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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.

GRINDING ·

**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.





POLISHING • MILLING • CUTTING • CUSTOMISED TOOLS

# 10 000

CUSTOMISED SOLUTIONS AND NUMEROUS  
INNOVATIONS DEPLOYED WORLDWIDE

DEVELOPING  
TOOLS FOR **80** YEARS



#### 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.



## 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)

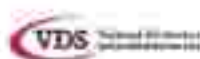


20

SECTORS AND INDUSTRIES  
PUT THEIR TRUST IN OUR  
QUALITY AND EXPERIENCE

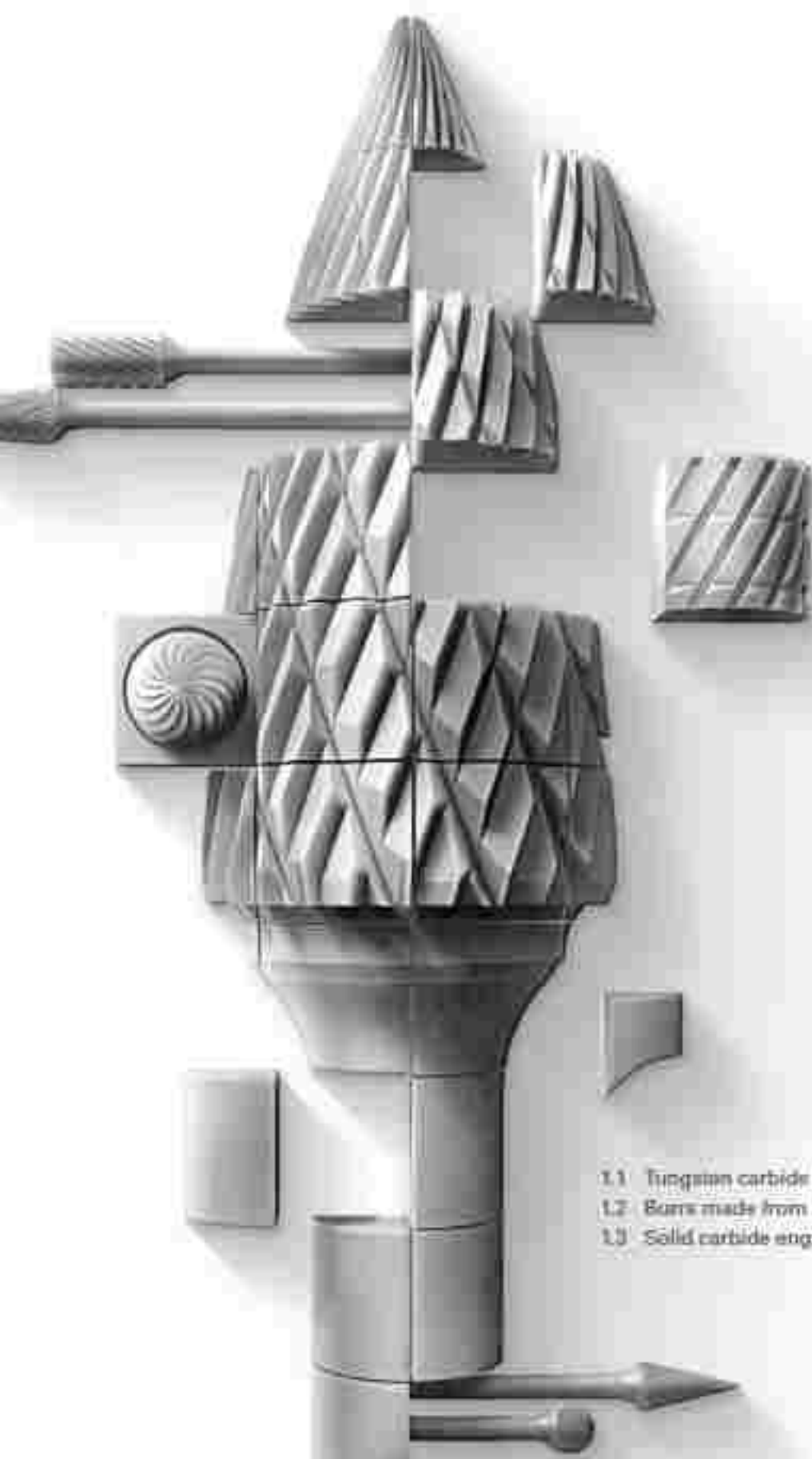
LUKAS IS DEDICATED TO QUALITY

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





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

# MILLING

- 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.

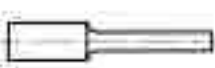













Use the highest speeds possible within the ranges listed. Speeds that are too low cause vibration, chipping and premature wear! Reduce the speed of the burrs only when working with large contact angles or materials with low heat conductivity. Never allow blue discoloration to appear on the shank and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


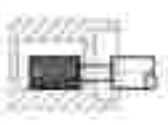



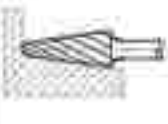



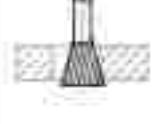
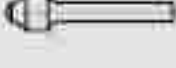


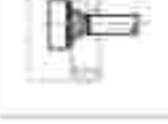
Always ensure the settings of your power tool are properly adjusted for the job and material at hand. Avoid a reduction in speed caused by insufficient drive power, especially when using pneumatic machines. Only use collets that run true. Run-out and vibration will result in chipping and premature wear. 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
	HFA Cylindrical	
	HFC Cylindrical chamfer burr	
	HFD Spherical	
	HFE Oval	
	HFF Arch round burr	
	HFG Anti-polluted burr	
	HFH Flame	

Shape		Application
	HFI Internal	
	HII Chamber burr	
	HFL Conical round burr	
	HFN Conical pointed burr	
	HFB Inverted cone	
	Burrs for radius (finishing external)	
	Burrs for radius (finishing internal)	

## LUKAS BURR SETS

Have the right tool for any application. Choose from our assortment of burs 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 final) from the table.

## STEP 2

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

Material	Spindle Speed	Machining	Cut	Recommended cutting speed (m/min)
Steel, cast steel	up to 800	coarse	Z5, Z7 Steel, ZK	500-700
		medium	Z5, Z42 Incol/Steel	300-500
		fine	Z53	500-700
	800 to 1,300	coarse	Z7 Steel, ZK	400-600
		medium	Z5	300-400
		fine	Z53	400-600
	from 1,300	coarse	Z7 Steel, Z4	300-500
		medium	Z5	300-400
		fine	Z53	400-600
Stainless steel	up to 800	coarse	Z2, ZK	400-500
		medium	Z5, Z7 Steel, Z4, Z5, Z42 Incol/Steel	300-500
		fine	Z53	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	Z53	400-700
		fine	Z53	400-700
Aluminium	up to 400	coarse	Z9 Alu	600-1,000
		medium	Z1	500-800
Steel and bronze	up to 800	coarse	Z9 Alu, Z1	400-600
	from 450	medium	Z2	400-600
		fine	Z53	500-800
Titanium	up to 900	coarse	Z6	300-500
		medium	Z7 Steel	300-400
		fine	Z53	500-700
	900 to 1,500	coarse	Z4	300-400
		medium	Z5	400-500
		fine	Z53	400-600
Plastic and wood	20 to 400	coarse	Composite coarse/fine, Z1, Z9 Alu	500-1,000
		fine	Composite coarse/fine, Wood	300-400
	400 to 1,000	coarse	Composite coarse/fine, Z1	500-800
		fine	Composite coarse/fine, Z2, Wood	400-600

## 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 <sub>c</sub> (m/min))							
		200	400	600	800	1000	1200	1400	1600
Tool diameter (mm)	2	40,000	84,000	80,000	26,000	77,000	172,000	142,000	150,000
	3	32,000	42,000	53,000	64,000	34,000	85,000	95,000	105,000
	4	24,000	32,000	40,000	48,000	56,000	64,000	72,000	80,000
	5	18,000	21,000	27,000	32,000	37,000	42,000	48,000	53,000
	6	12,000	16,000	20,000	24,000	28,000	32,000	36,000	40,000
	8	10,000	13,000	16,000	19,000	23,000	26,000	29,000	32,000
	10	8,000	11,000	13,000	16,000	19,000	21,000	24,000	27,000
	12	6,000	8,000	10,000	12,000	14,000	16,000	18,000	20,000
	16	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	Application	Page
 20 Alu	very coarse single cut with beveling for soft materials	21/22
 21	coarse cut for soft materials	20
 22 Brass	robust single cut for high shock removal	20
 23	medium single cut	20/21 21/20
 25 Hard	very fine single cut for high-quality surfaces	25 24/26
 ZF1 to ZF3	fine cross cuts from coarse to very fine for perfect surfaces	22/24
 Wood	rip cut for pattern construction	29

Cut	Application	Page
 240 (mix/Steel)	robust bevel cutting for mix and steel	20
 24	fine cross cut for hard materials	22/22
 26	robust cross cut	20
 27 Steel	medium cross cut	17-19 20
 Curl	robust cross cut specially designed for cast materials	21
 Composite Colors and Fine	cross cut for machining plastics	28
 2X	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.

