order to be used with our corresponding abrasive band on handheld surface grinders (conditioning machines). **Page 204**

## SBZY Ceramic abrasive band, cylindrical shape



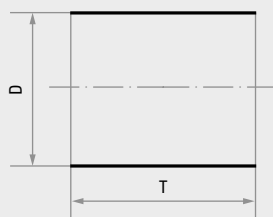
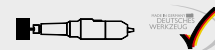
- especially robust ceramic grain for hard materials
- high stock removal rate and long tool life
- Hardened surfaces, wear-resistant steels, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- ▶ The matching mandrels can be found on **page 200**.

★★★

Product number	Description	Grit	D mm	T mm	Pack contains
A240603030040	SBZY 03030	Ceramic 40	30	30	50
A240603030060	SBZY 03030	Ceramic 60	30	30	50
A240604530040	SBZY 04530	Ceramic 40	45	30	50
A240604530060	SBZY 04530	Ceramic 60	45	30	50
A240604530080	SBZY 04530	Ceramic 80	45	30	50
A240606030040	SBZY 06030	Ceramic 40	60	30	25
A240606030060	SBZY 06030	Ceramic 60	60	30	25

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

## SBZY Z-Power abrasive band, cylindrical shape

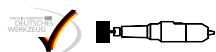


- made of zirconia alumina with active abrasive surface layer
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- ▶ The matching mandrels can be found on **page 200**.

★★★

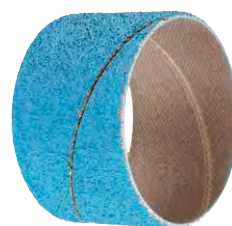
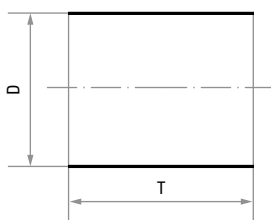
Product number	Description	Grit	D mm	T mm	Pack contains
A241203030036	SBZY 03030	Z-Power 36	30	30	50
A241203030050	SBZY 03030	Z-Power 50	30	30	50
A241203030060	SBZY 03030	Z-Power 60	30	30	50
A241203030080	SBZY 03030	Z-Power 80	30	30	50
A241204530036	SBZY 04530	Z-Power 36	45	30	50
A241204530050	SBZY 04530	Z-Power 50	45	30	50
A241204530080	SBZY 04530	Z-Power 80	45	30	50
A241206030036	SBZY 06030	Z-Power 36	60	30	25
A241206030050	SBZY 06030	Z-Power 50	60	30	25
A241206030080	SBZY 06030	Z-Power 80	60	30	25

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



## SBZY zirconia alumina abrasive band, cylindrical shape

- made of abrasive cloth with zirconia alumina
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- The matching mandrels can be found on **page 200**.

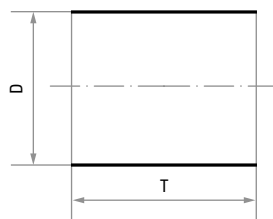
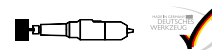


Product number	Description	Grit	D mm	T mm	Pack contains
A240201325050	SBZY 01325	ZK 50	13	25	50
A240201530050	SBZY 01530	ZK 50	15	30	50
A240201530060	SBZY 01530	ZK 60	15	30	50
A240201530080	SBZY 01530	ZK 80	15	30	50
A240201925036	SBZY 01925	ZK 36	19	25	50
A240201925050	SBZY 01925	ZK 50	19	25	50
A240202220036	SBZY 02220	ZK 36	22	20	50
A240202220050	SBZY 02220	ZK 50	22	20	50
A240202220060	SBZY 02220	ZK 60	22	20	50
A240202525036	SBZY 02525	ZK 36	25	25	50
A240202525050	SBZY 02525	ZK 50	25	25	50
A240202525080	SBZY 02525	ZK 80	25	25	50
A240203030036	SBZY 03030	ZK 36	30	30	50
A240203030050	SBZY 03030	ZK 50	30	30	50
A240203030060	SBZY 03030	ZK 60	30	30	50
A240203030080	SBZY 03030	ZK 80	30	30	50
A240204530036	SBZY 04530	ZK 36	45	30	50
A240204530050	SBZY 04530	ZK 50	45	30	50
A240204530060	SBZY 04530	ZK 60	45	30	50
A240204530080	SBZY 04530	ZK 80	45	30	50
A240206030036	SBZY 06030	ZK 36	60	30	50
A240206030050	SBZY 06030	ZK 50	60	30	50
A240206030060	SBZY 06030	ZK 60	60	30	50
A240206030080	SBZY 06030	ZK 80	60	30	50

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



## SBZY regular aluminium oxide abrasive band, cylindrical shape



- Regular aluminium oxide has good tool life when used on structural steel and for rough grinding.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with mandrels for use with straight grinders or machines with flexible shafts
- ▶ The matching mandrels can be found on **page 200**.

★★☆

Product number	Description	Grit	D mm	T mm	Pack contains
A240000810150	SBZY 00810	NK 150	8	10	50
A240001010080	SBZY 01010	NK 80	10	10	50
A240001010150	SBZY 01010	NK 150	10	10	50
A240001010240	SBZY 01010	NK 240	10	10	50
A240001010320	SBZY 01010	NK 320	10	10	50
A240001020080	SBZY 01020	NK 80	10	20	50
A240001020150	SBZY 01020	NK 150	10	20	50
A240001020240	SBZY 01020	NK 240	10	20	50
A240001020320	SBZY 01020	NK 320	10	20	50
A240001210080	SBZY 01210	NK 80	12	10	50
A240001210150	SBZY 01210	NK 150	12	10	50
A240001213080	SBZY 01213	NK 80	12	13	50
A240001213120	SBZY 01213	NK 120	12	13	50
A240001213240	SBZY 01213	NK 240	12	13	50
A240001225080	SBZY 01225	NK 80	12	25	50
A240001225150	SBZY 01225	NK 150	12	25	50
A240001225240	SBZY 01225	NK 240	12	25	50
A240001225320	SBZY 01225	NK 320	12	25	50
A240001325080	SBZY 01325	NK 80	13	25	50
A240001325150	SBZY 01325	NK 150	13	25	50
A240001510060	SBZY 01510	NK 60	15	10	50
A240001510080	SBZY 01510	NK 80	15	10	50
A240001510150	SBZY 01510	NK 150	15	10	50
A240001510240	SBZY 01510	NK 240	15	10	50
A240001510320	SBZY 01510	NK 320	15	10	50
A240001530040	SBZY 01530	NK 40	15	30	50
A240001530050	SBZY 01530	NK 50	15	30	50
A240001530060	SBZY 01530	NK 60	15	30	50
A240001530080	SBZY 01530	NK 80	15	30	50
A240001530120	SBZY 01530	NK 120	15	30	50
A240001530150	SBZY 01530	NK 150	15	30	50
A240001530240	SBZY 01530	NK 240	15	30	50
A240001530320	SBZY 01530	NK 320	15	30	50
A240001925060	SBZY 01925	NK 60	19	25	50
A240001925080	SBZY 01925	NK 80	19	25	50
A240001925150	SBZY 01925	NK 150	19	25	50
A240002210150	SBZY 02210	NK 150	22	10	50
A240002210240	SBZY 02210	NK 240	22	10	50
A240002210320	SBZY 02210	NK 320	22	10	50
A240002220050	SBZY 02220	NK 50	22	20	50
A240002220060	SBZY 02220	NK 60	22	20	50

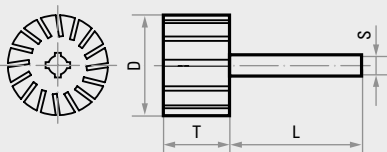
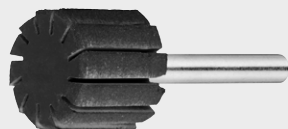
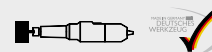
Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

Product number	Description	Grit	D mm	T mm	Pack contains
A240002220080	SBZY 02220	NK 80	22	20	50
A240002220150	SBZY 02220	NK 150	22	20	50
A240002220240	SBZY 02220	NK 240	22	20	50
A240002220320	SBZY 02220	NK 320	22	20	50
A240002525040	SBZY 02525	NK 40	25	25	50
A240002525060	SBZY 02525	NK 60	25	25	50
A240002525080	SBZY 02525	NK 80	25	25	50
A240002525150	SBZY 02525	NK 150	25	25	50
A240003020040	SBZY 03020	NK 40	30	20	50
A240003020050	SBZY 03020	NK 50	30	20	50
A240003020060	SBZY 03020	NK 60	30	20	50
A240003020080	SBZY 03020	NK 80	30	20	50
A240003020150	SBZY 03020	NK 150	30	20	50
A240003020240	SBZY 03020	NK 240	30	20	50
A240003030040	SBZY 03030	NK 40	30	30	50
A240003030050	SBZY 03030	NK 50	30	30	50
A240003030060	SBZY 03030	NK 60	30	30	50
A240003030080	SBZY 03030	NK 80	30	30	50
A240003030150	SBZY 03030	NK 150	30	30	50
A240003030240	SBZY 03030	NK 240	30	30	50
A240003030320	SBZY 03030	NK 320	30	30	50
A240003825040	SBZY 03825	NK 40	38	25	50
A240003825050	SBZY 03825	NK 50	38	25	50
A240003825060	SBZY 03825	NK 60	38	25	50
A240003825080	SBZY 03825	NK 80	38	25	50
A240003825150	SBZY 03825	NK 150	38	25	50
A240004530040	SBZY 04530	NK 40	45	30	50
A240004530050	SBZY 04530	NK 50	45	30	50
A240004530060	SBZY 04530	NK 60	45	30	50
A240004530080	SBZY 04530	NK 80	45	30	50
A240004530150	SBZY 04530	NK 150	45	30	50
A240004530240	SBZY 04530	NK 240	45	30	50
A240004530320	SBZY 04530	NK 320	45	30	50
A240005125040	SBZY 05125	NK 40	51	25	50
A240005125050	SBZY 05125	NK 50	51	25	50
A240005125060	SBZY 05125	NK 60	51	25	50
A240005125080	SBZY 05125	NK 80	51	25	50
A240005125150	SBZY 05125	NK 150	51	25	50
A240006030040	SBZY 06030	NK 40	60	30	50
A240006030050	SBZY 06030	NK 50	60	30	50
A240006030060	SBZY 06030	NK 60	60	30	50
A240006030080	SBZY 06030	NK 80	60	30	50
A240006030150	SBZY 06030	NK 150	60	30	50
A240007530040	SBZY 07530	NK 40	75	30	50
A240007530060	SBZY 07530	NK 60	75	30	50
A240007530080	SBZY 07530	NK 80	75	30	50
A240007530150	SBZY 07530	NK 150	75	30	50
A240010040040	SBZY 10040	NK 40	100	40	25
A240010040060	SBZY 10040	NK 60	100	40	25
A240010040080	SBZY 10040	NK 80	100	40	25
A240010040150	SBZY 10040	NK 150	100	40	25

Recommended for:  Steel  Cast material  Plastic/Wood  Inox/Steel  Aluminium  Titanium

GRINDING AND POLISHING  
(with flexible tools)

## STZY hard abrasive band mandrel, cylindrical shape

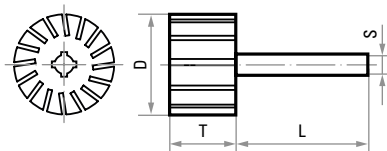
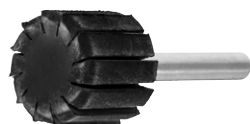
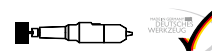


The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2500010103	STZY 01010.03	hard	10	10	3	25	54,000	5
A2500010106	STZY 01010.06	hard	10	10	6	40	57,000	5
A2500010206	STZY 01020.06	hard	10	20	6	40	57,000	5
A2500012106	STZY 01210.06	hard	12	10	6	40	46,500	5
A2500012132	STZY 01213.02	hard	12	13	2.35	40	26,000	5
A2500012256	STZY 01225.06	hard	12	25	6	40	46,500	5
A2500013256	STZY 01325.06	hard	13	25	6	40	44,000	5
A2500015106	STZY 01510.06	hard	15	10	6	40	38,000	5
A2500015306	STZY 01530.06	hard	15	30	6	40	38,000	5
A2500019256	STZY 01925.06	hard	19	25	6	40	30,000	5
A2500022106	STZY 02210.06	hard	22	10	6	40	26,000	5
A2500022206	STZY 02220.06	hard	22	20	6	40	26,000	5
A2500025256	STZY 02525.06	hard	25	25	6	40	22,500	5
A2500030206	STZY 03020.06	hard	30	20	6	40	19,000	5
A2500030306	STZY 03030.06	hard	30	30	6	40	19,000	5
A2500038256	STZY 03825.06	hard	38	25	6	40	15,000	5
A25000453060001	STZY 04530.06	hard	45	30	6	40	13,000	5
A2500051256	STZY 05125.06	hard	51	25	6	40	11,200	5
A25000603060001	STZY 06030.06	hard	60	30	6	40	9,500	5
A2500060308	STZY 06030.08	hard	60	30	8	40	9,500	5
A25000753080001	STZY 07530.08	hard	75	30	8	40	6,500	2

## STZY soft abrasive band mandrel, cylindrical shape



The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2501008103	STZY 00810.03	soft	8	10	3	40	47,500	5
A2501012256	STZY 01225.06	soft	12	25	6	40	31,500	5
A2501015306	STZY 01530.06	soft	15	30	6	40	25,000	5
A2501022206	STZY 02220.06	soft	22	20	6	40	17,000	5
A2501030206	STZY 03020.06	soft	30	20	6	40	12,500	5
A2501030306	STZY 03030.06	soft	30	30	6	40	12,500	5
A25010453060001	STZY 04530.06	soft	45	30	6	40	13,000	5
A25010603060001	STZY 06030.06	soft	60	30	6	40	6,500	5
A25011004080001	STZY 10040.08	soft	100	40	8	40	4,000	2

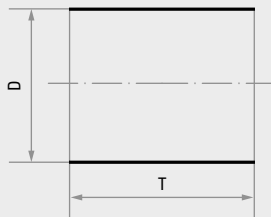
# THE ABRASIVE BAND FOR COMPLEX CONTOURS

FOR FLEXIBLE USE IN COMBINATION WITH A SOFT ABRASIVE BAND MANDREL



## SBZY abrasive band, cylindrical shape, without lining

- abrasive band without lining and therefore particularly flexible
- in combination with soft abrasive band mandrels for use with straight grinders or machines with flexible shafts



★★☆

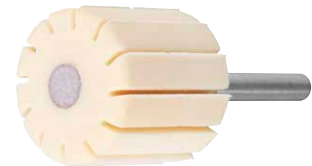
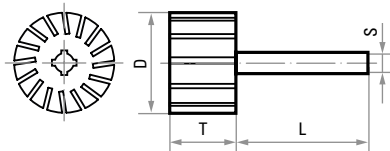
Product number	Description	Grit	D mm	T mm	Pack contains
A300003030080	SBZY 03030	NK 80	30	30	50
A300003030120	SBZY 03030	NK 120	30	30	50
A300003030150	SBZY 03030	NK 150	30	30	50
A300004530120	SBZY 04530	NK 120	45	30	50
A300004530150	SBZY 04530	NK 150	45	30	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium



## STZY soft abrasive band mandrel, cylindrical shape

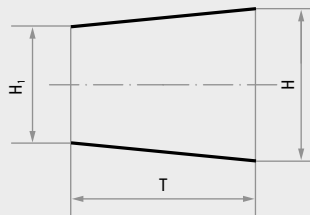
The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!



★★☆

Product number	Description	Type	D mm	T mm	S mm	L mm	$n_{max}$ rpm	Pack contains
A2502030306	STZY 03030.06	soft	30	30	6	40	9,500	5
A2502045306	STZY 04530.06	soft	45	30	6	40	6,300	5
A2502060306	STZY 06030.06	soft	60	30	6	40	4,700	5
A2502075308	STZY 07530.08	soft	75	30	8	40	3,800	2
A2502100408	STZY 10040.08	soft	100	40	8	40	2,800	2

## SBKE regular aluminium oxide abrasive band, conical shape



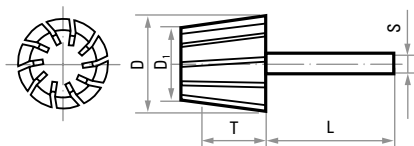
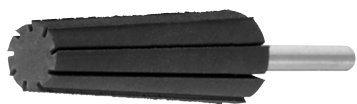
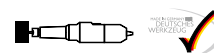
- tapered for grinding on hard-to-reach areas
- For rough grinding, regular aluminium oxide has good tool life when used on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with abrasive band mandrels for use with straight grinders or machines with flexible shafts

★★☆

Product number	Description	Grit	H mm	T mm	H <sub>1</sub> mm	Pack contains
A300002063040	SBKE 02063	NK 40	20	63	14	50
A300002063060	SBKE 02063	NK 60	20	63	14	50
A300002063080	SBKE 02063	NK 80	20	63	14	50
A300002063150	SBKE 02063	NK 150	20	63	14	50
A300002930040	SBKE 02930	NK 40	29	30	22	50
A300002930050	SBKE 02930	NK 50	29	30	22	50
A300002930060	SBKE 02930	NK 60	29	30	22	50
A300002930080	SBKE 02930	NK 80	29	30	22	50
A300002930150	SBKE 02930	NK 150	29	30	22	50
A300003660040	SBKE 03660	NK 40	36	60	22	50
A300003660050	SBKE 03660	NK 50	36	60	22	50
A300003660060	SBKE 03660	NK 60	36	60	22	50
A300003660080	SBKE 03660	NK 80	36	60	22	50
A300003660150	SBKE 03660	NK 150	36	60	22	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

## STKE hard abrasive band mandrel, conical shape



The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆

Product number	Description	Type	D mm	T mm	S mm	D <sub>1</sub> mm	L mm	n <sub>max</sub> rpm	Pack contains
A2500020636	STKE 02063.06	hard	20	63	6	14	40	21,000	5
A2500029306	STKE 02930.06	hard	29	30	6	22	40	21,000	5
A2500036606	STKE 03660.06	hard	36	60	6	22	40	13,500	5



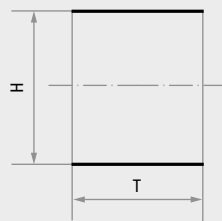
# ABRASIVE BANDS ALSO FOR CONDITIONING MACHINES

MEET EVERY CHALLENGE WITH LUKAS TOOLS

## SBZY abrasive band rolls



- abrasive band rolls in combination with a soft mandrel for use on conditioning machines
- For rough grinding, regular aluminium oxide has good tool life when used on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding



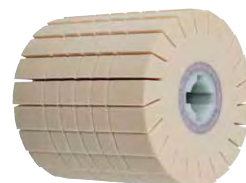
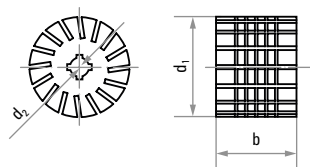
★★☆

Product number	Description	Grit	H mm	T mm	Pack contains
A2400100100060	SBZY 100100	NK 60	100	100	6
A2400100100080	SBZY 100100	NK 80	100	100	6
A2400100100120	SBZY 100100	NK 120	100	100	6
A2400100100150	SBZY 100100	NK 150	100	100	6

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium



## STWS soft abrasive band mandrel, cylindrical shape



The 19 mm bore has four 6 mm keyways.

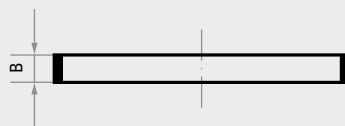
★★☆

Product number	Description	Type	d <sub>1</sub> mm	b mm	Bore d <sub>2</sub> mm	n <sub>max</sub> rpm	Pack contains
A2502100100	STWS 100100	soft	100	100	19	2,800	1

## LINISHING BELTS FROM LUKAS

BEST RESULTS TOGETHER WITH THE MATCHING LUKAS POWER TOOL

### SBL linishing belt



★★☆

- can be used on our AMIN 30 BSH pneumatic belt grinder
- operating speed: 28 m/s

Product number	Description	Grit	B mm	Length mm	Backing	Pack contains
A3000130305060T	SBLT	NK 60	13	305	robustly flexible	100
A3000130305080T	SBLT	NK 80	13	305	robustly flexible	100
A3000130305120T	SBLT	NK 120	13	305	robustly flexible	100
Recommended for: <span>● Steel</span> <span>● Cast material</span> <span>● Plastic/Wood</span> <span>● Inox/Steel</span> <span>● Aluminium</span> <span>● Titanium</span>						

### Belt grinder, insulated



#### Technical details:

- length: approx. 325 mm
- height: approx. 86 mm
- weight: approx. 0.90 kg
- drive: Vane motor

► Further technical details can be found on **page 301**.

#### Included with the machine:

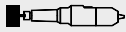
- clamping arm for linishing belts, dimension 13 x 305 mm
- air hose
- exhaust hose with muffler
- collet 6 mm
- operating tool

#### Special accessories:

- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"
- belt arms in various dimensions (lengths, widths and roll diameters) available from stock

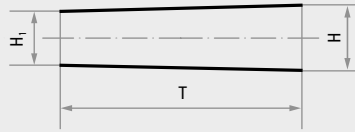
★★☆

Product number	Description	Valve	Idle speed (rpm)	Power consumption	Air consumption under load m³/min	Peripheral speed of band in m/s	Nominal hose size mm	Pack contains
A3993302113	AMIN 30 BSH	Lever	30,000	0.3	0.45	28	6	1



## SHKE conical abrasive sleeve

- tapered for grinding hard-to-reach areas
- For rough grinding, regular aluminium oxide has good tool life when working on structural steel and ensures cost-effective machining.
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with abrasive band mandrels for use with straight grinders or machines with flexible shafts



★★☆

Product number	Description	Grit	H mm	T mm	H <sub>1</sub> mm	Pack contains
A2101108080	SHKE 0885	NK 80	8	85	4.5	25
A2101108150	SHKE 0885	NK 150	8	85	4.5	25
A2101158080	SHKE 1385	NK 80	13	85	9.5	25
A2101158150	SHKE 1385	NK 150	13	85	9.5	25
A2101208080	SHKE 1885	NK 80	18	85	14.5	25
A2101208150	SHKE 1885	NK 150	18	85	14.5	25
A2101258080	SHKE 2385	NK 80	23	85	19.5	25
A2101258150	SHKE 2385	NK 150	23	85	19.5	25

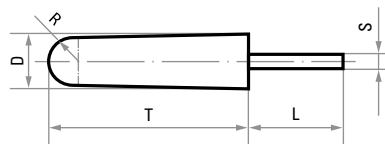
Recommended for: Steel Cast material Plastic/ Wood Inox/Steel Aluminium Titanium

GRINDING AND POLISHING  
(with flexible tools)



## GTKE conical abrasive sleeve mandrel

To reach deep machining areas, LUKAS grinding caps with a round conical shape (pp. 211–213) can also be used on this mandrel with a head length of 85 mm in addition to abrasive sleeves.



★★☆

Product number	Description	D mm	T mm	L mm	~ R mm	Shank diameter x length mm	n <sub>max</sub> rpm	Pack contains
A25001086	GTKE 0885	8	85	40	2	6 x 40	24,000	5
A25001586	GTKE 1385	13	85	40	5	6 x 40	17,000	5
A25002086	GTKE 1885	18	85	40	7.5	6 x 40	12,000	5
A25002586	GTKE 2385	23	85	40	9.5	6 x 40	10,000	5

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## Abrasive rolls and mandrels from LUKAS

SRZY CYLINDRICAL ABRASIVE ROLLS AND  
SRKE CONICAL ABRASIVE ROLLS

These abrasive rolls consist of wound abrasive cloth. Their design ensures that new abrasive grain is repeatedly exposed during the grinding process as the outer diameter wears down. Please pay attention to the rotational direction during use and mount the abrasive roll so that the bonded side points towards the mandrel.

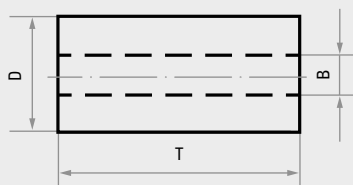
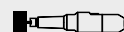
## Application examples:

- Deburring
- Cleaning
- Fettling

## SRTR ABRASIVE ROLL MANDREL

Reusable tool carrier for secure mounting of the cylindrical and conical abrasive rolls.

## SRZY Ceramic abrasive roll, cylindrical



- continuous grinding of small workpieces
- abrasive roll with ceramic grain for an exceptional tool life
- Hardened surfaces, wear-resistant steels, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- for deburring, cleaning or fettling of small workpieces
- enormous amount of abrasive coating due to the large, cylindrically wound working surface
- ▶ The matching tool carriers can be found on **page 208**.

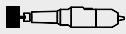
★★★

Product number	Description	Grit	D mm	T mm	B mm	$n_{max}$ rpm	Matching abrasive roll mandrels	Pack contains
A2403006380600001	SRZY 0638	Ceramic 60	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403006380800001	SRZY 0638	Ceramic 80	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403006381200001	SRZY 0638	Ceramic 120	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A2403010380600001	SRZY 1038	Ceramic 60	10	38	3	24,000	SRTR 3070.06	50
A2403010380800001	SRZY 1038	Ceramic 80	10	38	3	24,000	SRTR 3070.06	50
A2403010381200001	SRZY 1038	Ceramic 120	10	38	3	24,000	SRTR 3070.06	50
A2403013380600001	SRZY 1338	Ceramic 60	13	38	3	24,000	SRTR 3070.06	50
A2403013380800001	SRZY 1338	Ceramic 80	13	38	3	24,000	SRTR 3070.06	50
A2403013381200001	SRZY 1338	Ceramic 120	13	38	3	24,000	SRTR 3070.06	50

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

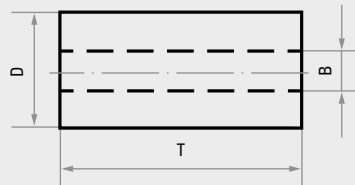
# MULTI-LAYER ABRASIVE COATING WOUND IN A CYLINDRICAL FORM

ACHIEVE AN EXCEPTIONAL TOOL LIFE WITH LUKAS ABRASIVE ROLLS



- for deburring, cleaning or fettling of small workpieces
  - Regular aluminium oxide has good tool life when used on structural steel, when rough grinding, and ensures cost-effective machining.
  - enormous amount of abrasive coating due to the large, cylindrically wound working surface
- The matching tool carriers can be found on **page 208**.

## SRZY regular aluminium oxide abrasive roll, cylindrical



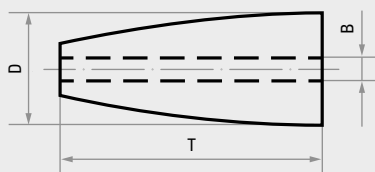
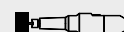
★★☆

Product number	Description	Grit	D mm	T mm	B mm	n <sub>max</sub> rpm	Matching abrasive roll mandrels	Pack contains
A240300625080	SRZY 0625	NK 80	6	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300625150	SRZY 0625	NK 150	6	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300638080	SRZY 0638	NK 80	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240300638150	SRZY 0638	NK 150	6	38	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025050	SRZY 1025	NK 50	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025080	SRZY 1025	NK 80	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301025150	SRZY 1025	NK 150	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240301038050	SRZY 1038	NK 50	10	38	3	24,000	SRTR 3070.06	50
A240301038080	SRZY 1038	NK 80	10	38	3	24,000	SRTR 3070.06	50
A240301038150	SRZY 1038	NK 150	10	38	3	24,000	SRTR 3070.06	50
A240301325050	SRZY 1325	NK 50	13	25	3	24,000	SRTR 3063.06	50
A240301325080	SRZY 1325	NK 80	13	25	3	24,000	SRTR 3063.06	50
A240301325150	SRZY 1325	NK 150	13	25	3	24,000	SRTR 3063.06	50
A240301338050	SRZY 1338	NK 50	13	38	3	24,000	SRTR 3070.06	50
A240301338080	SRZY 1338	NK 80	13	38	3	24,000	SRTR 3070.06	50
A240301338150	SRZY 1338	NK 150	13	38	3	24,000	SRTR 3070.06	50
A240302038050	SRZY 2038	NK 50	20	38	5	16,000	SRTR 5085.06	50
A240302038080	SRZY 2038	NK 80	20	38	5	16,000	SRTR 5085.06	50
A240302038150	SRZY 2038	NK 150	20	38	5	16,000	SRTR 5085.06	50
A240302050050	SRZY 2050	NK 50	20	50	5	16,000	SRTR 5085.06	50
A240302050080	SRZY 2050	NK 80	20	50	5	16,000	SRTR 5085.06	50

Recommended for: ● Steel ● Cast material ● Plastic / Wood ● Inox/Steel ● Aluminium ● Titanium



## SRKE regular aluminium oxide abrasive roll, conical



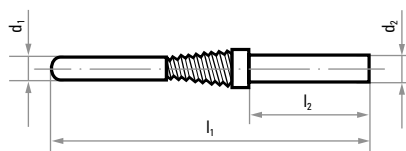
- for deburring, cleaning or fettling of small workpieces
- tapered for grinding hard-to-reach areas
- Regular aluminium oxide has good tool life when used on structural steel, when rough grinding, and ensures cost-effective machining.
- enormous amount of abrasive coating due to the large, cylindrically wound working surface
- ▶ The matching tool carriers can be found at the bottom of this page.

★★☆

Product number	Description	Grit	D mm	T mm	B mm	n <sub>max</sub> rpm	Matching abrasive roll mandrels	Pack contains
A240401025050	SRKE 1025	NK 50	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401025080	SRKE 1025	NK 80	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401025150	SRKE 1025	NK 150	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.06	50
A240401325050	SRKE 1325	NK 50	13	25	3	24,000	SRTR 3063.06	50
A240401325080	SRKE 1325	NK 80	13	25	3	24,000	SRTR 3063.06	50
A240401325150	SRKE 1325	NK 150	13	25	3	24,000	SRTR 3063.06	50
A240401338050	SRKE 1338	NK 50	13	38	3	24,000	SRTR 3070.06	50
A240401338080	SRKE 1338	NK 80	13	38	3	24,000	SRTR 3070.06	50
A240401338150	SRKE 1338	NK 150	13	38	3	24,000	SRTR 3070.06	50
A240401638050	SRKE 1638	NK 50	16	38	3	16,000	SRTR 3070.06	50
A240401638080	SRKE 1638	NK 80	16	38	3	16,000	SRTR 3070.06	50
A240401638150	SRKE 1638	NK 150	16	38	3	16,000	SRTR 3070.06	50
A240402050036	SRKE 2050	NK 36	20	50	5	16,000	SRTR 5085.06	50
A240402050050	SRKE 2050	NK 50	20	50	5	16,000	SRTR 5085.06	50
A240402050080	SRKE 2050	NK 80	20	50	5	16,000	SRTR 5085.06	50
A240402050150	SRKE 2050	NK 150	20	50	5	16,000	SRTR 5085.06	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

## SRTR abrasive roll mandrel



★★☆

Product number	Description	Type	d <sub>1</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	Pack contains
A32030130001	SRTR 3063.03	Inox	3	64	3	27	5
A32030160001	SRTR 3063.06	Inox	3	64	6	27	1
A32030260001	SRTR 3070.06	Inox	3	70	6	25	1
A32030460001	SRTR 5085.06	Inox	5	85	6	35	5

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS abrasive caps and mandrels

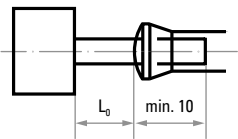
Our abrasive caps and sleeves consist of high-quality abrasive cloth and are manufactured to fit perfectly on our corresponding mandrels. We offer a large assortment of tools with the corresponding mandrel for various applications.

PERMISSIBLE SPEEDS

The maximum permissible speeds indicated in the respective table of abrasive cap mandrels apply for a maximum overhang length of 15 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

Application examples:

- Fine and ultra-fine grinding work, especially in hard-to-reach areas
- Machining in tool- and mouldmaking industry as well as pattern construction



ABRASIVE CAP CERAMIC	ABRASIVE CAP SPECIAL
★★★	★★☆
	
Self-sharpening ceramic grain for machining the most challenging materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem with this grain.	Special quality for the machining of corrosion and heat-resistant steels in the tool- and mouldmaking industry as well as for the universal machining of plastics, aluminium and non-ferrous metals. The surface layer with active abrasive additives enables enhanced stock removal rate and a longer tool life.

# THE GRINDING TOOL WITH SELF-SHARPENING EFFECT

GRIND LONGER ON THE HARDEST METALS WITH THE LUKAS CERAMIC ABRASIVE CAP



Whether tool steel, cast steel or titanium alloys – an increasing amount of extremely hard and tough metals are machined in industry. With the ceramic abrasive cap, a tool for straight grinders is now available that makes machining smaller parts and deburring extremely easy. An extra-long tool life is an added bonus thanks to the self-sharpening effect.

These abrasive caps are perfect for grinding uneven surfaces, machining small parts, deburring and regrinding small radii. The abrasive caps can even be used for stainless steel because they generate little heat during grinding.

## SELF-SHARPENING EFFECT REDUCES TOOL COSTS

Thanks to self-sharpening, Ceramic abrasive caps achieve a tool life many times that of ordinary caps. Tool changes are required much less frequently, thus reducing tool costs.

## NO MORE GLAZING

The grinding particles embedded in a resin matrix break off when worn and make way for new particles with sharp cutting edges. The dulling known as “glazing” familiar with other grinding tools does not occur when machining hard materials. As a result, the Ceramic abrasive cap continues to work like new despite wear.

**4** DIFFERENT  
SHAPES  
AVAILABLE



**AN ALL-ROUND TOOL  
FOR DEBURRING, GRINDING,  
BEVELLING AND REGRINDING**

## MAXIMUM CUTTING PERFORMANCE

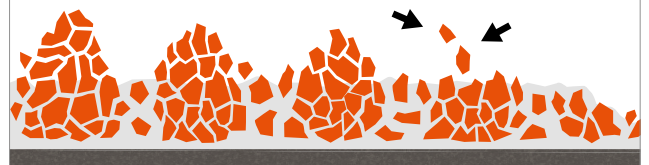
The abrasive caps with ceramic grain were developed for machining the most demanding materials. Hardened and wear-resistant steels, titanium alloys, weld seams and hard coatings are no longer a problem when using these abrasive caps. Due to its self-sharpening effect, this aggressive grinding behaviour is retained for a very long time.

## THE TROUBLESHOOTER FOR MACHINING METAL

The Ceramic abrasive caps represent a valuable addition as a tool for all industries in which hard metals are machined. These include the tool and mould industries as well as demanding mechanical and steel engineering and also the aerospace industry.

## THE SELF-SHARPENING EFFECT

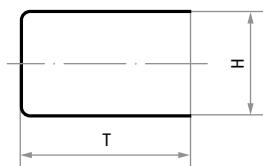
Worn grinding particles break off, exposing new particles with sharp cutting edges. That's why the abrasive cap remains as sharp as new for a long time.