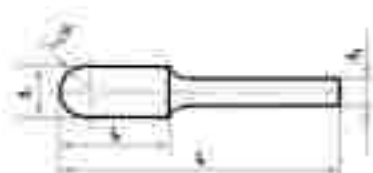
	Special feature	Properties	Coating	Friction coefficient
 <p><b>ARCool*</b></p>	general purpose	<ul style="list-style-type: none"> <li>• general-purpose wear protection when machining ferrous metals (like steel and cast iron) and plastic</li> <li>• high toughness</li> <li>• food safe</li> <li>• biocompatible</li> </ul>	<b>TiN</b> (titanium nitride)	0.05 - 0.10
 <p><b>HeavyDuty</b></p>	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, iron-hardening steels and stainless steels)</li> <li>• for milling under various conditions</li> <li>• for high-performance cutting</li> </ul>	<b>TiAlN</b> (titanium aluminium nitride) see page 17	0.10 - 0.25
 <p><b>ThermoShock*</b></p>	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 free deburring</li> </ul>	<b>TiCN</b> (titanium carbon nitride)	0.10 - 0.20
 <p><b>LowFriction*</b></p>	lubricating effect	<ul style="list-style-type: none"> <li>• special coating with tribo effect for long chip and shearing non-ferrous metals, especially aluminium alloys</li> <li>• significantly reduces friction and adhesive wear</li> <li>• reduces loading</li> </ul>	<b>LTE</b> (lubricating carbon-based coating)	0.10 - 0.20
 <p><b>LightFlow</b></p>	easy chip removal	<ul style="list-style-type: none"> <li>• contains high wear resistance with outstanding friction and anti-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*+C</b> (carbon layer made from solid carbon) see page 17	0.05 - 0.10 (dry)





## Z7 Steel burr with HeavyDuty coating

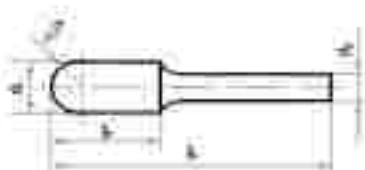
- high performance coating for processing very hard and abrasive materials
- for extreme applications
- for high thermal and mechanical shock loads



★★★

Product number	Description	Shape	Coil	Material ISO 4051	Ø mm	L mm	Ø mm	L mm	Part count/box
A10010016000T1ALN	HFA 0616.06		Z7 Steel	ZVA 0616	6	16	6	50	1
A10010020000T1ALN	HFA 0620.06		Z7 Steel	ZVA 0620	6	20	6	50	1
A10010020000T1ALN	HFA 1020.06		Z7 Steel	ZVA 1020	10	20	6	50	1
A10010020000T1AL1	HFA-S 0620.06		Z7 Steel	ZVA-S 0620	6	20	6	50	1
A10010020000T1AL1	HFA-S 1020.06		Z7 Steel	ZVA-S 1020	10	20	6	50	1
A10010022500T1AL1	HFA-S 1225.06		Z7 Steel	ZVA-S 1225	12	25	6	55	1
A10030030000T1ALN	HPC 0616.06		Z7 Steel	WPC 0616	6	16	6	50	1
A10030030000T1ALN	HPC 0620.06		Z7 Steel	WPC 0620	6	20	6	50	1
A10030030000T1ALN	HPC 1020.06		Z7 Steel	WPC 1020	10	20	6	50	1
A10030030000T1ALN	HPC 1225.06		Z7 Steel	WPC 1225	12	25	6	55	1
A10030006000T1ALN	HFD 0606.06		Z7 Steel	KLD 0606	6	5	6	50	1
A10030006000T1ALN	HFD 0607.06		Z7 Steel	KLD 0607	6	7	6	47	1
A10030006000T1ALN	HFD 1006.06		Z7 Steel	KLD 1006	10	6	6	49	1
A10041225000T1ALN	HFP 1225.06		Z7 Steel	RPF 1225	12	25	6	55	1
A10040010000T1ALN	HFG 0616.06		Z7 Steel	SPG 0616	6	16	6	50	1
A10040010000T1ALN	HFG 1020.06		Z7 Steel	SPG 1020	10	20	6	50	1
A10041225000T1ALN	HFG 1225.06		Z7 Steel	SPG 1225	12	25	6	55	1
A10041630000T1ALN	HFG 1630.06		Z7 Steel	SPG 1630	16	30	6	70	1
A10060030000T1ALN	HFH 0620.06		Z7 Steel	---	6	20	6	50	1
A10061330000T1ALN	HFH 1230.06		Z7 Steel	---	12	30	6	70	1
A10071000000T1ALN	HFL 1020.06		Z7 Steel	SEL 1020	10	20	6	50	1
A10081000000T1ALN	HFM 1020.06		Z7 Steel	SRM 1020	10	20	6	50	1

## Z7 Steel burr



- Thanks to the conical 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	Number of flutes	Ø, mm	L, mm	R, mm	L, mm	Flute geometry	
A10010213300	HFA 0213.02		Z7 Steel	Z7A 0213	3	13	3	40	1	
A10010413000	HFA 0413.06		Z7 Steel	Z7A 0413	4	13	6	50	1	
A10010613300	HFA 0613.03		Z7 Steel	Z7A 0613	6	13	3	43	1	
A10010618000	HFA 0618.06		Z7 Steel	Z7A 0618	6	18	6	50	1	
A10010820000	HFA 0820.06		Z7 Steel	Z7A 0820	8	20	6	60	1	
A10011020000	HFA 1020.06		Z7 Steel	Z7A 1020	10	20	6	60	1	
A10011025000	HFA 1025.06		Z7 Steel	Z7A 1025	10	25	6	65	1	
A10011225000	HFA 1225.06		Z7 Steel	Z7A 1225	12	25	6	65	1	
A10011625000	HFA 1625.06		Z7 Steel	Z7A 1625	16	25	6	65	1	
A10010213300001	HFA5 0213.03			Z7 Steel	Z7A-S 0213	3	13	3	40	1
A10010413000001	HFA5 0413.06			Z7 Steel	Z7A-S 0413	4	13	6	50	1
A10010613300001	HFA5 0613.03			Z7 Steel	Z7A-S 0613	6	13	3	43	1
A10010618000001	HFA5 0618.06			Z7 Steel	Z7A-S 0618	6	18	6	50	1
A10010820000001	HFA5 0820.06			Z7 Steel	Z7A-S 0820	8	20	6	60	1
A10011020000001	HFA5 1020.06			Z7 Steel	Z7A-S 1020	10	20	6	60	1
A10011025000001	HFA5 1025.06	Z7 Steel		Z7A-S 1025	10	25	6	65	1	
A10011225000001	HFA5 1225.06	Z7 Steel		Z7A-S 1225	12	25	6	65	1	
A10011625000001	HFA5 1625.06	Z7 Steel		Z7A-S 1625	16	25	6	65	1	
A10020210300	HFC 0210.03			Z7 Steel	W7C 0210	2	10	3	40	1
A10010213300	HFC 0213.02			Z7 Steel	W7C 0213	3	13	3	40	1
A10020413000	HFC 0413.06			Z7 Steel	W7C 0413	4	13	6	50	1
A10020613300	HFC 0613.03			Z7 Steel	W7C 0613	6	13	3	43	1
A10030618000	HFC 0618.06			Z7 Steel	W7C 0618	6	18	6	50	1
A10030820000	HFC 0820.06			Z7 Steel	W7C 0820	8	20	6	60	1
A10021020000	HFC 1020.06		Z7 Steel	W7C 1020	10	20	6	60	1	
A10021025000	HFC 1025.06		Z7 Steel	W7C 1025	10	25	6	65	1	
A10021225000	HFC 1225.06		Z7 Steel	W7C 1225	12	25	6	65	1	
A10021625000	HFC 1625.06		Z7 Steel	W7C 1625	16	25	6	65	1	
A10030213300	HFD 0213.03			Z7 Steel	K7D 0213	3	7	3	40	1
A10030404300001	HFD 0403.03			Z7 Steel	K7D 0403	4	3	3	34	1
A10030404600	HFD 0403.06			Z7 Steel	K7D 0403	4	3	6	50	1
A10030606300	HFD 0605.03			Z7 Steel	K7D 0605	6	5	3	35	1
A10030606600	HFD 0605.06			Z7 Steel	K7D 0605	6	5	6	50	1
A10030807000	HFD 0807.06	Z7 Steel		K7D 0807	8	7	6	41	1	
A10031010000	HFD 1010.06	Z7 Steel		K7D 1008	10	8	6	40	1	
A10031212000	HFD 1210.06	Z7 Steel		K7D 1210	12	10	6	51	1	
A10031210000	HFD 1210.06	Z7 Steel		K7D 1210	12	10	6	51	1	
A10031414000	HFD 1414.06	Z7 Steel		K7D 1414	14	14	6	54	1	
A10032020000	HFD 2018.06	Z7 Steel		K7D 2018	20	18	6	58	1	

Recommended for: Steel Cast iron Aluminum Titanium

Product number	Description	Image	Cut	Distance to End Face	φ mm	L mm	φ mm	L mm	Flut Condition		
A1000207300	HFE 0207.01		Z7 Slot	TRE 0207	3	7	3	40	1		
A1000010200	HFE 0010.01		Z7 Slot	TRE 0010	6	10	3	40	1		
A1000061000	HFE 0010.06		Z7 Slot	TRE 0010	6	10	6	50	1		
A1000091000	HFE 0010.09		Z7 Slot	TRE 0010	6	10	6	50	1		
A1000122000	HFE 0012.00		Z7 Slot	TRE 0012	12	20	6	60	1		
A1000162500	HFE 0025.16		Z7 Slot	TRE 0025	16	25	6	65	1		
A1010011300	HFF 0013.03		Z7 Slot	BBF 0013	3	13	3	40	1		
A1010011308	HFF 0013.03		Z7 Slot	BBF 0013	4	13	3	40	1		
A1010011600	HFF 0016.06		Z7 Slot	BBF 0016	6	16	4	50	1		
A1010020400	HFF 0020.04		Z7 Slot	-	6	20	4	60	1		
A101002000	HFF 0020.04		Z7 Slot	BBF 0020	10	20	4	60	1		
A1010122500	HFF 0225.12		Z7 Slot	BBF 0225	12	25	6	65	1		
A1010122500B	HFF 0225.08		Z7 Slot	BBF 0225	12	25	8	65	1		
A1010123600	HFF 0236.12		Z7 Slot	BBF 0236	12	36	6	70	1		
A1010163000	HFF 0630.16		Z7 Slot	BBF 0630	16	30	6	75	1		
A10040307300	HFG 0307.03			Z7 Slot	SPG 0307	3	7	3	40	1	
A1004031300B	HFG 0313.03			Z7 Slot	SPG 0313	3	13	3	40	1	
A1004061300	HFG 0613.06			Z7 Slot	SPG 0613	6	13	3	40	1	
A1004061600	HFG 0616.06	Z7 Slot		SPG 0616	6	16	4	50	1		
A1004082000	HFG 0820.08	Z7 Slot		-	8	20	4	60	1		
A1004102000B	HFG 1020.05	Z7 Slot		SPG 1020	10	20	6	60	1		
A1004122000	HFG 1220.08	Z7 Slot		SPG 1220	12	20	6	60	1		
A1004122500	HFG 1225.06	Z7 Slot		SPG 1225	12	25	6	65	1		
A1004123000	HFG 1230.06	Z7 Slot		SPG 1230	12	30	6	70	1		
A1004163000	HFG 1630.08	Z7 Slot		SPG 1630	16	30	6	70	1		
A1000061300B	HFH 0013.03			Z7 Slot	-	4	13	3	40	1	
A1000062000	HFH 0020.06			Z7 Slot	-	6	20	4	60	1	
A1000123000	HFH 0230.06		Z7 Slot	-	12	30	6	70	1		
A1000163500	HFH 0635.06		Z7 Slot	-	16	35	6	75	1		
A1000062000B	HFL 0020.06		Z7 Slot	-	6	20	4	60	1		
A1007102000	HFL 1020.04		Z7 Slot	REL 1020	10	20	6	60	1		
A1007122500	HFL 1225.08		Z7 Slot	REL 1225	12	25	6	65	1		
A1007123000	HFL 1230.06		Z7 Slot	REL 1230	12	30	6	70	1		
A1007163000	HFL 1630.04		Z7 Slot	REL 1630	16	30	6	70	1		
A1005007300	HFM 0007.03		Z7 Slot	GEM 0007	3	7	3	40	1		
A1005011300	HFM 0011.03		Z7 Slot	GEM 0011	3	11	3	40	1		
A1005061300	HFM 0013.06		Z7 Slot	GEM 0013	6	13	3	40	1		
A1005061600	HFM 0016.06		Z7 Slot	GEM 0016	6	16	4	50	1		
A1005082000	HFM 0020.06		Z7 Slot	-	8	20	6	60	1		
A1005102000	HFM 0020.06		Z7 Slot	GEM 1020	10	20	6	60	1		
A1005122500	HFM 0025.06		Z7 Slot	GEM 1225	12	25	6	65	1		
A10120007300	HWN 0007.03			Z7 Slot	WKN 0007	3	7	3	40	10'	1
A10120007300001	HWN-S 0007.03			Z7 Slot	WKN-S 0007	3	7	3	40	10'	1



## 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 finishing for perfect surface results
- Smoothly running, low vibration tool without chatter thanks to improved cutting angle

★★★

Product number	Description	Shape	Coil	Similar to Z42 Steel	Ø max	L max	Ø Shank	L Shank	Flute condition
A1001010020	HFA 0610.00		Z42 Inox/Steel	ZVA 0610	6	16	6	50	1
A1001000020	HFA 0620.00		Z42 Inox/Steel	ZVA 0620	8	20	6	60	1
A1001020020	HFA 1020.00		Z42 Inox/Steel	ZVA 1020	10	20	6	60	1
A1001025020	HFA 1225.00		Z42 Inox/Steel	ZVA 1225	12	25	6	65	1
A1002061020	HFC 0610.00		Z42 Inox/Steel	WFC 0610	6	16	6	50	1
A1002062020	HFC 0620.00		Z42 Inox/Steel	WFC 0620	8	20	6	60	1
A1002102020	HFC 1020.00		Z42 Inox/Steel	WFC 1020	10	20	6	60	1
A1002122520	HFC 1225.00		Z42 Inox/Steel	WFC 1225	12	25	6	65	1
A1003061020	HFD 0625.00		Z42 Inox/Steel	KLD 0625	6	7	6	50	1
A1003062020	HFD 0627.00		Z42 Inox/Steel	KLD 0627	8	7	6	41	1
A1003100020	HFD 1000.00		Z42 Inox/Steel	KLD 1000	10	9	6	40	1
A1003121020	HFD 1210.00		Z42 Inox/Steel	KLD 1210	12	10	6	51	1
A1000010020	HFF 0610.00		Z42 Inox/Steel	HBF 0610	6	10	6	50	1
A1000010020	HFF 0620.00		Z42 Inox/Steel	—	8	20	6	60	1
A1000100020	HFF 1020.00		Z42 Inox/Steel	HBF 1020	10	20	6	60	1
A1000122520	HFF 1225.00		Z42 Inox/Steel	HBF 1225	12	25	6	65	1
A1004061020	HFG 0610.00		Z42 Inox/Steel	SPG 0610	6	10	6	50	1
A1004062020	HFG 0620.00		Z42 Inox/Steel	—	8	20	6	60	1
A1004102020	HFG 1020.00		Z42 Inox/Steel	SPG 1020	10	20	6	60	1
A1004122520	HFG 1225.00		Z42 Inox/Steel	SPG 1225	12	25	6	65	1
A1005061020	HFM 0610.00		Z42 Inox/Steel	SKM 0610	6	10	6	50	1
A1005062020	HFM 0620.00		Z42 Inox/Steel	—	8	20	6	60	1
A1005102020	HFM 1020.00		Z42 Inox/Steel	SKM 1020	10	20	6	60	1
A1005122520	HFM 1225.00		Z42 Inox/Steel	SKM 1225	12	25	6	65	1

Recommended for: Steel Cast Iron



# CAST – THE BURR FOR CAST MATERIAL

FOR HIGH REMOVAL RATES ON CAST MATERIALS

With its faceted tooling, 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 dripping 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

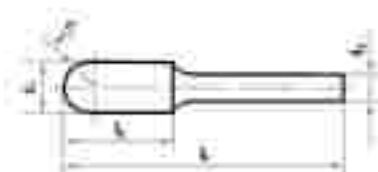


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Product number	Description	Shape	Mat.	Number to DIN 8003	κ mm	L mm	κ mm	L mm	Flute condition
A5001010621	HFA 0610.06		Cast	ZYA 0610	6	10	6	50	1
A5001020621	HFA 0620.06		Cast	ZYA 0620	6	20	6	60	1
A50011020621	HFA 1020.06		Cast	ZYA 1020	10	20	6	60	1
A5001125621	HFA 1225.06		Cast	ZYA 1225	12	25	6	65	1
A5002010621	HFC 0610.06		Cast	WFC 0610	6	10	6	50	1
A5002020621	HFC 0620.06		Cast	WFC 0620	6	20	6	60	1
A50021020621	HFC 1020.06		Cast	WFC 1020	10	20	6	60	1
A5002125621	HFC 1225.06		Cast	WFC 1225	12	25	6	65	1
A5003010621	HFD 0605.06		Cast	K3D 0605	6	5	6	50	1
A5003020621	HFD 0620.06		Cast	K3D 0620	6	20	6	60	1
A50031010621	HFD 1010.06		Cast	K3D 1010	10	10	6	40	1
A50031210621	HFD 1210.06		Cast	K3D 1210	12	10	6	55	1
A5004010621	HFE 0610.06		Cast	TRE 0610	6	10	6	50	1
A50040310621	HFE 0612.06		Cast	TRE 0612	6	12	6	55	1
A50041010621	HFE 1010.06		Cast	TRE 1010	10	10	6	50	1
A50041220621	HFE 1220.06		Cast	TRE 1220	12	20	6	60	1
A5010010621	HFF 0610.06		Cast	BBF 0610	6	10	6	50	1
A5010020621	HFF 0620.06		Cast	BBF 0620	6	20	6	60	1
A5010030621	HFF 0625.06		Cast	BBF 0625	6	25	6	65	1
A50101225621	HFF 1225.06		Cast	BBF 1225	12	25	6	65	1
A5004010621	HFG 0610.06		Cast	SPC 0610	6	10	6	50	1
A5004020621	HFG 0620.06		Cast	SPC 0620	6	20	6	60	1
A50041020621	HFG 1020.06		Cast	SPC 1020	10	20	6	60	1
A50041225621	HFG 1225.06		Cast	SPC 1225	12	25	6	65	1

Recommended for Cast material

## Z4 burr



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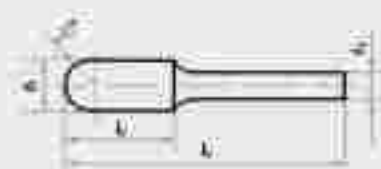
• Free zones cut for hard materials