## SK Ceramic abrasive caps NEW

- self-sharpening
- for the hardest materials
- exceptionally long tool life
- precise fit
- also for stainless steel



★★★

Product number	Description	Shapes	Grit	H mm	T mm	Pack contains
A21120052080	SKWR 0511		Ceramic 80	5	11	100
A21120052150	SKWR 0511		Ceramic 150	5	11	100
A21120072080	SKWR 0713		Ceramic 80	7	13	100
A21120072150	SKWR 0713		Ceramic 150	7	13	100
A21120102080	SKWR 1015		Ceramic 80	10	15	100
A21120102150	SKWR 1015		Ceramic 150	10	15	100
A21120132080	SKWR 1319		Ceramic 80	13	19	100
A21120132150	SKWR 1319		Ceramic 150	13	19	100
A21120162080	SKWR 1626		Ceramic 80	16	26	100
A21120162150	SKWR 1626		Ceramic 150	16	26	100
A2112051080	SKKE 0515		Ceramic 80	5	15	100
A2112051150	SKKE 0515		Ceramic 150	5	15	100
A2112112080	SKKE 1125		Ceramic 80	11	25	100
A2112112150	SKKE 1125		Ceramic 150	11	25	100
A2112163080	SKKE 1632		Ceramic 80	16	32	100
A2112163150	SKKE 1632		Ceramic 150	16	32	100
A2112224080	SKKE 2140		Ceramic 80	21	40	100
A2112224150	SKKE 2140		Ceramic 150	21	40	100
A21120051080	SKZY 0510		Ceramic 80	5	10	100
A21120051150	SKZY 0510		Ceramic 150	5	10	100
A21120071080	SKZY 0712		Ceramic 80	7	12	100
A21120071150	SKZY 0712		Ceramic 150	7	12	100
A21120101080	SKZY 1015		Ceramic 80	10	15	100
A21120101150	SKZY 1015		Ceramic 150	10	15	100
A21120131080	SKZY 1317		Ceramic 80	13	17	100
A21120131150	SKZY 1317		Ceramic 150	13	17	100
A21120161080	SKZY 1626		Ceramic 80	16	26	100
A21120161150	SKZY 1626		Ceramic 150	16	26	100
A21120053080	SKWK 0511		Ceramic 80	5	11	100
A21120053150	SKWK 0511		Ceramic 150	5	11	100
A21120073080	SKWK 0713		Ceramic 80	7	13	100
A21120073150	SKWK 0713		Ceramic 150	7	13	100
A21120103080	SKWK 1015		Ceramic 80	10	15	100
A21120103150	SKWK 1015		Ceramic 150	10	15	100
A21120133080	SKWK 1319		Ceramic 80	13	19	100
A21120133150	SKWK 1319		Ceramic 150	13	19	100
A21120163080	SKWK 1626		Ceramic 80	16	26	100
A21120163150	SKWK 1626		Ceramic 150	16	26	100

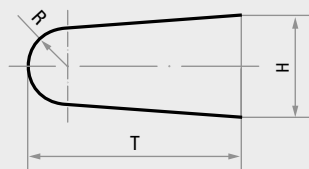
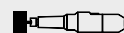
Recommended for: ● Inox/Steel ● Steel ● Cast material ● Titanium

GRINDING AND POLISHING  
(with flexible tools)

# THE PROBLEM-SOLVER IN TOOL- AND MOULDMAKING

ENHANCED STOCK REMOVAL RATE AND LONGER TOOL LIFE

## SKS Special abrasive cap



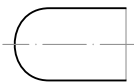
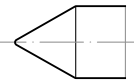
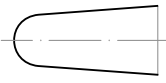
- enhanced stock removal rate using regular aluminium oxide with active abrasive surface layer
- suitable for corrosion and heat-resistant steels as well as for universal machining of plastics, non-ferrous metals and many other materials

★★☆

	Product number	Description	Shapes	Grit	H mm	T mm	Pack contains
	A21020051080	SKZYS 0510		NKS 80	5	10	100
	A21020051150	SKZYS 0510		NKS 150	5	10	100
NEW	A21020051320	SKZYS 0510		NKS 320	5	10	100
	A21020071060	SKZYS 0712		NKS 60	7	12	100
	A21020071080	SKZYS 0712		NKS 80	7	12	100
	A21020071150	SKZYS 0712		NKS 150	7	12	100
NEW	A21020071320	SKZYS 0712		NKS 320	7	12	100
	A21020101060	SKZYS 1015		NKS 60	10	15	100
	A21020101080	SKZYS 1015		NKS 80	10	15	100
	A21020101150	SKZYS 1015		NKS 150	10	15	100
NEW	A21020101320	SKZYS 1015		NKS 320	10	15	100
NEW	A21020131060	SKZYS 1317		NKS 60	13	17	100
NEW	A21020131080	SKZYS 1317		NKS 80	13	17	100
NEW	A21020131150	SKZYS 1317		NKS 150	13	17	100
NEW	A21020131320	SKZYS 1317		NKS 320	13	17	100
NEW	A21020161060	SKZYS 1626		NKS 60	16	26	100
NEW	A21020161080	SKZYS 1626		NKS 80	16	26	100
NEW	A21020161150	SKZYS 1626		NKS 150	16	26	100
NEW	A21020161320	SKZYS 1626		NKS 320	16	26	100
	A21020052080	SKWRS 0511		NKS 80	5	11	100
	A21020052150	SKWRS 0511		NKS 150	5	11	100
NEW	A21020052320	SKWRS 0511		NKS 320	5	11	100

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood



Product number	Description	Shapes	Grit	H mm	T mm	Pack contains	
A21020072060	SKWRS 0713		NKS 60	7	13	100	
A21020072080	SKWRS 0713		NKS 80	7	13	100	
A21020072150	SKWRS 0713		NKS 150	7	13	100	
A21020072320	SKWRS 0713		NKS 320	7	13	100 <b>NEW</b>	
A21020102060	SKWRS 1015		NKS 60	10	15	100	
A21020102080	SKWRS 1015		NKS 80	10	15	100	
A21020102150	SKWRS 1015		NKS 150	10	15	100	
A21020102320	SKWRS 1015		NKS 320	10	15	100 <b>NEW</b>	
A21020132060	SKWRS 1319		NKS 60	13	19	100	
A21020132080	SKWRS 1319		NKS 80	13	19	100	
A21020132150	SKWRS 1319		NKS 150	13	19	100	
A21020132320	SKWRS 1319		NKS 320	13	19	100 <b>NEW</b>	
A21020162060	SKWRS 1626		NKS 60	16	26	100 <b>NEW</b>	
A21020162080	SKWRS 1626		NKS 80	16	26	100 <b>NEW</b>	
A21020162150	SKWRS 1626		NKS 150	16	26	100 <b>NEW</b>	
A21020162320	SKWRS 1626		NKS 320	16	26	100 <b>NEW</b>	
A21020053060	SKWKS 0511		NKS 60	5	11	100 <b>NEW</b>	
A21020053080	SKWKS 0511		NKS 80	5	11	100	
A21020053150	SKWKS 0511		NKS 150	5	11	100	
A21020053320	SKWKS 0511		NKS 320	5	11	100 <b>NEW</b>	
A21020073060	SKWKS 0713		NKS 60	7	13	100	
A21020073080	SKWKS 0713		NKS 80	7	13	100	
A21020073150	SKWKS 0713		NKS 150	7	13	100	
A21020073320	SKWKS 0713		NKS 320	7	13	100 <b>NEW</b>	
A21020103060	SKWKS 1015		NKS 60	10	15	100	
A21020103080	SKWKS 1015		NKS 80	10	15	100	
A21020103150	SKWKS 1015		NKS 150	10	15	100	
A21020103320	SKWKS 1015		NKS 320	10	15	100 <b>NEW</b>	
A21020133060	SKWKS 1319		NKS 60	13	19	100	
A21020133080	SKWKS 1319		NKS 80	13	19	100	
A21020133150	SKWKS 1319		NKS 150	13	19	100	
A21020133320	SKWKS 1319		NKS 320	13	19	100 <b>NEW</b>	
A21020163060	SKWKS 1626		NKS 60	16	26	100 <b>NEW</b>	
A21020163080	SKWKS 1626		NKS 80	16	26	100 <b>NEW</b>	
A21020163150	SKWKS 1626		NKS 150	16	26	100 <b>NEW</b>	
A21020163320	SKWKS 1626		NKS 320	16	26	100 <b>NEW</b>	
Product number	Description	Shapes	Grit	H mm	T mm	~ R mm	Pack contains
A2102051080	SKKES 0515		NKS 80	5	15	2	25 <b>NEW</b>
A2102051150	SKKES 0515		NKS 150	5	15	2	25 <b>NEW</b>
A2102112060	SKKES 1125		NKS 60	11	25	5	25 <b>NEW</b>
A2102112080	SKKES 1125		NKS 80	11	25	5	25 <b>NEW</b>
A2102112150	SKKES 1125		NKS 150	11	25	5	25 <b>NEW</b>
A2102163060	SKKES 1632		NKS 60	16	32	7.5	25
A2102163080	SKKES 1632		NKS 80	16	32	7.5	25
A2102163150	SKKES 1632		NKS 150	16	32	7.5	25
A2102224060	SKKES 2140		NKS 60	21	40	9.5	25 <b>NEW</b>
A2102224080	SKKES 2140		NKS 80	21	40	9.5	25 <b>NEW</b>
A2102224150	SKKES 2140		NKS 150	21	40	9.5	25 <b>NEW</b>

Recommended for:

Inox/Steel

Steel

Aluminium

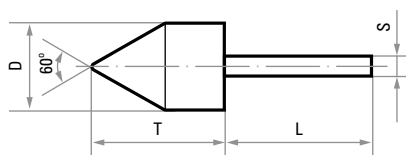
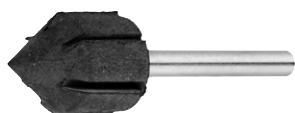
Cast material

Plastic/Wood

 Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood

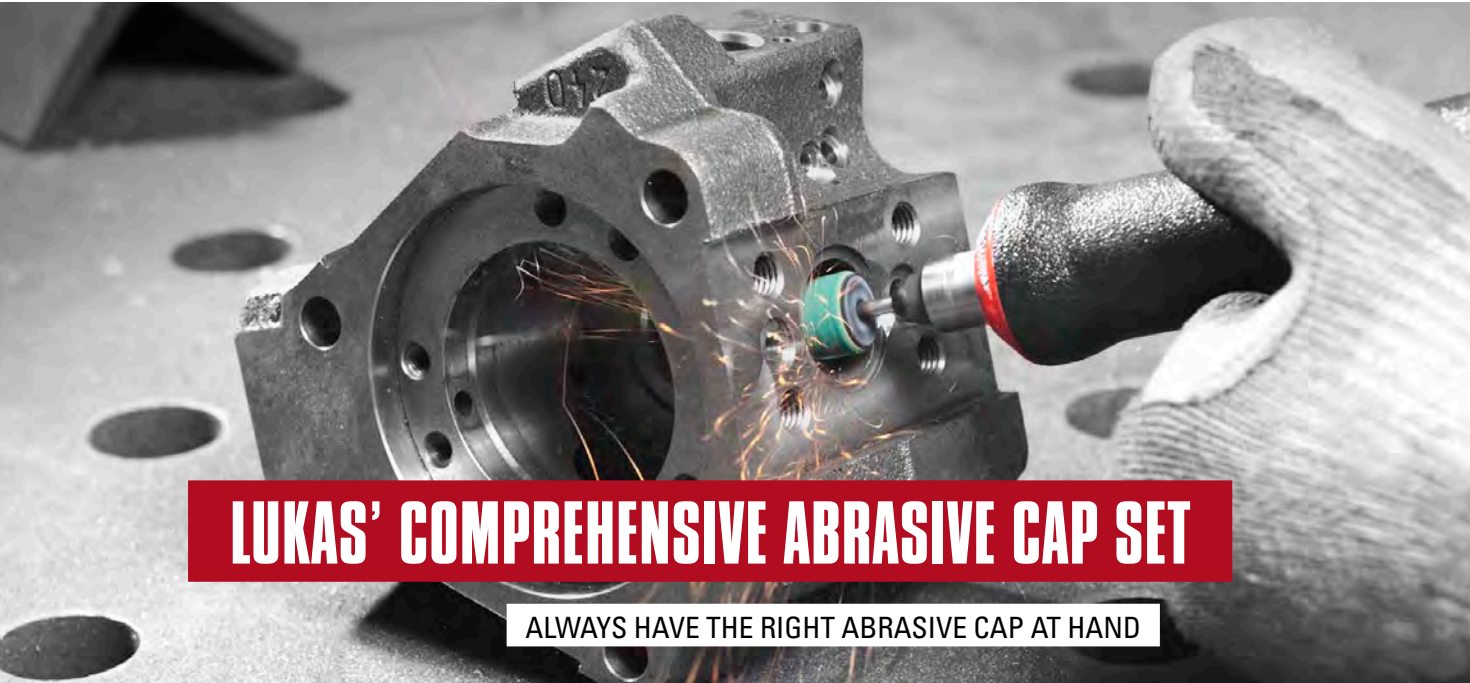
 GRINDING AND POLISHING  
(with flexible tools)

## Abrasive cap mandrel



★★☆

Product number	Description	Shapes	D mm	T mm	Shank diameter x length mm		n <sub>max</sub> rpm	Pack contains
A250000511	GTZY 0510		5	10	1/8" x 25		95,000	5
A250000513	GTZY 0510		5	10	3 x 25		95,000	5
A250000713	GTZY 0712		7	12	3 x 25		65,000	5
A250001011	GTZY 1015		10	15	1/8" x 25		45,000	5
A250001013	GTZY 1015		10	15	3 x 25		45,000	5
A250001313	GTZY 1317		13	17	3 x 25		35,000	5
A250001613	GTZY 1626		16	26	3 x 25		18,000	5
A250001616	GTZY 1626		16	26	6 x 40		30,000	5
A250000521	GTWR 0511		5	11	1/8" x 25		95,000	5
A250000523	GTWR 0511		5	11	3 x 25		95,000	5
A250000721	GTWR 0713		7	13	1/8" x 25		65,000	5
A250000723	GTWR 0713		7	13	3 x 25		65,000	5
A250001021	GTWR 1015		10	15	1/8" x 25		45,000	5
A250001023	GTWR 1015		10	15	3 x 25		45,000	5
A250001323	GTWR 1319		13	19	3 x 25		35,000	5
A250001621	GTWR 1626		16	26	1/8" x 25		18,000	5
A250001623	GTWR 1626		16	26	3 x 25		18,000	5
A250001626	GTWR 1626		16	26	6 x 40		30,000	5
A250000531	GTWK 0511		5	11	1/8" x 25		95,000	5
A250000533	GTWK 0511		5	11	3 x 25		95,000	5
A250000733	GTWK 0713		7	13	3 x 25		65,000	5
A250001033	GTWK 1015		10	15	3 x 25		45,000	5
A250001333	GTWK 1319		13	19	3 x 25		35,000	5
A250001633	GTWK 1626		16	26	3 x 25		18,000	5
A250001636	GTWK 1626		16	26	6 x 40		30,000	5
Product number	Description	Shapes	D mm	T mm	~ R mm	Shank diameter x length mm	n <sub>max</sub> rpm	Pack contains
A25000511	GTKE 0515		5	15	2	1/4" x 40	95,000	5
A25000513	GTKE 0515		5	15	2	3 x 25	57,000	5
A25000516	GTKE 0515		5	15	2	6 x 40	95,000	5
A25001126	GTKE 1125		11	25	5	6 x 40	40,000	5
A25001636	GTKE 1632		16	32	7.5	6 x 40	30,000	5
A25002246	GTKE 2140		21	40	9.5	6 x 40	20,000	5



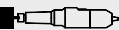
LUKAS' COMPREHENSIVE ABRASIVE CAP SET

ALWAYS HAVE THE RIGHT ABRASIVE CAP AT HAND

Be prepared for every eventuality: The LUKAS cap assortment offers you a large selection of different shapes and sizes – of course with the matching mandrel.

This set of special-quality abrasive caps contains a total of 640 caps and 23 mandrels. With its practical transport case, you can use this set whenever you need it at the workplace, in the factory or even in a model workshop. It is also suitable for testing the various shapes of LUKAS abrasive caps.

GRINDING AND POLISHING  
(with flexible tools)



WS abrasive cap assortment



- consists of 640 abrasive caps and 23 mandrels
- box outer dimensions: 372 x 189 x 46 mm

★★☆

Product number	Description	Quantity	Content				Pack contains
A210000065001	WS 65 NKS	50 pieces 100 per pack 50 per pack 20 per pack 10 pieces	Abrasive caps, grain NKS 150:  SKKES 0515 SKZYS 0510      SKWRS 0511      SKWKS 0511 SKZYS 0712      SKWRS 0713      SKWKS 0713 SKZYS 1015      SKWRS 1015 SKKES 1125				1
		20 pieces 10 per pack 15 per pack	Abrasive caps, grain NKS 80:  SKWKS 1015 SKZYS 1317      SKWRS 1319      SKWKS 1319      SKKES 1632 SKWKS 1626      SKWRS 1626				
		2 per pack  1 per pack	Mandrels, shank 3 mm:  GTZY 0510      GTWR 0511      GTWK 0511      GTZY 0712 GTWR 0713      GTWK 0713 GTZY 1015      GTWR 1015      GTWK 1015      GTZY 1317 GTWR 1319      GTWK 1319				
		1 per pack	Mandrels, shank 6 mm:  GTKE 0515      GTKE 1125      GTWK 1626      GTWR 1626 GTKE 1632				
		Recommended for: <span>●</span> Inox/Steel <span>●</span> Steel <span>●</span> Aluminium <span>●</span> Cast material <span>●</span> Plastic/Wood					

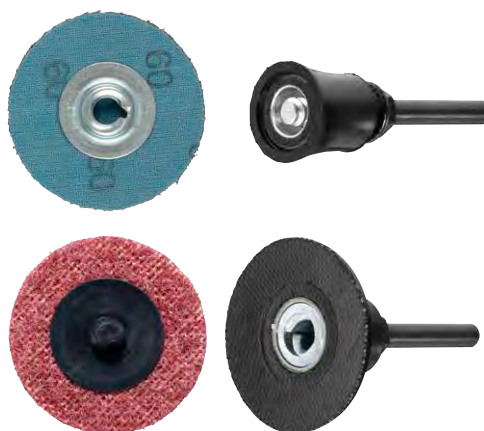
## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## Abrasive discs and carriers from LUKAS

## PSG/PSR SELF-CLAMPING ABRASIVE DISCS

LUKAS abrasive discs – PSG/PSR – are self-clamping. The back of the abrasive discs is fitted with a “quick lock” made of metal or plastic (PSG) or a plastic thread (PSR). The abrasive disc is attached to the corresponding carrier with a small twist. In this tool category, the PSG abrasive discs represents our most extensive range. Numerous diameters, many different grit sizes, and above all abrasive qualities for every application, help you to solve your grinding problem.

► Find out more about these abrasive discs on **pages 218–225**.



## PSK ADHESIVE ABRASIVE DISCS

LUKAS abrasive discs – PSK – are self-adhesive. The rubberised back of the abrasive discs is covered with a protective film. After removing this film, the abrasive discs are stuck to the respective carrier. These discs are suitable for machining many different surfaces. The adhesive bond does not permit reuse once the disc has been peeled off the carrier. These abrasive discs are available in regular aluminium oxide and silicon carbide as well as with different grit sizes, as illustrated in the following tables.

► Find out more about these abrasive discs on **pages 228/229**.



## PSH SELF-FIXING ABRASIVE DISCS

LUKAS abrasive discs – PSH – are self-fixing. The abrasive discs have a Velcro backing, with the corresponding carriers covered with hooked fabric. These discs are suitable for machining both flat and concave surfaces. Abrasive discs that have not been completely worn down during machining can be removed and reused another time. These abrasive discs are available in a quality and grit size adapted to the respective application as illustrated in the following tables.

► Find out more about these abrasive discs on **pages 231–234**.




## PSG ABRASIVE DISCS

# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

You will find all abrasive discs from the PSG range in the following overview. Read through the properties and application details of the different workpiece materials to find the right quality to meet your requirements.

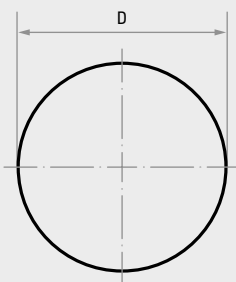
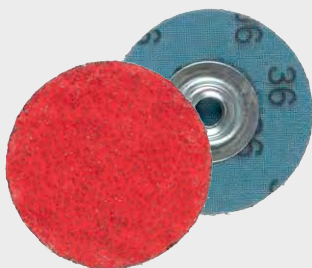
Quality		Properties	Application areas/machining	Page
	<b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	220
	<b>NKE</b> Abrasive cloth Regular aluminium oxide with reinforced backing material	very tough abrasive, high resilience	The reinforcement makes these discs suitable for the toughest demands and beveling.	221
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	ideal for Hastelloy, Inconel, non-rusting steel and metals that are difficult to machine	219
	<b>Z-Power</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	excellent stock removal rate, long tool life	ideal for machining non-rusting steel; special surface layer prevents clogging	219
	<b>Ceramic</b> Abrasive cloth Ceramic grain	excellent stock removal rate without grain shredding, particularly stable due to reinforced backing, cool cutting	ideal for machining non-rusting steel and nickel alloys	218
	<b>SIC</b> Abrasive cloth Silicon carbide	minimum heat accumulation, special quality for the aerospace industry	Ideal for machining titanium, titanium alloys and aluminium (aviation industry). Plastics and ceramics can also be processed.	223
	Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect with the fibre structure, consistent results due to continuous exposure of new grinding particles; long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of surface quality	222
	Abrasive fleece Regular aluminium oxide medium/red-brown			
	Abrasive fleece Regular aluminium oxide fine/blue			



# MACHINE ULTRA-HARD MATERIALS

INNOVATIVE CERAMIC GRAIN WITH SELF-SHARPENING EFFECT

## PSG Ceramic self-clamping abrasive disc

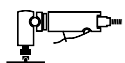


- especially robust ceramic grain for hard materials
  - fitted with a "quick lock" – fastened to the respective carrier by a small twist
  - high stock removal rate and long tool life
  - Hardened surfaces, wear-resistant steel, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- The matching tool carriers can be found on **page 223**.

★★★☆☆

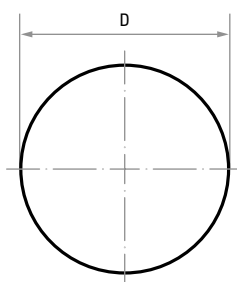
	Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
<b>NEW</b>	A33790250360458	PSG 025	Ceramic 36	25	38,000	GTG 025	100
<b>NEW</b>	A33790250600458	PSG 025	Ceramic 60	25	38,000	GTG 025	100
<b>NEW</b>	A33790250800458	PSG 025	Ceramic 80	25	38,000	GTG 025	100
<b>NEW</b>	A33790251200458	PSG 025	Ceramic 120	25	38,000	GTG 025	100
	A33790380360458	PSG 038	Ceramic 36	38	25,000	GTG 038	100
	A33790380600458	PSG 038	Ceramic 60	38	25,000	GTG 038	100
	A33790380800458	PSG 038	Ceramic 80	38	25,000	GTG 038	100
	A33790381200458	PSG 038	Ceramic 120	38	25,000	GTG 038	100
	A33790500360458	PSG 050	Ceramic 36	50	25,000	GTG 038 and GTG 050	100
<b>NEW</b>	A33790500500458	PSG 050	Ceramic 50	50	25,000	GTG 038 and GTG 050	100
	A33790500600458	PSG 050	Ceramic 60	50	25,000	GTG 038 and GTG 050	100
	A33790500800458	PSG 050	Ceramic 80	50	25,000	GTG 038 and GTG 050	100
	A33790501200458	PSG 050	Ceramic 120	50	25,000	GTG 038 and GTG 050	100
	A33790750360458	PSG 075	Ceramic 36	75	20,000	GTG 075	50
	A33790750600458	PSG 075	Ceramic 60	75	20,000	GTG 075	50
	A33790750800458	PSG 075	Ceramic 80	75	20,000	GTG 075	50
	A33790751200458	PSG 075	Ceramic 120	75	20,000	GTG 075	50

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



## PSG Z-Power self-clamping abrasive disc

- made of zirconia alumina with active abrasive surface layer
- ideal for machining stainless steel
- special surface layer prevents clogging
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 223**.



★★☆

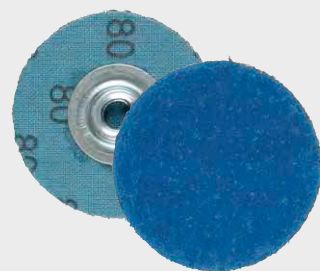
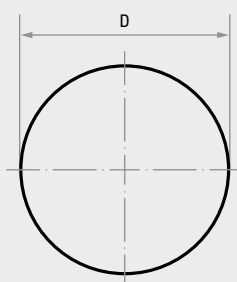
Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33770380360458	PSG 038	Z-Power 36	38	25,000	GTG 038	100
A33770380600458	PSG 038	Z-Power 60	38	25,000	GTG 038	100
A33770380800458	PSG 038	Z-Power 80	38	25,000	GTG 038	100
A33770381200458	PSG 038	Z-Power 120	38	25,000	GTG 038	100
A33770500360458	PSG 050	Z-Power 36	51	25,000	GTG 038 and GTG 050	100
A33770500600458	PSG 050	Z-Power 60	51	25,000	GTG 038 and GTG 050	100
A33770500800458	PSG 050	Z-Power 80	51	25,000	GTG 038 and GTG 050	100
A33770750360458	PSG 075	Z-Power 36	76	20,000	GTG 075	50
A33770750600458	PSG 075	Z-Power 60	76	20,000	GTG 075	50
A33770750800458	PSG 075	Z-Power 80	76	20,000	GTG 075	50
A33770751200458	PSG 075	Z-Power 120	76	20,000	GTG 075	50

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

GRINDING AND POLISHING  
(with flexible tools)

## PSG self-clamping zirconia alumina abrasive disc

- made from abrasive cloth with zirconia alumina
- ideal for Hastelloy, Inconel, stainless steel and metals that are difficult to machine
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 223**.



★★☆

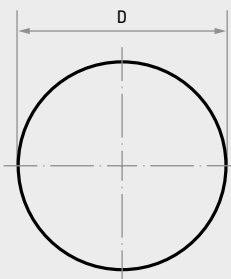
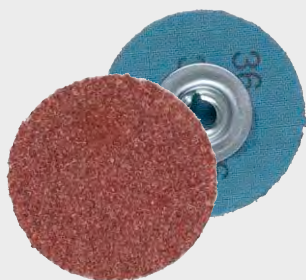
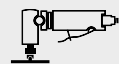
Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33530250600458	PSG 025	ZK 60	25	38,000	GTG 025	100
A33530250800458	PSG 025	ZK 80	25	38,000	GTG 025	100
A33530380600458	PSG 038	ZK 60	38	25,000	GTG 038	100
A33530380800458	PSG 038	ZK 80	38	25,000	GTG 038	100
A33530500360458	PSG 050	ZK 36	51	25,000	GTG 038 and GTG 050	100
A33530500600458	PSG 050	ZK 60	51	25,000	GTG 038 and GTG 050	100
A33530500800458	PSG 050	ZK 80	51	25,000	GTG 038 and GTG 050	100
A33530750360458	PSG 075	ZK 36	76	20,000	GTG 075	50
A33530750600458	PSG 075	ZK 60	76	20,000	GTG 075	50

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

# FOR UNIVERSAL USE

SELF-CLAMPING ABRASIVE DISCS FROM LUKAS WITH REGULAR ALUMINIUM OXIDE

## PSG self-clamping regular aluminium oxide abrasive disc



- for universal grinding and deburring work
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 223**.

★★☆

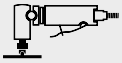
Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33510200600458	PSG 020	NK 60	19	47,000	GTG 020	100
A33510200800458	PSG 020	NK 80	19	47,000	GTG 020	100
A33510201200458	PSG 020	NK 120	19	47,000	GTG 020	100
A33510250360458	PSG 025	NK 36	25	38,000	GTG 025	100
A33510250600458	PSG 025	NK 60	25	38,000	GTG 025	100
A33510250800458	PSG 025	NK 80	25	38,000	GTG 025	100
A33510251200458	PSG 025	NK 120	25	38,000	GTG 025	100
A33510380360458	PSG 038	NK 36	38	25,000	GTG 038	100
A33510380600458	PSG 038	NK 60	38	25,000	GTG 038	100
A33510380800458	PSG 038	NK 80	38	25,000	GTG 038	100
A33510381200458	PSG 038	NK 120	38	25,000	GTG 038	100
A33510500360458	PSG 050	NK 36	51	25,000	GTG 038 and GTG 050	100
A33510500500458	PSG 050	NK 50	51	25,000	GTG 038 and GTG 050	100
A33510500600458	PSG 050	NK 60	51	25,000	GTG 038 and GTG 050	100
A33510500800458	PSG 050	NK 80	51	25,000	GTG 038 and GTG 050	100
A33510501200458	PSG 050	NK 120	51	25,000	GTG 038 and GTG 050	100
A33510501800458	PSG 050	NK 180	51	25,000	GTG 038 and GTG 050	100
A33510502400458	PSG 050	NK 240	51	25,000	GTG 038 and GTG 050	100
A33510750600458	PSG 075	NK 60	76	20,000	GTG 075	50
A33510750800458	PSG 075	NK 80	76	20,000	GTG 075	50
A33510751200458	PSG 075	NK 120	76	20,000	GTG 075	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium



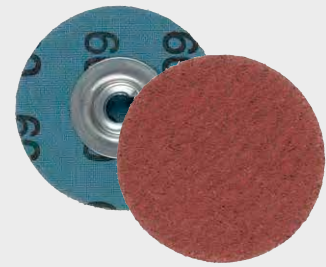
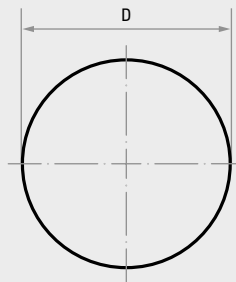
## CAN ALSO HANDLE EDGES

THANKS TO THE REINFORCED BACKING MATERIAL  
ALSO SUITABLE FOR THE TOUGHEST APPLICATIONS



### PSG reinforced self-clamping regular aluminium oxide abrasive disc

- made of abrasive cloth with regular aluminium oxide and reinforced backing material
- The reinforcement makes these discs suitable for the toughest applications and beveling.
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found on **page 223**.

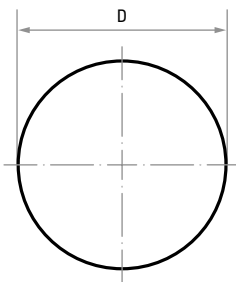
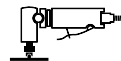


★★★

Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33520250600458	PSG 025	NKE 60	25	38,000	GTG 025	100
A33520250800458	PSG 025	NKE 80	25	38,000	GTG 025	100
A33520251200458	PSG 025	NKE 120	25	38,000	GTG 025	100
A33520251800458	PSG 025	NKE 180	25	38,000	GTG 025	100
A33520252400458	PSG 025	NKE 240	25	38,000	GTG 025	100
A33520380600458	PSG 038	NKE 60	38	25,000	GTG 038	100
A33520380800458	PSG 038	NKE 80	38	25,000	GTG 038	100
A33520381200458	PSG 038	NKE 120	38	25,000	GTG 038	100
A33520500360458	PSG 050	NKE 36	51	25,000	GTG 038 and GTG 050	100
A33520500600458	PSG 050	NKE 60	51	25,000	GTG 038 and GTG 050	100
A33520500800458	PSG 050	NKE 80	51	25,000	GTG 038 and GTG 050	100
A33520501200458	PSG 050	NKE 120	51	25,000	GTG 038 and GTG 050	100
A33520501800458	PSG 050	NKE 180	51	25,000	GTG 038 and GTG 050	100
A33520502400458	PSG 050	NKE 240	51	25,000	GTG 038 and GTG 050	100
A33520750800458	PSG 075	NKE 80	76	20,000	GTG 075	50

Recommended for: ● Steel ● Cast material ● Plastic/Wood ● Inox/Steel ● Aluminium ● Titanium

## PSG self-clamping abrasive disc, abrasive fleece

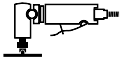


- ideal for removing rust or paint, scratches and pre-grinding marks
- Improvement of surface quality
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on **page 223**.

★★☆

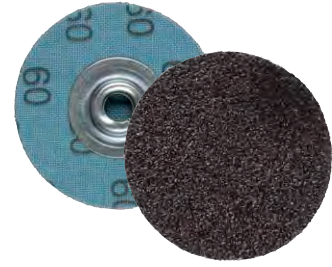
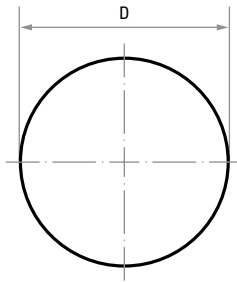
	Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
<b>NEW</b>	A33740250040458	PSG 025	P coarse	25	15,000	GTG 025	50
<b>NEW</b>	A33740250020458	PSG 025	P medium	25	15,000	GTG 025	50
	A33740380050458	PSG 038	P fine	38	10,000	GTG 038	50
	A33740380040458	PSG 038	P coarse	38	10,000	GTG 038	50
	A33740380020458	PSG 038	P medium	38	10,000	GTG 038	50
	A33740500050458	PSG 050	P fine	50	7,500	GTG 038 and GTG 050	50
	A33740500040458	PSG 050	P coarse	50	7,500	GTG 038 and GTG 050	50
	A33740500020458	PSG 050	P medium	50	7,500	GTG 038 and GTG 050	50
	A33740750050458	PSG 075	P fine	75	5,000	GTG 075	25
	A33740750040458	PSG 075	P coarse	75	5,000	GTG 075	25
	A33740750020458	PSG 075	P medium	75	5,000	GTG 075	25
<b>NEW</b>	A33550380040458	PSG 038	V coarse	38	10,000	GTG 038	50
<b>NEW</b>	A33550380020458	PSG 038	V medium	38	10,000	GTG 038	50
<b>NEW</b>	A33550380050458	PSG 038	V fine	38	10,000	GTG 038	50
<b>NEW</b>	A33550500040458	PSG 050	V coarse	50	8,000	GTG 038 and GTG 050	50
<b>NEW</b>	A33550500020458	PSG 050	V medium	50	8,000	GTG 038 and GTG 050	50
<b>NEW</b>	A33550500050458	PSG 050	V fine	50	8,000	GTG 038 and GTG 050	50
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: yellow;">●</span> Plastic/Wood <span style="color: orange;">●</span> Aluminium <span style="color: red;">●</span> Cast material <span style="color: black;">●</span> Titanium							





## PSG self-clamping silicon carbide abrasive disc

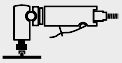
- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminium (aerospace industry), as well as plastics and ceramics
- fitted with a "quick lock" – fastened to the respective carrier by a small twist
- The matching tool carriers can be found at the bottom of this page.



★★☆

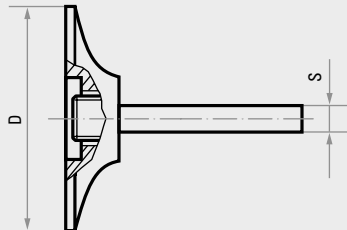
Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33780380360458	PSG 038	SIC 36	38	25,000	GTG 038	100
A33780380600458	PSG 038	SIC 60	38	25,000	GTG 038	100
A33780380800458	PSG 038	SIC 80	38	25,000	GTG 038	100
A33780500600458	PSG 050	SIC 60	51	25,000	GTG 038 and GTG 050	100
A33780500800458	PSG 050	SIC 80	51	25,000	GTG 038 and GTG 050	100
A33780501200458	PSG 050	SIC 120	51	25,000	GTG 038 and GTG 050	100

Recommended for: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material



## GTG abrasive disc carrier for self-clamping abrasive discs

The carriers are supplied in a universally-used medium hardness. This medium type is suitable for almost every application. Please use the hard type for the toughest machining jobs (Z-Power and Ceramic).



★★☆


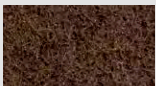
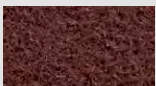
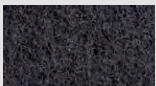
Product number	Description	Type	D mm	S mm	n <sub>max</sub> rpm	Pack contains
A335002000260458	GTG 020.06	medium	18	6	47,000	1
A335002500260458	GTG 025.06	medium	23	6	38,000	1
A335003800260458	GTG 038.06	medium	33	6	30,000	1
A335005000260458	GTG 050.06	medium	45	6	25,000	1
A335005000360458	GTG 050.06	hard	45	6	25,000	1
A335007500260458	GTG 075.06	medium	70	6	20,000	1
A335007500360458	GTG 075.06	hard	70	6	20,000	1

## PSR ABRASIVE DISCS

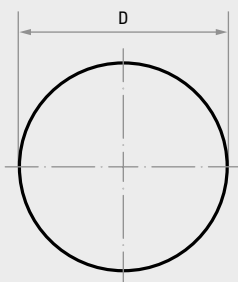
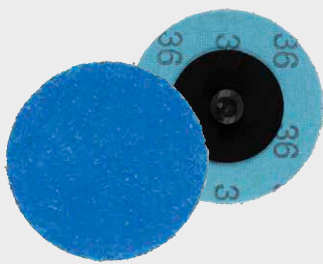
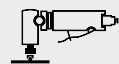
# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a

very wide selection. You will find all abrasive discs from the PSR range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality		Properties	Application areas/machining	Page
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resilient grain with high pressure resistance	ideal for Hastelloy, Inconel, stainless steel and metals that are difficult to machine	224
	Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect with the fibre structure, consistent results due to continuous exposure of new grinding particles; long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of surface quality	225
	Abrasive fleece Regular aluminium oxide medium/red-brown			
	Abrasive fleece Regular aluminium oxide fine/blue			

## PSR self-clamping zirconia alumina abrasive disc

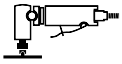


- made from abrasive cloth with zirconia alumina
- ideal for Hastelloy, Inconel, stainless steel and metals that are to machine
- with a plastic thread – fastened to the respective carrier by a small twist
- The matching tool carrier can be found on **page 227**.

★★☆

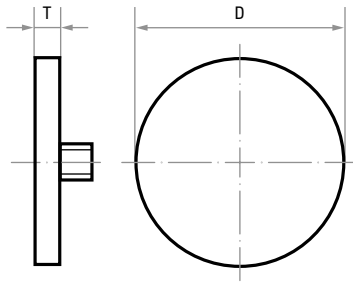
Product number	Description	Quality/grit size	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33630500360458	PSR 050	ZK 36	51	25,000	GTR 038 and GTR 050	100
A33630500600458	PSR 050	ZK 60	51	25,000	GTR 038 and GTR 050	100
A33630500800458	PSR 050	ZK 80	51	25,000	GTR 038 and GTR 050	100
<b>NEW</b> A33630501200458	PSR 050	ZK 120	51	25,000	GTR 038 and GTR 050	100
A33630750360458	PSR 075	ZK 36	76	20,000	GTR 075	50
A33630750600458	PSR 075	ZK 60	76	20,000	GTR 075	50
A33630750800458	PSR 075	ZK 80	76	20,000	GTR 075	50

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



## PSR self-clamping abrasive disc, narrow abrasive fleece

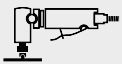
- ideal for removing rust or paint, scratches and pre-grinding marks
- P version with narrow abrasive fleece
- Improvement of surface quality
- with a plastic thread – fastened to the respective carrier by a small twist
- The matching tool carrier can be found on **page 227**.



★★☆

Product number	Description	Quality/grit size	D mm	T mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33750380020458	PSR 038	P medium	38	6	10,000	GTR 038	50
A33750380050458	PSR 038	P fine	38	6	10,000	GTR 038	50
A33750500040458	PSR 050	P coarse	51	6	7,500	GTR 038 and GTR 050	50
A33750500020458	PSR 050	P medium	51	6	7,500	GTR 038 and GTR 050	50
A33750500050458	PSR 050	P fine	51	6	7,500	GTR 038 and GTR 050	50
A33750750040458	PSR 075	P coarse	76	6	5,000	GTR 038, GTR 050 and GTR 075	25
A33750750050458	PSR 075	P fine	76	6	5,000	GTR 038, GTR 050 and GTR 075	25
A33750750020458	PSR 075	P medium	76	6	5,000	GTR 038, GTR 050 and GTR 075	25

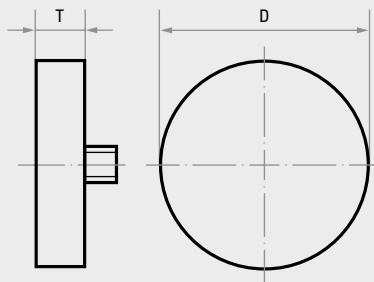
Recommended for: ● Inox/Steel ● Steel ● Plastic/Wood ● Aluminium ● Cast material ● Titanium



## PSR self-clamping abrasive disc, wide abrasive fleece

NEW

- ideal for removing rust or paint, scratches and pre-grinding marks
- V version with wider and softer abrasive fleece
- Improvement of surface quality
- with a plastic thread – fastened to the respective carrier by a small twist
- The matching tool carrier can be found on **page 227**.

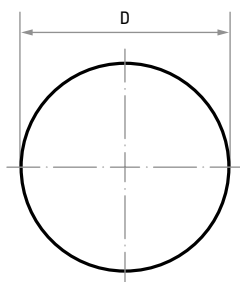
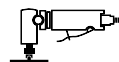


★★☆

Product number	Description	Quality/grit size	D mm	T mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33760500040458	PSR 050	V coarse	51	12	8,000	GTR 038 and GTR 050	50
A33760500020458	PSR 050	V medium	51	10	8,000	GTR 038 and GTR 050	50
A33760500050458	PSR 050	V fine	51	8	8,000	GTR 038 and GTR 050	50

Recommended for: ● Inox/Steel ● Steel ● Plastic/Wood ● Aluminium ● Cast material ● Titanium

## SLTG self-clamping lamellar flap disc

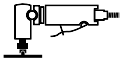


- excellent machining performance
- good grip even at low contact pressure
- long tool life (compared to surface grinding discs)
- Flap projection
- elastic
- perfectly suitable for use with robots
- with a plastic thread – fastened to the respective carrier by a small twist

★★☆

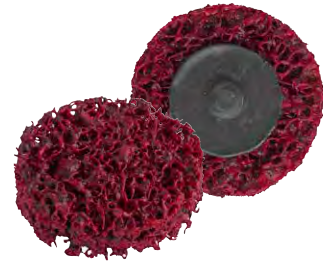
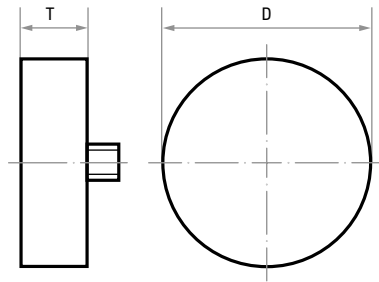
Product number	Description	Grit	D mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A33310500401623	SLTG 050 R	ZK 40	50	19,000	GTR 038.06	10
A33310500601623	SLTG 050 R	ZK 60	50	19,000	GTR 038.06	10
A33310500801623	SLTG 050 R	ZK 80	50	19,000	GTR 038.06	10
A33310501201623	SLTG 050 R	ZK 120	50	19,000	GTR 038.06	10
A33310650401623	SLTG 065 R	ZK 40	65	14,700	GTR 050.06	10
A33310650601623	SLTG 065 R	ZK 60	65	14,700	GTR 050.06	10
A33310650801623	SLTG 065 R	ZK 80	65	14,700	GTR 050.06	10
A33310750401623	SLTG 075 R	ZK 40	75	12,700	GTR 050.06	10
A33310750601623	SLTG 075 R	ZK 60	75	12,700	GTR 050.06	10
A33310750801623	SLTG 075 R	ZK 80	75	12,700	GTR 050.06	10
A33310751201623	SLTG 075 R	ZK 120	75	12,700	GTR 050.06	10

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



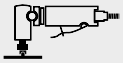
## ASVR self-clamping flap disc NEW

- the all-rounder for removing paint, adhesive residue and rust, as well as cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long tool life, high stock removal performance and fast operation
- with a plastic thread – fastened to the respective carrier by a small twist



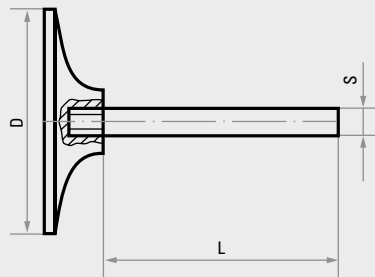
★★☆

Product number	Description	D mm	T mm	n <sub>max</sub> rpm	Matching abrasive disc carrier	Pack contains
A2291050002	ASVR 050	51	16	10,500	GTR 050.06	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material <span style="color: black;">●</span> Titanium						



## GTR abrasive disc carrier for self-clamping abrasive discs and flap discs

The carriers are supplied in a universally-used medium hardness. This medium type is suitable for almost every application.



★★☆

Product number	Description	Type	D mm	L mm	S mm	n <sub>max</sub> rpm	Pack contains
A336003800260458	GTR 038.06	medium	33	40	6	30,000	1
A336005000260458	GTR 050.06	medium	45	40	6	25,000	1
A336007500260458	GTR 075.06	medium	70	40	6	20,000	1



## PSK ABRASIVE DISCS

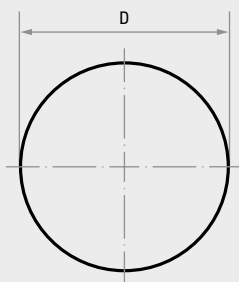
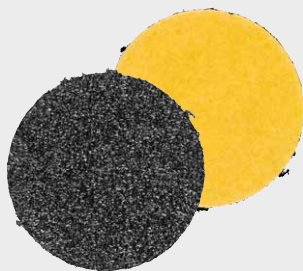
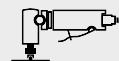
# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

You will find all abrasive discs from the PSK range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality	Properties	Application areas/machining	Page
 <p><b>NK</b> Abrasive cloth Regular aluminium oxide</p>	very tough abrasive, high resilience	universal grinding and deburring	229
 <p><b>SIC</b> Abrasive cloth Silicon carbide</p>	minimum heat accumulation, special quality for the aviation industry	Ideal for machining titanium, titanium alloys and aluminium (aerospace industry). Plastics and ceramics can also be processed.	228

## PSK adhesive silicon carbide abrasive disc



- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminium (aviation industry), as well as plastics and ceramic
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- ▶ The matching tool carrier can be found on **page 230**.

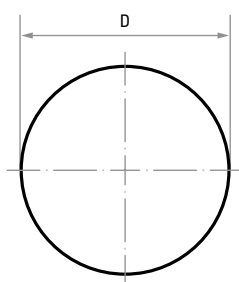
★★☆

Product number	Description	Grit	D mm	Pack contains
A2305018080	PSK 018	SIC 80	21	100
A2305018120	PSK 018	SIC 120	21	100
A2305030080	PSK 030	SIC 80	33	100
A2305030120	PSK 030	SIC 120	33	100
A2305045120	PSK 045	SIC 120	48	100

Recommended for: ● Aluminium ● Plastic/Wood ● Titanium ● Inox/Steel ● Steel ● Cast material



## PSK adhesive regular aluminium oxide abrasive disc



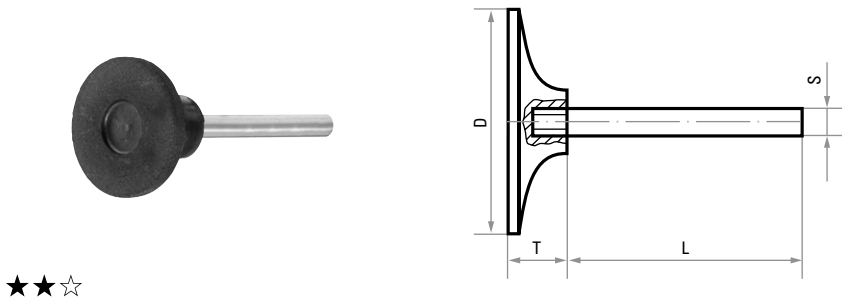
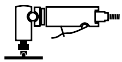
- for universal grinding and deburring
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- The matching tool carrier can be found on **page 230**.



Product number	Description	Grit	D mm	Pack contains
A2300018060	PSK 018	NK 60	21	100
A2300018080	PSK 018	NK 80	21	100
A2300018120	PSK 018	NK 120	21	100
A2300018150	PSK 018	NK 150	21	100
A2300018180	PSK 018	NK 180	21	100
A2300018240	PSK 018	NK 240	21	100
A2300030060	PSK 030	NK 60	33	100
A2300030080	PSK 030	NK 80	33	100
A2300030120	PSK 030	NK 120	33	100
A2300030150	PSK 030	NK 150	33	100
A2300030180	PSK 030	NK 180	33	100
A2300030240	PSK 030	NK 240	33	100
A2300045060	PSK 045	NK 60	48	100
A2300045080	PSK 045	NK 80	48	100
A2300045120	PSK 045	NK 120	48	100
A2300045150	PSK 045	NK 150	48	100
A2300045180	PSK 045	NK 180	48	100
A2300045240	PSK 045	NK 240	48	100
A2300060060	PSK 060	NK 60	63	100
A2300060080	PSK 060	NK 80	63	100
A2300060120	PSK 060	NK 120	63	100
A2300060150	PSK 060	NK 150	63	100
A2300075060	PSK 075	NK 60	78	100
A2300075080	PSK 075	NK 80	78	100
A2300075120	PSK 075	NK 120	78	100
A2300075150	PSK 075	NK 150	78	100

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium

GTK abrasive disc carrier for adhesive abrasive discs



The specified maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths.

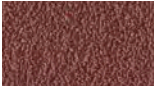



Product number	Description	D mm	S mm	T mm	L mm	$n_{max}$ rpm	Pack contains
A250301830001	GTK 018.03	18	3	11	30	20,000	5
A250303030001	GTK 030.03	30	3	12	30	12,500	5
A250303060001	GTK 030.06	30	6	12	40	12,500	5
A250304560001	GTK 045.06	45	6	11	40	10,000	5
A250306060001	GTK 060.06	60	6	13	40	8,000	5
A250307560001	GTK 075.06	75	6	15	40	6,000	2

PSH ABRASIVE DISCS

# Quality and applications

LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a

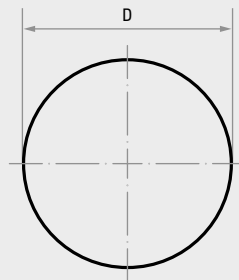
very wide selection. You will find all abrasive discs from the PSH range in the following overview. Read through the properties and application details for the different workpiece materials to find the right abrasives and tools that meet your requirements.

Quality		Properties	Application areas/machining	Page
	<b>NK</b> Abrasive cloth Regular aluminium oxide	very tough abrasive, high resilience	universal grinding and deburring	231–233
	Abrasive fleece Regular aluminium oxide coarse/brown	polishing effect due to fibre structure, consistent results thanks to continuous exposure of new grinding particles, long tool life	ideal for removing rust or paint, scratches and pre-grinding marks; general improvement of the surface finish	234
	Abrasive fleece Regular aluminium oxide medium/red-brown			
	Abrasive fleece Regular aluminium oxide fine/green			

GRINDING AND POLISHING  
(with flexible tools)



## PSH self-fixing regular aluminium oxide abrasive disc



★★☆

- suitable for the universal machining of both flat and concave surfaces
- with Velcro material for fast tool changes
- The matching tool carrier can be found on [page 332](#).

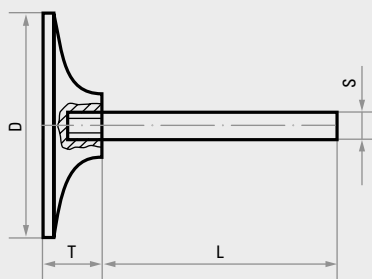
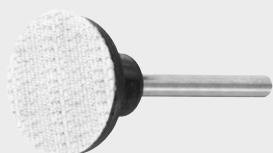
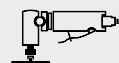
Product number	Description	Grit	D mm	Pack contains
A3300018060	PSH 018	NK 60	20	100
A3300018080	PSH 018	NK 80	20	100
A3300018120	PSH 018	NK 120	20	100
A3300018150	PSH 018	NK 150	20	100
A3300018180	PSH 018	NK 180	20	100
A3300018240	PSH 018	NK 240	20	100
A3300018320	PSH 018	NK 320	20	100
A3300030060	PSH 030	NK 60	33	100
A3300030080	PSH 030	NK 80	33	100
A3300030120	PSH 030	NK 120	33	100
A3300030150	PSH 030	NK 150	33	100
A3300030180	PSH 030	NK 180	33	100
A3300030240	PSH 030	NK 240	33	100

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium

Product number	Description	Grit	D mm	Pack contains
A3300030320	PSH 030	NK 320	33	100
A3300045060	PSH 045	NK 60	48	100
A3300045080	PSH 045	NK 80	48	100
A3300045120	PSH 045	NK 120	48	100
A3300045150	PSH 045	NK 150	48	100
A3300045180	PSH 045	NK 180	48	100
A3300045240	PSH 045	NK 240	48	100
A3300060060	PSH 060	NK 60	63	100
A3300060080	PSH 060	NK 80	63	100
A3300060120	PSH 060	NK 120	63	100
A3300060150	PSH 060	NK 150	63	100
A3300060180	PSH 060	NK 180	63	100
A3300060240	PSH 060	NK 240	63	100
A3300060320	PSH 060	NK 320	63	100
A3300075060	PSH 075	NK 60	78	100
A3300075080	PSH 075	NK 80	78	100
A3300075120	PSH 075	NK 120	78	100
A3300075150	PSH 075	NK 150	78	100
A3300075180	PSH 075	NK 180	78	100
A3300075240	PSH 075	NK 240	78	100
A3300075320	PSH 075	NK 320	78	100
A3300120060	PSH 125	NK 60	125	100
A3300120080	PSH 125	NK 80	125	100

Recommended for: ● Inox/Steel ● Steel ● Cast material ● Plastic/Wood ● Aluminium ● Titanium

## GTH abrasive disc carrier for self-fixing abrasive discs



The GTH abrasive disc carriers with diameters of 18 and 30 mm have Inox hooks. Hooks with a diameter of 45 mm and greater are made of polyamide.

The stated maximum permissible speeds apply for a maximum overhang length  $L_0$  of 20 mm. The maximum permissible speed must be calculated separately for other overhang lengths.

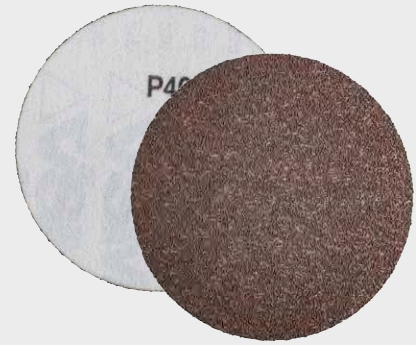
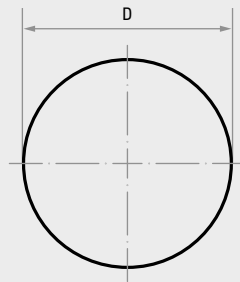
★★☆

Product number	Description	D mm	S mm	T mm	L mm	$n_{max}$ rpm	Pack contains
A250401830001	GTH 018.03	18	3	11	30	20,000	5
A250403030001	GTH 030.03	30	3	12	30	12,500	5
A250403060001	GTH 030.06	30	6	12	40	12,500	5
A250404560001	GTH 045.06	45	6	11	40	10,000	5
A250406060001	GTH 060.06	60	6	13	40	8,000	5
A250407560001	GTH 075.06	75	6	15	40	6,000	2
A25041206	GTH 120.06	120	6	20	25	4,000	2





## PSH self-fixing compact grain abrasive disc NEW



- With high grain density on cutting edges thanks to compact grain: guarantees extremely high stock removal performance
- does not clog even with soft or smearing materials
- with Velcro material for fast tool changes

★★☆

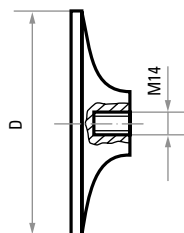
Product number	Description	Grit	D mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A73001150800001	PSH 115	NK 80	115	4,800	8,000	50
A73001151200004	PSH 115	NK 120	115	4,800	8,000	50
A73001152400005	PSH 115	NK 240	115	4,800	8,000	50
A73001154000005	PSH 115	NK 400	115	4,800	8,000	50
A73001158000005	PSH 115	NK 800	115	4,800	8,000	50
A73001151210005	PSH 115	NK 1200	115	4,800	8,000	50
A73001250800005	PSH 125	NK 80	125	4,600	7,650	50
A73001251200005	PSH 125	NK 120	125	4,600	7,650	50
A73001252400005	PSH 125	NK 240	125	4,600	7,650	50
A73001254000005	PSH 125	NK 400	125	4,600	7,650	50
A73001258000005	PSH 125	NK 800	125	4,600	7,650	50
A73001251210005	PSH 125	NK 1200	125	4,600	7,650	50
A73001500800005	PSH 150	NK 80	150	3,800	6,350	50
A73001501200006	PSH 150	NK 120	150	3,800	6,350	50
A73001502400005	PSH 150	NK 240	150	3,800	6,350	50
A73001504000005	PSH 150	NK 400	150	3,800	6,350	50
A73001508000005	PSH 150	NK 800	150	3,800	6,350	50
A73001501210005	PSH 150	NK 1200	150	3,800	6,350	50

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

GRINDING AND POLISHING  
(with flexible tools)



## GTHX abrasive disc carrier for self-fixing abrasive discs with thread NEW



★★☆

Product number	Description	Quality	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151004	GTHX 115	medium for Velcro discs	115	M14	8,300	1
A38311251004	GTHX 125	medium for Velcro discs	125	M14	7,600	1
A38311501004	GTHX 150	medium for Velcro discs	150	M14	6,300	1

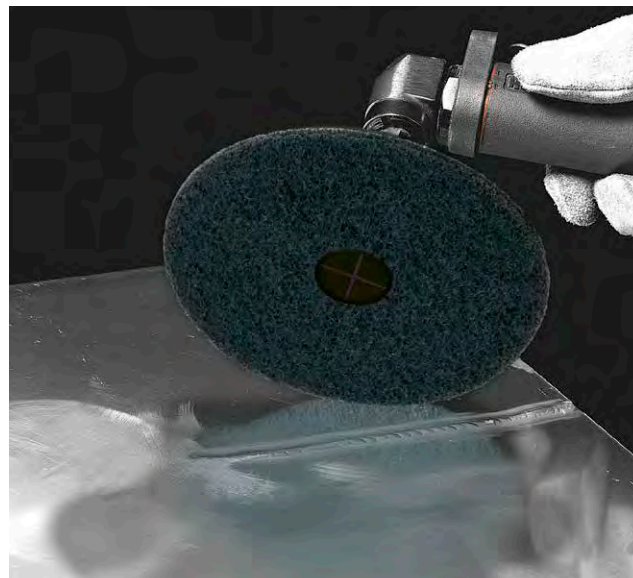
## SELF-FIXING ABRASIVE FLEECE DISCS

### ATTACHMENT MADE EASY THANKS TO THE FIXING SYSTEM

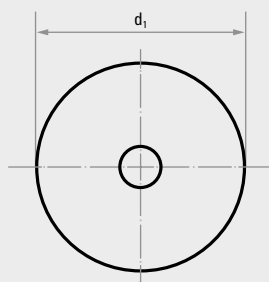
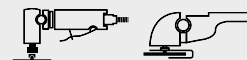
LUKAS PSH abrasive discs made of abrasive fleece are suitable for machining both flat and concave surfaces. Whether for removing rust or paint, scratches or pre-grinding marks, the polyamide material allows these discs to adapt themselves perfectly to uneven surfaces. You need less effort and time for your work, and yet still achieve perfect surface results. The fibre structure of the discs also produces a polishing effect and enables consistent results due to the constant exposure of new abrasive particles.

### SECURE AND FAST

In addition, time-consuming tool changes are also a thing of the past because these abrasive discs are self-fixing. The respective disc carrier uses a Velcro backing quick change system, which keeps the tool firmly in position. This eliminates needless waste of packaging material unlike other self-adhesive discs, for example. Abrasive discs that have not been completely worn down during machining can be removed and reused another time.



### NEW PSH self-fixing abrasive disc, abrasive fleece

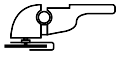


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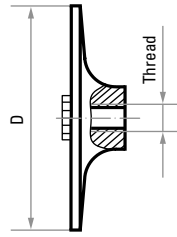
- suitable for machining both flat and concave surfaces
- adapts itself to uneven surfaces
- self-fixing to the respective carrier for a quick tool change
- ▶ The matching tool carrier can be found on **page 235**.

Product number	Description	Quality	D mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A3380115102001	PSH 115	Fleece coarse	115	4,100	8,300	10
A3380115104001	PSH 115	Fleece medium	115	4,100	8,300	10
A3380115107001	PSH 115	Fleece very fine	115	4,100	8,300	10
A3380125102001	PSH 125	Fleece coarse	125	3,800	7,600	10
A3380125104001	PSH 125	Fleece medium	125	3,800	7,600	10
A3380125107001	PSH 125	Fleece very fine	125	3,800	7,600	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/ Wood ● Titanium



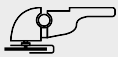
## GTH abrasive disc carrier for abrasive fleece with centering pin NEW



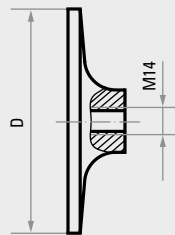
► especially for PSH with centering pin on page 234

★★☆

Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A25041151402	GTHZ 115	115	M14	8,300	1
A25041251402	GTHZ 125	125	M14	7,600	1



## GTH abrasive disc carrier for abrasive fleece



★★☆

Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151003	GTH 115	115	M14	8,300	1
A38311251003	GTH 125	125	M14	7,600	1

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## Fibre discs and carriers from LUKAS

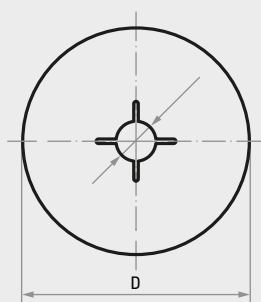
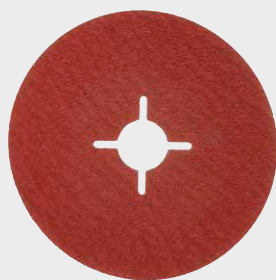
## FIS FIBRE DISCS

FIS fibre discs are used together with an STF backing pad on angle grinders. We offer these very popular tools in the qualities NK, ZK, Ceramic, as well as in an NK quality (BASE) for the price-conscious user.

## SHF SEMI-FLEXIBLE GRINDING DISCS

The semi-flexible SHF grinding discs consist of a stable fibre backing with a structured abrasive coating of silicon carbide. This combination is particularly suitable for rough grinding work on many different materials. Typical applications include removing paint, rust and adhesives, but also machining fibre-reinforced plastics such as CFRP and GFRP, e.g. in the manufacture of wind turbine blades. Like fibre discs, semi-flexible grinding discs for angle grinders are only used together with a STF backing pad.

## FIS Ceramic fibre disc with cross slot



★★★★



- single layer of abrasive with ceramic grain for the toughest applications
- high stock removal rate and long tool life
- Hardened surfaces, wear-resistant steel, scale and hard coatings, titanium alloys and reinforced weld seams can be machined quickly.
- used together with a backing pad on angle grinders
- ▶ The matching tool carriers can be found on **page 241**.

Product number	Description	Grit	D mm	Bore mm	n <sub>max</sub> rpm	Pack contains
A383011502030001	FIS 115	Ceramic 20	115	22	13,300	50
A383011503630001	FIS 115	Ceramic 36	115	22	13,300	50
A383011504030001	FIS 115	Ceramic 40	115	22	13,300	50
A383011505030001	FIS 115	Ceramic 50	115	22	13,300	50
A383011506030001	FIS 115	Ceramic 60	115	22	13,300	50
A383011508030001	FIS 115	Ceramic 80	115	22	13,300	50
A383012502030001	FIS 125	Ceramic 20	125	22	12,200	50
A383012502430001	FIS 125	Ceramic 24	125	22	12,200	50
A383012503630001	FIS 125	Ceramic 36	125	22	12,200	50
A383012504030001	FIS 125	Ceramic 40	125	22	12,200	50
A383012506030001	FIS 125	Ceramic 60	125	22	12,200	50
A383012508030001	FIS 125	Ceramic 80	125	22	12,200	50
A383012512030001	FIS 125	Ceramic 120	125	22	12,200	50
A383015002030001	FIS 150	Ceramic 20	150	22	10,200	50
A383015003630001	FIS 150	Ceramic 36	150	22	10,200	50
A383015004030001	FIS 150	Ceramic 40	150	22	10,200	50
A383018002030001	FIS 180	Ceramic 20	180	22	8,500	50
A383018003630001	FIS 180	Ceramic 36	180	22	8,500	50
A383018004030001	FIS 180	Ceramic 40	180	22	8,500	50
A383018006030001	FIS 180	Ceramic 60	180	22	8,500	50
A383018008030001	FIS 180	Ceramic 80	180	22	8,500	50

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

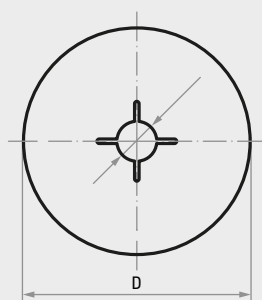
## FINE AND CONSISTENT SURFACE FINISH

LUKAS FIBRE DISCS FOR YOUR REQUIRED SURFACE RESULTS



### FIS zirconia alumina fibre disc with cross slot

- single layer of abrasive for the toughest applications
- made of exceptionally tough zirconia alumina with high resilience to pressure
- used together with a backing pad on angle grinders
- The matching tool carriers can be found on **page 241**.



★★☆

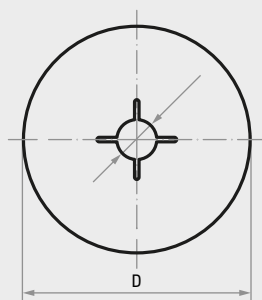
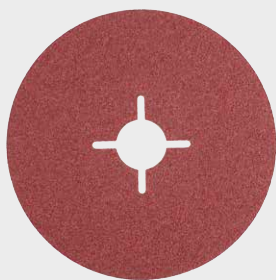
Product number	Description	Grit	D mm	Bore mm	n <sub>max</sub> rpm	Pack contains
A38301150362	FIS 115	ZK 36	115	22	13,300	50
A38301150402	FIS 115	ZK 40	115	22	13,300	50
A38301150602	FIS 115	ZK 60	115	22	13,300	50
A38301150802	FIS 115	ZK 80	115	22	13,300	50
A38301250362	FIS 125	ZK 36	125	22	12,200	50
A38301250402	FIS 125	ZK 40	125	22	12,200	50
A38301250602	FIS 125	ZK 60	125	22	12,200	50
A38301250802	FIS 125	ZK 80	125	22	12,200	50

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





## FIS regular aluminium oxide fibre disc with cross slot



★★☆

- single layer of abrasive for tough applications
- regular aluminium oxide for cost-effective working
- used together with a backing pad on angle grinders
- ▶ The matching tool carriers can be found on [page 241](#).

Product number	Description	Grit	D mm	Bore mm	n <sub>max</sub> rpm	Pack contains
A38301150241	FIS 115	NK 24	115	22	13,300	50
A38301150361	FIS 115	NK 36	115	22	13,300	50
A38301150401	FIS 115	NK 40	115	22	13,300	50
A38301150601	FIS 115	NK 60	115	22	13,300	50
A38301150801	FIS 115	NK 80	115	22	13,300	50
A38301151201	FIS 115	NK 120	115	22	13,300	50
A38301250241	FIS 125	NK 24	125	22	12,200	50
A38301250361	FIS 125	NK 36	125	22	12,200	50
A38301250401	FIS 125	NK 40	125	22	12,200	50
A38301250601	FIS 125	NK 60	125	22	12,200	50
A38301250801	FIS 125	NK 80	125	22	12,200	50
A38301500601	FIS 150	NK 60	150	22	10,200	50
A38301800241	FIS 180	NK 24	180	22	8,500	50
A38301800361	FIS 180	NK 36	180	22	8,500	50
A38301800401	FIS 180	NK 40	180	22	8,500	50
A38301800601	FIS 180	NK 60	180	22	8,500	50
A38301800801	FIS 180	NK 80	180	22	8,500	50

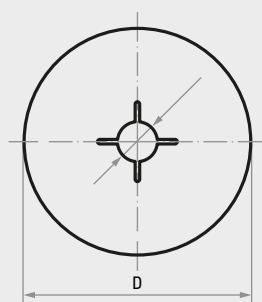
Recommended for: ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Inox/Steel ● Titanium

## COST-EFFECTIVE GRINDING

EXCELLENT PRICE-PERFORMANCE RATIO WITH LUKAS BASE-X



- single layer of abrasive for tough applications
- for the price-conscious user
- regular aluminium oxide for cost-effective working
- used together with a backing pad on angle grinders
- The matching tool carriers can be found on **page 241**.



### FIS BASE-X fibre disc with cross slot

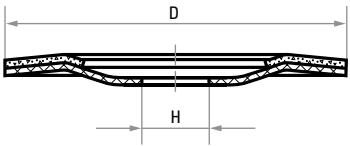


★☆☆

Product number	Description	Grit	D mm	Bore mm	n <sub>max</sub> rpm	Pack contains
A7830115024101	FIS 115	NK 24	115	22	13,300	25
A7830115036101	FIS 115	NK 36	115	22	13,300	25
A7830115040101	FIS 115	NK 40	115	22	13,300	25
A7830115060101	FIS 115	NK 60	115	22	13,300	25
A7830115080101	FIS 115	NK 80	115	22	13,300	25
A7830125024101	FIS 125	NK 24	125	22	12,200	25
A7830125036101	FIS 125	NK 36	125	22	12,200	25
A7830125040101	FIS 125	NK 40	125	22	12,200	25
A7830125060101	FIS 125	NK 60	125	22	12,200	25
A7830125080101	FIS 125	NK 80	125	22	12,200	25
A7830125120101	FIS 125	NK 120	125	22	12,200	25
A7830180036101	FIS 180	NK 36	180	22	8,500	25
A7830180060101	FIS 180	NK 60	180	22	8,500	25

Recommended for: ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Inox/Steel

# SHF semi-flexible grinding disc



- consists of a stable fibre backing with a structured abrasive coating of silicon carbide
- for removing paint, rust and adhesives, but also for machining fibre-reinforced plastics such as CFRP and GFRP (e.g. for wind turbine blades)
- also very suitable for animal hooves
- may only be used with backing pads
- ▶ The matching tool carriers can be found on **page 241**.

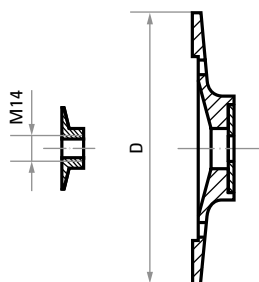
★★☆

Product number	Description	Grit	D mm	H mm	n <sub>max</sub> rpm	Pack contains
A38351150164	SHF 115	SIC 16	115	22.23	13,300	25
A38351150244	SHF 115	SIC 24	115	22.23	13,300	25
A38351150364	SHF 115	SIC 36	115	22.23	13,300	25
A38351150604	SHF 115	SIC 60	115	22.23	13,300	25
A38351250244	SHF 125	SIC 24	125	22.23	12,200	25
A38351250364	SHF 125	SIC 36	125	22.23	12,200	25
Recommended for: <span>● Steel</span> <span>● Aluminium</span> <span>● Stone/Construction material</span> <span>● Cast material</span> <span>● Plastic/Wood</span>						



## STF HL fibre disc backing pad with cooling slots

The carriers are supplied in a universally applicable degree of hardness; our medium type is suitable for almost every application. Other types are available on request for roughing work or radius grinding. Cooling slots and ventilation holes increase the stock removal rate and tool life.



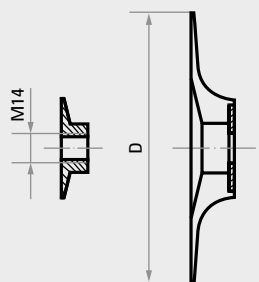
★★★

Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151002	STF HL	113	M14	13,300	1
A38311251002	STF HL	123	M14	12,200	1
A38311501002	STF HL	148	M14	10,200	1
A38311801002	STF HL	175	M14	8,500	1



## STF fibre disc backing pad

The carriers are supplied in a universally applicable degree of hardness; our medium type is suitable for almost every application. Other types are available on request for roughing work or radius grinding.



★★☆

■ nuts included

Product number	Description	D mm	Thread	n <sub>max</sub> rpm	Pack contains
A38311151001	STF 115	113	M14	13,300	1
A38311251001	STF 125	123	M14	12,200	1
A38311501001	STF 150	148	M14	10,200	1
A38311701001	STF 180	175	M14	8,500	1

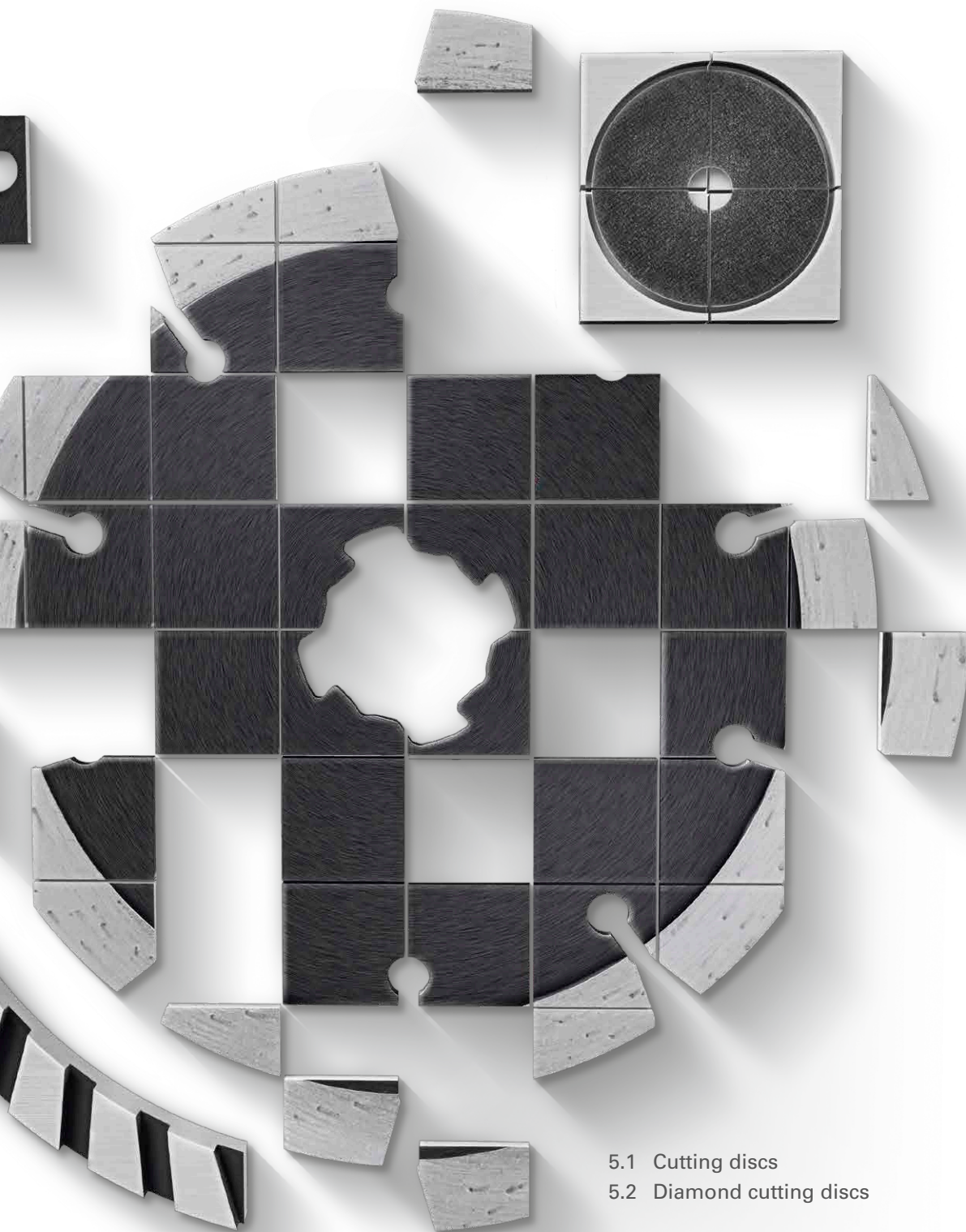




# CUTTING

- 5.1 Cutting discs
- 5.2 Diamond cutting discs

244–259  
260–267



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.