Product number	Description	Shape	Cut	Number of flutes	Ø <sub>max</sub> mm	L <sub>max</sub> mm	Ø <sub>min</sub> mm	L <sub>min</sub> mm	Flute geometry		
A1001021304	HFA 0313.03		Z4	ZYA 0313	3	13	3	40	1		
A1001041604	HFA 0416.06		Z4	ZYA 0416	6	16	6	50	1		
A1001062004	HFA 0620.06		Z4	ZYA 0620	6	20	6	60	1		
A1001082004	HFA 0820.08		Z4	ZYA 0820	10	20	6	60	1		
A1001025004	HFA 1025.10		Z4	ZYA 1025	10	25	6	65	1		
A1001122504	HFA 1225.12		Z4	ZYA 1225	12	25	6	65	1		
A1001122504	HFA 1225.08		Z4	ZYA 1225	12	25	8	65	1		
A1001031304001	HFA-S 0313.03			Z4	ZYA-S 0313	3	13	3	40	1	
A1001041604001	HFA-S 0416.06			Z4	ZYA-S 0416	6	16	6	50	1	
A1001062004001	HFA-S 0620.06			Z4	ZYA-S 0620	6	20	6	60	1	
A1001082004001	HFA-S 0820.08			Z4	ZYA-S 0820	10	20	6	60	1	
A1001025004001	HFA-S 1025.10			Z4	ZYA-S 1025	10	25	6	65	1	
A1001122504001	HFA-S 1225.12			Z4	ZYA-S 1225	12	25	6	65	1	
A1001122504001	HFA-S 1225.08			Z4	ZYA-S 1225	12	25	8	65	1	
A1002031304	HPC 0313.03				Z4	WRC 0313	3	13	3	40	1
A1002041604	HPC 0416.06	Z4			WRC 0416	6	16	6	50	1	
A1002061604	HPC 0616.06	Z4			WRC 0616	6	16	6	50	1	
A1002082004	HPC 0820.08	Z4			WRC 0820	8	20	6	60	1	
A1002102004	HPC 1020.10	Z4			WRC 1020	10	20	6	60	1	
A1002102004	HPC 1020.08	Z4			WRC 1020	10	20	8	60	1	
A1002122504	HPC 1225.12	Z4			WRC 1225	12	25	6	65	1	
A1003031304	HFD 0313.03				Z4	KJD 0313	3	13	3	40	1
A1003041604	HFD 0416.06		Z4		KJD 0416	6	16	6	50	1	
A1003061604	HFD 0616.06		Z4		KJD 0616	6	16	6	50	1	
A1003082004	HFD 0820.08		Z4		KJD 0820	8	20	6	60	1	
A1003102004	HFD 1020.10		Z4		KJD 1020	10	20	6	60	1	
A1003121204	HFD 1212.12		Z4		KJD 1212	12	12	6	51	1	
A1003121204	HFD 1212.08		Z4		KJD 1212	12	12	8	51	1	
A1003161604	HFD 1616.16		Z4		KJD 1616	16	16	6	54	1	
A1004061604	HFE 0616.06			Z4	TRE 0616	6	16	6	50	1	
A1004081604	HFE 0816.08			Z4	TRE 0816	8	16	6	53	1	
A1004122004	HFE 1220.12			Z4	TRE 1220	12	20	6	60	1	
A1008031304	HFF 0313.03				Z4	RBF 0313	3	13	3	40	1
A1008061604	HFF 0616.06				Z4	RBF 0616	6	16	6	50	1
A1008102004	HFF 1020.10				Z4	RBF 1020	10	20	6	60	1
A1008122504	HFF 1225.12				Z4	RBF 1225	12	25	6	65	1
A1004031304	HFG 0313.03				Z4	SPG 0313	3	13	3	40	1
A1004061604	HFG 0616.06				Z4	SPG 0616	6	16	6	50	1
A1004102004	HFG 1020.10				Z4	SPG 1020	10	20	6	60	1
A1004122504	HFG 1225.12				Z4	SPG 1225	12	25	6	65	1
A1004122504	HFG 1225.08				Z4	SPG 1225	12	25	8	65	1
A1004162004	HFG 1620.16				Z4	SPG 1620	16	20	6	70	1
A1004162004	HFG 1620.08				Z4	SPG 1620	16	20	8	70	1

Product number	Description	Shape	Dia	Similar to DIN 8022	$\phi$ mm	L mm	$\phi$ mm	L mm	Flank condition		
A1000013304	HFH 0413.02		24	-	8	13	2	40	1		
A1000027004	HFH 0630.04		24	-	8	20	6	60	1		
A1000123004	HFH 1230.04		24	-	12	30	8	70	1		
Product number	Description	Shape	Dia	Similar to DIN 8022	$\phi$ mm	L mm	$\phi$ mm	L mm	r mm	$\alpha$ °	Flank condition
A1001225004	HFL 1225.06		24	KEL 1225	12	25	6	60	5.5	14°	1
A1001230004	HFL 1230.06		24	KEL 1230	12	30	6	70	2.8	14°	1
A1001230004	HFL 1230.06		24	KEL 1230	12	30	6	70	2.8	14°	1
Product number	Description	Shape	Dia	Similar to DIN 8022	$\phi$ mm	L mm	$\phi$ mm	L mm	Flank condition		
A1005001004	HFM 0610.08		24	SKM 0610	6	10	6	50	1		
A1005102004	HFM 1020.08		24	SKM 1020	10	20	6	60	1		
A1005122504	HFM 1225.08		24	SKM 1225	12	25	6	65	1		
Product number	Description	Shape	Dia	Similar to DIN 8022	$\phi$ mm	L mm	$\phi$ mm	L mm	r mm	$\alpha$ °	Flank condition
A1012002004	HFN 0620.08		24	WKN 0620	6	20	6	50	10°	1	
A1012013004	HFN 1013.08		24	WKN 1013	10	13	6	53	10°	1	
A1012123004	HFN 1213.08		24	WKN 1213	12	13	6	57	20°	1	
A1012203004	HFN 2013.08		24	-	20	13	6	53	30°	1	
A1012301613	HFN-S 1613.08		24	WKN-S 1613	16	13	6	53	20°	1	



Z8 burr



• Burr with robust cores cut

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Product number	Description	Shape	Dia	Similar to DIN 8022	$\phi$ mm	L mm	$\phi$ mm	L mm	Flank condition
A1002000000	HFC 0620.06		20	WFC 0620	6	20	6	60	1
A1002100000	HFC 1020.06		20	WFC 1020	10	20	6	60	1
A1002122500	HFC 1225.06		20	WFC 1225	12	25	6	65	1
A1002100000	HFF 1020.06		20	HFP 1020	10	20	6	60	1

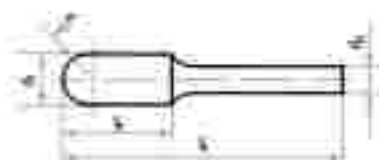








## Z5 small burr

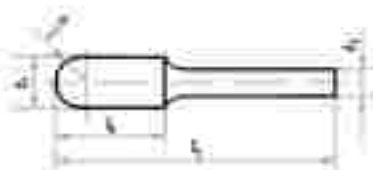


• with 3 mm shank diameter

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Product number	Description	Shape	Coat	Material ISO 513	d mm	L mm	L <sub>1</sub> mm	L <sub>2</sub> mm	Part number	
A1000210305	HFA 0210.03		Z5 Hard	ZYA 0210	2	10	3	40	1	
A1000213305	HFA 0213.03		Z5 Hard	ZYA 0213	3	13	3	40	1	
A1000207305	HFA 0207.03		Z5 Hard	ZYA 0207	4	7	3	37	1	
A10002013305	HFA 0201.03		Z5 Hard	ZYA 0201	6	13	3	40	1	
A1000210050001	HFA-S 0210.03		Z5 Hard	ZYA-S 0210	2	10	3	40	1	
A1000213050001	HFA-S 0213.03		Z5 Hard	ZYA-S 0213	3	13	3	40	1	
A10002073050001	HFA-S 0207.03		Z5 Hard	ZYA-S 0207	4	7	3	37	1	
A100020133050001	HFA-S 0201.03		Z5 Hard	ZYA-S 0201	6	13	3	40	1	
A1002010305	HFC 0210.03			Z5 Hard	WRC 0210	2	10	3	40	1
A1002013305	HFC 0213.03			Z5 Hard	WRC 0213	3	13	3	40	1
A1002010305	HFC 0210.03	Z5 Hard		WRC 0210	4	7	3	37	1	
A1002013305	HFC 0213.03		Z5 Hard	KLD 0213	3	13	3	43	1	
A1002010305	HFC 0210.03		Z5 Hard	KLD 0210	4	7	3	40	1	
A100200403050001	HFC 0204.03		Z5 Hard	KLD 0204	4	3	3	34	1	
A10020080305	HFC 0208.03		Z5 Hard	KLD 0208	6	5	3	35	1	
A1004010305	HFE 0210.03		Z5 Hard	TRE 0210	3	7	3	40	1	
A1004010305	HFE 0210.03		Z5 Hard	TRE 0210	4	10	3	40	1	
A1004010305	HFF 0210.03		Z5 Hard	RSF 0210	3	7	3	40	1	
A1004013305	HFF 0213.03		Z5 Hard	RSF 0213	3	13	3	40	1	
A1004013305	HFF 0213.03		Z5 Hard	RSF 0213	4	13	3	43	1	
A1004010305	HFG 0210.03		Z5 Hard	SPG 0207	3	7	3	40	1	
A1004013305	HFG 0213.03		Z5 Hard	SPG 0213	3	13	3	40	1	
A1004013305	HFG 0213.03		Z5 Hard	SPG 0213	4	13	3	40	1	
A1004010305	HFH 0210.03		Z5 Hard		3	7	3	40	1	
A1004013305	HFH 0213.03		Z5 Hard		4	13	3	43	1	
A10050107305	HFM 0207.03		Z5 Hard	SEM 0207	3	7	3	40	1	
A1005013305	HFM 0213.03		Z5 Hard	SEM 0213	3	13	3	40	1	
A1005013305	HFM 0213.03		Z5 Hard	SEM 0213	4	13	3	40	1	
A10050213305	HFM 0213.03		Z5 Hard	SEM 0213	6	13	3	40	1	
A1012007305	WFM 0207.03		Z5 Hard	WKN 0207	3	7	3	40	1	
A1012007305	WFM 0207.03		Z5 Hard	WKN 0207	4	7	3	37	1	
A10120073050001	WFM-S 0207.03		Z5 Hard	WKN-S 0207	3	7	3	40	1	
A10120073050001	WFM-S 0207.03	Z5 Hard	WKN-S 0207	4	7	3	37	1		