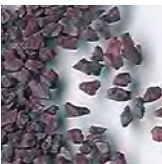
The following overview provides all the information concerning the abbreviations and markings.



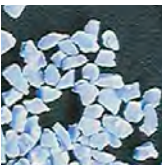
**A**  
Semi-friable  
aluminium oxide



**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

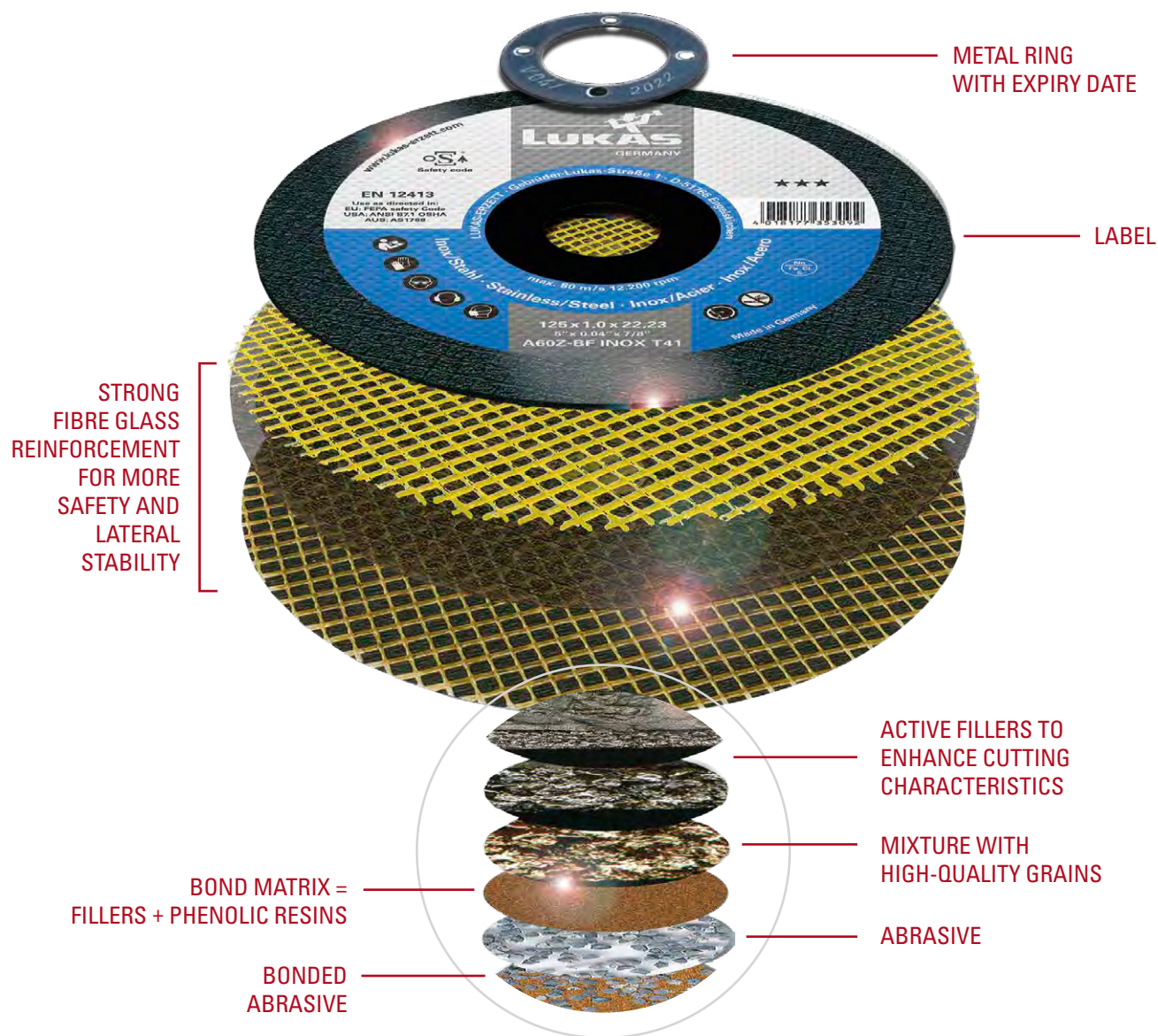
BOND

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											

## WORK SAFETY

# Safe cutting with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

## APPLIED STANDARDS

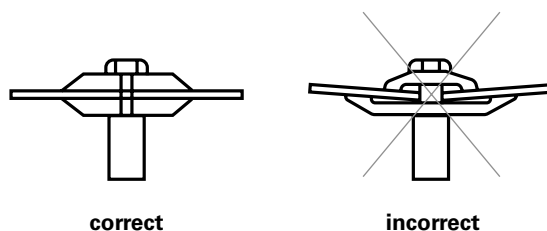
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

## SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced cutting discs on power tools.
- Store discs **in a dry place at room temperature.**
- Do not **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Use only discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Do not apply lateral pressure **to cutting discs.** Avoid bending the disc.
- Do not press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Do not cant and seize** the disc **when** cutting.
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Do not drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage.
- Do only use the machine only in a position where you have full control and are well balanced.

## CLAMPING SYSTEM

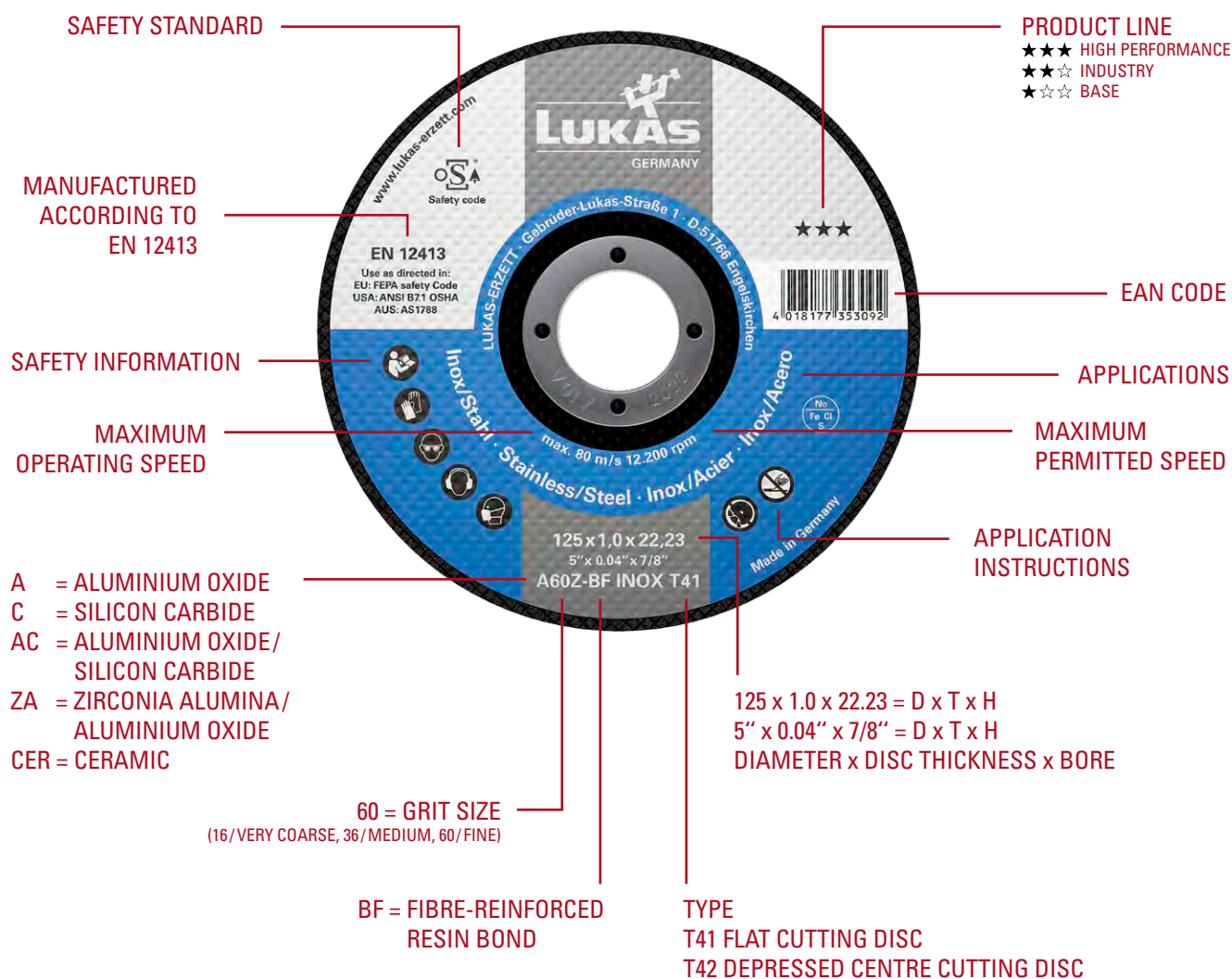
The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).





## LABELLING

## All important markings on the label



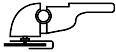





















## TYPES OF RESIN-BONDED CUTTING DISCS

T41 Flat cutting discs	T42 Depressed centre cutting disc
<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 1)</p>	<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 27)</p>
<ul style="list-style-type: none"> <li>Available in diameters from 50 mm (2") to 230 mm (9"), for handheld use</li> <li>From 300 mm (12") to 500 mm (20") for stationary machines</li> </ul>	<ul style="list-style-type: none"> <li>Available in diameters from 76 mm (3") to 230 mm (9"), approved for handheld use</li> </ul>



## AREA OF USE

## Overview of types of LUKAS cutting discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast metal/ Construction material
<b>Handheld cutting discs for angle grinders</b> Diameter 100–230 mm 	★★★	 Pages 249 – 251	 Page 255		 Pages 263 and 266	 Page 262
	★★☆	 Page 252	 Page 255	 Page 256	 Pages 263, 265 and 266	
	★☆☆	 Pages 254 and 259	 Page 256		 Pages 257, 265 and 267	
<b>Handheld cutting discs with X-LOCK system for angle grinders</b> Diameter 115–125 mm 	★★☆	 Page 253			 Pages 264 and 267	
<b>Stationary cutting discs</b> Diameter Larger than 230 mm  	★★★				 Page 263	 Page 262
	★★☆				 Pages 263–264 and 266	
	★☆☆	 Page 258	 Pages 258 / 259			

# MAXIMUM PERFORMANCE AND COOL CUTTING

EXTREMELY DURABLE FOR CUTTING STAINLESS STEEL

LUKAS cutting discs with ceramic grain are perfectly suited for high performance steel cutting. Thanks to the fast but cool cutting, they can machine inox without any blue discolouration whatsoever and have an exceptional tool life due to the self-sharpening effect. In addition, this tool requires little force to be applied.

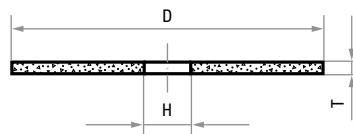
## EXTREME TOOL LIFE DUE TO SELF-SHARPENING EFFECT

The high performance cutting discs contain ceramic grit that constantly releases extremely fine particles in use. When the particles break off due to wear, new, sharp abrasive particles are immediately exposed. This self-sharpening effect allows

the highly-versatile cutting discs to achieve an excellent cutting performance consistently over the tool service life with little force required and boast impressive durability. This reduces the frequency of tool replacement significantly – lowering tool costs.

## FASTER CUTS WITH HIGHER EFFICIENCY

The ceramic grain allows hard materials, such as hardened surfaces, wear-resistant steels, scale and hardened coatings, titanium alloys and reinforced weld seams, to be cut easily and quickly.



- extremely long tool life
- energy optimised for the highest performance angle grinders
- maximum cutting performance
- little force required
- cool cutting

## Ceramic cutting disc **NEW**



★★★

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT008310V9802	T41 115x1.0	CER 46U-BF Inox	115	1.0	22.23	13,300	25
AT008312V9802	T41 125x1.0	CER 46U-BF Inox	125	1.0	22.23	12,200	25
AT008320V9802	T41 230x2.0	CER 46U-BF Inox	230	2.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium



# LUKAS CUTTING DISCS IN 3-STAR QUALITY

TOP PERFORMANCE FOR THE TOUGHEST JOBS

CUTTING

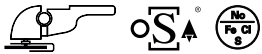
Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS cutting discs achieve the ultimate results.

The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star cutting discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety.

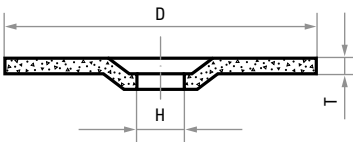
Eco-friendly production combined with first-class raw materials, optimised formulas and state-of-the-art production processes provide for high quality and a maximum storage time.

- maximum tool life and cutting performance with innovative bonding technology
- high cutting speed at a cool cutting temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in to quality thanks to top quality raw materials
- energy optimised for your high-performance angle grinders
- environmentally friendly production using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of inox and steel materials
- precise cutting

## COOL JOBBER – cutting and grinding disc for stainless steel



★★★



- for cutting and grinding with one tool
- carry out two work steps without changing tools
- practical, precise and safe

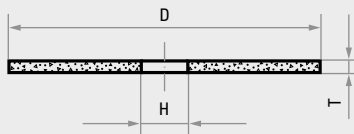
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS015675V9802	T27 115x2.0	A36V-BF Inox COOL JOBBER	115	2.0	22.23	13,300	25
AS015676V9802	T27 125x2.0	A36V-BF Inox COOL JOBBER	125	2.0	22.23	12,200	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium



## Cutting disc for stainless steel

- iron-, chloride- and sulphur-free tool
- cuts precisely at a high cutting speed and low cutting temperature
- maximum tool life and cutting performance through innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



★★★

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007231V9802	T41 115x1.0	A60Z-BF Inox		115	1.0	22.23	13,300	50
AT007235V9802	T41 115x1.6	A46Z-BF Inox		115	1.6	22.23	13,300	50
AT007211V9802	T41 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT007233V9802	T41 125x1.0	A60Z-BF Inox		125	1.0	22.23	12,200	50
AT007237V9802	T41 125x1.6	A46Z-BF Inox		125	1.6	22.23	12,200	50
AT007213V9802	T41 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007239V9802	T41 150x1.2	A60Z-BF Inox		150	1.2	22.23	10,200	50
AT007241V9802	T41 150x1.6	A46Z-BF Inox		150	1.6	22.23	10,200	25
AT007243V9802	T41 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007245V9802	T41 230x2.0	A46Z-BF Inox		230	2.0	22.23	6,600	25
AT007219V9802	T41 230x2.5	A30Z-BF Inox		230	2.5	22.23	6,600	25
AT005301V9802	T42 115x0.8	A60Z-BF Inox		115	0.8	22.23	13,300	50
AT007212V9802	T42 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT005302V9802	T42 125x0.8	A60Z-BF Inox		125	0.8	22.23	12,200	50
AT007214V9802	T42 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007244V9802	T42 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007246V9802	T42 230x1.9	A46Z-BF Inox		230	1.9	22.23	6,600	25
AT007220V9802	T42 230x2.5	A30Z-BF Inox		230	2.5	22.23	6,600	25

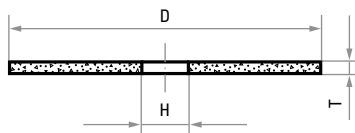
Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

CUTTING



## Cutting disc set

- The handy choice, e.g. for the construction site
- cutting discs in a metal can
  - safely packed
  - moisture-proof



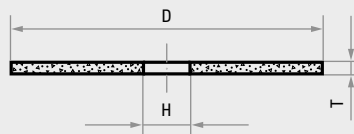
★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007231V9807010	T41 115x1.0	A60Z-BF Inox	115	1.0	22.23	13,300	10
AT007233V9807010	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	10

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



## Cutting disc for stainless steel



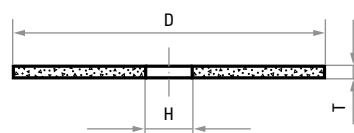
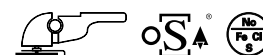
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005841V9802	T41 115x1.0	A60X-BF Inox		115	1.0	22.23	13,300	50
AT003346V9802	T41 115x1.6	A46X-BF Inox		115	1.6	22.23	13,300	50
AT001657V9802	T41 115x2.0	A36U-BF Inox		115	2.0	22.23	13,300	25
AT005842V9802	T41 125x1.0	A60X-BF Inox		125	1.0	22.23	12,200	50
AT003348V9802	T41 125x1.6	A46X-BF Inox		125	1.6	22.23	12,200	50
AT001687V9802	T41 125x2.0	A36U-BF Inox		125	2.0	22.23	12,200	25
AT003327V9802	T41 150x1.6	A46X-BF Inox		150	1.6	22.23	10,200	25
AT001743V9802	T41 180x2.0	A36U-BF Inox		180	2.0	22.23	8,500	25
AT005864V9802	T41 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT001782V9802	T41 230x2.0	A36U-BF Inox		230	2.0	22.23	6,600	25
AT001696V9802	T42 125x2.5	A30U-BF Inox		125	2.5	22.23	12,200	25
AT005571V9802	T42 180x1.6	A46X-BF Inox		180	1.6	22.23	8,500	25
AT005877V9802	T42 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT004464V9802	T42 230x3.0	A30U-BF Inox		230	3.0	22.23	6,600	25

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

## Cutting disc set



- The handy choice, e.g. for the construction site
- cutting discs in a metal can
  - safely packed
  - moisture-proof

★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005841V9807010	T41 115x1.0	A60X-BF Inox	115	1.0	22.23	13,300	10
AT005842V9807010	T41 125x1.0	A60X-BF Inox	125	1.0	22.23	12,200	10

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



Photo: Bosch

## TOOL CHANGE WITH JUST A CLICK

CHANGING CUTTING DISCS IS FASTER AND SIMPLER THAN EVER

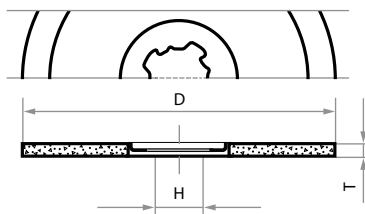
With the new X-LOCK system, simply position the LUKAS cutting disc on the angle grinder's mounting fixture, allow it to engage and you're done. The click sound tells you the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

### TOOL CHANGE IN NO TIME AT ALL

The X-LOCK allows you to change LUKAS cutting discs in seconds, as well as other LUKAS tool products such as the mounted flap discs found on **pages 144 and 154**.



- faster and simpler tool changes thanks to the latest X-LOCK system
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



### X-LOCK cutting disc **NEW**



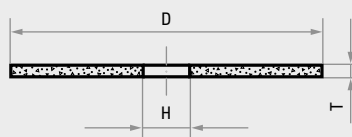
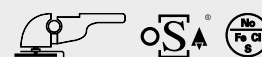
★★★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT115010V980201	T41 115x1.0x22.23 X-LOCK	A46U-BF Inox	115	1.0	22.23	13,300	50
AT125010V980202	T41 125x1.0x22.23 X-LOCK	A46U-BF Inox	125	1.0	22.23	12,200	50

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

CUTTING

## Cutting disc for stainless steel



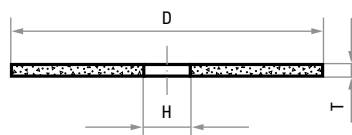
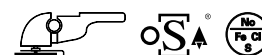
- free of iron, chlorine and sulphur
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT003108V9802	T41 100x1.0	A60S-BF Inox		100	1.0	16.00	15,300	50
AT004643V9802	T41 115x1.0	A60S-BF Inox		115	1.0	22.23	13,300	50
AT000647V9802	T41 115x1.6	A46T-BF Inox		115	1.6	22.23	13,300	50
AT002672V9802	T41 125x1.0	A60S-BF Inox		125	1.0	22.23	12,200	50
AT000674V9802	T41 125x1.6	A46T-BF Inox		125	1.6	22.23	12,200	50
AT000700V9802	T41 150x1.6	A46T-BF Inox		150	1.6	22.23	10,200	25
AT000716V9802	T41 180x1.6	A46T-BF Inox		180	1.6	22.23	8,500	25
AT000742V9802	T41 230x1.9	A46T-BF Inox		230	1.9	22.23	6,600	25
AT003568V9802	T41 230x3.0	A24/30S-BF Inox		230	3.0	22.23	6,600	25
AT001442V9802	T42 115x2.5	A24/30S-BF Inox		115	2.5	22.23	13,300	25
AT004157V9802	T42 125x2.5	A24/30S-BF Inox		125	2.5	22.23	12,200	25
AT000718V9802	T42 180x1.6	A46T-BF Inox		180	1.6	22.23	8,500	25
AT000744V9802	T42 230x1.9	A46T-BF Inox		230	1.9	22.23	6,600	25
AT005451V9802	T42 230x2.5	A24/30S-BF Inox		230	2.5	22.23	6,600	25
AT004168V9802	T42 230x3.0	A24/30S-BF Inox		230	3.0	22.23	6,600	25

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

## Cutting disc set



- The handy choice, e.g. for the construction site
- cutting discs in a metal can
  - safely packed
  - moisture-proof

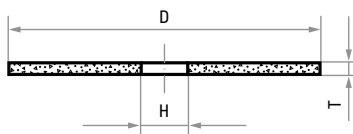
☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT004643V9807010	T41 115x1.0	A60S-BF Inox	115	1.0	22.23	13,300	10
AT002672V9807010	T41 125x1.0	A60S-BF Inox	125	1.0	22.23	12,200	10

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



- cuts precisely at a high cutting speed and low cutting temperature
- maximum tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



## Cutting disc for machining steel



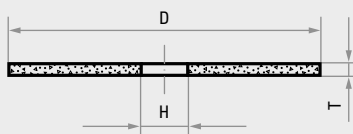
★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007276V9802	T41 115x1.0	A60Z-BF Steel	115	1.0	22.23	13,300	50
AT007271V9802	T41 115x1.6	A46Z-BF Steel	115	1.6	22.23	13,300	50
AT007278V9802	T41 125x1.0	A60Z-BF Steel	125	1.0	22.23	12,200	50
AT007273V9802	T41 125x1.6	A46Z-BF Steel	125	1.6	22.23	12,200	50
AT007284V9802	T41 230x1.9	A46Z-BF Steel	230	1.9	22.23	6,600	25

Recommended for: ● Steel ● Cast material



- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



## Cutting disc for steel

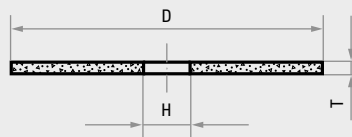
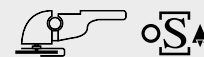


★★★

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005840V9802	T41 115x1.0	A60X-BF Steel		115	1.0	22.23	13,300	50
AT013301V9802	T41 115x1.6	A46X-BF Steel		115	1.6	22.23	13,300	50
AT001656V9802	T41 115x2.0	A36U-BF Steel		115	2.0	22.23	13,300	25
AT005835V9802	T41 125x1.0	A60X-BF Steel		125	1.0	22.23	12,200	50
AT013302V9802	T41 125x1.6	A46X-BF Steel		125	1.6	22.23	12,200	50
AT001686V9802	T41 125x2.0	A36U-BF Steel		125	2.0	22.23	12,200	25
AT011086V9802	T41 125x2.5	A30X-BF Steel		125	2.5	22.23	12,200	25
AT013303V9802	T41 150x1.6	A46X-BF Steel		150	1.6	22.23	10,200	25
AT013305V9802	T41 180x1.6	A46X-BF Steel		180	1.6	22.23	8,500	25
AT001742V9802	T41 180x2.0	A36U-BF Steel		180	2.0	22.23	8,500	25
AT005867V9802	T41 230x1.9	A46X-BF Steel		230	1.9	22.23	6,600	25
AT001781V9802	T41 230x2.0	A36U-BF Steel		230	2.0	22.23	6,600	25
AT001785V9802	T41 230x3.0	A30U-BF Steel		230	3.0	22.23	6,600	25
AT001665V9802	T42 115x2.5	A30U-BF Steel		115	2.5	22.23	13,300	25
AT001695V9802	T42 125x2.5	A30U-BF Steel		125	2.5	22.23	12,200	25
AT001724V9802	T42 150x2.5	A30U-BF Steel		150	2.5	22.23	10,200	25
AT001750V9802	T42 180x3.0	A30U-BF Steel		180	3.0	22.23	8,500	25
AT001790V9802	T42 230x2.5	A30U-BF Steel		230	2.5	22.23	6,600	25

Recommended for: ● Steel ● Cast material

## Cutting disc for steel



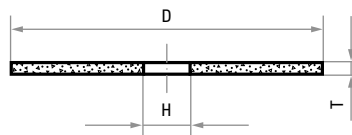
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT006440V9802	T41 115x1.0	A60S-BF Steel		115	1.0	22.23	13,300	50
AT006448V9802	T41 115x1.6	A46T-BF Steel		115	1.6	22.23	13,300	50
AT00656V9802	T41 115x2.5	A24R-BF Steel		115	2.5	22.23	13,300	25
AT006710V9802	T41 125x1.0	A60S-BF Steel		125	1.0	22.23	12,200	50
AT00675V9802	T41 125x1.6	A46T-BF Steel		125	1.6	22.23	12,200	50
AT00679V9802	T41 125x2.5	A24R-BF Steel		125	2.5	22.23	12,200	25
AT00707V9802	T41 150x2.5	A24R-BF Steel		150	2.5	22.23	10,200	25
AT00717V9802	T41 180x1.6	A46T-BF Steel		180	1.6	22.23	8,500	25
AT00728V9802	T41 180x3.0	A24R-BF Steel		180	3.0	22.23	8,500	25
AT00743V9802	T41 230x1.9	A46T-BF Steel		230	1.9	22.23	6,600	25
AT00967V9802	T41 230x2.0	A36T-BF Steel		230	2.0	22.23	6,600	25
AT00750V9802	T41 230x3.0	A24R-BF Steel		230	3.0	22.23	6,600	25
AT00662V9802	T42 115x2.5	A24R-BF Steel		115	2.5	22.23	13,300	25
AT00688V9802	T42 125x2.5	A24R-BF Steel		125	2.5	22.23	12,200	25
AT00732V9802	T42 180x3.0	A24R-BF Steel		180	3.0	22.23	8,500	25
AT00745V9802	T42 230x1.9	A46T-BF Steel		230	1.9	22.23	6,600	25
AT00754V9802	T42 230x3.0	A24R-BF Steel		230	3.0	22.23	6,600	25

Recommended for: ● Steel ● Cast material

## NEW Cutting disc for machining non-ferrous metals



- easily cuts soft, light metals
- no smearing when used on aluminium
- ideal combination of abrasive grit and bonding agent

☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT000920V9802	T41 115x1.0	A60N-BF Alu	115	1.0	22.23	13,300	50
AT000950V9802	T41 125x1.0	A60N-BF Alu	125	1.0	22.23	12,200	50
AT001694V9802	T41 125x2.5	A36N-BF Alu	125	2.5	22.23	12,200	25
AT001789V9802	T41 230x2.5	A36N-BF Alu	230	2.5	22.23	6,600	25

Recommended for: ● Aluminium

# THE DISC FOR UNIVERSAL USE

EFFICIENTLY CUT CONCRETE, STONE OR CAST MATERIAL

## FLEXIBLE, FAST WORKING

Especially in structural and civil engineering, for new buildings or structural alterations on existing ones and in road construction, tools are required that allow flexible machining of a broad range of building materials. Regardless of whether you are working with brickwork, cast pipes or concrete supports – LUKAS cutting discs for stone, concrete and cast material cut reliably and quickly. They are the perfect alternative for tradespeople who do not regularly use diamond cutting discs.

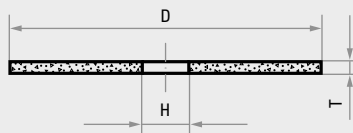
## BROAD RANGE OF APPLICATIONS

This disc is also used for fettling in many foundries and fettling shop, where they come into their own thanks to their high silicon carbide content. As a result, cast parts with inclusions and defects in the surface can be machined quickly and reliably. Risers and sprues can easily be cut off.



## Cutting disc for stone and cast material **NEW**

- for universal use
- for use on construction sites
- preferable to diamond cutting discs thanks to its excellent value for money and high speed



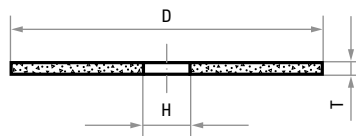
★☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT115025V980201	T41 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980201	T41 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT180030V980201	T41 180x3.0	C24S-BF Stone		180	3.0	22.23	8,500	25
AT230030V980201	T41 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT115025V980202	T42 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980202	T42 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT230030V980202	T42 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT230030V980203	T42 230x3.0	C24R-BF Stone		230	3.0	22.23	6,600	25

Recommended for: ● Stone ● Cast material



## Stationary cutting disc for machining stainless steel



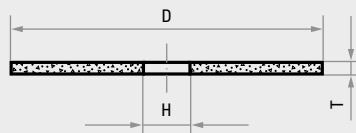
★☆☆

- free of iron, chlorine and sulphur
- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

Product number	Description	Quality	D mm	T mm	H mm	$n_{max}$ rpm	Pack contains
AT010003	T41 300x3.5	A30S-BF Inox	300	3.5	32.00	5,100	10
AT020208	T41 350x2.6	A30S-BF Inox	350	2.6	25.40	4,400	10

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

## Cutting disc for machining steel



★☆☆

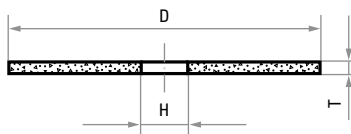
- large cutting disc for stationary and handheld use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

Product number	Description	Quality	D mm	T mm	H mm	$n_{max}$ rpm	Pack contains
AT010052	T41 300x4.0	A24R-BF	300	4.0	20.00	6,400	10
AT010055	T41 350x4.0	A24R-BF	350	4.0	20.00	5,400	10
AT010057	T41 350x4.0	A24R-BF	350	4.0	25.40	5,400	10

Recommended for: ● Steel ● Cast material



## Stationary cutting disc for machining steel

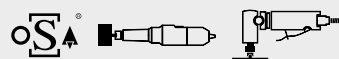


- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT010028	T41 300x2.6	A36S-BF Steel	300	2.6	25.40	6,400/80 m/s	10
AT001774	T41 300x3.5	A30T-BF Steel	300	3.5	22.23	6,400/100 m/s	10
AT001776	T41 300x3.5	A30T-BF Steel	300	3.5	25.40	6,400/100 m/s	10
AT010020	T41 300x3.5	A30T-BF Steel	300	3.5	32.00	6,400/100 m/s	10
AT010029	T41 350x2.6	A36S-BF Steel	350	2.6	25.40	5,400/80 m/s	10
AT010022	T41 350x3.5	A30T-BF Steel	350	3.5	25.40	5,400/100 m/s	10
AT010023	T41 350x3.5	A30T-BF Steel	350	3.5	32.00	5,400/100 m/s	10
AT010030	T41 400x3.2	A36S-BF Steel	400	3.2	25.40	4,700/80 m/s	5
AT010026	T41 400x4.0	A30T-BF Steel	400	4.0	32.00	4,700/100 m/s	5

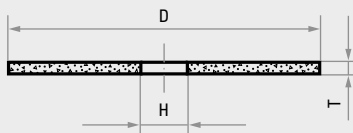
Recommended for: ● Steel ● Cast material



## Small cutting disc for machining stainless steel

NEW

- The thin width of less than a millimetre allows you to get to hard-to-reach places.
- delicately machine small parts
- free of iron, chlorine and sulphur
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n max rpm	Pack contains
AT501006V9802	T41 50x1.0	A46S-BF Inox	50	1.0	6.0	30,500	50
AT501010V9802	T41 50x1.0	A46S-BF Inox	50	1.0	10.0	30,500	50
AT761006V9802	T41 76x1.0	A46S-BF Inox	76	1.0	6.0	20,100	50
AT761010V9802	T41 76x1.0	A46S-BF Inox	76	1.0	10.0	20,100	50
AT763010V9802	T41 76x3.0	A46S-BF Inox	76	3.0	10.0	20,100	50

Recommended for: ● Inox/Steel ● Steel

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# **LUKAS diamond cutting discs**

## **DIAMOND**

Diamond is the hardest material in the world. The type of diamond chosen depends on what it is used for. Only synthetic diamonds are used for the diamond cutting discs. Unlike natural diamonds, their properties can be reproduced and controlled.

The following characteristics are significant when selecting diamonds:

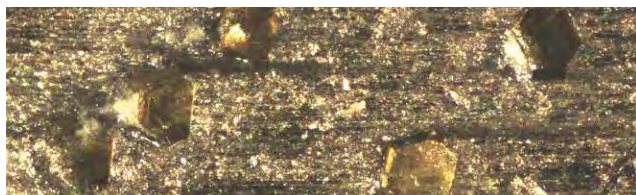
- degree of purity
- defined fracture strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grit sizes.



## **SEGMENT**

The segments consist of a diamond-embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists of bronze, cobalt, iron, carbide, or tungsten carbide, for example. The various characteristics of the metal powder give the segment sharpness and the all-important wear resistance. The segment coating is produced by a sintering process. A hard bond is selected for abrasive construction materials, while a soft bond is needed for hard structural materials.



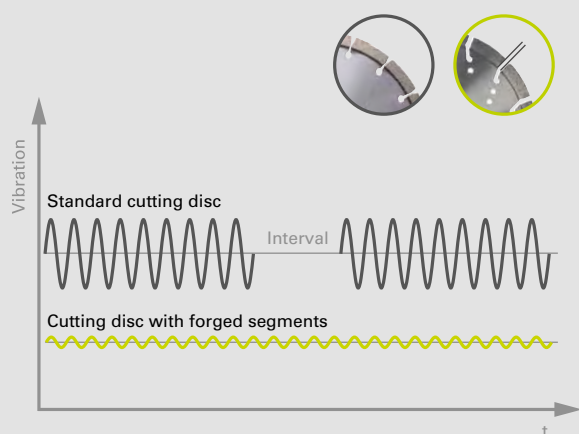
## **SEGMENT GEOMETRY**

The patented forged segment geometry allows even tall segments to be arranged very close to each other. This significantly reduces vibration for the user. Another crucial advantage is safety. The dense, porelessly forged segments have welds that provide much more safety against fracturing compared to the usual sintered segments.

- universal and fast due to new types of alloys in the segments
- less vibration through trapezium segment geometry
- more safety due to segment feet that are poreless and provide the utmost safety against fracturing
- long tool life thanks to taller segments and slower rate of diamond shedding

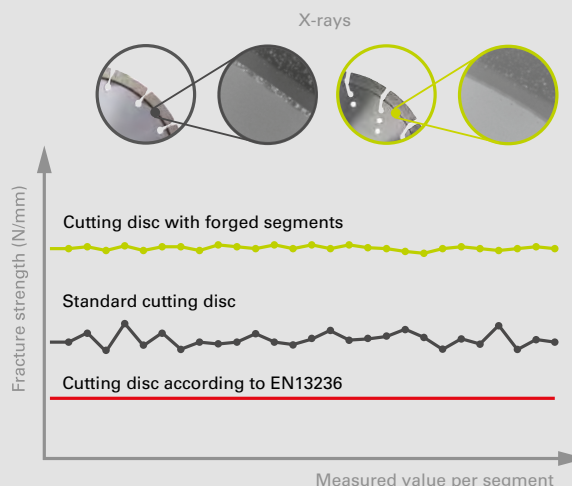
## **COMPARISON OF CUTTING PROPERTIES**

Low-vibration, narrow-gap cutting discs compared to cutting discs with forged segment



## **WELDING PROPERTIES OF FORGED SEGMENTS**

Highest level of safety against fracturing



## USAGE INSTRUCTIONS

# The right disc for your application

LUKAS has diamond cutting discs for a variety of materials. Whether you are working with concrete, tile or asphalt, you'll

find the perfect tool for every application. Select the material that you want to cut from the table below.