## Z3 Universal burr



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\* with single cut for universal applications

Product number	Description	Shape	Cut	Similar to Universal	L mm	L mm	L mm	L mm	Feed mm/min	
A10010213303	HEA 0313.03		Z3 Universal	ZYA 0313	3	13	3	40	1	
A10010413803	HFA 0413.06		Z3 Universal	ZYA 0413	4	13	4	50	1	
A10010614803	HFA 0616.06		Z3 Universal	ZYA 0616	6	16	6	50	1	
A10010810603	HFA 0820.06		Z3 Universal	ZYA 0820	8	20	8	60	1	
A10010810803	HFA 1013.08		Z3 Universal	ZYA 1013	10	13	8	53	1	
A10011020403	HFA 1020.09		Z3 Universal	ZYA 1020	10	20	8	60	1	
A10011225403	HFA 1225.09		Z3 Universal	ZYA 1225	12	25	8	65	1	
A10011625403	HFA 1625.09		Z3 Universal	ZYA 1625	16	25	8	65	1	
A10010213303001	HEAS 0313.03			Z3 Universal	ZYA-S 0313	3	13	3	40	1
A10010413803001	HEAS 0413.06			Z3 Universal	ZYA-S 0413	4	13	4	50	1
A10010614803001	HFA-S 0616.06			Z3 Universal	ZYA-S 0616	6	16	6	50	1
A1001082003001	HFA-S 0820.06			Z3 Universal	ZYA-S 0820	8	20	6	60	1
A10010810803001	HFA-S 1013.06			Z3 Universal	ZYA-S 1013	10	13	6	53	1
A1001102003001	HEAS 1020.06			Z3 Universal	ZYA-S 1020	10	20	6	60	1
A1001122503001	HFA-S 1225.09			Z3 Universal	ZYA-S 1225	12	25	6	65	1
A1001162503001	HFA-S 1625.09			Z3 Universal	ZYA-S 1625	16	25	6	65	1
A10020113303	HFC 0313.03		Z3 Universal	WRC 0313	3	13	3	40	1	
A10020413803	HFC 0413.06		Z3 Universal	WRC 0413	4	13	4	50	1	
A10020610803	HFC 0616.06		Z3 Universal	WRC 0616	6	16	6	50	1	
A1002082003	HFC 0820.06		Z3 Universal	WRC 0820	8	20	6	60	1	
A10021010603	HFC 1013.06		Z3 Universal	WRC 1013	10	13	6	60	1	
A1002122503	HFC 1225.06		Z3 Universal	WRC 1225	12	25	6	65	1	
A1002162503	HFC 1625.06		Z3 Universal	WRC 1625	16	25	6	65	1	
A1002182503	HFC 1825.06		Z3 Universal	WRC 1825	18	25	6	65	1	
A10030010203	HFD 0302.03		Z3 Universal	KUD 0302	3	2	3	40	1	
A10030404003	HFD 0403.06		Z3 Universal	KUD 0403	4	3	4	50	1	
A10030606003	HFD 0603.06		Z3 Universal	KUD 0603	6	5	6	50	1	
A10030808003	HFD 0807.06		Z3 Universal	KUD 0807	8	7	6	67	1	
A10031010003	HFD 1008.06		Z3 Universal	KUD 1008	10	8	6	60	1	
A10031212003	HFD 1210.06		Z3 Universal	KUD 1210	12	10	6	57	1	
A10031616003	HFD 1614.06		Z3 Universal	KUD 1614	16	14	6	54	1	
A10031818003	HFD 1814.06		Z3 Universal	KUD 1814	18	14	6	54	1	
A10032020003	HFD 2018.06	Z3 Universal	KUD 2018	20	18	6	58	1		
A10032020003	HFD 2018.06	Z3 Universal	KUD 2018	20	18	8	56	1		
A100600107203	HFE 0307.03		Z3 Universal	TRE 0307	3	7	3	40	1	
A10060106003	HFE 0610.06		Z3 Universal	TRE 0610	6	10	6	50	1	
A10060113003	HFE 0813.06		Z3 Universal	TRE 0813	8	13	6	53	1	
A10061220003	HFE 1220.06		Z3 Universal	TRE 1220	12	20	6	60	1	
A10061625003	HFE 1625.06		Z3 Universal	TRE 1625	16	25	8	65	1	

Product number	Description	Shape	Cut	Number to (per inch)	Ø max.	L max.	Ø min.	L min.	r	Peak condition	
A101007001	HFF 0211.06		Z3 Universal	HFF 0211	3	7	3	40	1		
A101008001	HFF 0611.06		Z3 Universal	HFF 0611	6	10	6	50	1		
A1010082001	HFF 0821.06		Z3 Universal	-	8	20	6	60	1		
A101010001	HFF 1021.06		Z3 Universal	HFF 1021	10	20	6	60	1		
A1010125001	HFF 1225.06		Z3 Universal	HFF 1225	12	25	6	65	1		
A1010125001	HFF 1225.06		Z3 Universal	HFF 1225	12	25	6	65	1		
A1010123001	HFF 1230.06		Z3 Universal	HFF 1230	12	30	6	70	1		
A1010163001	HFF 1630.06		Z3 Universal	HFF 1630	16	30	8	70	1		
A1004011301	HFG 0213.06			Z3 Universal	SPG 0213	3	13	3	40	1	
A1004041001	HFG 0410.06			Z3 Universal	SPG 0410	6	10	6	50	1	
A1004061001	HFG 0610.06	Z3 Universal		-	6	20	6	60	1		
A1004102001	HFG 1020.06	Z3 Universal		SPG 1020	10	20	6	60	1		
A1004122001	HFG 1220.06	Z3 Universal		SPG 1220	12	20	6	60	1		
A1004125001	HFG 1225.06	Z3 Universal		SPG 1225	12	25	6	65	1		
A1004125001	HFG 1225.06	Z3 Universal		SPG 1225	12	25	6	65	1		
A1004123001	HFG 1230.06	Z3 Universal		SPG 1230	12	30	6	70	1		
A1004163001	HFG 1630.06	Z3 Universal		SPG 1630	16	30	8	70	1		
A1008011201	HFH 0412.06			Z3 Universal	-	6	13	3	40	1	
A1008021001	HFH 0610.06		Z3 Universal	-	6	20	6	60	1		
A1008123001	HFH 1230.06		Z3 Universal	-	12	30	6	70	1		
A1000123001	HFH 1230.06		Z3 Universal	-	12	30	6	70	1		
A1000123001	HFH 1230.06		Z3 Universal	-	12	30	6	70	1		
Product number	Description	Shape	Cut	Number to (per inch)	Ø max.	L max.	Ø min.	L min.	r	Peak condition	
A1007163001	HFL 0821.06		Z3 Universal	-	8	20	6	60	1.5	14°	
A1007102001	HFL 1020.06		Z3 Universal	KEL 1020	10	20	6	60	2.0	14°	
A10071225001	HFL 1225.06		Z3 Universal	KEL 1225	12	25	6	65	2.2	14°	
A1007123001	HFL 1230.06		Z3 Universal	KEL 1230	12	30	6	70	2.6	14°	
A1007163001	HFL 1630.06		Z3 Universal	KEL 1630	16	30	6	70	4.0	14°	
Product number	Description	Shape	Cut	Number to (per inch)	Ø max.	L max.	Ø min.	L min.	r	Peak condition	
A1005021301	HFM 0213.06		Z3 Universal	SAM 0213	3	7	3	40	1		
A1005061001	HFM 0610.06		Z3 Universal	SAM 0610	6	10	6	50	1		
A1005082001	HFM 0820.06		Z3 Universal	-	8	20	6	60	1		
A1005102001	HFM 1020.06		Z3 Universal	SAM 1020	10	20	6	60	1		
A1005122501	HFM 1225.06		Z3 Universal	SAM 1225	12	25	6	65	1		
A1005123001	HFM 1230.06		Z3 Universal	SAM 1230	12	25	6	65	1		
Product number	Description	Shape	Cut	Number to (per inch)	Ø max.	L max.	Ø min.	L min.	r	Peak condition	
A1012101301	HWN 1013.06		Z3 Universal	WKM 1013	10	13	6	53	10°	1	
A1012121301	HWN 1213.06		Z3 Universal	WKM 1213	12	13	6	53	30°	1	
A1012161301	HWN 1613.06		Z3 Universal	WKM 1613	16	13	6	53	20°	1	
A1012101301001	HWN 1013.06		Z3 Universal	WKM S 1013	10	13	6	53	10°	1	
A1012121301001	HWN 1213.06		Z3 Universal	WKM S 1213	12	13	6	53	20°	1	
A1012161301001	HWN 1613.06		Z3 Universal	WKM S 1613	16	13	6	53	20°	1	
A1012161301001	HWN 1613.06		Z3 Universal	WKM S 1613	16	13	6	53	20°	1	
A1012161301001	HWN 1613.06		Z3 Universal	WKM S 1613	16	13	6	53	20°	1	



# 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 fistful 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	L <sub>1</sub> mm	L <sub>2</sub> mm	d mm	L mm	Flute condition
A10086315023	HFAS 0215.03	Composite Coarse	3	15	3	42	1
A10086425023	HFAS 0525.06	Composite Coarse	6	25	6	64	1
A10086530023	HFAS 0828.08	Composite Coarse	8	28	8	73	1

## 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	L <sub>1</sub> mm	L <sub>2</sub> mm	d mm	L mm	Flute condition
A10086625024	HFAS 0525.06	Composite Fine	6	25	6	64	1
A10086828024	HFAS 0828.08	Composite Fine	8	28	8	73	1
A10087020024	HFAS 1030.10	Composite Fine	10	30	10	77	1