<div><div></div></div> best suitable	<div><div></div></div> suitable	Tile			Granite, hard materials			Concrete			Building material				Asphalt, abrasive materials						
Page	Product	Product line	Segment height mm	Tile	Fine stoneware	Granite tile	Granite	Porphyry	Clinker brick	Reinforced concrete	Exposed aggregate concrete	Concrete products	Brick, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Screed	Fresh concrete	Asphalt	Grey iron
Diamond cutting discs																					
262	VDC	★★★★	7																		
263	LD Multi S13		13																		
263/264	LD3 S10/ LD3 S10 X-LOCK	★★★☆☆	10																		
264	LD7 S10		10																		
265	Turbo S10		10																		
265	Blue Cut S10	★★☆☆☆	10																		
265	TC7		7																		
Tile cutting discs																					
266	FAST CUT S10	★★★★	10																		
266/267	FLIESE S7/ FLIESE S7 X-LOCK	★★★☆☆	7																		
267	FC7	★★☆☆☆	7																		

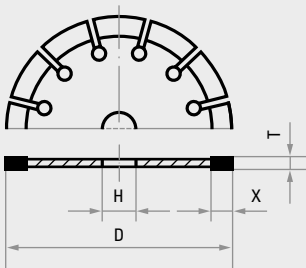
# VDC – AGGRESSIVE APPLICATION WITH EXTREME TOOL LIFE

STAYS COOL. NO DUST OR ODOURS. NO EXPIRY DATE.



CUTTING

## VDC diamond cutting disc



★★★

- the diamond cutting disc that revolutionised cutting cast iron
- ideal for cutting cast iron (GG, GGG), fibreglass reinforced plastics (GFRP) and mineralisation
- not suitable for high-alloy materials containing nickel!

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A34901152222	VDC 115022	115	7.0	2.2	22.23	13,300	1
A34901252222	VDC 125022	125	7.0	2.2	22.23	12,200	1
A34901802622	VDC 180026	180	7.0	2.2	22.23	8,500	1
A34902303022	VDC 230030	230	7.0	3.0	22.23	6,600	1
A34903503632	VDC 350036	350	7.0	3.6	32.00	4,400	1

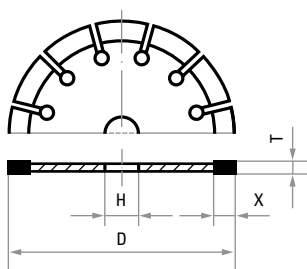
Recommended for: ● Stone/Construction material ● Cast material ● Plastic





## LD Multi S13 diamond cutting disc

- professional disc for concrete and construction materials
- extremely versatile with optimum cutting speed
- long tool life
- Trapezium-shaped segments ensure low vibration.
- segment produced using forge technology



★★★

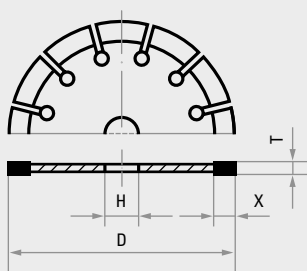
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344031151213083	LD Multi S13	115	13	2.4	22.23	13,300	1
A344031251213093	LD Multi S13	125	13	2.4	22.23	12,200	1
A344031501213113	LD Multi S13	150	13	2.4	22.23	10,200	1
A344031801213133	LD Multi S13	180	13	2.4	22.23	8,500	1
A344032301213153	LD Multi S13	230	13	2.6	22.23	6,600	1
A344033002213183	LD Multi S13	300	13	2.8	25.4	6,400	1
A344033502213213	LD Multi S13	350	13	3.0	25.4	5,500	1
A344034002213243	LD Multi S13	400	13	3.2	25.4	4,800	1

Recommended for: ● Stone/Construction material



## LD3 S10 diamond cutting disc

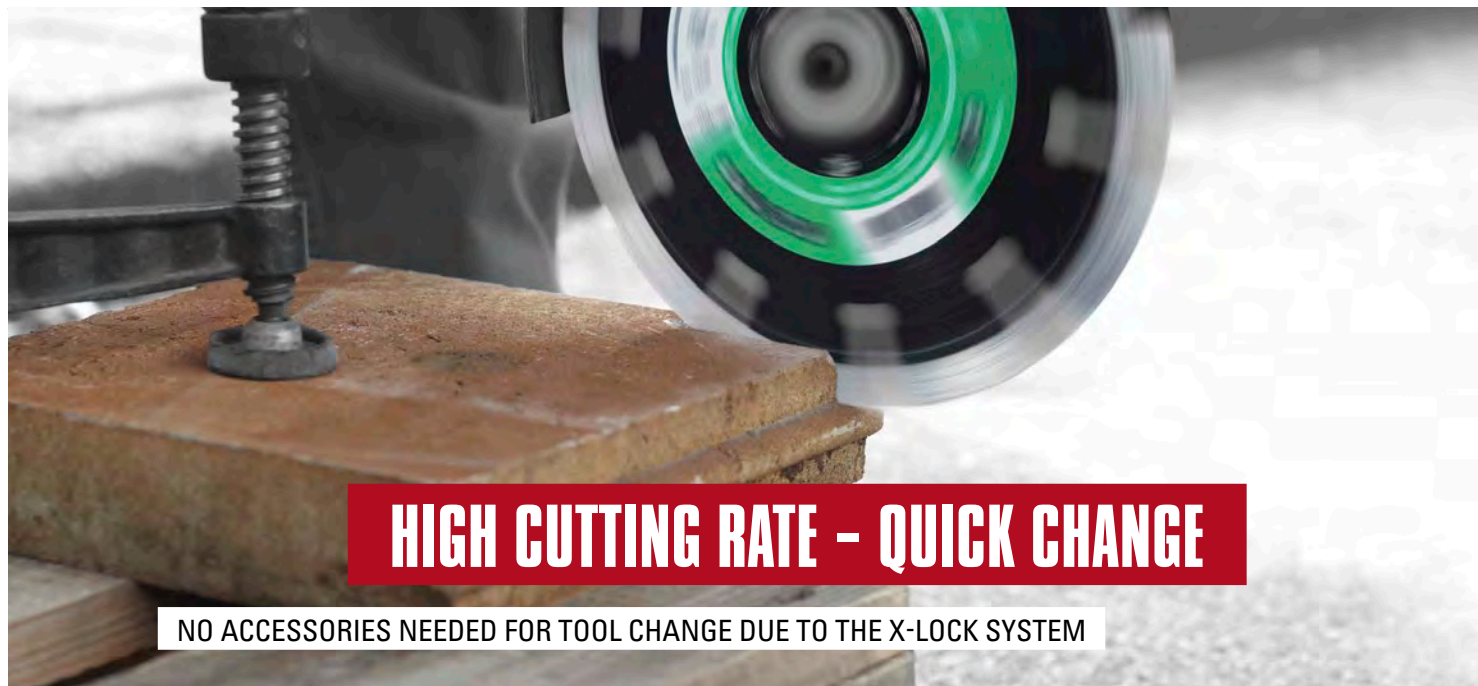
- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- excellent price-performance ratio
- laser-welded joints



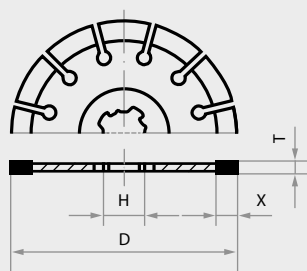
★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344131151210083	LD3 S10	115	11	2.4	22.23	13,300	1
A344131251210093	LD3 S10	125	11	2.4	22.23	12,200	1
A344131801210143	LD3 S10	180	11	2.4	22.23	8,500	1
A344132301210163	LD3 S10	230	11	2.6	22.23	6,600	1
A344133002210163	LD3 S10	300	11	2.8	25.4	6,400	1
A344133502210163	LD3 S10	350	11	3.0	25.4	5,500	1
A344134002210163	LD3 S10	400	11	3.2	25.4	4,800	1

Recommended for: ● Stone/Construction material



### NEW LD3 S10 X-LOCK diamond cutting disc



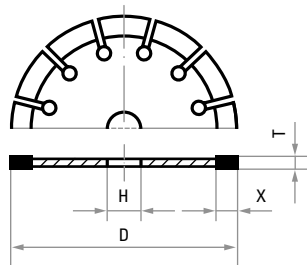
- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- Tool change is as easy as a click. No accessories needed due to the innovative X-LOCK system.
- excellent price-performance ratio
- laser-welded joints

★★★

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344131259210083	LD3 S10 X-LOCK	125	10	2.3	22.23	12,200	10

Recommended for: ● Stone/Construction material

### LD 7 S10 diamond cutting disc



- perfect for cutting asphalt
- specially formed segments for high running smoothness and core protection
- laser-welded joints

★★★

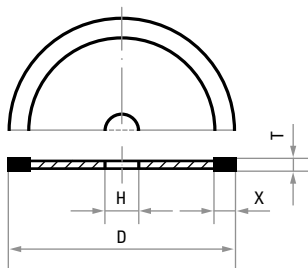
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344173002210183	LD7 S10	300	11	3.2	25.4	6,400	1
A344173502210213	LD7 S10	350	11	3.2	25.4	5,500	1
A344174002210243	LD7 S10	400	11	3.5	25.4	4,800	1
A344174502210283	LD7 S10	450	11	4.0	25.4	2,700	1

Recommended for: ● Stone/Construction material



## TURBO S10 diamond cutting disc

- ideal for cleanly cutting construction materials or concrete
- suitable for various applications



★★☆

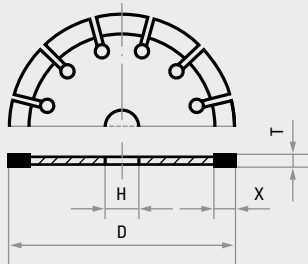
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344141151110013	TURBO S10	115	10	1.8	22.23	13,300	1
A344141251110013	TURBO S10	125	10	1.8	22.23	12,200	1
A344141801110013	TURBO S10	180	10	2.2	22.23	8,500	1
A344142301110013	TURBO S10	230	10	2.4	22.23	6,600	1

Recommended for: ● Stone/Construction material



## Blue Cut S10 diamond cutting disc

- especially popular on construction sites
- excellent price-performance ratio



★★☆

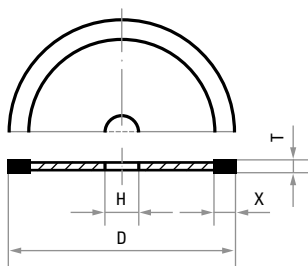
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345241151110085	Blue Cut S10	115	10	2.0	22.23	13,300	1
A345241251110095	Blue Cut S10	125	10	2.0	22.23	12,200	1
A345241501110125	Blue Cut S10	150	10	2.2	22.23	10,200	1
A345241801110145	Blue Cut S10	180	10	2.4	22.23	8,500	1
A345242301110165	Blue Cut S10	230	10	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material



## TC7 diamond cutting disc

- the turbo disc for precise cutting
- great price-performance ratio

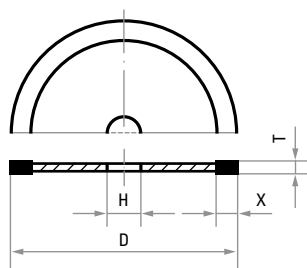


★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345241151107775	TC7	115	7	2.4	22.23	13,300	1
A345241251107775	TC7	125	7	2.6	22.23	12,200	1
A345242301107775	TC7	230	7	3.2	22.23	6,600	1

Recommended for: ● Stone/Construction material

## FAST CUT diamond cutting disc



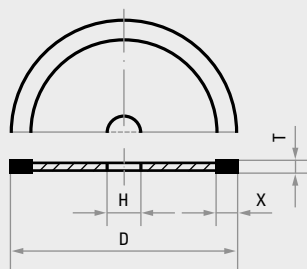
★★★

- extra-thin diamond cutting disc for ceramic and fine stone applications
- cuts through the hardest tiles quickly and cleanly
- offers an extra-thin segment coating and reinforced flange area

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344091151110013	FAST CUT S10	115	10	1.4	22.23	13,300	1
A344091251110013	FAST CUT S10	125	10	1.4	22.23	12,200	1

Recommended for: ● Stone/Construction material

## FLIESE S7 diamond cutting disc



★★☆

- the popular choice cutting discs for tile and ceramic
- also cuts exactly through glazed ceramic

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344111151107013	FLIESE S7	115	7	1.6	22.23	13,300	1
A344111251107013	FLIESE S7	125	7	1.6	22.23	12,200	1
A344112301107013	FLIESE S7	230	7	2.0	22.23	6,600	1

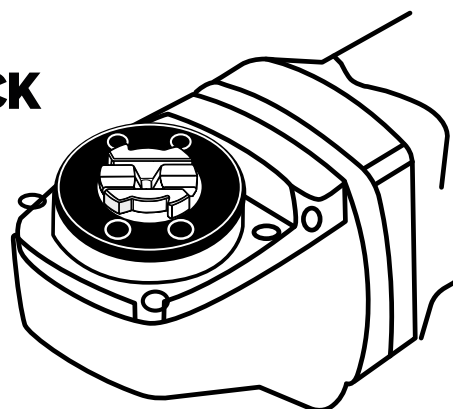
Recommended for: ● Stone/Construction material

# TOOL CHANGE WITH JUST A CLICK

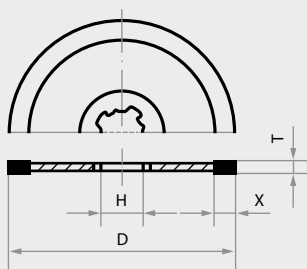
CHANGE TOOL QUICKLY AND EASILY WITH NO NEEDED ACCESSORIES

With the new X-LOCK system, simply position the LUKAS diamond cutting disc on the angle grinder's mounting fixture, allow it to engage and you are done. The click sound lets you know that the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

## X-LOCK



## FLIESE S7 X-LOCK diamond cutting disc **NEW**



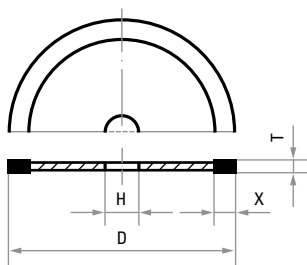
- cutting disc for tile and ceramic, with practical X-LOCK system
- tool change without accessories; turn in your hand
- also cuts exactly through glazed ceramic

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A344111259107013	FLIESE S7 X-LOCK	125	7	1.5	22.23	12,200	10
Recommended for: ● Stone/Construction material							



## FC7 diamond cutting disc



- cuts through tiles with ease
- excellent price-performance ratio

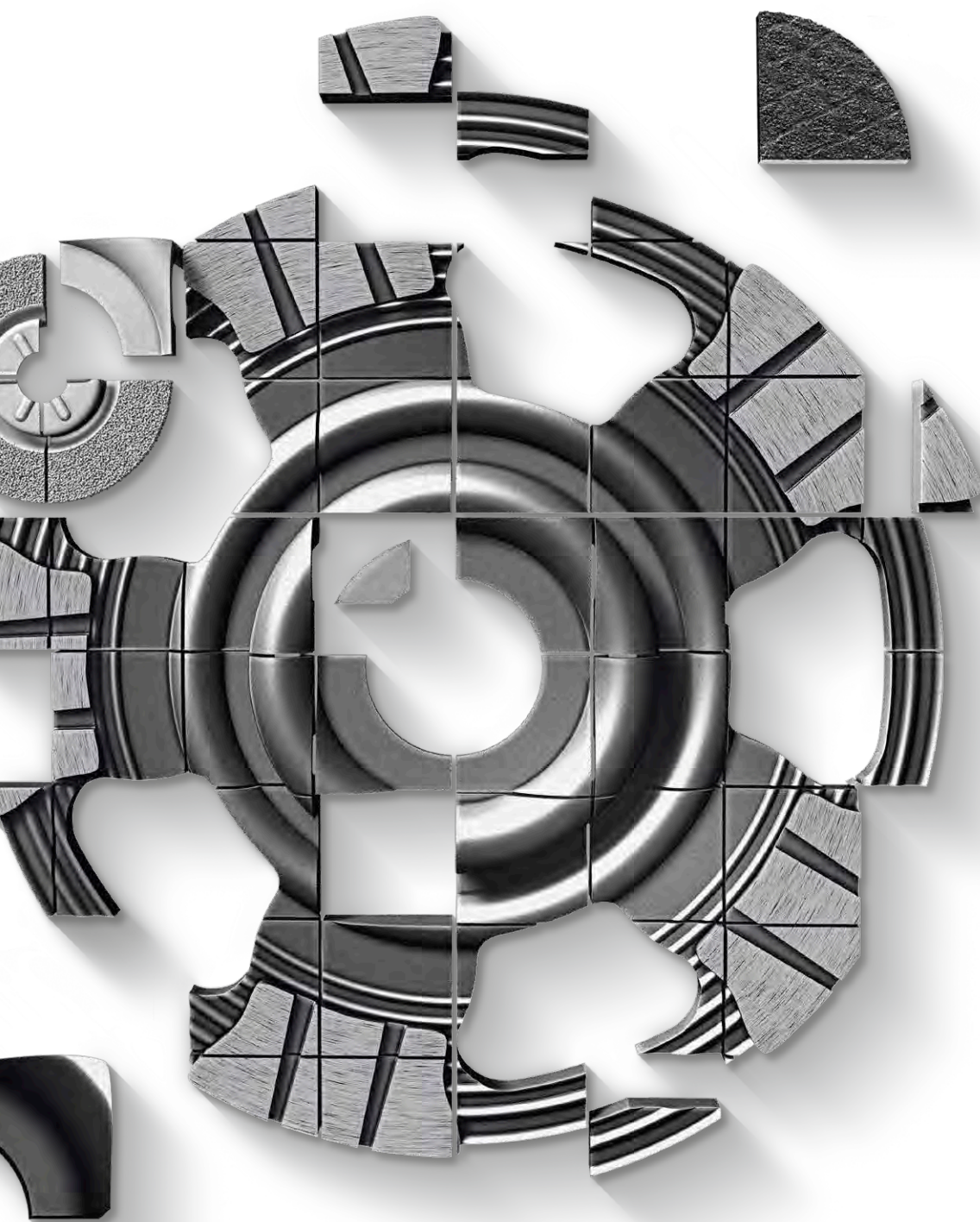
★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345211151107015	FC7	115	7	1.8	22.23	13,300	1
A345211251107015	FC7	125	7	2.0	22.23	12,200	1
A345212301107015	FC7	230	7	2.5	22.23	6,600	1
Recommended for: ● Stone/Construction material							





# ROUGH GRINDING



6.1 Grinding discs	270–281
6.2 Diamond cup wheels	282
6.3 Tungsten carbide granulate-tipped tools	283

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS grinding discs

SHELF LIFE

Resin-bonded grinding discs for handheld use may only be used 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 GRINDING DISCS

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

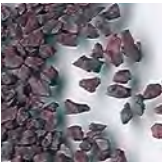
The following overview provides all the information concerning the abbreviations and markings.



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

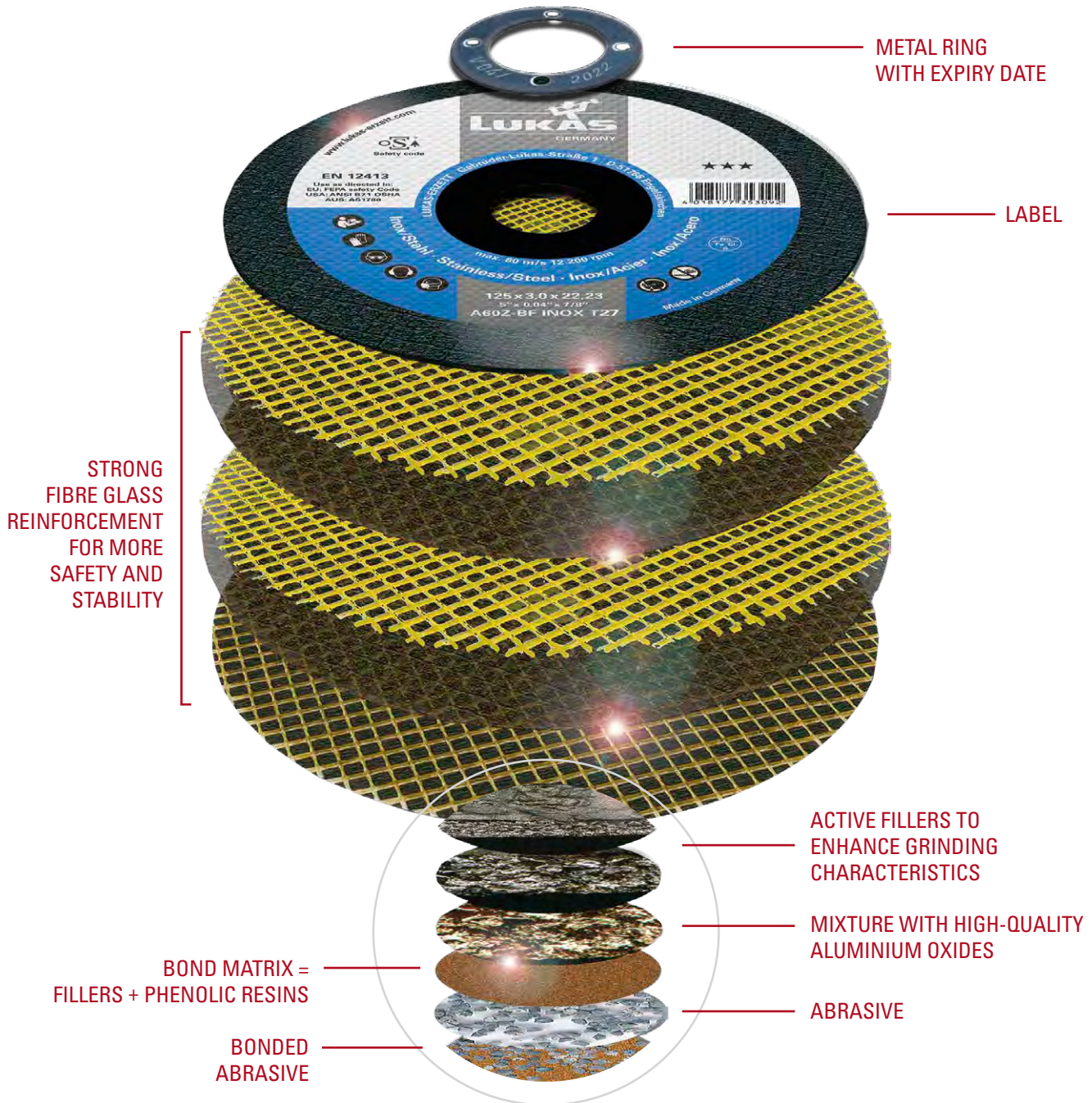
BOND

The bond holds the abrasive grain to the grinding disc. LUKAS grinding discs are available with the following bonds:

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

## TECHNICAL INFORMATION

# Construction and components of LUKAS grinding discs



## OPERATING SPEED

LUKAS grinding discs are developed and tested for specified maximum operating speeds and grinding processes. Before fixing 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 grinding disc.

Maximum operating speed	Grinding 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											



## WORK SAFETY

# Safely grinding with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

## APPLIED STANDARDS

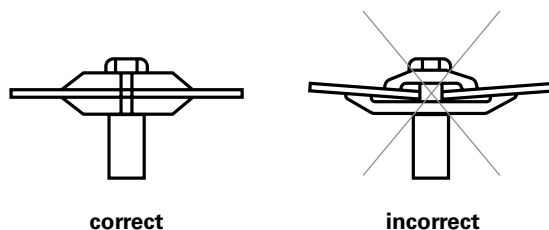
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

## SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced grinding discs on power tools.
- Store discs **in a dry place at room temperature.**
- Don't **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Only use discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Avoid bending the disc.
- Don't press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Don't cant and seize** the disc **when grinding.**
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Don't drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage. When grinding with a depressed centre grinding disc, maintain an angle of more than 20° to the workpiece.
- Use the machine only in a position where you have full control and are well balanced.

## CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).



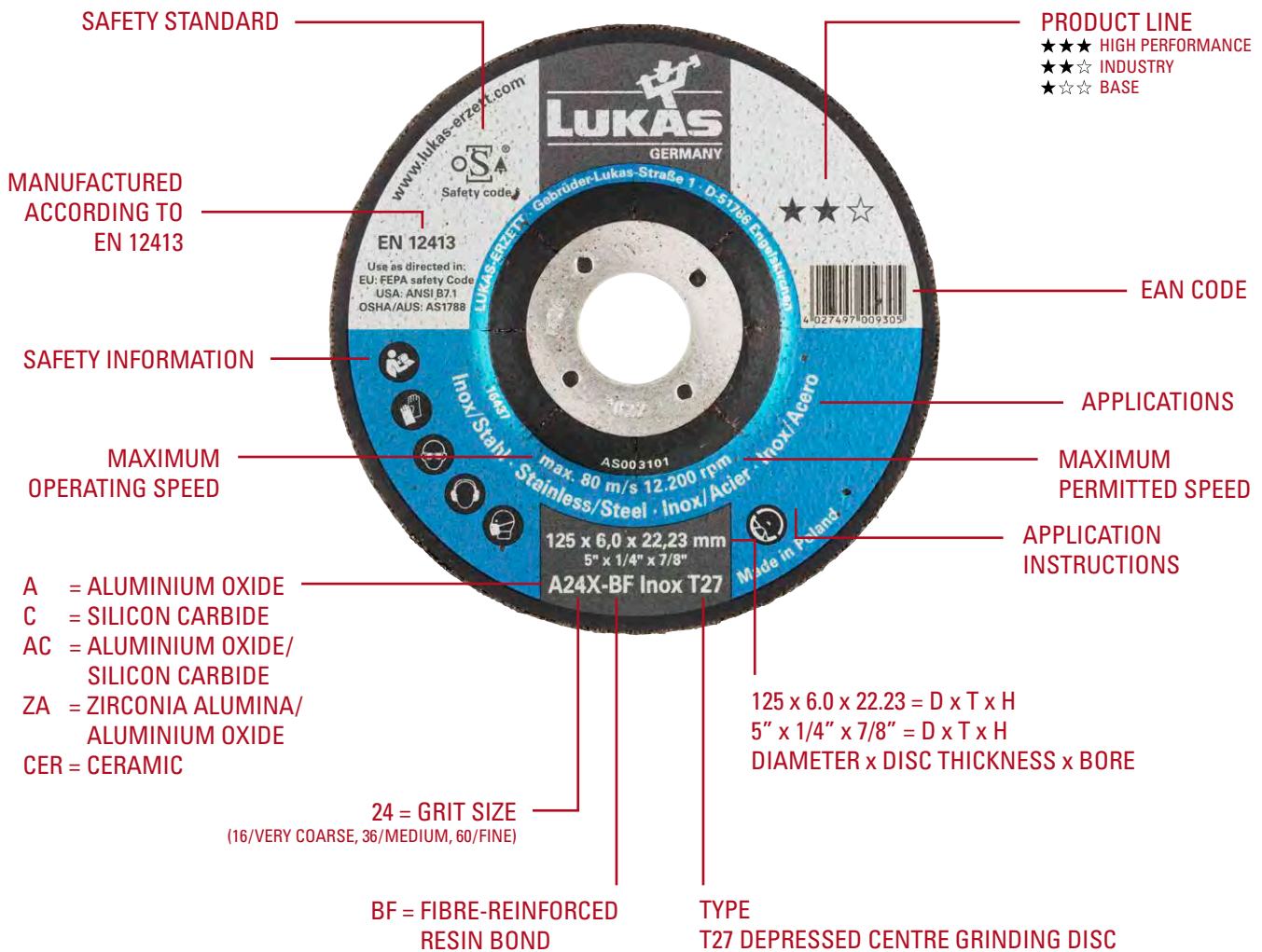
correct

incorrect

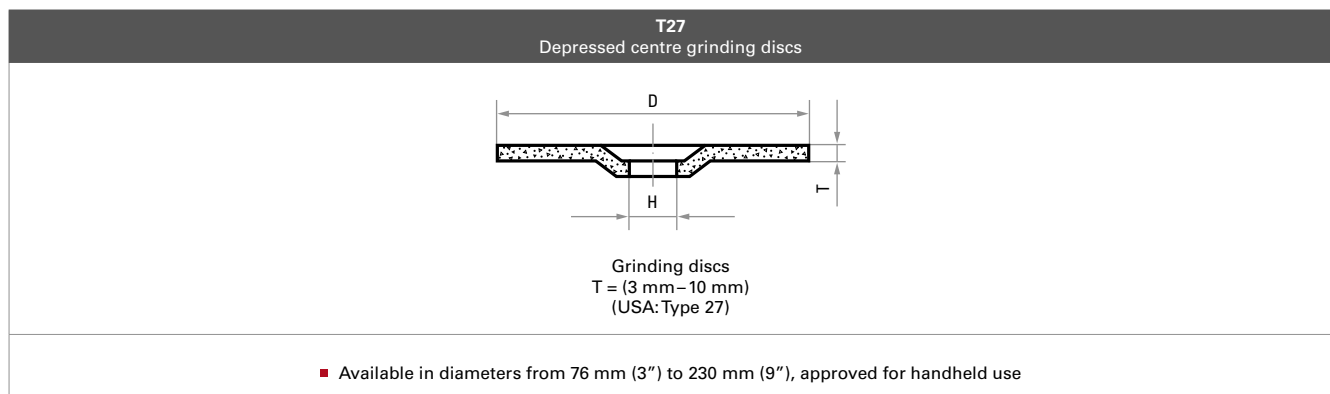


## LABELLING

## All important markings on the label

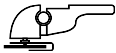














## TYPES OF RESIN-BONDED GRINDING DISCS



## AREA OF USE

## Overview of types of LUKAS grinding discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast material
<b>Handheld grinding discs for angle grinders</b> 	★★★	 Pages 275 and 276	 Page 278			
	★★☆	 Page 277	 Page 278	 Page 280	 Page 281	 Page 281
	★☆☆		 Page 279			
<b>Diamond cup wheels for angle grinders</b> 	★★☆				 Page 282	
<b>Tungsten carbide granulate-tipped disc for angle grinders</b> 	★★☆				 Page 283	

THE PERFECT ALTERNATIVE TO THE GRINDING DISC: THE **iQ-SERIES FLAP DISK** FROM LUKAS!  
GO TO **PAGES 134 – 151** AND TEST THEM NOW!

# MAXIMUM PERFORMANCE AND COOL REMOVAL

EFFICIENTLY MACHINE EVEN THE HARDEST MATERIALS

The LUKAS grinding discs with ceramic grain are perfectly suited for highly productive machining of steels. Thanks to the fast but cool cutting, they can machine inox without any blue discolouration and have an exceptional tool life due to the self-sharpening effect. In addition, these require only little effort during use. The low applied grinding pressure also contributes to low operating temperatures.

## EXTREME TOOL LIFE DUE TO SELF-SHARPENING EFFECT

The high-performance grinding discs consist of ceramic grain that constantly releases extremely fine particles in use. When

the particles break off due to wear, new, sharp abrasive particles are immediately exposed. Thanks to this self-sharpening effect, the grinding discs achieve outstanding tool lives.

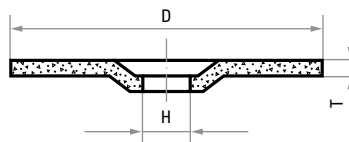
## AGGRESSIVE REMOVAL WITH LITTLE FINISHING WORK

Hard materials like Inox and steel can be machined with high productivity with the ceramic grain. In the process, the tool achieves an impressive surface quality for grinding discs – allowing you to get the desired finish quickly. Thanks to its long tool life based on the self-sharpening effect, the LUKAS ceramic grinding disc is also economical.

ROUGH GRINDING



- extremely hard and sharp for an impressively long tool life
- energy optimised for the highest performance angle grinders
- little force required
- cool removal



## Ceramic grinding disc **NEW**



★★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS008321V9802	T27 115x7.0	CER 30Q-BF Inox	115	7.0	22.23	13,300	25
AS008322V9802	T27 125x7.0	CER 30Q-BF Inox	125	7.0	22.23	12,200	25
AS008324V9802	T27 180x7.0	CER 30Q-BF Inox	180	7.0	22.23	8,500	25
AS008325V9802	T27 230x7.0	CER 30Q-BF Inox	230	7.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium





LUKAS GRINDING DISCS IN 3-STAR QUALITY

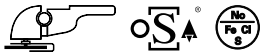
EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE

Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS grinding discs achieve the ultimate results. The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star grinding discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety. Eco-friendly production combined with first-class raw materials, optimised formulas and the state-of-the-art production processes provide for high quality and a maximum storage time.

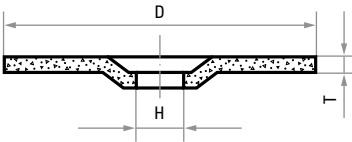
- maximum tool life and grinding performance with innovative bonding technology
- high maximum speed at a cool grinding temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in quality owing to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of Inox and steel materials

ROUGH GRINDING

Grinding disc for machining stainless steel



★★★



- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

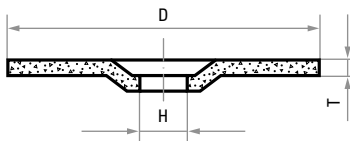
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS013491V9802	T27 115x7.0	A24U-BF Inox	115	7.0	22.23	13,300	10
AS013492V9802	T27 125x7.0	A24U-BF Inox	125	7.0	22.23	12,200	10
AS013496V9802	T27 230x7.0	A24U-BF Inox	230	7.0	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium



## Grinding disc for machining stainless steel

- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows ergonomical working with little use of force



★★☆

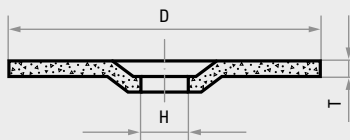
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS003100V9802	T27 115x6.0	A24X-BF Inox	115	6.0	22.23	13,300	10
AS003101V9802	T27 125x6.0	A24X-BF Inox	125	6.0	22.23	12,200	10
AS003103V9802	T27 180x6.0	A24X-BF Inox	180	6.0	22.23	8,500	10
AS003104V9802	T27 230x6.0	A24X-BF Inox	230	6.0	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium



## Grinding disc for machining stainless steel

- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

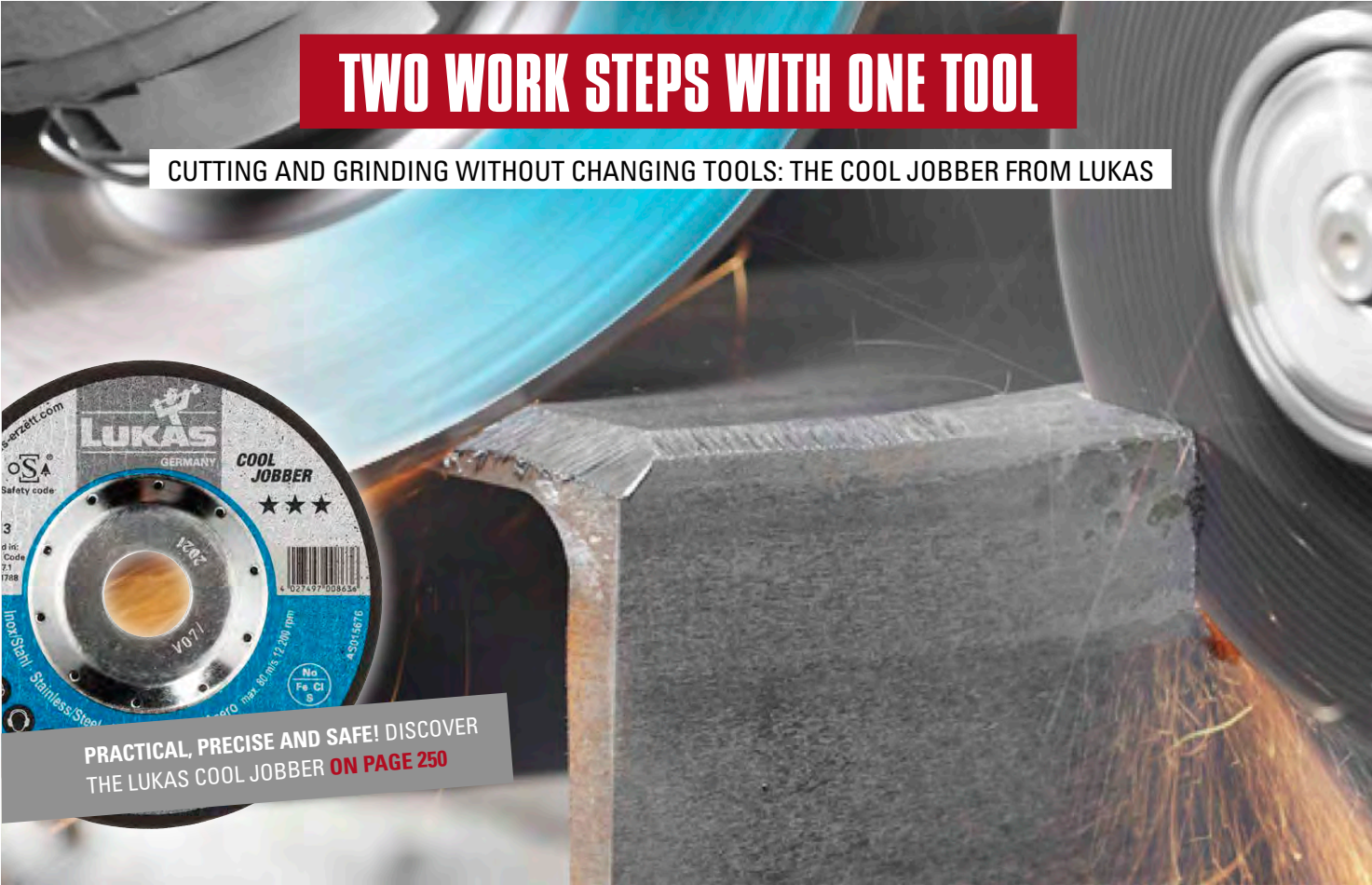


★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS002037V9802	T27 100x6.0	A24/30S-BF Inox	100	6.0	16.00	15,300	10
AS000105V980201	T27 115x6.0	A24/30S-BF Inox	115	6.0	22.23	13,300	10
AS000106V980201	T27 125x6.0	A24/30S-BF Inox	125	6.0	22.23	12,200	10
AS000107V9802	T27 150x6.0	A24/30S-BF Inox	150	6.0	22.23	10,200	10
AS000108V9802	T27 180x6.0	A24/30S-BF Inox	180	6.0	22.23	8,500	10
AS000109V9802	T27 230x6.0	A24/30S-BF Inox	230	6.0	22.23	6,600	10

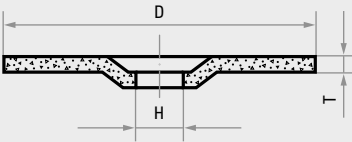
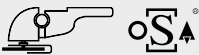
Recommended for: ● Inox/Steel ● Steel





PRACTICAL, PRECISE AND SAFE! DISCOVER THE LUKAS COOL JOBBER **ON PAGE 250**

Grinding disc for machining steel



★★★

- optimised for precise machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

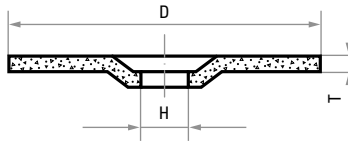
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS012451V9802	T27 115x7.0	A24X-BF Steel	115	7.0	22.23	13,300	10
AS012453V9802	T27 125x7.0	A24X-BF Steel	125	7.0	22.23	12,200	10
AS012466V9802	T27 180x7.0	A24X-BF Steel	180	7.0	22.23	8,500	10
AS012468V9802	T27 230x7.0	A24X-BF Steel	230	7.0	22.23	6,600	10

Recommended for: ● Steel



## Grinding disc for machining steel

- cut steel with ease
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force



★★☆

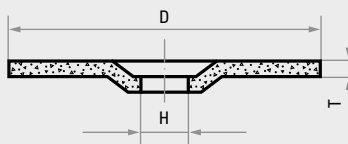
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS001679V9802	T27 115x6.0	A24/30T-BF Steel	115	6.0	22.23	13,300	10
AS001710V9802	T27 125x6.0	A24/30T-BF Steel	125	6.0	22.23	12,200	10
AS001811V9802	T27 230x6.0	A24/30T-BF Steel	230	6.0	22.23	6,600	10

Recommended for: ● Steel



## Grinding disc for machining steel

- designed for easy machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force



★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS000667V9802	T27 115x6.0	A24/30S-BF Steel	115	6.0	22.23	13,300	10
AS000690V9802	T27 125x4.0	A24/30S-BF Steel	125	4.0	22.23	12,200	10
AS000692V9802	T27 125x6.0	A24/30S-BF Steel	125	6.0	22.23	12,200	10
AS000712V9802	T27 150x6.0	A24/30S-BF Steel	150	6.0	22.23	10,200	10
AS000737V9802	T27 180x7.0	A24/30S-BF Steel	180	7.0	22.23	8,500	10
AS000762V9802	T27 230x6.0	A24/30S-BF Steel	230	6.0	22.23	6,600	10

Recommended for: ● Steel

# MACHINE SOFT LIGHT METALS TROUBLE-FREE

## DESIGNED FOR PERFECTLY MACHINING ALUMINIUM

Aluminium and other non-ferrous metals are difficult to machine – especially because they are so soft. The LUKAS grinding disc for aluminium and non-ferrous metals machines light and non-ferrous metals without interruption.