## 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 retains high speed
- long tool life thanks to tungsten carbide
- smooth running without vibrations
- Applications: pattern construction and wood, metal milling, cast and soft materials



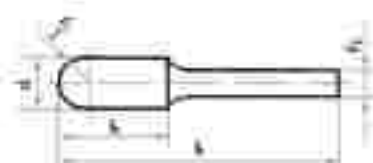
### Wood burr

★★★

Product number	Description	Shape	Cut	d mm	L mm	d1 mm	L1 mm	Flank angle
A1002125018	HFC 125.00		Wood	12	25	8	65	1
A1003121018	HFD 1210.00		Wood	12	10	8	50	1
A1006122018	HFE 1220.00		Wood	12	20	8	60	1
A1008018018	HFF 0818.00		Wood	8	18	8	58	1
A1010002018	HFF 0020.00		Wood	8	20	8	60	1

MILWAUKEE

## Z2 Brass burr



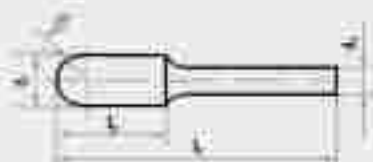
★★☆

\* robust single cut for high stock removal

Product number	Description	Shape	Cut	Similar to 229 020	Ø mm	L mm	L <sub>1</sub> mm	L <sub>2</sub> mm	L <sub>3</sub> mm	Flute condition
A1000013302	HFC 0113.03		Z2 Brass	WRC 0113	3	13	3	40	-	1
A1002015402	HFC 0614.06		Z2 Brass	WRC 0614	6	14	6	50	-	1
A1001225002	HFC 1225.06		Z2 Brass	WRC 1225	12	25	6	65	-	1
A1000010302	HFD 0103.03		Z2 Brass	KUD 0303	3	3	3	40	-	1
A1004011802	HFC 0618.06		Z2 Brass	SPC 0618	6	18	6	50	-	1
A1001225802	HFC 1225.08		Z2 Brass	SPC 1225	12	25	6	65	-	1
A1004123002	HFC 1230.06		Z2 Brass	SPC 1230	12	30	6	70	-	1
A1000013302	HF40013.03		Z2 Brass	-	6	13	3	43	-	1

Recommended for:   Aluminum   Cast metal   Plastic/Wood   Steel

## Z1 burr



★★☆

\* coarse single cut for soft materials  
e.g. aluminum and copper

Product number	Description	Shape	Cut	Similar to 229 020	Ø mm	L mm	L <sub>1</sub> mm	L <sub>2</sub> mm	L <sub>3</sub> mm	F mm	W°	Flute condition
A100201802	HFC 0618.06		Z1	WRC 0618	6	18	6	50	-	-	-	1
A1001225802	HFC 1225.08		Z1	WRC 1225	12	25	6	65	-	-	-	1
A1001225802	HFF 1225.08		Z1	BBF 1225	12	25	8	65	-	-	-	1
A100401802	HFC 0618.06		Z1	SPC 0618	6	18	6	50	-	-	-	1
A1002123802	HFC 1238.08		Z1	KEI 1238	12	38	6	70	2.8	14°	-	1
A10021225802	HFM 1225.08		Z1	GRM 1225	12	25	8	65	-	-	-	1

Recommended for:   Aluminum   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 race-sharp cutting edges
- the perfect synergies between burr and Lightflow coating
- high chip volume thanks to coarse cut for quick work
- faceted tooling for perfect surface results
- maximum cutting cross section for effortless processing



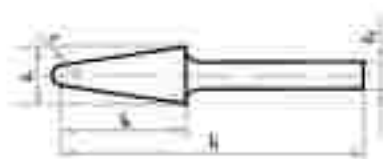
★★★

Product number	Designation	Shape	Mat.	Order to LUKAS	d mm	L mm	l mm	L mm	Flank condition
A100102500LF	HPC 0616.06		Z9 Alu	WHC 0616	6	16	6	50	1
A100122500LF	HPC 1225.06		Z9 Alu	WHC 1225	12	25	6	55	1
A100001800LF	HFP 0616.06		Z9 Alu	EDF 0616	6	16	6	50	1
A100122500LF	HFP 1225.06		Z9 Alu	EDF 1225	12	25	6	55	1
A10012000LF	HPL 1230.06		Z9 Alu	REL 1230	12	30	6	70	1

Recommended Set Aluminium Plastic/Wood



## Z9 Alu burr



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

★★☆

Product number	Description	Shape	Coat	Manufacturer	φ <sub>max</sub> mm	L <sub>max</sub> mm	φ <sub>2</sub> mm	L <sub>1</sub> mm	Flute condition	
A100021300	HFA 0213.00		Z9 Alu	Z9A 0213	3	10	3	40	1	
A100041200	HFA 0412.00		Z9 Alu	Z9A 0412	4	16	4	50	1	
A100122500	HFA 1225.00		Z9 Alu	Z9A 1225	12	25	6	65	1	
A100122580	HFA 1225.80		Z9 Alu	Z9A 1225	12	25	8	65	1	
A100162500	HFA 1625.00		Z9 Alu	Z9A 1625	16	25	6	65	1	
A100001300	HFC 0013.00			Z9 Alu	WHC 0013	3	13	3	40	1
A100061000	HFC 0610.00			Z9 Alu	WHC 0610	6	10	6	50	1
A100081000	HFC 0810.00			Z9 Alu	WHC 0810	8	20	6	50	1
A100122500	HFC 1225.00	Z9 Alu		WHC 1225	12	20	6	65	1	
A100122580	HFC 1225.80		Z9 Alu	WHC 1225	12	25	8	65	1	
A100162500	HFC 1625.00		Z9 Alu	WHC 1625	16	25	6	65	1	
A100040200	HFD 0402.00			Z9 Alu	KUD 0402	4	2	3	34	1
A100300500	HFD 0305.00			Z9 Alu	KUD 0305	6	5	6	50	1
A100112100	HFD 1121.00	Z9 Alu		KUD 1121	12	10	6	50	1	
A100141000	HFD 1410.00	Z9 Alu		KUD 1414	14	14	6	54	1	
A100161000	HFD 1610.00		Z9 Alu	KUD 1614	16	14	8	54	1	
A100122500	HFE 1225.00			Z9 Alu	TRE 1225	12	25	6	65	1
A100162500	HFE 1625.00			Z9 Alu	TRE 1625	16	25	8	65	1
A100001300	HFF 0013.00				Z9 Alu	BBF 0013	3	13	3	40
A100061000	HFF 0610.00	Z9 Alu			BBF 0610	6	10	6	50	1
A100122500	HFF 1225.00	Z9 Alu	BBF 1225		12	20	6	65	1	
A100122580	HFF 1225.80	Z9 Alu	BBF 1225		12	25	8	65	1	
A100163000	HFF 1630.00		Z9 Alu	BBF 1630	16	30	6	70	1	
A100163080	HFF 1630.80		Z9 Alu	BBF 1630	16	30	8	70	1	
A1004031300	HFG 40313.00			Z9 Alu	SPQ 0313	3	10	3	40	1
A100702000	HFL 0020.00			Z9 Alu	-	6	20	6	60	1
A1007102000	HFL 1020.00	Z9 Alu		KEI 1020	10	20	6	60	1	
A1007122500	HFL 1225.00	Z9 Alu		KEI 1225	12	25	6	65	1	
A1007123000	HFL 1230.00		Z9 Alu	KEI 1230	12	30	6	70	1	
A1007123080	HFL 1230.80		Z9 Alu	KEI 1230	12	30	8	70	1	
A1005061000	HFM 0610.00			Z9 Alu	SKM 0610	6	10	6	50	1



# BENEFITS OF BURR AND FILE IN A SINGLE TOOL

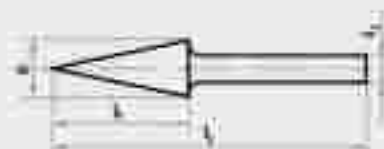
## EVEN CUTS SOFT MATERIALS WITHOUT CLOGGING



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 tooling 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.



- outstanding surface thanks to fine tooling
- long tool life thanks to tungsten carbide
- no clogging
- for outstanding surface



## ZF1 - ZF3 rotary file



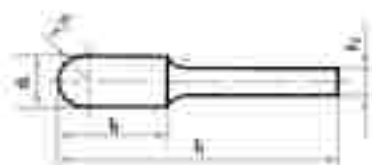
Product number	Description	Shape	Cut	Ø mm	L mm	Ø mm	L mm	Part number
A1001125016001	HFAS 125.06		ZF1	12	25	6	65	1
A1002125016	HFC 125.06		ZF1	12	25	6	65	1
A10041230038	HFG 1230.06		ZF1	12	30	6	70	1
A1005061615001	HFAC 0616.06		ZF2	6	10	6	50	1
A1001125016001	HFAS 125.06		ZF2	12	25	6	65	1
A1002125016	HFC 125.06		ZF2	12	25	6	65	1
A1003100015	HFD 1000.06		ZF2	10	9	6	48	1
A10040618015	HFG 0618.06		ZF2	6	10	6	50	1
A1004123015	HFG 1230.06		ZF2	12	30	6	70	1

Recommended Cut: Steel Cast material Plastic Wood Titanium

Product number	Description	Shape	Cut	L <sub>min</sub> mm	L <sub>max</sub> mm	Ø <sub>max</sub> mm	L <sub>cut</sub> mm	Flute condition
A1001225811	HFM 1225.08		ZF2	12	25	6	25	1
A10010156140001	HFAS 0610.06		ZF3	6	10	6	50	1
A1001011614	HFC 0610.06		ZF3	6	10	6	50	1
A1004018114	HFS 0610.06		ZF3	6	10	6	50	1
A1004123014	HFS 1230.06		ZF3	12	30	6	70	1
A1001010400	HFI 0204.03		ZZF	2.5	4	2	40	1
A10010108301	HFI 0408.03		ZZF	4	8	3	50	1
A1001010600	HFI 0610.06		ZZF	6	10	6	55	1