### GRINDING ALUMINIUM WITHOUT “SMEARING”

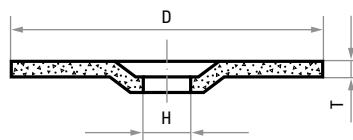
The major advantage of this grinding disc is that the "smearing" effect can be avoided. When machining pure aluminium and soft alloys, soft chips can stick to the aluminium edges if the tool is not designed specifically for this purpose. However, LUKAS grinding discs were developed and tested for aluminium. The special combination of abrasive grain and bonding agent is a reliable means to prevent this undesirable effect.

### CAN BE USED ON STANDARD MACHINES

This tool can be used on standard angle grinders and is available in different sizes. This allows for light metals to be machined easily and above all with a high level of productivity.



## NEW Grinding disc for machining non-ferrous metals



- for perfectly machining aluminium and non-ferrous metals
- no clogging or smearing
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for economical working with little use of force

★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS001708V9802	T27 125x7.0	A24N-BF Alu	125	7.0	22.23	12,200	10

Recommended for: ● Aluminium

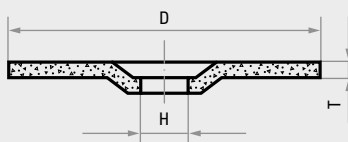


# FLEXIBLY GRIND A WIDE RANGE OF BUILDING MATERIALS

ULTIMATE FLEXIBILITY FOR TRADESPEOPLE AND CONSTRUCTION WORKERS



- for universal use
- for use on construction sites
- preferable to diamond cutting discs thanks to its excellent value for money and high speed
- low odour and dust levels in daily use
- allows for ergonomic working with little use of force



## Grinding disc for machining stone **NEW**



★★★☆☆

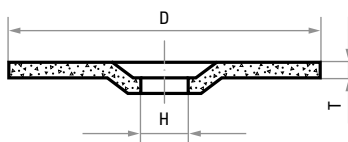
Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS115060V980201	T27 115x6.0	C24R-BF Stone	115	6.0	22.23	13,300	10
AS125060V980201	T27 125x6.0	C24R-BF Stone	125	6.0	22.23	12,200	10
AS000320V9802	T27 180x6.0	C24R-BF Stone	180	6.0	22.23	8,500	10
AS180080V980201	T27 180x8.0	C24R-BF Stone	180	8.0	22.23	8,500	10

Recommended for: ● Stone ● Cast material

ROUGH GRINDING



- for quickly and reliably machining castings with inclusions and surface defects
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomic working with little use of force



## Grinding disc for machining cast material



★★★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AS001711V9802	T27 125x6.0	ZA24R-BF Cast	125	6.0	22.23	12,200	10
AS001773V9802	T27 180x6.0	ZA24R-BF Cast	180	6.0	22.23	8,500	10
AS001812V980201	T27 230x6.0	ZA24R-BF Cast	230	6.0	22.23	6,600	10

Recommended for: ● Cast material

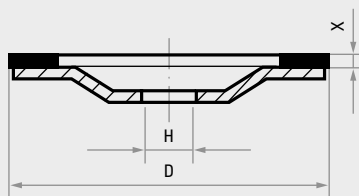
# THE DIAMOND CUP WHEEL FOR UNIVERSAL USE

EFFICIENT AND FLEXIBLE GRINDING OF BUILDING MATERIALS

## S6 diamond cup wheel



★★☆



- excellent value for money
- optimised segment arrangement for high grinding performance and clean surfaces
- well suited for: concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice)
- also suitable for: reinforced concrete, exposed aggregate concrete, dense sand-lime, refractory brick and screed

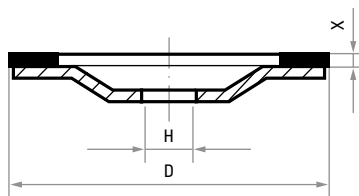
Product number	Description	D mm	Segment height X mm	H mm	n <sub>max</sub> rpm	Pack contains
A344431151506053	DST S6	115	6	22.23	13,300	1
A344431251506053	DST S6	125	6	22.23	12,200	1
A344431801506053	DST S6	180	6	22.23	8,500	1

Recommended for: ● Stone

## S5 diamond cup wheel



★★☆



- the inexpensive cup wheel for many different applications
- suitable for concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice) and dense sand-lime brick

Product number	Description	D mm	Segment height X mm	H mm	n <sub>max</sub> rpm	Pack contains
A345531151607185	DST S5	115	5	22.23	13,300	1
A345531251607185	DST S5	125	5	22.23	12,200	1

Recommended for: ● Stone



# FROM ANIMAL HOOVES TO MACHINING STONE

## TUNGSTEN CARBIDE GRANULATE-TIPPED DISCS FOR A WIDE VARIETY OF APPLICATIONS

Tungsten carbide granulate-tipped tools (HGW) from LUKAS are available in grit sequences from very coarse to extra fine with dense and open coating. Simply find the grit you require in the illustration below.



### APPLICATIONS

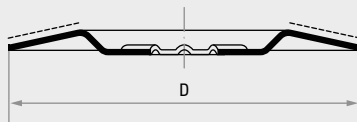
Coarse grit is suitable for machining soft materials. **The harder the material, the finer the required grit.** The LUKAS tungsten carbide granulate-tipped flap disc can be used for many applications. It can be used to roughen rubber (e.g. when repairing conveyor belts), remove residues from cladding or to clean the hooves of horses and cows. It can also be used on glass, ceramic and stone.

The grit of the granulate-tipped disc ranges from extra fine to very coarse, meaning you have the right tool for every application. In addition to the standard products offering, the LUKAS tungsten carbide granulate-tipped disc can be specially coated to meet your needs.



### HWGT tungsten carbide granulate-tipped disc

- extremely versatile grinding tool
- perfect as a hoof disc for grinding animal hooves
- also suitable for machining glass, ceramic and stone



Product number	Description	Grit	Shape	Type	D mm	Bore mm	n <sub>max</sub> rpm	Pack contains
A18031152E	HGWT 115 S	0.8 – 1.2 E		dished	115	22.2	10,500	1
A18031153E	HGWT 115 S	1.2 – 1.8 E		dished	115	22.2	10,500	1
A18031255E	HGWT 125 S	2.5 – 3.0 E		flat	125	22.2	9,600	1

Recommended for: ● Stone/Construction material ● Plastic/Wood





- 7.1 Coarse fleece
- 7.2 Brushes
- 7.3 Rolls and sheets

# CLEANING

287/288  
289–295  
296–298

## GENERAL INFORMATION AND PRODUCT INFORMATION

## LUKAS BRUSHES, FLEECE AND ABRASIVE CLOTH – ALL YOU NEED FOR CLEANING AND MORE

No matter whether you want to remove wood, car paint or concrete residue or prepare, roughen, derust, debur, clean, polish or texture a wide variety of materials like aluminium, stainless steel, cast material, steel or titanium, at LUKAS you will find the right tool to suit your application. From abrasive paper to cleaning fleece and wire brushes in a wide range of shapes and types, LUKAS offers you the right cleaning tool for construction sites, production lines or your DIY workshop at home.

### MACHINE-POWERED CLEANING TOOLS

LUKAS cleaning tools can be used with standard power tools. For instance, you can use the wheel brushes on angle grinders or wire brushes on drilling machines and cordless screwdrivers. The shank dimensions make it easy to fit the brushes into commercially available drilling machines.

LUKAS end brushes let you easily clean even the most inaccessible areas. Depending on the required thickness and elasticity, they are available in both twist-knotted and crimped types.

### TOOLS FOR MANUAL USE

In addition to hand wire brushes for cleaning surfaces or finishing weld seams, LUKAS also offers abrasive fleece and paper, both of which are ideal for manually removing old paint from both wood and metal or for cleaning stainless steel. LUKAS abrasive fleece is available in rolls or pads that are perfect for manual use.

## AS CLEANING FLEECE

## EFFICIENTLY TREAT SURFACES IN A WIDE VARIETY OF MATERIALS

LUKAS AS cleaning fleece consists of a coarse polyamide non-woven material impregnated with high-impact abrasive particles. Thanks to this combination of polyamide non-woven material and hard abrasive particles, LUKAS cleaning fleece is ideal for efficient surface finishing, including removing paint or concrete residue and rust, cleaning, polishing or graining wood. The tool is widely used in the building sector, bodywork and shipbuilding.

With its combination of materials, the cleaning fleece (or disc) offers significant advantages in practical use. Heat generation and the grinding pressure applied are kept to a minimum, ensuring no clogging or damage to workpieces. In practical terms, this means that your cleaning fleece or disc is a tool that you can use efficiently and effectively for a long time to come.

## APPLICATION RECOMMENDATIONS

The tools in our AS cleaning fleece range are ideal for the following applications:

- removing paint and adhesive residue
- removing cement and concrete residue
- removing rust, cleaning and polishing a wide variety of surface materials
- graining and cleaning wood
- rust removal and cleaning jobs (e.g. barnacles on boats and ships)
- cleaning car undersides, various vehicle coachbuilding tasks
- cleaning weld seams – before and after welding

## PROPERTIES

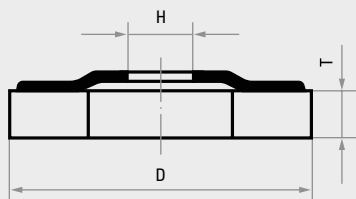
- low heat generation
- operation at low grinding pressure possible
- no clogging
- no damage to workpieces

## SAFETY ADVICE

Please adhere to our recommended, never-exceed cutting speeds.



- can be used universally without a backing pad on adjustable or low-speed angle grinders
- the all-rounder for removing paint and adhesive residue, as well as rust removal, cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long service life, high removal rate and fast operation



## ASVT flap disc



★★☆

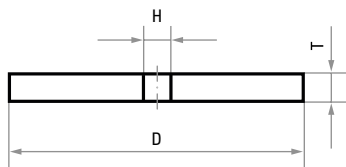
Product number	Description	D mm	T mm	H mm	n recomm. rpm	n max. rpm	Pack contains
A270111500114	ASVT 115	115	13	22.23	5,300	10,500	10
A270112500114	ASVT 125	125	13	22.23	4,900	9,600	10

Recommended for: ● Plastic/Wood ● Titanium ● Aluminium ● Inox/Steel ● Steel ● Cast material

ALSO TRY LUKAS AS CLEANING FLEECE  
WITH A PRACTICAL PLASTIC THREAD  
FOR FAST TOOL CHANGING ON **PAGE 227**



## ASVS grinding disc

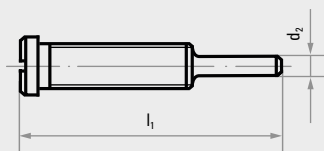


- grinding disc for flexible shaft grinders or drilling machines
- the all-rounder for removing paint and adhesive residue, as well as rust removal, cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long service life, high removal performance and fast operation
- requires only a low grinding pressure

★★☆

Product number	Description	D mm	T mm	H mm	n recomm. rpm	n max. rpm	Matching mounting arbor	Pack contains
A22900601201	ASVS 060	60	13	13	8,000	9,500	ASB 06	10
A22901001201	ASVS 100	100	13	13	5,000	5,700	ASB 06	10
A22901251201	ASVS 125	125	13	13	4,000	4,500	ASB 08	10
A22901501201	ASVS 150	150	13	13	3,000	3,800	ASB 08	10
Recommended for: <span style="color: yellow;">●</span> Plastic/Wood <span style="color: grey;">●</span> Titanium <span style="color: orange;">●</span> Aluminium <span style="color: blue;">●</span> Inox/Steel <span style="color: lightgrey;">●</span> Steel <span style="color: red;">●</span> Cast material								

## ASB mounting arbor



- mounting arbor for ASVS grinding discs
- perfect dimensional stability: fits optimally into the power tool
- stainless thanks to zinc-nickel coating
- supplied with spring washers and nuts

★★☆

Product number	Description	Thread	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A1610021007301	ASB 06	M12	6	60	1
A1610021007302	ASB 08	M12	8	60	1

## GENERAL INFORMATION AND PRODUCT INFORMATION

**LUKAS high-quality technical brushes****FILAMENT QUALITY****High quality steel wire**

We use high-quality steel wire with high tensile strength, which ensures an exceptionally long and economical tool life.

**Stainless steel wire**

This wire is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.

**Abrasive impregnated nylon filaments**

Abrasive impregnated nylon filaments are very flexible and optimally follow the contour of the workpiece without being too aggressive. During use, new abrasive grains are constantly exposed, thus achieving a consistent performance and long tool life.

**TYPES**

We supply brushes in both wire qualities with crimped or twist-knotted filaments. Compared to crimped types, brushes with twist-knotted steel wire generally offer a longer tool life and more rugged abrasive performance and are thus suited for extreme requirements. We also supply brushes in high quality crimped steel wire embedded in a resin bond, thus enhancing their performance. These brushes are ideally suited for achieving uniform surfaces and precise edges.

**APPLICATIONS**

A wide range of jobs can be performed with steel wire brushes. Here are just a few examples: deburring, descaling, derusting, surface cleaning, roughening and paint stripping. Brushes with abrasive impregnated nylon filaments are perfect for removing stains on metal surfaces, graining soft wood, car body repair jobs, stripping off paint residues etc.

**WORKING MODE AND POWER TOOLS**

Technical brushes are flexible tools that follow the contours of the workpiece. In order to achieve best results, only the tip of the filament should be in contact with the workpiece. Elasticity of the brush depends on the exposed length of the filaments, and in the case of steel wire brushes, on the wire thickness. Brushes with very long filaments are very flexible and should only be used with low pressure. Excessive pressure reduces the life of the brush and results in premature wearing. Technical brushes can be used on stationary and handheld power tools.

**OPERATING SPEEDS**

Steel wire brushes have a harder effect at higher speeds and a softer effect at low speeds. We recommend the following operating speeds for crimped types to achieve the desired results:

- Machining steel: approx. 30 m/s
- Machining non-ferrous metals: approx. 18 – 20 m/s
- Machining plastic: approx. 15 m/s

Higher operating speeds can be selected for twist knotted types e.g.:

- Machining steel: approx. 40 m/s

Brushes made from nylon filaments achieve best results at operating speeds of 18 to 22 m/s, depending on the material to be machined.

**SAFETY ADVICE**

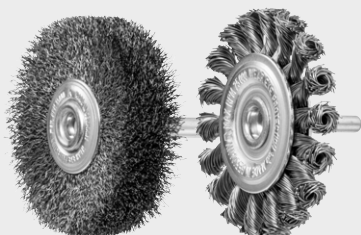
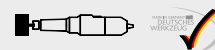
Technical brushes are manufactured according to a rigorous quality control (according to EN 1083-2). However, it is always advisable to wear safety clothing when working with technical brushes.



## FLEXIBLE MACHINING OF THE MOST COMPLEX CONTOURS

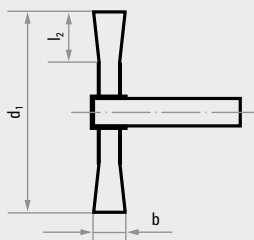
CLEANING METAL SURFACES WITH LUKAS HIGH QUALITY STEEL WIRE

### BS wheel brush with shank



crimped

knotted



- follow the contours of every workpiece thanks to their flexibility
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.
- perfect dimensional stability: fits optimally into power tools
- shank diameter: 6 mm

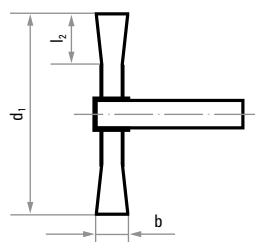
★★☆

Product number	Description	Material	Type	d <sub>1</sub> mm	b mm	l <sub>2</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A35010401011	BSSW 04010	steel	crimped	40	10	9	0.2	18,000	10
A350005026	BSSW 05010	steel	crimped	50	10	12	0.2	15,000	10
A350105014111	BSSW 05014	steel	crimped	50	14	12	0.2	15,000	10
A350006036	BSSW 06018	steel	crimped	60	16	12	0.2	15,000	10
A350106018113	BSSW 06018	steel	crimped	60	19	17	0.3	15,000	10
A350007036	BSSW 07018	steel	crimped	70	16	19	0.2	15,000	10
A350107018113	BSSW 07018	steel	crimped	70	16	19	0.3	15,000	10
A350107508135	BSSZ 07508	steel	knotted	75	12	15	0.5	25,000	10
Recommended for: <span>● Steel</span> <span>● Cast material</span> <span>● Plastic/Wood</span>									
A350107508235	BSVZ 07508	stainless	knotted	75	12	15	0.5	25,000	10
A351004036	BSVW 04011	stainless	crimped	40	11	9	0.2	18,000	10
A350105014211	BSVW 05014	stainless	crimped	50	14	12	0.2	15,000	10
A351006036	BSVW 06018	stainless	crimped	60	16	17	0.2	15,000	10
A350107018213	BSVW 07018	stainless	crimped	70	16	19	0.3	15,000	10
A351007036	BSVW 07018	stainless	crimped	70	16	19	0.2	15,000	10
Recommended for: <span>● Inox/Steel</span> <span>● Steel</span> <span>● Titanium</span>									



## BSN wheel brush

- highly flexible tool with abrasive impregnated nylon filaments
- exactly follows the contours of your workpiece
- moderately aggressive action on surfaces
- achieves an even abrasive performance and long tool life
- shank diameter: 6 mm



★★☆

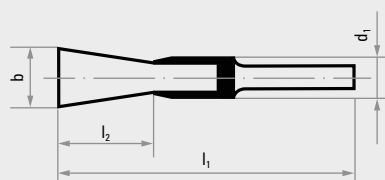
Product number	Description	Type	d <sub>1</sub> mm	b mm	l <sub>2</sub> mm	n <sub>max</sub> rpm	Pack contains
A350105010048	BSNG 05010	coarse	50	10	12	15,000	10
A350105010049	BSNF 05010	fine	50	10	12	15,000	10
A350107012048	BSNG 07012	coarse	70	12	20	15,000	10
A350107012049	BSNF 07012	fine	70	12	20	15,000	10
A350110007048	BSNG 10007	coarse	100	8	22	4,500	10
A350110008050	BSNF 10008	fine	100	8	22	4,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium ● Plastic/Wood



## BP end brush

- flexibly withstands the toughest challenges
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.
- shank diameter: 6 mm



crimped



knotted

★★☆

Product number	Description	Material	Type	d <sub>1</sub> mm	b mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A350101006	BPSW 01020	steel	crimped	10	10	20	60	0.3	20,000	10
A350101506	BPSW 01725	steel	crimped	16	17	22	65	0.3	20,000	10
A350502029134	BPSZ 02029	steel	knotted	19	20	28	72	0.35	20,000	10
A350102206	BPSW 02525	steel	crimped	22	25	25	68	0.3	18,000	10
A350502329134	BPSZ 02329	steel	knotted	22	23	28	72	0.35	20,000	10
A350102806	BPSW 03025	steel	crimped	29	30	25	68	0.3	18,000	10

Recommended for: ● Steel ● Cast material ● Plastic/Wood

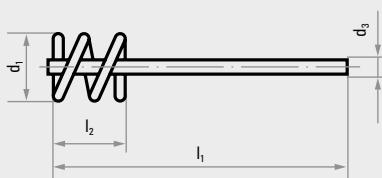
A351101006	BPVW 01020	stainless	crimped	10	10	20	60	0.3	20,000	10
A351101506	BPVW 01725	stainless	crimped	16	17	22	65	0.3	20,000	10
A350502029232	BPVZ 02029	stainless	knotted	19	20	28	72	0.25	20,000	10
A351102206	BPVW 02525	stainless	crimped	22	25	25	68	0.3	18,000	10
A351102806	BPVW 03025	stainless	crimped	29	30	25	68	0.3	18,000	10

Recommended for: ● Inox/Steel ● Steel ● Titanium

# EASILY DEBURR EVEN SMALL BORES

LUKAS PIPE BRUSHES WITH STEEL WIRE OR NYLON FILAMENTS

## RBSD pipe brush



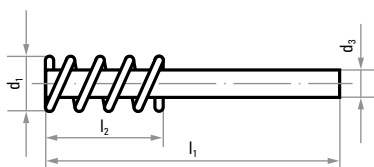
★★☆

- brush with steel wire filaments
- deburring of bores, cross-holes and O-ring grooves
- polishing and cleaning of nozzles, small and threaded bores

Product number	Description	Material	Type	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>3</sub> mm	l <sub>1</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A359901025	RBSD 1025	steel	crimped	10	25	3.8	90	0.12	2,000	10
A359901325	RBSD 1325	steel	crimped	13	25	3.8	90	0.12	2,000	10
A359901625	RBSD 1625	steel	crimped	16	25	3.8	90	0.12	2,000	10
A359902525	RBSD 2525	steel	crimped	25	25	3.8	90	0.2	2,000	10

Recommended for: ● Steel ● Cast material ● Plastic/Wood

## RBSN pipe brush



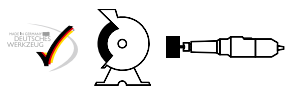
★★☆

- brush with abrasive nylon and silicon carbide filaments
- deburring of bores, cross-holes and O-ring grooves
- polishing and cleaning of nozzles, small and threaded bores

Product number	Description	Material	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>3</sub> mm	l <sub>1</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A359901065120	RBSN 1065	C 120	10	65	3.7	125	0.6	2,000	10
A359901365120	RBSN 1365	C 120	13	65	3.7	125	0.6	2,000	10
A359901665120	RBSN 1665	C 120	16	65	5.2	125	0.6	2,000	10
A359902565120	RBSN 2565	C 120	25	65	5.5	125	0.6	2,000	10

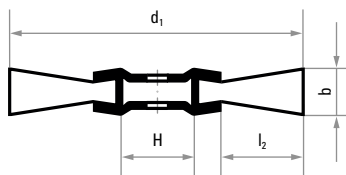
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium ● Plastic/Wood





## BR wheel brush, crimped

All crimped wheel brushes are supplied with adapter sets for mounting on all standard grinding machines.



The following bores can be accommodated:

- brushes with a bore diameter of H 40 mm:  
40 mm, 32 mm, 1", 22.23 mm, 20 mm,  
16 mm, 1/2"
- brushes with a bore diameter of H 50 mm:  
50 mm, 32 mm, 1", 22.23 mm, 20 mm,  
16 mm, 1/2"

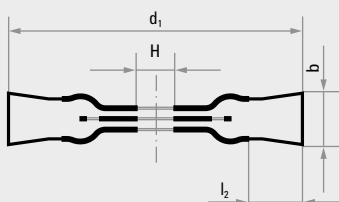
★★☆

Product number	Description	Material	Type	d <sub>1</sub> mm	b mm	H mm	l <sub>2</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A350315022114	BRSW 15022	steel	crimped	150	22	40	33	0.35	6,000	1
A350320024114	BRSW 20024	steel	crimped	200	24	50	48	0.35	6,000	1
Recommended for: ● Steel ● Cast material										
A350315023213	BRVW 15023	stainless	crimped	150	23	50	33	0.3	6,000	1
Recommended for: ● Inox/Steel ● Steel ● Titanium										



## BR wheel brush, knotted

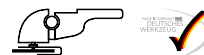
- designed for extreme brush requirements
- can be used on commercially available angle grinders
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.



★★☆

Product number	Description	Material	Type	d <sub>1</sub> mm	b mm	H mm	l <sub>2</sub> mm	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A350211512135	BRSZ 11512	steel	knotted	115	14	22.23	20	0.5	12,500	1
A350312514135	BRSZ 12514	steel	knotted	125	14	22.23	20	0.5	12,500	1
A350317814135	BRSZ 17814	steel	knotted	178	14	22.23	32	0.5	9,000	1
Recommended for: ● Steel ● Cast material										
A350211512234	BRVZ 11512	stainless	knotted	115	14	22.23	20	0.35	12,500	1
A350312514235	BRVZ 12514	stainless	knotted	125	14	22.23	20	0.5	12,500	1
Recommended for: ● Inox/Steel ● Steel ● Titanium										

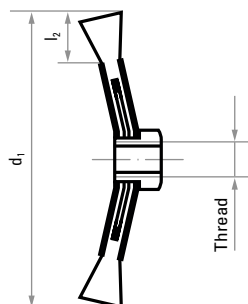
## BK conical brush



crimped

knotted

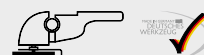
★★☆



- with practical M14 thread
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.

Product number	Description	Material	Type	d <sub>1</sub> mm	b mm	l <sub>2</sub> mm	Thread	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A350610012114	BKSW 10012	steel	crimped	100	10	20	M14	0.35	12,500	1
A350610013135	BKSZ 10013	steel	knotted	100	13	20	M14	0.5	12,500	1
Recommended for: <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material										
A350610012213	BKVV 10012	stainless	crimped	100	10	20	M14	0.3	12,500	1
A350610013235	BKVZ 10013	stainless	knotted	100	13	20	M14	0.5	12,500	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: darkgrey;">●</span> Titanium										

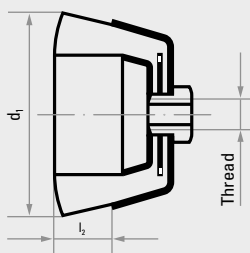
## BTG cup brush



crimped

knotted

★★☆



- with practical M14 thread
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.

Product number	Description	Material	Type	d <sub>1</sub> mm	l <sub>2</sub> mm	Thread	Wire Ø mm	n <sub>max</sub> rpm	Pack contains
A350406020114	BTSW 06020 G	steel	crimped	60	20	M14	0.35	12,000	1
A350406520135	BTSZ 06520 G	steel	knotted	65	20	M14	0.5	12,500	1
A350408020135	BTSZ 08020 G	steel	knotted	80	20	M14	0.5	9,000	1
A350408025114	BTSW 08025 G	steel	crimped	80	25	M14	0.35	8,500	1
A350410030114	BTSW 10030 G	steel	crimped	100	30	M14	0.35	9,000	1
Recommended for: <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material									
A350406021213	BTWV 06021 G	stainless	crimped	60	20	M14	0.3	12,000	1
A350406520234	BTWV 06520 G	stainless	knotted	65	20	M14	0.35	12,500	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: darkgrey;">●</span> Titanium									

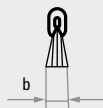
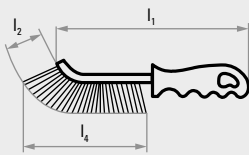
FLEXIBLE HAND BRUSH FOR UNIVERSAL USE

FOLLOWS EVERY CONTOUR FROM COOKING GRATES TO COMPLEX WORKPIECES



BHU, hand brushes for universal use

- for universal use
- follow the contours of every workpiece thanks to their flexibility
- perform a wide variety of manual jobs such as deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- “Stainless” quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.



steel



stainless

★★★☆☆

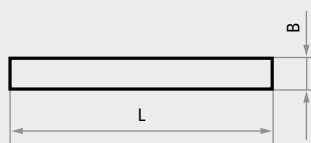
Product number	Description	Material	b mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>4</sub> mm	Wire Ø mm	Pack contains
A350726525113	BHUS 26528	steel	15	28	265	130	0.35	1
Recommended for: <span>● Steel</span> <span>● Cast material</span>								
A350726525213	BHUV 26525	stainless	15	28	265	130	0.3	1
Recommended for: <span>● Inox/Steel</span> <span>● Steel</span> <span>● Titanium</span>								



## FLEXIBLE REWORKING

LUKAS ECONOMY ROLLS WITH REGULAR ALUMINIUM OXIDE FOR EVERY CONTOUR

### SPR economy roll, abrasive material



- for practical manual reworking
- LUKAS economy rolls with their excellent grinding properties help you to optimise manual grinding tasks.

★★☆

Product number	Description	Grit	Width B mm	Length L m	Pack contains
A3821025040	SPR 025	NK 40	25	50	1
A3821025060	SPR 025	NK 60	25	50	1
A3821025080	SPR 025	NK 80	25	50	1
A3821025100	SPR 025	NK 100	25	50	1
A3821025120	SPR 025	NK 120	25	50	1
A3821025150	SPR 025	NK 150	25	50	1
A3821025180	SPR 025	NK 180	25	50	1
A3821025240	SPR 025	NK 240	25	50	1
A3821025320	SPR 025	NK 320	25	50	1
A3821025400	SPR 025	NK 400	25	50	1
A3821040040	SPR 040	NK 40	40	50	1
A3821040060	SPR 040	NK 60	40	50	1
A3821040080	SPR 040	NK 80	40	50	1
A3821040100	SPR 040	NK 100	40	50	1
A3821040120	SPR 040	NK 120	40	50	1
A3821040150	SPR 040	NK 150	40	50	1
A3821040180	SPR 040	NK 180	40	50	1
A3821040240	SPR 040	NK 240	40	50	1
A3821040320	SPR 040	NK 320	40	50	1
A3821040400	SPR 040	NK 400	40	50	1

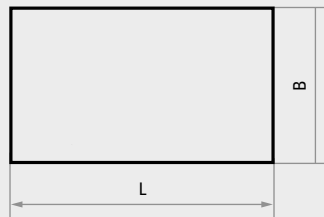
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

# PERFECT SURFACES

USE LUKAS SHEETS OF ABRASIVE CLOTH FOR MANUAL OPTIMISATION



## SLB sheets of abrasive cloth



- for practical manual reworking
- LUKAS sheets of abrasive cloth with their excellent grinding properties help you to optimise manual grinding tasks.

★★☆

Product number	Description	Grit	Width B mm	Length L m	Pack contains
A3825230280040	SLB 230280	NK 40	230	280	50
A3825230280060	SLB 230280	NK 60	230	280	50
A3825230280080	SLB 230280	NK 80	230	280	50
A3825230280100	SLB 230280	NK 100	230	280	50
A3825230280120	SLB 230280	NK 120	230	280	50
A3825230280150	SLB 230280	NK 150	230	280	50
A3825230280180	SLB 230280	NK 180	230	280	50
A3825230280220	SLB 230280	NK 220	230	280	50
A3825230280240	SLB 230280	NK 240	230	280	50
A3825230280320	SLB 230280	NK 320	230	280	50
A3825230280400	SLB 230280	NK 400	230	280	50
A3825230280999	SLB 230280	NK 1000	230	280	50

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium



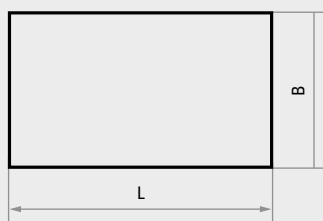
# FROM MEDIUM TO ULTRA-FINE

ACHIEVE THE DESIRED SURFACE QUALITY QUICKLY AND EASILY

## SVB fleece pads



★★☆



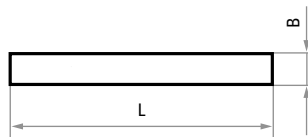
- for practical manual reworking
- LUKAS fleece pads are ideal for removing corrosion and surface staining and for cleaning, polishing and finishing all kinds of materials.

Product number	Description	Quality	Type	Width B mm	Length L m	Pack contains
A380115023011	SVB 150230	A Medium	red-brown	150	230	10
A380115023012	SVB 150230	A Fine	green	150	230	10
A380115023013	SVB 150230	A Very Fine	red-brown	150	230	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkred;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium						
A380115023024	SVB 150230	C Ultra Fine	grey	150	230	10
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkred;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium						

## SVR fleece roll



★★☆



- for practical manual reworking
- LUKAS fleece rolls are ideal for removing corrosion and surface staining and for cleaning, polishing and finishing all kinds of materials.

Product number	Description	Quality	Type	Width B mm	Length L m	Pack contains
A382011501012	SVR 115	A Fine	green	115	10	1
A382011501013	SVR 115	A Very Fine	red-brown	115	10	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkred;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium						
A382011501024	SVR 115	C Ultra Fine	grey	115	10	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: orange;">●</span> Aluminium <span style="color: darkred;">●</span> Cast material <span style="color: yellow;">●</span> Plastic/Wood <span style="color: darkgrey;">●</span> Titanium						



# POWER TOOLS

TECHNICAL INFORMATION

The most important product information at a glance

GENERAL

Our pneumatic power tools are characterised by high performance and low air consumption. The robust vane motors remain undamaged even when they stop under load.

The tools are fitted with a speed limiter, always keeping the idle speed within the specified tolerance. The service-friendly design allows wearing parts to be replaced quickly and easily.

COMPRESSED AIR SUPPLY

The motors operate at full power from a flow pressure of just 0.63 MPa (= 6.3 bar). We would be happy to advise you regarding the ideal specifications for the compressed air supply line. Please refer to the technical information for details about hose cross sections.

Air consumption (see machine data)	Connecting thread
0.05–0.5 m³/min	G 1/4"
0.15–0.9 m³/min	G 3/8"
0.5–1.5 m³/min	G 1/2"
0.8–6.0 m³/min	G 3/4"

VANE MOTOR LUBRICATION

A maintenance unit, comprising a water separator and an oiler, reliably protects the vane motors against wear, minimises the maintenance requirements, and prolongs their service life.

ERGONOMICS AND SAFETY

Vibration

To protect the operators, all of our power tools are tested and labelled in compliance with the current European Noise and Vibration Directive. The vibrations are recorded and calculated in three dimensions.