Recommended for: ■ Aluminum ■ Steel ■ Cast iron ■ Titanium ■ Stainless

## 25 Hard burr



• with very fine angle cut for high quality surfaces with least vibration

★★☆

Product number	Description	Shape	Cut	Similar to tool code	L <sub>min</sub> mm	L <sub>max</sub> mm	Ø <sub>max</sub> mm	L <sub>cut</sub> mm	Flute condition
A1001010305	HFA 0210.03		25 Hard	ZVA 0210	2	10	2	40	1
A10010103815	HFA 0313.03		25 Hard	ZVA 0313	3	13	3	40	1
A10010607305	HFA 0607.03		25 Hard	ZVA 0607	6	7	3	37	1
A10010112315	HFA 0613.03		25 Hard	ZVA 0613	6	13	3	43	1
A1001010605	HFA 0610.06		25 Hard	ZVA 0610	6	10	6	50	1
A10010607615	HFA 0631.06		25 Hard	ZVA 0630	6	20	6	50	1
A10011225805	HFA 1225.06		25 Hard	ZVA 1225	12	25	6	65	1
A10010210350001	HFAS 0210.03		25 Hard	ZVA-S 0210	2	10	3	40	1
A10010113350001	HFAS 0313.03		25 Hard	ZVA-S 0313	3	13	3	40	1
A10010607300001	HFAS 0607.03		25 Hard	ZVA-S 0607	6	7	3	37	1
A10010113350001	HFAS 0613.03		25 Hard	ZVA-S 0613	6	13	3	43	1
A10010106150001	HFAS 0610.06		25 Hard	ZVA-S 0610	6	10	6	50	1
A10010210350001	HFAS 0210.06		25 Hard	ZVA-S 0210	6	20	6	50	1
A1001225810001	HFAS 1225.06		25 Hard	ZVA-S 1225	12	25	6	65	1

Recommended for: ■ Steel ■ Aluminum ■ Titanium

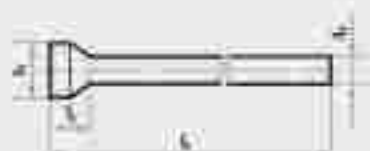
Product number	Description	Shape	Cut	Similar to DIN 8582	Ø mm	L mm	Ø mm	L mm	Flut condition	
A10020210305	HFC 0210.03		25 Hard	WFC 0210	2	10	2	40	1	
A10020113305	HFC 0113.03		25 Hard	WFC 0113	2	13	2	40	1	
A10020613305	HFC 0613.03		25 Hard	WFC 0613	6	13	2	40	1	
A10020016305	HFC 0016.06		25 Hard	WFC 0016	6	16	6	55	1	
A10020820305	HFC 0020.08		25 Hard	WFC 0020	8	20	6	60	1	
A10021020305	HFC 0020.10		25 Hard	WFC 0020	10	20	6	60	1	
A10011225305	HFC 1225.06		25 Hard	WFC 1225	12	25	6	65	1	
A10030303305	HFD 0303.03			25 Hard	KLD 0303	3	3	3	40	1
A10030404305001	HFD 0403.03			25 Hard	KLD 0403	4	3	3	34	1
A10030606305	HFD 0603.03			25 Hard	KLD 0606	6	3	3	35	1
A10000000005	HFD 0005.06	25 Hard		KLD 0005	6	5	6	50	1	
A10000000005	HFD 0007.06	25 Hard		KLD 0007	6	7	6	47	1	
A10021010005	HFD 1008.06	25 Hard		KLD 1000	10	8	6	40	1	
A10031212005	HFD 1210.06	25 Hard		KLD 1210	12	10	6	33	1	
A1000007305	HFE 0070.03		25 Hard	TRE 0007	3	7	3	40	1	
A1000010105	HFE 0010.03		25 Hard	TRE 0010	4	10	3	40	1	
A1000007305	HFF 0070.03		25 Hard	HBF 0007	3	7	3	40	1	
A1000013305	HFF 0113.03		25 Hard	HBF 0013	3	13	3	40	1	
A1000013305	HFF 0013.03		25 Hard	HBF 0013	6	13	3	40	1	
A1000016305	HFF 0016.06		25 Hard	HBF 0016	6	16	6	50	1	
A1004007305	HFG 0307.03			25 Hard	SPG 0307	3	7	3	40	1
A1004013305	HFG 0313.03	25 Hard		SPG 0313	3	13	3	40	1	
A10040013305	HFG 0013.03	25 Hard		SPG 0013	6	13	3	40	1	
A1004016305	HFG 0016.06	25 Hard		SPG 0016	6	16	6	50	1	
A10041010005	HFG 1020.06	25 Hard		SPG 1020	10	20	6	60	1	
A10041230005	HFG 1230.06	25 Hard		SPG 1230	12	30	6	70	1	
A1000007305	HFH 0070.03		25 Hard	-	3	7	3	40	1	
A1000013305	HFH 0013.03		25 Hard	-	6	13	3	40	1	
<b>Product number</b>	<b>Description</b>	<b>Shape</b>	<b>Cut</b>	<b>Similar to DIN 8582</b>	<b>Ø mm</b>	<b>L mm</b>	<b>Ø mm</b>	<b>L mm</b>	<b>Flut condition</b>	
A10071230005	HFL 1230.06		25 Hard	KEL 1230	12	30	6	70	2.0 14°	1
<b>Product number</b>	<b>Description</b>	<b>Shape</b>	<b>Cut</b>	<b>Similar to DIN 8582</b>	<b>Ø mm</b>	<b>L mm</b>	<b>Ø mm</b>	<b>L mm</b>	<b>Flut condition</b>	
A1005007305	HFM 0007.03		25 Hard	SAM 0007	3	7	3	40	1	
A1005011305	HFM 0211.03		25 Hard	SAM 0211	3	11	3	40	1	
A10050613305	HFM 0613.03		25 Hard	SAM 0613	6	13	3	40	1	
A10050016005	HFM 0016.06		25 Hard	SAM 0016	6	16	6	50	1	
A1012007305	HFN 0307.03		25 Hard	WKN 0307	3	7	3	40	1	
A1012007305	HFN 0007.03		25 Hard	WKN 0007	6	7	3	37	1	
A1012007305001	HFN-S 0307.03		25 Hard	WKN-S 0307	3	7	3	40	1	
A1012007305001	HFN-S 0007.03		25 Hard	WKN-S 0007	6	7	3	37	1	

# BACK DEBURRING MADE EASY

CREATE CHAMFERS IN PIPES, CONTAINERS AND DESIGN COMPONENTS



## Z3 Universal inverse deburring tool (internal)



- external 45° bevel
- for different base 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	$d_2$ mm	$L_1$ mm	$d_1$ mm	$L$ mm	Flute structure
A10770104303	HFT 0504.03	Z3 Universal	5	4	3	40	1
A10770105303	HFT 1005.03	Z3 Universal	7	5	3	40	1
A10770106303	HFT 1006.06	Z3 Universal	10	6	6	60	1
A10171012303	HFT 1202.06	Z3 Universal	12	7	6	85	1
A10171010003	HFT 1010.06	Z3 Universal	10	10	6	70	1
A10171018003	HFT 1018.08	Z3 Universal	16	10	8	120	1
A10171011003	HFT 1011.08	Z3 Universal	10	11	8	120	1



### SAFETY ADVICE

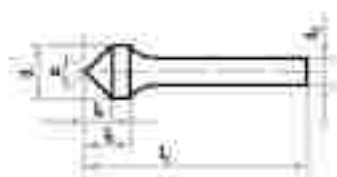
Reduced speed for burrs with a total length  $L_1 > 120$  mm: max. 11,000 rpm.





## Z3 Universal burr for deburring

- Removes 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



★★☆

Product number	Description	Cut	Similar to DIN 8002	d mm	L mm	d <sub>1</sub> mm	L <sub>1</sub> mm	L <sub>2</sub> mm	α	Flank condition
A100000000	HFJ 0625.26	Z3 Universal	K5J 0625	6	5	6	50	—	60°	1
A100000003	HFJ 1015.26	Z3 Universal	K2K 1005	10	5	6	50	10	90°	1
A100000005	HFJ 1013.06	Z3 Universal	K5J 1006	10	6	6	53	13	60°	1
A100000007	HFJ 1613.26	Z3 Universal	K2K 1608	16	6	6	53	13	90°	1
A100000009	HFJ 1613.06	Z3 Universal	K2K 1608	16	6	6	53	13	90°	1
A100000013	HFJ 1610.26	Z3 Universal	K5J 1613	16	14	6	56	16	60°	1

Recommended use:  Drill  Bore/Slot  Reamer  Cut parallel  Threading



## Z3 + Z5 burrs for deburring (external)

- perfectly shaped to fit bores/bore of varying size

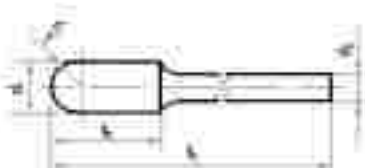


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Product number	Description	Cut	d mm	L mm	d <sub>1</sub> mm	L <sub>1</sub> mm	L <sub>2</sub> mm	Flank condition
A1014012600	HFR 0012.26	Z3 Universal	6	12	6	52	3	1
A1014101500	HFR 1015.26	Z3 Universal	10	15	6	55	2	1
A1014115403	HFR 1215.26	Z3 Universal	12	15	6	55	6	1
A1014115405	HFR 1215.06	Z3 Universal	12	15	6	55	6	1
A1014115409	HFR 1215.26	Z3 Universal	12	15	6	55	3	1
A1014115403	HFR 1215.26	Z3 Universal	12	15	6	55	3	1
A1014115405	HFR 1215.26	Z5 Hard	12	15	6	55	2	1