Ergonomics

Compared to electrical power tools, pneumatic motors offer greater performance at a lower weight. Thanks to their ergonomically shaped and insulated handles, the tools lie comfortably in the hand and won't tire the user.

Even difficult-to-access workpieces can be effortlessly machined using LUKAS pneumatic tools, as the spindle length, air outlet and valve design of many of the machine tools can be perfectly adapted to suit the user's requirements.

Safety

They can even be used in areas where there is a risk of explosion.

Quality

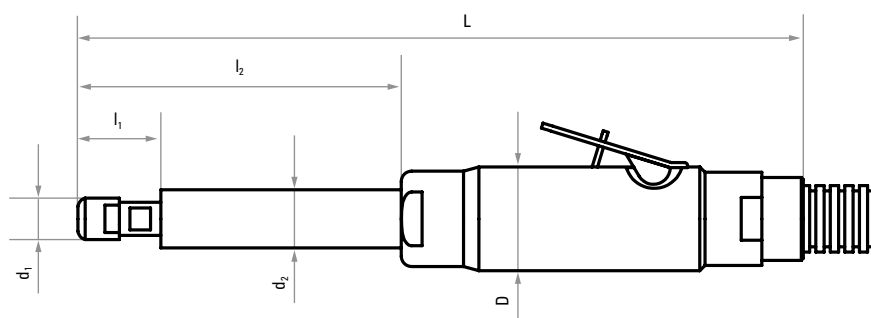
All of our power tools have a robust aluminium casing and are designed for use in harsh environments. The motors cannot overheat even when used continuously at maximum power. As part of our full quality control policy, all tools are subjected to speed and performance tests before they leave the factory.

Safety advice

Only tools that are suitable and approved in terms of safety for the peripheral speeds that can be attained with the respective machines may be used.

## TECHNICAL INFORMATION

## All LUKAS power tools at a glance



Power tool	Description	Speed rpm	Power kW	$d_1$ mm	$l_1$ mm	$d_2$ mm	$l_2$ mm	D mm	L mm	Page
Belt grinder, insulated	AMIN 30 BSH	30,000	0.300	19	28	h = 86		35	220	303
Straight grinder, insulated	AMIN 12-030 GD	12,000	0.300	16	26	–	–	35	195	304
	AMIN 15-030 GD	15,000	0.300	16	26	–	–	35	195	
	AMIN 12-030 GH	12,000	0.300	16	26	–	–	35	195	
Straight grinder with extension, insulated	AMIN 15-070 GH2L	15,300	0.700	24	35	24	440	46	630	305
Straight grinder, insulated	AMIN 19-100 GH	19,000	1.000	24	37	34	148	51	350	306
	AMIN 19-100 GHK	19,000	1.000	24	44	–	–	51	245	
Straight grinder, insulated	AMIN 20-030 GD	20,000	0.300	16	26	–	–	35	195	307
	AMIN 20-030 GH	20,000	0.300	16	26	–	–	35	195	
Straight grinder, insulated	AMIN 30-030 GD	30,000	0.300	14	16	–	–	36	190	308
	AMIN 30-030 GH	30,000	0.300	14	16	–	–	36	190	
Straight grinder, insulated	AMIN 32-027 GD	32,000	0.270	13	20	23	35	29	210	309
Straight grinder, insulated	AMIN 45-030 GD	45,000	0.300	14	16	–	–	36	190	310
	AMIN 45-030 GH	45,000	0.300	14	16	–	–	36	190	
Straight grinder, insulated	AMIN 55-011 GD	55,000	0.110	9	14	–	–	20	125	311
Straight grinder, insulated	AMIN 72-013 GD	72,000	0.130	10	15	–	–	29	165	312
Conditioning machine	ESM 1310 S	1,300–3,050	1,300	–	–	–	–	–	–	313

## MADE TO TACKLE THE TOUGHEST CHALLENGES

### PREMIUM-QUALITY POWER TOOLS FOR PREMIUM-QUALITY TOOLS

A range of LUKAS pneumatic grinders and LUKAS pneumatic tools is available so that you can use LUKAS tools in the most effective way. Our range of pneumatic grinders and pneumatic tools includes angle grinders (with turbine drive), belt grinders and a wide variety of straight grinders.

LUKAS pneumatic grinders and pneumatic tools are designed according to the most stringent quality requirements for withstanding extreme strain and to get the most out of LUKAS

top-performance tools. LUKAS power tools are characterised by their high performance and low air consumption during use. The robust vane motors achieve steadfast performance, even for harder cutting work. Even stopping under load won't damage them! Speed limiters keep the idle speed within the design tolerances. As an added benefit, replacing the wearing parts of LUKAS pneumatic grinders and pneumatic tools can be done quickly and easily.





# Belt grinder, insulated

Included with the machine:

- clamping arm for long belts, size 13 x 305 mm
- air feed hose
- exhaust air hose with muffler
- collet 6 mm
- operating tool/spanner

Special accessories:

- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"
- belt arms in various dimensions (lengths, widths and roll diameters) available from stock

Technical details:


- length: approx. 325 mm
- height: approx. 86 mm
- weight: approx. 0.90 kg
- drive type: vane motor

► Further technical details can be found on **page 301**.

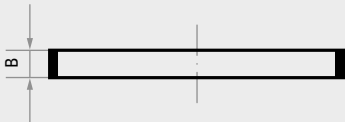


★★☆

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Abrasive belt peripheral speed m/s	Nominal hose size mm	Pack contains
A3993302113	AMIN 30 BSH	Lever	30,000	0.3	0.45	28	6	1

 **Suitable long belts are available from stock.**  
Please pay attention to the respective speed specifications on our tool packaging.

# SBL finishing belt



★★☆

Product number	Description	Grit	B mm	Length mm	Fabric	Pack contains
A3000130305060T	SBLT	NK 60	13	305	robustly flexible	100
A3000130305080T	SBLT	NK 80	13	305	robustly flexible	100
A3000130305120T	SBLT	NK 120	13	305	robustly flexible	100

Recommended for: 

Steel

Cast material

Plastic/Wood

Inox/Steel

Aluminium

Titanium

## Straight grinder, insulated



### Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.90 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 301**.

### Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

### Special accessories:

- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

★★☆

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m <sup>3</sup> /min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101112	AMIN 12-030 GD	Twist	12,000	0.3	0.49	6	8	1
A3993102112	AMIN 12-030 GH	Lever	12,000	0.3	0.49	6	8	1
A3993101115003	AMIN 15-030 GD	Twist	15,000	0.3	0.52	6	8	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 12-030 GD/GH	Tungsten carbide burrs	up to Ø 20 mm	17–43
	HSS burrs	up to Ø 8 mm	48–55
	SFV/M mounted flap wheels	Ø 40 mm	175–180
	SFI mounted flap wheels	Ø 30 mm	172
	SFA mounted flap wheels	Ø 15 mm, 20 mm, 30 mm	173
	SBZY abrasive bands	up to Ø 30 mm	196–199, 201
	SBKE abrasive bands	up to Ø 36 mm	202
	SRZY/SRKE abrasive rolls	up to Ø 20 mm	206–208
	SK/SKS abrasive caps	up to Ø 21 mm	211–213
	SHKE abrasive sleeves	0885, 1385, 1885	205
	P1 polishing points	4020	101
	P2 polishing points	Ø 20 mm	104
	P5 polishing points	up to Ø 32 mm	113
AMIN 15-030 GD	Tungsten carbide burrs	up to Ø 16 mm	17–43
	HSS burrs	up to Ø 6 mm	48–53
	SFI mounted flap wheels	Ø 30 mm	172
	SFA mounted flap wheels	Ø 15 mm, 20 mm, 30 mm	173
	SBZY abrasive bands	up to Ø 25 mm	197–199
	SBKE abrasive bands	up to Ø 29 mm	202
	SRZY/SRKE abrasive rolls	up to Ø 20 mm	206–208
	SK/SKS abrasive caps	up to Ø 16 mm	211–213
	SHKE abrasive sleeves	0885, 1385	205



Please pay attention to the respective speed specifications on our tool packaging.



## Straight grinder with spindle extension, insulated

### Included with the machine:

- air feed hose
- exhaust air hose with muffler
- two spindle extensions (each 200 mm long)
- collet 6 mm
- operating tool/spanner

### Special accessories:

- spindle extension: 200 mm (max. spindle extensions up to 1200 mm)
- collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"

### Technical details:

- length: approx. 615 mm (size incl. two spindle extensions)
- casing diameter: 47 mm
- weight: approx. 2.1 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 301**.



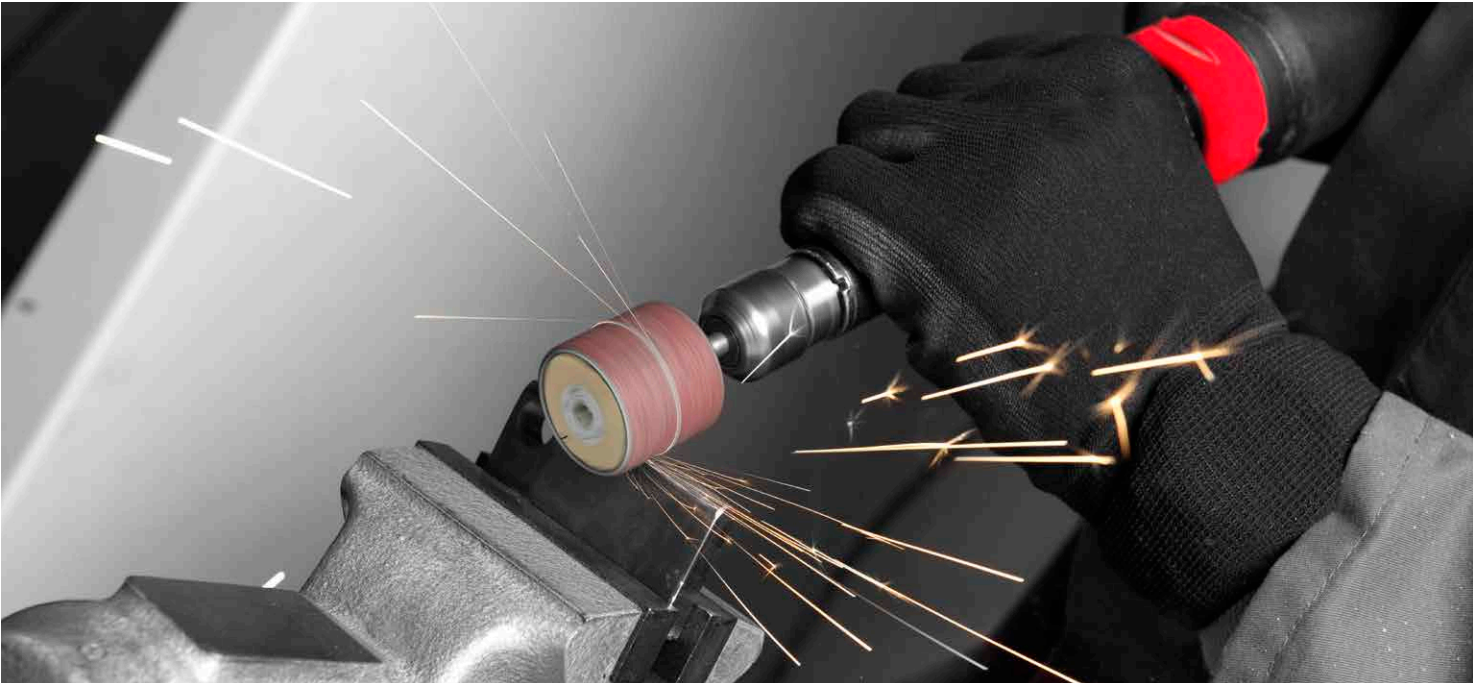
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Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993102115002	AMIN 15-070 GH2L	Lever	15,300	0.7	0.7	6	10	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 15-070 GH2L	SFL/SFB/SFT/SFE/SFC mounted flap wheels	up to Ø 40 mm	164–171
	SFI mounted flap wheels	Ø 30 mm	172
	SFA mounted flap wheels	Ø 15 mm, 20 mm, 30 mm	173
	SBZY spiral belts	up to Ø 25 mm	197–199
	SBKE spiral belts	up to Ø 29 mm	202
	SRZY/SRKE abrasive rolls	up to Ø 20 mm	206–208
	SK/SKS abrasive caps	up to Ø 16 mm	211–213
	SHKE abrasive sleeves	0885, 1385	205
	P1 polishing points	Ø 32 mm	101
	P2 polishing points	Ø 16 mm	104



Please pay attention to the respective speed specifications on our tool packaging.



Straight grinder, insulated



★★☆

Technical details:

- length AMIN 19-100 GH: approx. 310 mm
- length AMIN 19-100 GHK: approx. 190 mm
- casing diameter: 52 mm
- weight GH: approx. 2.3 kg
- weight GHK: approx. 1.7 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 301**.

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Special accessories:

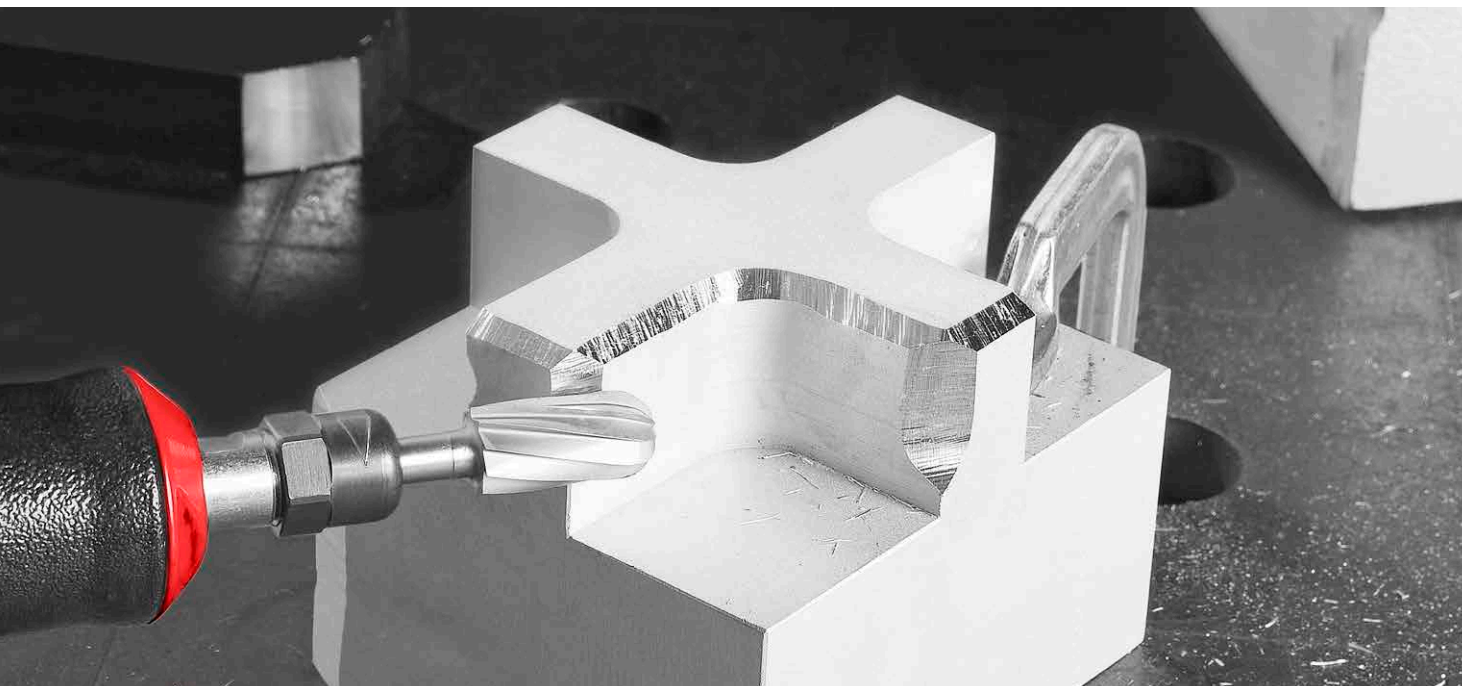
- collets for Ø 8 mm, 9 mm, 3/16", 1/4", 5/16"

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993102119	AMIN 19-100 GH	Lever	19,000	1	1	6	12	1
A3993102119001	AMIN 19-100 GHK	Lever	19,000	1	1	6	12	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 19-100 GH/GHK	Tungsten carbide burrs		up to Ø 12 mm	17–43
	HSS burrs		up to Ø 4 mm	50–53
	Mounted points		up to Ø 50 mm	73–93
	P1 polishing points		up to Ø 50 mm	100–101
	P2 polishing points		up to Ø 12 mm	103–104
	P3 polishing points		up to Ø 10 mm	106–07
	P5 polishing points		up to Ø 50 mm	113
	P6 polishing points		up to Ø 16 mm	116–20
	SK/SKS abrasive caps		up to Ø 13 mm	211–214
	SRZY/SRKE abrasive rolls		up to Ø 13 mm	206–208
	SBZY abrasive bands		up to Ø 19 mm	197–198
	SBKE abrasive bands		up to Ø 29 mm	202



Please pay attention to the respective speed specifications on our tool packaging.



## Straight grinder, insulated

### Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

### Special accessories:

- collets for Ø 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

### Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.90 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 301**.



★★☆

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101120	AMIN 20-030 GD	Twist	20,000	0.3	0.53	6	8	1
A3993102120	AMIN 20-030 GH	Lever	20,000	0.3	0.45	6	8	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 20-030 GD/GH	Tungsten carbide burrs		up to Ø 12 mm	17–43
	HSS burrs		up to Ø 4 mm	50–53
	SFL mounted flap wheels		Ø 20 mm	164–165
	SBZY abrasive bands		up to Ø 19 mm	197–198
	SBKE abrasive bands		up to Ø 29 mm	202
	SRZY/SRKE abrasive caps		up to Ø 13 mm	206–208
	SK/SKS abrasive caps		up to Ø 13 mm	211–214
	SHKE abrasive sleeves		Ø 885	265
	Mounted points, shank 6 mm		Ø 22 mm, 25 mm, 32 mm, 40 mm	73–93
	P2 polishing points		Ø 13 mm	103–104



Please pay attention to the respective speed specifications on our tool packaging.





Straight grinder, insulated



★★☆

Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.70 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on **page 301**.

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Special accessories:

- collets for Ø 3 mm, 3.25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101130	AMIN 30-030 GD	Twist	30,000	0.3	0.45	6	6	1
A3993102130	AMIN 30-030 GH	Lever	30,000	0.3	0.45	6	6	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 30-030 GD / GH	Tungsten carbide burrs		up to Ø 8 mm	17–43
	HSS burrs		up to Ø 3 mm	50–52
	Mounted points		up to Ø 32 mm	73–93
	P1 polishing points		up to Ø 32 mm	100–101
	P2 polishing points		up to Ø 10 mm	103–104
	P3 polishing points		up to Ø 10 mm	106–107
	P5 polishing points		up to Ø 32 mm	113
	P6 polishing points		up to Ø 12 mm	120
	SK/SKS abrasive caps		up to Ø 10 mm	211–214
	SBZY abrasive bands		up to Ø 12 mm	198



Please pay attention to the respective speed specifications on our tool packaging.



Straight grinder, insulated

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/spanner

Special accessories:

- collets for Ø 3 mm, 1/8", 1/4"

Technical details:

- length: approx. 206 mm
- casing diameter: approx. 30 mm
- spindle casing diameter: approx. 23 mm
- weight: approx. 0.40 kg
- drive type: vane motor
- frontal exhaust air (partial, can be shut off)


► Further technical details can be found on **page 301**.



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Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101132	AMIN 32-027 GD	Twist	32,000	0.27	0.3	6	6	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 32-027 GD	Tungsten carbide burrs		up to Ø 8 mm	17–43
	HSS burrs		up to Ø 3 mm	50–52
	Mounted points		up to Ø 32 mm	73–93
	P1 polishing points		up to Ø 32 mm	100–101
	P2 polishing points		up to Ø 10 mm	103–104
	P3 polishing points		up to Ø 10 mm	106–107
	P5 polishing points		up to Ø 32 mm	113
	P6 polishing points		up to Ø 12 mm	120
	SK/SKS abrasive caps		up to Ø 10 mm	211–214
	SBZY abrasive bands		up to Ø 12 mm	198

 Please pay attention to the respective speed specifications on our tool packaging.



Straight grinder, insulated



★★☆

- Technical details:**
- length: approx. 175 mm
  - casing diameter: 34.5 mm
  - weight: approx. 0.70 kg
  - drive type: vane motor

► Further technical details can be found on **page 301**.

- Included with the machine:**
- air feed hose
  - exhaust air hose with muffler
  - collet: 6 mm
  - operating tool/spanner

- Special accessories:**
- collets for Ø 3 mm, 3.25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101145	AMIN 45-030 GD	Twist	45,000	0.3	0.5	6	6	1
A3993102145	AMIN 45-030 GH	Lever	45,000	0.3	0.5	6	6	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 45-030 GD / GH	Tungsten carbide burrs		up to Ø 6 mm	17–43
	Mounted points		up to Ø 20 mm	73–90
	P1 polishing points		up to Ø 20 mm	100–101
	P2 polishing points		up to Ø 6 mm	103–104
	P3 polishing points		up to Ø 6 mm	106–107
	P5 polishing points		up to Ø 20 mm	113
	P6 polishing points		up to Ø 10 mm	120
	SK/SKS abrasive caps		up to Ø 5 mm	211–214
	SBZY abrasive bands		up to Ø 12 mm	198



Please pay attention to the respective speed specifications on our tool packaging.

## Straight grinder, insulated

### Properties:

- most powerful tool in its class
- compact design
- lockable speed switch

### Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 3 mm
- operating tool/spanner

### Technical details:

- length: approx. 130 mm
- casing diameter: 16 mm
- weight: approx. 0.24 kg
- drive type: vane motor



### Special accessories:

- collets for Ø 2 mm, 3.25 mm, 1/8", 3/32"

► Further technical details can be found on **page 301**.



Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101155	AMIN 55-011 GD	Twist	55,000	0.11	0.15	3	3	1

Can be used with the following LUKAS tools			Dimensions	Catalogue page
AMIN 55-011 GD	Tungsten carbide burrs		up to Ø 5 mm	18–43
	Mounted points		up to Ø 16 mm	73–89
	P1 polishing points		up to Ø 16 mm	100–101
	P2 polishing points		up to Ø 5 mm	103–104
	P5 polishing points		up to Ø 16 mm	113
	SK/SKS abrasive caps		up to Ø 5 mm	211–214
	SBZY abrasive bands		up to Ø 10 mm	198



Please pay attention to the respective speed specifications on our tool packaging.

Straight grinder, insulated



Technical details:

- length: approx. 154 mm
- casing diameter: 275 mm
- weight: approx. 0.45 kg
- drive type: vane motor

Included with the machine:

- air feed hose
- exhaust air hose with muffler
- collet: 3 mm
- operating tool/spanner

Special accessories:

- collets for Ø 2 mm, 3.25 mm, 1/8", 3/32"

★★☆

► Further technical details can be found on **page 301**.

Product number	Description	Valve	Idle speed (rpm)	Power kW	Air consumption under load m³/min	Collet Ø mm	Nominal hose size mm	Pack contains
A3993101172	AMIN 72-013 GD	Twist	72,000	0.13	0.21	3	5	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
AMIN 72-013 GD	Tungsten carbide burrs	up to Ø 4 mm	18–42
	Mounted points	up to Ø 13 mm	73–89
	P1 polishing points	up to Ø 13 mm	100–101
	P2 polishing points	up to Ø 4 mm	103–104
	P5 polishing points	up to Ø 13 mm	113



Please pay attention to the respective speed specifications on our tool packaging.





Conditioning machine

Properties:

- heavy-duty motor (stable)
- double gear reduction (long service life)
- dust-protected bearings (low wear)
- Shadow-free metal, wood or plastic surfaces without transitions can be achieved with the ideal tool.

With the appropriate tool, perfect for:

- conditioning
- structuring
- polishing
- brushing
- smoothening
- deburring
- matt finishing

Technical details:

- weight: approx. 2.8 kg
- electronic control with soft start, infinitely variable speed control, temperature and overload cut-off


► Further technical details can be found on **page 301**.



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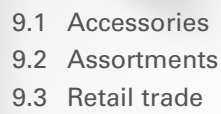
Product number	Description	Idle speed (rpm)	Power kW	Tool max. Ø mm	Tool width mm	Tool holder mm	Pack contains
A3995ESM1310	ESM 1310 S	1,300–3,050	1.3	120	100	19	1

Can be used with the following LUKAS tools		Dimensions	Catalogue page
ESM 1310 S	P6 polishing rolls	100 x 50 mm, 100 x 100 mm	122
	SBZY abrasive belt rolls	100 x 100 mm	203
	LWL/LWV/LWM/LWF abrasive flap rolls	100 x 50 mm, 100 x 100 mm	190–193

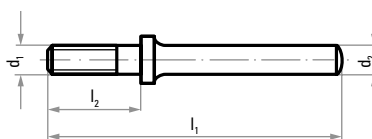
 Please pay attention to the respective speed specifications on our tool packaging.



316–318  
319–323  
324–333



## Arbors for felt polishing wheels



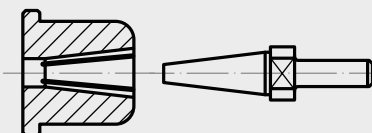
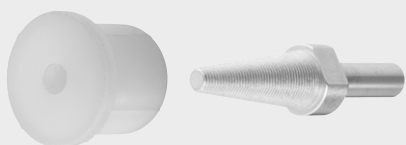
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### Included (per arbor):

- two washers, diameter 18 mm
- two washers, diameter 30 mm
- one hex nut

Product number	Description	d <sub>1</sub>	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	n <sub>max</sub> rpm	Pack contains
A1630780	ASB 780	M6	20	6	63	7,000	5
A1630781	ASB 781	M6	30	6	73	7,000	5

## Mounting system for polishing wheels

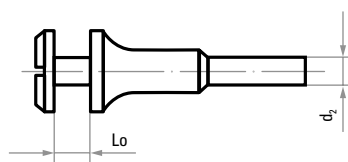
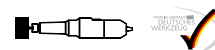


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The mounting system for polishing wheels consists of a plastic sleeve (MCA) and a mounting arbor with 8 mm diameter shank (K25), which is solely applicable to shape SE1 in the dimensions 10010 B 25 and 10020 B 25. This system is not designed to be used for polishing wheels with larger diameters. The maximum cutting speed for this mounting system is 10 m/s. This results in a maximum spindle speed of 1900 rpm with a wheel diameter of 100 mm.

Product number	Description	Pack contains
A6981008000	Mounting system MCA + K25 H	1

## Arbors for small cutting and rough grinding wheels

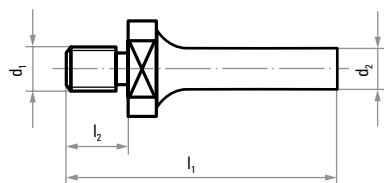


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Product number	Description	Tool internal diameter mm	L <sub>0</sub> mm	d <sub>2</sub> mm	Pack contains
A36600060604	ASB 6/6	6	0–4	6	1
A36600061004	ASB 6/1	10	0–4	6	1
A36600081048	ASB 8/10	10	4–8	8	1

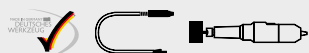


## Arbors for tools with an internal thread

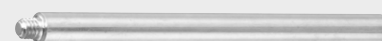
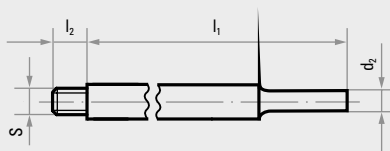


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Product number	Description	d <sub>1</sub>	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A16303422	ASB 342 B	M10	12	6	52	5
A16303423	ASB 342 C	M12	14	6	54	5
A16303424	ASB 342 D	M8	10	6	50	5
A16303442	ASB 344 B	M10	12	8	52	5
A16303443	ASB 344 C	M12	14	8	54	5
A16303452	ASB 345 B	M10	12	10	52	5



## Tool adapters for SFI mounted flap wheels



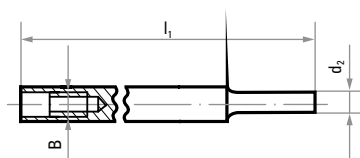
► only for use with the LUKAS mounted flap wheels on **page 172**

★★☆

Product number	Description	d <sub>1</sub> mm	l <sub>1</sub> mm	S	l <sub>2</sub> mm	Pack contains
A36300404	WADI 0404	6	80	M4	4	1
A36300407	WADI 0407	6	80	M4	7	1
A36300609	WADI 0609	6	100	M6	9	1
A36300612	WADI 0612	6	100	M6	12	1



## Tool adapter for SFA mounted flap wheels



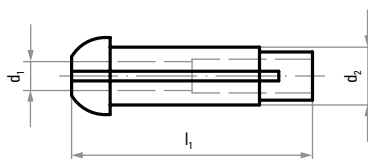
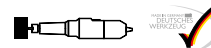
► only for use with the LUKAS mounted flap wheels on **page 173**

★★☆

Product number	Description	d <sub>2</sub> mm	l <sub>1</sub> mm	B	Pack contains
A36300518	WADA 05	6	100	M5	1



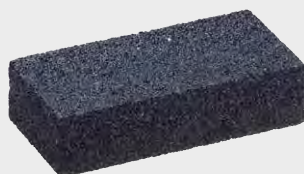
## Reducing bush



★★☆

Product number	Description	d <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A3630006	SP 6	3	6	25	5
A3630008	SP 8	6	8	30	1

## Sharpening stones



★★☆

RU 1–4 are 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						

## AVAILABLE DIMENSIONS

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

Shape	Length mm	Width mm	Height mm
	150	25	10–35
	150	50	10–35
	200	50	10–35
Half-round	216	78	20–35
	150	13	5–35

► For detailed information about sharpening stones, please refer to **page 95**.



## Carbide burrs assortments

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



★★☆

Product number	Description	Cut	Shank diameter mm	Contents per pack	Pack contains
A10390010	F10 S3	Z7 Steel	3	10 parts: HFA 0313 HFC 0613 HFG 0313 HFF 0313	1
A1039001006	F10 S6	Z7 Steel	6	10 parts: HFAS 0616 HFC 1225 HFD 1210 HFF 0820	1
Recommended for: <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material <span style="color: grey;">●</span> Titanium					
A1039001020	Assortment	Z42 Inox/Steel	6	10 parts: HFA 0616 HFC 1225 HFG 0618 HFF 1225	1
Recommended for: <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material					
A1039000509	Assortment	Z9 Alu	3	5 parts: HFA 0313 HFF 0313	1
A10390005096	Assortment	Z9 Alu	6	5 parts: HFA 0616 HFF 0618	1
Recommended for: <span style="color: orange;">●</span> Aluminium <span style="color: yellow;">●</span> Plastic/Wood <span style="color: grey;">●</span> Titanium					



## ZX Universal carbide burrs assortments

- Always the right tool to hand. LUKAS' practical assortment of tools means you always have exactly what you need.
- perfectly suited for testing different tools

- just as suitable for use in the home, hobby workshop or in industry
- the all-round burr for universal applications, with cross cut for high performance



F5 S3 BASE-X

★★☆

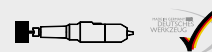
Product number	Description	Cut	Shank diameter mm	Contents per pack	Pack contains
A10390053	F5 S3 BASE-X	ZX	3	5 parts: HFA 0313 HFF 0313	1
A10390056	F5 S6 BASE-X	ZX	6	5 parts: HFA 1225 HFF 1225	1
Recommended for: <span style="color: grey;">●</span> Steel <span style="color: red;">●</span> Cast material <span style="color: blue;">●</span> Inox/Steel <span style="color: grey;">●</span> Titanium					

# READY FOR EVERY JOB

THE LUKAS TOOL ASSORTMENTS ALWAYS PROVIDE THE RIGHT TOOL FOR THE JOB



## HSS burrs assortments



F1



F3



F4

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

★★☆

Product number	Description	Cut	Shank diameter mm	Content per pack	Pack contains
A1239000110	F1	Z5	3	10 parts: MF 807 MF 845 MF 864 MF 874	MF 813 MF 850 MF 841 MF 853 MF 866 MF 872
A123900003	F3	Z3	6	10 parts: MFA 0616 MFD 0403 MFG 1230 MFM 0618	MFA 1225 MFD 1210 MFC 1225 MFE 1220 MFK 1230 MFL 1230
A123900004	F4	Z3/Z5	6	20 parts: Z3: MFA 0616 MFC 1225 MFE 1220 MFG 1230 MFM 0618 MFN 1230  Z5: MFA 0304 MFN 0606	MFA 1013 MFD 0807 MFE 1625 MFK 1230 MFM 1230  MFA 1225 MFD 1210 MFE 1220 MFL 1630 MFN 1213  MFA 0607 MFN 0303

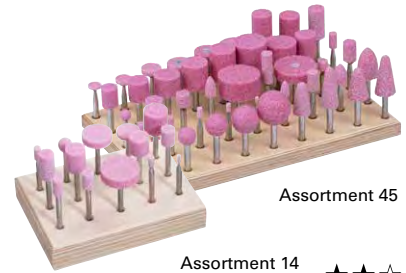
Recommended for: ● Steel ● Aluminium



## EKR mounted point assortments

- Always the right tool to hand. LUKAS' practical assortment of tools means you always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry
- for use on structural steel, for rough grinding and finishing

- top results with regular aluminium oxide
- extremely hard and sharp for an impressively long tool life
- also machines hard materials efficiently



Assortment 45

Assortment 14



Product number	Description	Quality	Shank diameter mm	Content per pack	Pack contains
A204700001402	Assortment 14	EKR	3 x 30	<b>14 parts:</b> 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
A204600000202	Assortment 45	EKR	6 x 40	<b>45 parts:</b> 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



## Mounted point assortments, mini mounted points

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



Assortment 36, EKBR



Assortment 36, EKR



Product number	Description	Quality	Shank diameter mm	Content per pack	Pack contains
A204800003611	Assortment 36	EKBR	3 x 30	<b>36 parts:</b> 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
A204800003602	Assortment 36	EKR	3 x 30	<b>36 parts:</b> 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

## NDW mounted point assortment



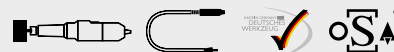
- Always the right tool to hand. LUKAS' practical assortment of tools means you always have exactly what you need.
- perfectly suited for testing different tools
- just as suitable for use in the home, hobby workshop or in industry

- optimised grain combinations for unhardened and hardened tool steel
- high quality grain types for efficient machining of unhardened tool steel

★★★

Product number	Description	Quality	Shank diameter mm	Content 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: <input checked="" type="radio"/> Steel							

## Group P1 polishing points assortment



- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel
- manufactured in line with DIN 69170
- a match for all polishing requirements
- 14 different shapes for quick tool change

★★☆

Product number	Description	Content per pack					Pack contains
A2600114	Assortment 114	14 parts: P1ZY 0408.03 P1ZY 1010.03 P1ZY 1316.03	P1ZY 0510.03 P1ZY 1013.03 P1ZY 1604.03	P1ZY 0610.03 P1ZY 1016.03 P1ZY 1616.03	P1ZY 0710.03 P1ZY 1303.03 P1ZY 2006.03	P1ZY 0810.03 P1ZY 1313.03	1
Recommended for: <input checked="" type="radio"/> Inox/Steel <input type="radio"/> Steel <input type="radio"/> Cast material <input type="radio"/> Titanium							



# THE RIGHT ABRASIVE CAP FOR EVERY CHALLENGE

640 ABRASIVE CAPS AND 23 MANDRELS IN A SINGLE ASSORTMENT



## WS abrasive cap assortment



★★★☆☆

- consists of 640 abrasive caps and 23 mandrels
- box outer dimensions:  
372 mm x 189 mm x 46 mm

Product number	Description	Quantity	Content	Pack contains
A210000065001	WS 65 NKS	50 pieces 100 per pack 50 per pack 20 per pack 10 pieces	Abrasive caps, grain NKS 150: SKKES 0515 SKWRS 0511 SKWKS 0511 SKZYS 0510 SKWRS 0713 SKWKS 0713 SKZYS 0712 SKWRS 1015 SKWKS 1015 SKZYS 1015 SKWRS 1125 SKKES 1125	1
		20 pieces 10 per pack 15 per pack	Abrasive caps, grain NKS 80: SKWKS 1015 SKWRS 1319 SKWKS 1319 SKKES 1632 SKZYS 1317 SKWRS 1626 SKWKS 1626 SKWRS 1626	
		2 per pack 1 per pack	Mandrel, shank 3 mm: GTZY 0510 GTWR 0511 GTWK 0511 GTZY 0712 GTWR 0713 GTWK 0713 GTWK 1015 GTZY 1317 GTZY 1015 GTWR 1015 GTWK 1319 GTWR 1319 GTWK 1319	
		1 per pack	Mandrel, shank 6 mm: GTKE 0515 GTKE 1125 GTWK 1626 GTWR 1626 GTKE 1632	

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

## RETAIL TRADE SELECTION

## Take advantage of the LUKAS service for retailers

As retailers, you know exactly what your customers want. Therefore you want to present and sell LUKAS products in a way that speaks to your customers. We have just the right thing

for you: the LUKAS presentation stand will help you boost your sales of industrial tools for cutting, milling, grinding and polishing for the long term.



### THE LUKAS DISPLAY WALL

Stable, self-supporting presentation stand with perforated panel. Assemble your own, customised display panel with hook hangers for Euro hole packaging, hook hangers for all products with a hole, a brochure dispenser for further information or suspended shelves for boxes to display products in a professional way.

### CARDBOARD COUNTER DISPLAY FOR CUTTING DISCS OR MOUNTED FLAP WHEELS

Presentation aid with quick assembly for presenting unique LUKAS mounted flap wheels or cutting and grinding discs on your sales counter. Available for tools with a diameter of 115 mm or 125 mm.

### COUNTER DISPLAY FOR TUNGSTEN CARBIDE BURRS

Lockable display for presentation and individual sale of valuable LUKAS tungsten carbide burrs with a 3 mm or 6 mm shank. Place it on your sales counter or shelves.

### OUR INDIVIDUAL PACKAGING

Eye-catching and informative individual packaging for the most popular LUKAS tools such as flap discs from the patented iQ series, tungsten carbide burrs, mounted flap wheels made of abrasive material, abrasive fleece or a combination of the two, as well as our mounted points selection for steel or inox. All of these are individually packaged and come with a Euro hole, available for your customised "display module" just like our cutting discs, diamond cutting discs, grinding discs and conventional flap discs, which you can simply hang on the display.

## DISPLAY ACCESSORIES

# Presenting LUKAS tools made easy and attractive

## CARBIDE BURRS

The popular carbide burrs Z42 Inox/Steel and ZX Universal in practical retail packaging.  
**Pages 328/329**

## FLAP WHEELS

SFL, SFV and SFM flap wheels in retail packaging for a wide variety of applications. **Pages 331/332**

## DIAMOND CUTTING DISCS

The efficient diamond cutting disc for the construction site and the inexpensive option for cutting tiles in retail packaging.  
**Page 333**

## COUNTER DISPLAY, LOCKABLE

For the presentation and individual sale of LUKAS burrs. Place it on your sales counter or shelves. **Page 328**



### OUR RETAIL TRADE SELECTION



### ADDITIONAL LUKAS PRODUCTS

This display wall is not only ideal for attractively presenting practical LUKAS retail trade products, many other LUKAS tools can also be displayed to advantage on the flexibly designed perforated stand. Select suitable products from the overview below and design your sales area the way you want.

## DISPLAY WALL

Appeal to customers directly with LUKAS products.  
**Page 326**

## CUTTING DISC SETS

Various cutting disc sets in high quality, practical and secure metal boxes. **Page 327**

## MOUNTED POINTS SELECTION

Mounted points in various shapes in retail packaging. Ideal for letting your customers test our product. **Page 330**

## COUNTER DISPLAY

Counter display for up to 10 metal boxes of LUKAS cutting disc sets for direct dispensing to customers. **Page 326**

### LUKAS PRODUCT HIGHLIGHTS FOR YOUR DISPLAY STAND

Milling tools	Page 43	Flap wheels	Pages 164–180
HZB special drill	Page 61	LSL flap wheels in abrasive cloth with thread	Page 182
Diamond dry drills	Page 61	Fibre discs with backing plate	Pages 236–241
Diamond drill bit for socket outlets	Page 63	Cutting discs	Pages 244–259
P6PT range	Pages 117–119	Diamond cutting discs	Pages 260–267
Small polishing points with soft elastomer bond	Page 123	Grinding discs	Pages 270–281
iQ series tools	Pages 134–151	ASVT grinding disc	Page 287
Additional mounted flap wheels	Pages 152–161		



## Display stand



★★☆

- stable, self supporting displaystand with perforated panel
- customised presentation

Product number	Description	Dimensions (W x H x D) m	Accessories	Pack contains
A89404	Display stand	1 x 2.10 x 0.37	Hook hangers for Euro-hole packaging Hook hangers for all products with a hole, suspended shelf and brochure dispenser	1

## Counter display



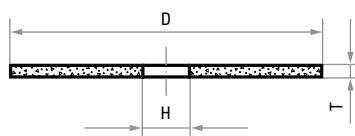
★★☆

- counter display (without contents) for 10 boxes of cutting disc sets

Product number	Description	Dimensions (W x H x D) mm	Pack contains
A89406	Counter display	145 x 440 x 145	1



## 3-star cutting disc set



The practical packaging for construction sites etc.

- cutting disc in metal box
- securely packaged
- protected from moisture

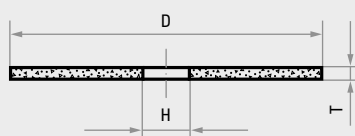
★★★

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT007231V9807010	T41 115x1.0	A60Z-BF Inox	115	1.0	22.23	13,300	10
AT007233V9807010	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	10

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



## 2-star cutting disc set



The practical packaging for construction sites etc.

- cutting disc in metal box
- securely packaged
- protected from moisture

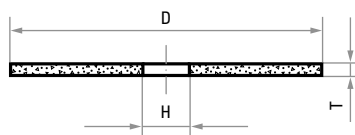
★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT005841V9807010	T41 115x1.0	A60X-BF Inox	115	1.0	22.23	13,300	10
AT005842V9807010	T41 125x1.0	A60X-BF Inox	125	1.0	22.23	12,200	10

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



## 1-star cutting disc set



The practical packaging for construction sites etc.

- cutting disc in metal box
- securely packaged
- protected from moisture

★★☆

Product number	Description	Quality	D mm	T mm	H mm	n <sub>max</sub> rpm	Pack contains
AT004643V9807010	T41 115x1.0	A60S-BF Inox	115	1.0	22.23	13,300	10
AT002672V9807010	T41 125x1.0	A60S-BF Inox	125	1.0	22.23	12,200	10

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



## Counter display for tungsten carbide burrs

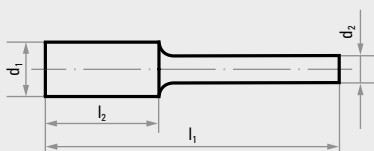
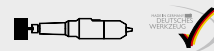


★☆☆

- for the presentation and individual sale of LUKAS carbide burrs with a 3 mm or 6 mm shank diameter
- lockable display
- also fits into shelves

Product number	Description	Dimensions (W x H x D) mm	Content 2 per pack			Pack contains
A5039004022	Counter display for tungsten carbide burrs	235 x 250 x 400	HFA 0313.03 ZX HFA 1225.06 ZX HFC 1020.06 ZX, HFD 0807.06 ZX HFG 0313.03 ZX HFG 1225.06 ZX HFF 1020.06 ZX	HFA 0820.06 ZX HFC 0313.03 ZX HFC 1225.06 ZX HFD 1009.06 ZX HFG 0820.06 ZX HFM 0311.03 ZX HFF 1225.06 ZX	HFA 1020.06 ZX HFC 0820.06 ZX HFD 0605.03 ZX HFD 1210.06 ZX HFG 1020.06 ZX HFF 0820.06 ZX	1

## Z42 Inox/Steel burr



- one burr for two materials: perfectly process steel and stainless steel with just a single tool
- in retail packaging
- high chip volume thanks to coarse cut for quick working
- faceted toothing for perfect surface results
- smooth running, low-vibration tool without chatter thanks to improved cutting angle

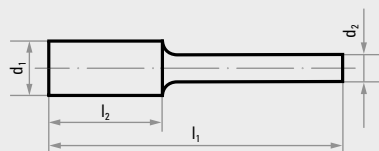
★★☆

Product number	Description	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010820620F1	HFA 0820.06	Z42 Inox/Steel	ZYA 0820	8	20	6	60	1
A10011225620F1	HFA 1225.06	Z42 Inox/Steel	ZYA 1225	12	25	6	65	1
A10020820620F1	HFC 0820.06	Z42 Inox/Steel	WRC 0820	8	20	6	60	1
A10021225620F1	HFC 1225.06	Z42 Inox/Steel	WRC 1225	12	25	6	65	1
A10030605620F1	HFD 0605.06	Z42 Inox/Steel	KUD 0605	6	5	6	50	1
A10030807620F1	HFD 0807.06	Z42 Inox/Steel	KUD 0807	8	7	6	47	1
A10031210620F1	HFD 1210.06	Z42 Inox/Steel	KUD 1210	12	10	6	51	1
A10100820620F1	HFF 0820.06	Z42 Inox/Steel	–	8	20	6	60	1
A10101225620F1	HFF 1225.06	Z42 Inox/Steel	RBF 1225	12	25	6	65	1
A10040820620F1	HFG 0820.06	Z42 Inox/Steel	SPG 0820	8	20	6	60	1
A10041225620F1	HFG 1225.06	Z42 Inox/Steel	SPG 1225	12	25	6	65	1

Recommended for: ● Inox/Steel ● Steel

# ZX UNIVERSAL – PERFORMS WELL ON ALL MATERIALS

MINIMISE RETOOLING WITH UNIVERSAL CROSS CUT



## ZX Universal burr



- the all-round burr for universal use in retail packaging
- with cross cut for high performance

★☆☆

Product number	Description	Cut	Similar to DIN 8033	d <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	l <sub>1</sub> mm	Pack contains
A10010313322F1	HFA 0313.03 ZX	ZX	ZYA 0313	3	13	3	40	1
A10010820622F1	HFA 0820.06 ZX	ZX	ZYA 0820	8	20	6	60	1
A10011225622F1	HFA 1225.06 ZX	ZX	ZYA 1225	12	25	6	65	1
A10020313322F1	HFC 0313.03 ZX	ZX	WRC 0313	3	13	3	40	1
A10020820622F1	HFC 0820.06 ZX	ZX	WRC 0820	8	20	6	60	1
A10021225622F1	HFC 1225.06 ZX	ZX	WRC 1225	12	25	6	65	1
A10030605322F1	HFD 0605.03 ZX	ZX	KUD 0605	6	5	3	35	1
A10030807622F1	HFD 0807.06 ZX	ZX	KUD 0807	8	7	6	47	1
A10031210622F1	HFD 1210.06 ZX	ZX	KUD 0313	12	10	6	51	1
A10100820622F1	HFF 0820.06 ZX	ZX	–	8	20	6	60	1
A10101225622F1	HFF 1225.06 ZX	ZX	RBF 1225	12	25	6	65	1
A10040313322F1	HFG 0313.03 ZX	ZX	SPG 0313	3	13	3	40	1
A10040820622F1	HFG 0820.06 ZX	ZX	SPG 0820	8	20	6	60	1
A10041225622F1	HFG 1225.06 ZX	ZX	SPG 1225	12	25	6	65	1
A10050311322F1	HFM 0311.03 ZX	ZX	SKM 0311	3	11	3	40	1

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

## Ceramic mounted point assortment



★★★★

- maximum aggressiveness and hardness with ceramic self-sharpening effect
- five different shapes for fast tool change in retail packaging
- impressive tool life
- higher and faster stock removal particularly on hardened surfaces, scale, hard coatings and armour steel welds

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

Recommended for: ● Steel ● Titanium ● Inox/Steel

## Inox mounted point assortment



★★★☆☆

- for non-rusting steel
- 4 different shapes for fast tool changes, in specialist retail packaging
- excellent stock removal performance, also under adverse conditions

Product number	Description	Shank diameter mm	Quality	Content	Pack contains
A20480004627WF1	Inox assortment	6	NK BA	4 parts: ZY 1332.06 NK 24 N BA soft ZY 2040.06 NK 24 N BA soft ZY2 4006.06 NK 24 N BA soft KU 2525.06 NKB/NK 24 R BA 98	1

Recommended for: ● Inox/Steel ● Steel ● Aluminium

## Steel mounted point assortment



★★★☆☆

- top results with regular aluminium oxide, on structural steel, when rough grinding and finishing
- 5 different shapes for fast tool changes, in specialist retail packaging
- extremely hard and sharp for an impressively long tool life
- also machines hard materials efficiently

Product number	Description	Shank diameter mm	Quality	Content	Pack contains
A20480005602F1	Steel assortment	6	EKR	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

Recommended for: ● Steel

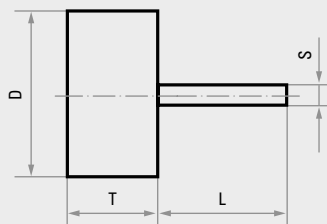
# EFFICIENT AND PRODUCTIVE SURFACE GRINDING

THE PRACTICAL ALL-ROUND MOUNTED FLAP WHEELS FROM LUKAS



## SFL mounted flap wheels

- mounted flap wheels with abrasive cloth for manual use in retail packaging
- ideal for finishing, derusting, fettling, deburring, surface grinding, decorative finishing and bevelling
- impressive tool life working with various materials



★★☆

Product number	Description	Grit	D mm	T mm	S mm	L mm	n <sub>rec</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2200030103060F1	SFL 03010.03	NK 60	30	10	3	40	16,000	18,000	1
A2200030103080F1	SFL 03010.03	NK 80	30	10	3	40	16,000	18,000	1
A2200030103120F1	SFL 03010.03	NK 120	30	10	3	40	16,000	18,000	1
A2200040206060F1	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	1
A2200040206080F1	SFL 04020.06	NK 80	40	20	6	40	12,000	19,100	1
A2200040206120F1	SFL 04020.06	NK 120	40	20	6	40	12,000	19,100	1
A2200060306040F1	SFL 06030.06	NK 40	60	30	6	40	8,000	12,700	1
A2200060306060F1	SFL 06030.06	NK 60	60	30	6	40	8,000	12,700	1
A2200060306080F1	SFL 06030.06	NK 80	60	30	6	40	8,000	12,700	1
A2200060306120F1	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	1

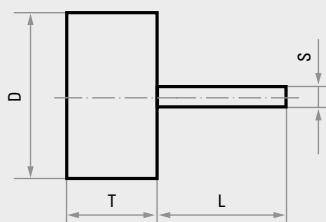
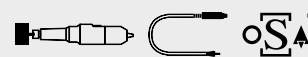
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Plastic/Wood ● Titanium

# THE FINISHING TOUCH FOR SURFACES

ABRASIVE FLEECE FOR MANUAL USE



## SFV mounted flap wheels



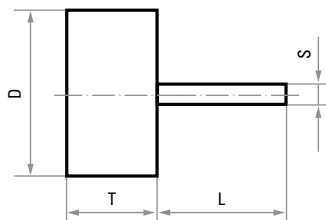
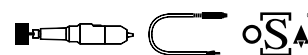
- flap wheels with regular aluminium oxide in retail packaging
- consisting of abrasive fleece flaps radially located around the hub of the tool
- ideal for matting, conditioning, polishing, finishing and fine surface finishing

★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2203040206104F1	SFV 04020.06	A 104	NK 100	40	20	6	40	7,500	14,000	1
A2203040206106F1	SFV 04020.06	A 106	NK 180	40	20	6	40	7,500	14,000	1
A2203060306104F1	SFV 06030.06	A 104	NK 100	60	30	6	40	5,000	9,000	1
A2203060306106F1	SFV 06030.06	A 106	NK 180	60	30	6	40	5,000	9,000	1

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Plastic/Wood ● Titanium

## SFM mounted flap wheels



- flap wheels with regular aluminium oxide in retail packaging
- in a combination of abrasive fleece and cloth for a high stock removal performance
- suitable for cleaning, derusting, pre-finishing, graining and keying

★★☆

Product number	Description	Quality	Grit	D mm	T mm	S mm	L mm	n <sub>recom</sub> rpm	n <sub>max</sub> rpm	Pack contains
A2204040206104F1	SFM 04020.06	A 104/80	NK 100/80	40	20	6	40	7,500	14,000	1
A2204040206106F1	SFM 04020.06	A 106/150	NK 180/150	40	20	6	40	7,500	14,000	1
A2204060306104F1	SFM 06030.06	A 104/80	NK 100/80	60	30	6	40	5,000	9,000	1
A2204060306106F1	SFM 06030.06	A 106/150	NK 180/150	60	30	6	40	5,000	9,000	1

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Plastic/Wood ● Titanium



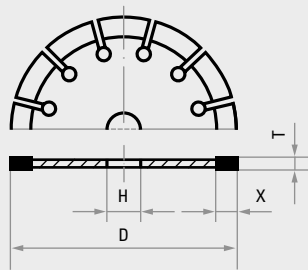
# IDEAL FOR USE ON CONSTRUCTION SITES

## LUKAS DIAMOND CUTTING DISCS FOR EFFICIENT USE

This diamond cutting disc for construction sites is coated with synthetic diamonds bonded with an innovative alloy. It enables universal cutting of the hardest materials at a high operating speed.



- in retail packaging
- especially popular on construction sites
- excellent price-to-performance ratio



### Blue Cut S10 diamond cutting disc



★☆☆

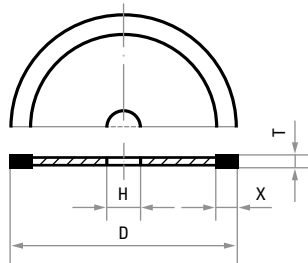
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345241151110085	Blue Cut S10	115	10	2.0	22.23	13,300	1
A345241251110095	Blue Cut S10	125	10	2.0	22.23	12,200	1
A345241501110125	Blue Cut S10	150	10	2.2	22.23	10,200	1
A345241801110145	Blue Cut S10	180	10	2.4	22.23	8,500	1
A345242301110165	Blue Cut S10	230	10	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material



### FC7 diamond cutting disc

- in retail packaging
- especially popular on construction sites
- excellent price-to-performance ratio



★☆☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n <sub>max</sub> rpm	Pack contains
A345211151107015	FC7	115	7	1.8	22.23	13,300	1
A345211251107015	FC7	125	7	2.0	22.23	12,200	1
A345212301107015	FC7	230	7	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material

## A

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- SBL finishing belt ..... 204, 303
- SBZY abrasive band, cylindrical shape, without lining .. 201
- SBZY Ceramic abrasive band, cylindrical shape ..... 196
- SBZY regular aluminium oxide abrasive band, cylindrical shape ..... 198/199
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- SBZY zirconia alumina abrasive band, cylindrical shape ..... 197

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- STZY hard abrasive band mandrel, cylindrical shape ..... 200
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- PSG reinforced self-clamping regular aluminium oxide abrasive disc ..... 221
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- PSK adhesive regular aluminium oxide abrasive disc ..... 229
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- PSH self-fixing regular aluminium oxide abrasive disc ..... 231/232

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- GTH abrasive disc carrier for self-fixing abrasive discs ..... 232
- GTHX abrasive disc carrier for self-fixing abrasive discs with thread ..... 233
- GTK abrasive disc carrier for adhesive abrasive discs ..... 230

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- GTHX abrasive disc carrier for self-fixing abrasive discs with thread ..... 233
- GTG abrasive disc carrier for self-clamping abrasive discs ..... 223
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# General terms and conditions

## I. SCOPE OF APPLICATION

1. The following conditions are final and an integral part of the contract. They apply to all (current and future) agreements, contracts and other services. All offers are exclusively based on our General Terms of Business which are deemed accepted upon order placement or acceptance of delivery. We shall not be bound to any conflicting or differing terms of business submitted to us by the buyer even if we do not expressly object to such other terms.
2. Oral ancillary agreements besides or in addition to these Terms of Business do not exist. Any ancillary agreements, differing terms or amendments to our General Terms of Business become applicable and binding only upon our written confirmation. This applies in particular to agreements regarding the quality and condition of our products.
3. These General Terms of Business only apply to companies, legal entities under public law or public special funds or assets ("Sondervermögen" pursuant to German law).

## II. OFFERS AND PROPOSALS

1. Our offers and proposals are subject to change and not binding. Any documents in connection therewith, such as drawings, illustrations, technical data, references to applicable standards, and any information given in brochures, shall not be deemed an agreement regarding the quality and condition of the product, unless expressly designated as such in writing.
2. Any samples as well as specifications regarding the composition, quality and condition of our products are based on our experience and expertise, but do not constitute any guarantee or other binding commitment.
3. We reserve the right of ownership and copyright to all brochures, illustrations, drawings, sketches and any other documents. Any such materials may not be reproduced, copied from the Internet or made available to any third party without our prior permission, and must be returned to us immediately upon our request.

## III. CONTRACT CONCLUSION

1. An order is deemed accepted if it has been confirmed in writing or delivered.
2. Content and scope of an order are subject to order confirmation.
3. The buyer is liable for the correctness of any documents to be supplied by them, such as drawings, samples, etc. Oral agreements about dimensions, etc. are required to be in writing.

## IV. PRICING

1. Our prices are quoted in euros ex works Engelskirchen (pursuant to Incoterms 2020), excluding packaging, freight, postage, customs duties and tariffs, and insurance. Surcharges and discounts are based on the basic price. The same applies to any partial or express shipments requested by the buyer.
2. The minimum order value is EUR 130.00 net. For orders under EUR 130.00 we charge a handling fee of EUR 15.00.
3. All prices are net prices and subject to the currently applicable VAT.
4. The prices given in the order confirmation apply to deliveries with a delivery period of up to four months. Deliveries with a delivery period of more than four months are subject to the prices applicable at the day of delivery in case the cost price, material, labour and other production costs have changed and the applicable prices are within reason for the buyer.

## V. TERMS OF PAYMENT

1. Payments are due within 14 days of the date of invoice less 2% discount or 30 days net. Payments are deemed to be made on time if they are received in our accounts no later than on the due date.
2. In the event of default, interest at the legal rate of currently 9% above the base rate of the European Central Bank (as of 2019) will be added. We retain the right to claim higher damages for default if applicable.
3. First deliveries are always required to be paid upfront or by cash on delivery.
4. If doubts arise regarding the solvency of the buyer, e.g. due to an application for the opening of insolvency proceedings, imminent suspension of payments or a significant deterioration of the financial status of the buyer, we are entitled to withhold further deliveries. In this case, we may declare the remaining debt due immediately, and set the customer a reasonable period for a delivery-against-payment transaction or the provision of collateral, even in the case of payment by check. After the fruitless expiry of such deadline, we are entitled to cease further fulfilment of our contractual obligations. In the event of an application for insolvency proceedings, we are entitled to immediately terminate the contract. This does not release the buyer from his or her duties and obligations arising in connection with those parts of the contract already fulfilled by us or in connection with earlier or not yet fulfilled contracts.
5. We retain the right to assign any accounts receivable to a third party.
6. The buyer is only entitled to a setoff if his counterclaims are res judicata, uncontested or accepted by us. Furthermore, the buyer is only entitled to a right of retention if his counterclaim is due and based on the same contractual relationship.

## VI. RESERVATION OF TITLE

1. The delivered goods remain our property ("goods subject to retention of title") until full payment of all claims (current and future) has been made, including all ancillary claims (e.g. financing costs, interest, etc.) arising from the business relationship between us and the buyer. Payment is deemed to be made upon receipt of the countervalue of the delivered goods.
2. The buyer is obliged to treat any goods that are subject to retention of title with due care. We are entitled to insure any goods that are subject to retention of

title against theft, breakage, fire, water and other damages at the buyer's expense unless they can demonstrate that they have taken out such insurance themselves.

3. The buyer is entitled to process, combine, mix and/or resell the delivery items within the ordinary course of business. Any such processing or transformation of the delivery items by the buyer is always carried out for us as the manufacturer. If the delivery items are processed together with other items not our own, we become co-owners of the new item, whereby the value of such ownership is based on the ratio of the delivery item's initial value to that of the other processed items at the time of processing. Furthermore, any stipulations applicable to the goods subject to retention of title also apply to the processed goods.
4. In the event that the buyer sells any delivery item prior to payment of all our accounts receivable secured by such delivery items, the buyer assigns to us, at the time of conclusion of the delivery contract, the associated receivables against any such purchaser or other third party in connection with the resale, as collateral for our accounts receivable. We accept any such assignment. We authorise the buyer, until further notice, to collect the assigned accounts receivable. We are entitled to revoke this authorisation if our secured accounts receivable are in jeopardy, including, but not limited to the buyer being in default with their payments. The authorisation to collect expires without further notice at the time at which the buyer stops their payments or files an application for the opening of insolvency proceedings. After the revocation or expiration of such authorisation, we are entitled and the buyer is obliged to notify the debtor of the assigned accounts receivable about such assignment. The buyer must refrain from any collection but keep incoming amounts in a separate account for us. At our request, the buyer must provide us in writing with the contact details of the buyer of the resold delivery items and hand over to us all information and documents regarding the assigned accounts receivable. Upon request of the buyer, we undertake to release any collateral we are entitled to, insofar as the value of such collateral exceeds the secured accounts receivable by more than 20 %. We reserve the right to select which collateral shall be released.
5. Extraordinary disposal of the collateral, including but not limited to possessory or non-possessory liens or assignment and security agreements, requires our prior consent. In the event of liens or other third-party claims, the buyer must inform us immediately in writing and submit to us any documents and information required for us to protect our rights. This also applies if such measures are imminent. The enforcement officer or the respective third party must be informed of our ownership. The buyer bears all costs in connection with the suspension of the seizure, lien or other type of execution and the replacement of the goods subject to retention of title, insofar as these costs cannot be collected from any third party.
6. If the buyer is in breach of contract, including but not limited to default, we are, after issuing a reminder, entitled to claim the return of the goods and the buyer is obliged to return them to us. If we terminate the contract as per section V.4 above due to an application for insolvency proceedings, we are entitled to claim the immediate return of any goods subject to retention of title.

## VII. DELIVERY PERIODS

1. Delivery periods may be agreed as binding or non-binding and are required to be in writing. They do not start before receipt of (i) all required documents from the buyer, (ii) all required releases and approvals, (iii) the agreed down payments and (iv) the fulfilment of all other obligations incumbent on the buyer.
2. The delivery date is considered to be met if, by that date, the delivery items have left our site or the buyer has been informed about the readiness for dispatch of the goods. In the case of unforeseeable events which we were unable to avert despite reasonable care, the delivery period can be reasonably extended – even within the scope of a default – irrespective of whether these circumstances occurred at our site or at our sub-suppliers' site(s), rendering them unable to supply us on time, including but not limited to operational disruptions, consequences of industrial or job actions, or similar.
3. The delivery period shall be extended in particular if our non-compliance with the delivery date is due to a late or defective delivery by our suppliers to us, which presupposes that we had concluded a so-called congruent or matching supply arrangement in good time ("kongruentes Deckungsgeschäft" as per German law) with our supplier at the time of contract conclusion with the buyer. We will prove to the buyer that we had concluded any such contract with our supplier upon request.
4. If the delivery or service becomes impossible due to the events mentioned in sections 2 and 3, or if the delivery or service is delayed by more than six weeks, both the buyer and we are entitled to terminate the contract without either being subject to any claims for damages.
5. To a reasonable extent, we are entitled to make partial deliveries.

## VIII. SCOPE AND EXECUTION OF DELIVERY; TRANSFER OF RISK

1. The scope of delivery is subject to our delivery note. The minimum order quantity is one packaging unit.
2. Inconsistencies in quantity must be communicated within eight days upon receipt of goods.
3. Items on stock as listed in our catalogue are available in the specified packaging units and will be delivered and invoiced accordingly. We reserve the right to change the packaging units from time to time.
4. Due to manufacturing conditions, changes of up to +/- 15% of the ordered quantity are permissible for products not held in stock.
5. We reserve the right to technical modifications of our products resulting from continuous research and development.

6. Risk passes over to the buyer when the goods are handed over to the carrier or forwarding agent, but not later than at the time of departure from our warehouse or, in the case of drop-shipping, at the time of departure from the supplier's site. This also applies to any free-of-charge deliveries. Upon express request of the buyer, we will take out insurance against shipping damage at the buyer's expense.
7. In the case of call-off (aka blanket) orders, the goods are delivered upon call-off by the buyer. Call-off periods expire 12 months as of the date of order confirmation. We are entitled to manufacture the entire order quantity at once. Requests for changes to any order after order confirmation are not possible unless this has been expressly agreed upon beforehand. Any quantities that have not been called off by the buyer by the end of the call-off period will be shipped to the buyer and invoiced upon the expiration date.

#### IX. CLAIMS FOR DEFECTS

1. Claims for defects are only applicable if the buyer has fulfilled all obligations pursuant to the German Commercial Code to properly examine the goods and give notice of defects. If a delivery item is defective, we undertake, at our discretion, to either deliver a defect-free item (replacement) or rectify the defect. In the event of rectification, we bear all expenses incurring from such rectification provided that costs are not increased by the delivery item having been moved to a place other than the place of performance. If the rectification or the replacement ultimately fails or is considered to have failed, the buyer is entitled to either reduce the purchase price or rescind the contract, at their own discretion. As a rule, the seller is reasonably entitled to a minimum of two attempts to replace or rectify the defects.
2. Our liability for any replaced or rectified delivery items is equal to that for the originally delivered goods. In the event of a replacement delivery, the statute of limitations for claims for defects starts anew. The statute of limitations for claims for defects is 12 months as from the time of delivery of the goods to the buyer.
3. We do not assume any liability for damages caused by the following: unsuitable or improper storage or use, faulty assembly, implementation or commissioning by the buyer or third parties, natural wear and tear, faulty or negligent handling, unsuitable operating materials, and chemical, electrochemical or electrical influences, unless they are our fault. We are not liable for any consequential damages if such damages are caused by improper modifications or maintenance work by the buyer or any third party without our prior approval.

#### X. LIABILITY

1. We are fully liable for damages caused by our and our vicarious agents' (as per §278 German Civil Code) willful misconduct or gross negligence. We are furthermore liable (i) for any breach of warranty, (ii) when accepting a procurement risk or any other binding assurances, (iii) in the event of culpable personal injury to life, body or health or (iv) within the scope of the German Product Liability Act. In the event of culpable breach of material contractual duties, i.e. of any such obligation that renders the proper execution of the contract possible in the

first place and the fulfilment of which the buyer can or does therefore reasonably expect, we accept liability in so far as the prerequisites for any such claim are fulfilled. The amount of liability is limited to the reasonably foreseeable damages typical for the relevant contract. We expressly exclude any further liability.

2. Insofar as our liability is excluded or limited, such exclusion or limitation also applies to the personal liability of our staff, employee representatives and vicarious agents.
3. These provisions are not intended to reverse the burden of proof.

#### XI. RETURN AND/OR REPLACEMENT

The buyer is entitled to return and/or have the goods replaced without stating any reason within four weeks after delivery quoting our consignment number. Goods are to be returned free of charge for us. The right to return or have the goods replaced does not affect any claims for defects pursuant to section IX above.

Processing costs will be charged at EUR 25.00. Custom-made articles are excluded from this right and may not be returned or replaced.

#### XII. DATA PRIVACY

1. Both the buyer and we undertake to comply with the applicable data protection laws and regulations, including but not limited to the GDPR and the Federal Data Protection Act of Germany.
2. Further information on how we process data is available in our Privacy Policy at <https://lukas-erzett.com/en/footer-navigation/privacy-note-gdpr.html> or as attached. To the extent required by the applicable data protection laws, the buyer will make such data privacy statement available to the respective employees, service providers or any other involved third parties.

#### XIII. PLACE OF PERFORMANCE, FORUM, APPLICABLE LAW AND PARTIAL UNENFORCEABILITY

1. Place of performance for all obligations under any contract is Engelskirchen, Germany.
2. The exclusive forum for any litigation with buyers who are registered merchants (as per German law), a legal entity under public law or so-called public special funds or assets ("öffentlich-rechtliches Sondervermögen" as per German law) is the court competent for our headquarters. We reserve the right, however, to file any action at the buyer's headquarters.
3. International deliveries are governed by German law. Regulations for the international sale or purchase of goods such as the CISG do not apply.
4. If individual provisions of these Terms or any delivery contract are or become invalid, the remaining provisions will continue to apply. If one of the provisions is or becomes partially invalid, the remaining part of such provision will continue to apply.

Issued: December 2019

## CONDITIONS

List prices quoted are ex-works Engelskirchen excluding packing and value added tax. Surcharges and discounts will be individually applied to the list price.

This price list is for the sole use of the recipient, and duplication in part or whole for a third party is not permitted. In all other aspects, our general terms and conditions apply as detailed on the last page.

## MINIMUM ORDER VALUE 130,00€ NET

For orders below 130,00€ net we have to invoice 15,00€ handling charge.

## TERMS OF PAYMENT

14 days less 2 % cash-discount or 30 days net.

## MINIMUM ORDER QUANTITY

Packing unit

## SPECIAL PRODUCTION

Minimum quantity/order quantity on request. For production reasons, excess and short deliveries of up to 15% of the ordered quantity shall be admissible for products which are not available ex stock.

## CALL-OFF ORDER

Call-off orders can cover a maximum period of 12 months from the date of acknowledgement. We have the right to manufacture the complete order, and any quantity not taken by the end of the contract period will be despatched and invoiced in full.

## RETURNS AND EXCHANGES

Any returns or exchanges, for whatever reason, must be received by us carriage paid within 4 weeks after receipt, stating batch number under which the goods were supplied. In such events, a handling charge of 25,00€ will apply.

## TECHNICAL ALTERATIONS

We reserve the right to make any technical alterations to our products resulting from our continuous research and development programme.

**Please note the contents of this and the last page to avoid any dispute.**

*Misprints reserved.*

## SAFETY SYMBOLS

These may vary depending on the product



Wear eye protection



Wear ear protection



Wear a mask



Observe safety recommendations



Wear protective gloves



Only to be used with a back-up pad



Do not use for wet grinding



Do not use for face grinding



Do not use if damaged

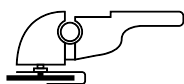


Do not use with hand-held grinding machine

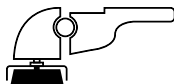
## POWER TOOLS



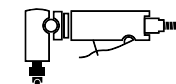
Straight grinder



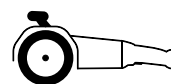
Hand-held angle grinder



Free-hand angle grinder with special protection cover



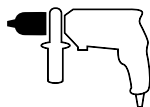
Pneumatic angle grinder



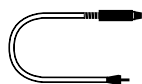
Conditioning machine



Bench grinder



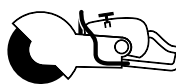
Drilling machine



Flexible shaft grinder



Bench cut-off machine



Petrol cut-off machine



Manual use

## OUR PRODUCT LINES

The product line is indicated with a simple star system:



**High Performance**



**Industry**



**Base**

## OUR APPLICATION RECOMMENDATIONS

Our application recommendations are divided into

● **best suitable** and ● **suitable**.

● Inox/Steel

● Steel

● Aluminium

● Stone/  
Construction material

● Cast material

● Plastic/Wood

● Titanium

You can find the corresponding application recommendations for each product directly below every product table.

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LUKAS-ERZETT

Vereinigte Schleif- und Fräs-  
zeugfabriken GmbH & Co. KG  
Gebrüder-Lukas-Straße 1

51766 Engelskirchen, Germany

Phone +49 2263 84-0

Fax +49 2263 84-327 (Domestic Sales)

Fax +49 2263 84-300 (International Sales)

le@lukas-erzett.de

**Realisation** aliaz werbeagentur gmbh  
www.aliaz.de

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## PRODUCTION AND SALES LOCATIONS

### LUKAS-ERZETT

Vereinigte Schleif- und Fräswerk-  
zeugfabriken GmbH & Co. KG  
Gebrüder-Lukas-Straße 1  
51766 Engelskirchen, Germany  
Phone +49 2263 84-0  
Fax +49 2263 84-327 (Domestic Sales)  
Fax +49 2263 84-300 (International Sales)  
le@lukas-erzett.de

Kayson Green Limited  
Clough Road  
Severalls Business Park Colchester  
CO4 9QS Essex  
Phone +44 1206 751500  
Fax +44 1206 751212  
abrasives@kaysongreen.co.uk

LUKAS CZ spol. s r. o.  
Tovární 478  
35134 Skalná  
Phone +420 357 070600  
Fax +420 357 070613  
obchod@lukascz.cz  
www.lukas-erzett.com

LUKAS-ERZETT  
Vereinigte Schleif- und Fräswerk-  
zeugfabriken GmbH & Co. KG  
C/Violeta, 1 Pol. Ind. El Lomo  
28970 Humanes de Madrid  
Phone 900 974 924  
Fax 900 974 925  
le@lukas-erzett.de

LUKAS ABRASIVES SA (PTY) LTD.  
1288 Harriet Avenue  
Driehoek  
1401 Germiston  
Phone +27 11 8251550  
Fax +27 11 8720144  
abrasives@lukas.co.za  
www.lukas.co.za

Beijing Representative Office  
Room 2228 · 19th Floor  
C-King Apartment  
No. 19 Madian East Rd.  
100080 Haidian District Beijing  
Phone +86 10 82961338  
Fax +86 10 82800015  
beijing@lukas-erzett.com.cn

LUKAS Tools Trading Shanghai Co. Ltd.  
In German Centre  
Unit 313 B · Block 2, Tower 1  
88 Keyuan Road  
Zhang Jiang Hi-Tech Park  
Pudong New District  
201 203 Shanghai  
lukas-trading@lukas-erzett.com