Recommended use:  Drill  Bore/Slot  Reamer  Cut parallel  Threading

## 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	Ø mm	L mm	L <sub>1</sub> mm	L <sub>2</sub> mm	v <sub>c</sub> (rpm)	Flute condition
A1001125688200	HFA 1225.06 L		Z7 Steel	12	25	8	22	2,300	1
A1002067448200	HFC 0675.04 L		Z7 Steel	6	14	6	21	2,300	1
A1003062548200	HFC 0625.04 L		Z7 Steel	8	10	6	22	4,200	1
A1002103068200	HFC 1030.06 L		Z7 Steel	10	20	6	22	4,200	1
A1002122568200	HFC 1225.06 L		Z7 Steel	12	25	6	22	3,400	1
A1003062548200	HFD 0625.04 L		Z7 Steel	6	9	6	20	3,400	1
A1003067548200	HFD 0675.04 L		Z7 Steel	8	7	6	20	2,900	1
A1003100688200	HFD 1000.06 L		Z7 Steel	10	9	6	20	2,300	1
A1003121088200	HFD 1210.06 L		Z7 Steel	12	10	6	21	5,200	1
A1003121088200	HED 1210.06 L	Z7 Steel	Z7 Steel	12	10	6	21	5,200	1
A1006121008200	HFE 1210.06 L		Z7 Steel	12	20	6	22	2,500	1
A100601088200	HFF 0610.06 L		Z7 Steel	6	10	6	21	4,300	1
A1001123088200	HFF 1230.06 L		Z7 Steel	12	30	8	23	3,500	1
A100401088200	HFG 0610.06 L		Z7 Steel	6	14	6	21	4,300	1
A1004123088200	HFG 1230.06 L		Z7 Steel	12	30	8	23	3,500	1
A1009100688200	HFH 1000.06 L		Z7 Steel	10	20	6	22	2,900	1

Recommended for:  Steel  Cast material  Titanium



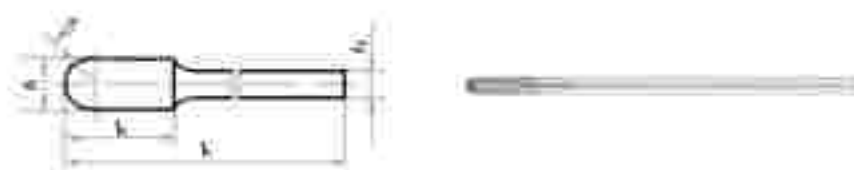
## SAFETY ADVICE

To prevent shank breakage, never exceed the maximum permitted tool speed when there is no tool contact (see product label). 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 mm	L mm	d <sub>s</sub> mm	L <sub>s</sub> mm	P mm	Flute count
A1000061600200	HFC 0616.06 L		Z3 Universal	6	16	6	216	4,200	1
A1000060900200	HFC 0609.06 L		Z3 Universal	6	9	6	226	3,400	1
A1000060500200	HFC 0605.06 L		Z3 Universal	6	5	6	236	3,200	1
A1000060700200	HFC 0607.06 L		Z3 Universal	6	7	6	237	4,800	1
A1000100900200	HFD 1009.06 L		Z3 Universal	10	9	6	226	3,000	1
A1000121000200	HFD 1210.06 L		Z3 Universal	12	10	6	210	3,400	1
A1000120600200	HFE 1206.06 L		Z3 Universal	12	6	6	226	2,500	1
A100061800200	HFF 0618.06 L		Z3 Universal	6	18	6	216	4,100	1
A100061800200	HFC 0618.06 L		Z3 Universal	6	18	6	216	4,100	1
A1000100600200	HFF 1006.06 L		Z3 Universal	10	6	6	226	2,300	1

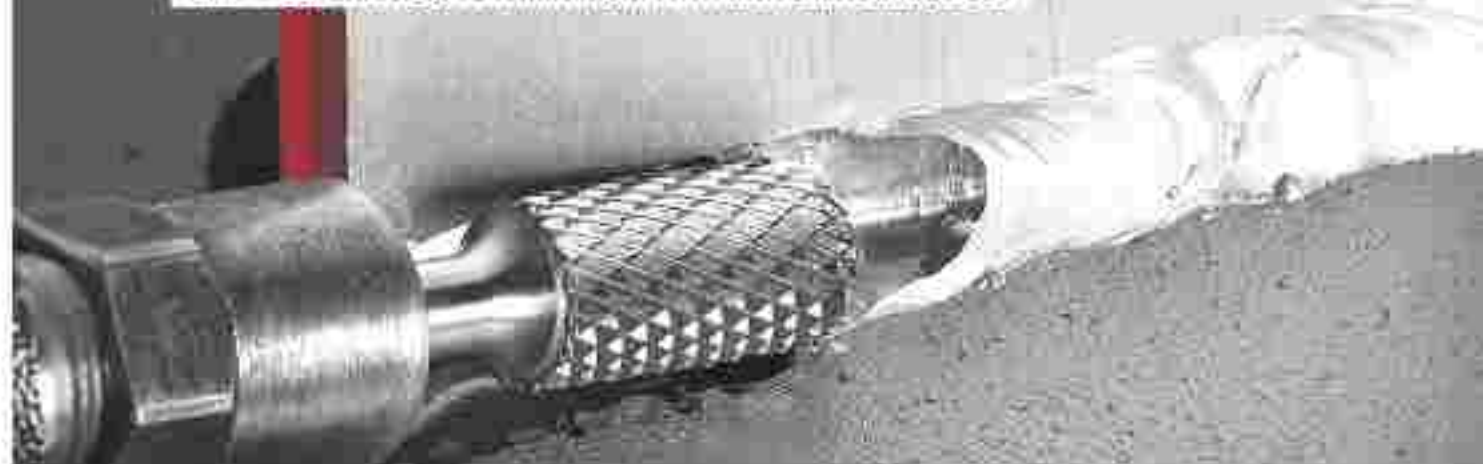
### SAFETY ADVICE

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

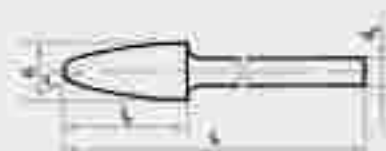
with the workpiece or inserted into a channel or brooch before the power tool is switched on, and remains there until the power tool comes to a complete standstill.

# 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	Ø mm	L mm	Ø mm	L mm	n/rev	Part availability
A10070820622150	HFC 0820.06 BASE-X		ZX Universal	8	20	6	170	5,500	1
A1007100822150	HFC 1020.06 BASE-X		ZX Universal	10	28	6	170	4,700	1
A1001225622150	HFC 1225.06 BASE-X		ZX Universal	12	25	6	175	3,600	1
Product number	Description	Shape	Cut	Ø mm	L mm	Ø mm	L mm	n/rev	Part availability
A1003063022150	HFD 0630.06 BASE-X		ZX UNIVERSAL	6	7	6	157	7,900	1
A1007100822150	HFD 1008.06 BASE-X		ZX UNIVERSAL	10	8	6	156	6,600	1
A1006030622150	HFF 0625.06 BASE-X		ZX UNIVERSAL	8	20	6	170	5,500	1
A10081225622150	HFF 1225.06 BASE-X		ZX UNIVERSAL	12	25	6	175	3,600	1



### SAFETY ADVICE

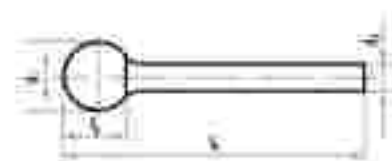
To prevent shank breakage, never exceed the maximum permitted tool speed when there is no tool contact into product table! You may work at twice the maximum permitted speed only if the burr is in contact

with the workpiece or insert 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



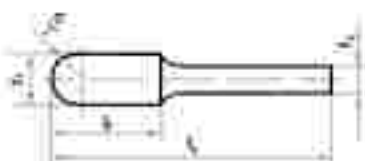
- the all rounder for universal applications
- with cross cut for high performance



Product number	Description	Shape	Cut	Similar to product	L mm	L mm	L mm	L mm	Flute	Flute	
A1001033022	HFA 0313.03 BASE-X		ZX Universal	ZVA 0313	3	13	3	40	10		
A1001001022	HFA 0616.06 BASE-X		ZX Universal	ZVA 0616	6	16	6	50	10		
A1001003022	HFA 0620.06 BASE-X		ZX Universal	ZVA 0620	6	20	6	60	10		
A1001010022	HFA 1020.10 BASE-X		ZX Universal	ZVA 1020	10	20	6	60	10		
A1001225022	HFA 1225.12 BASE-X		ZX Universal	ZVA 1225	12	25	6	65	5		
A1002033022	HFC 0313.03 BASE-X		ZX Universal	WFC 0313	3	13	3	40	10		
A1002051322	HFC 0513.05 BASE-X		ZX Universal	WFC 0513	5	13	3	43	10		
A1002001022	HFC 0616.06 BASE-X		ZX Universal	WFC 0616	6	16	6	50	10		
A1002002022	HFC 0620.06 BASE-X		ZX Universal	WFC 0620	6	20	6	60	10		
A1002102022	HFC 1020.10 BASE-X		ZX Universal	WFC 1020	10	20	6	60	10		
A10021225022	HFC 1225.12 BASE-X	ZX Universal	WFC 1225	12	25	6	65	5			
A1003040322	HFD 0403.03 BASE-X		ZX Universal	KUD 0403	4	3	3	34	10		
A1003060322	HFD 0605.05 BASE-X		ZX Universal	KUD 0605	6	5	3	36	10		
A10030607022	HFD 0607.06 BASE-X		ZX Universal	KUD 0607	6	7	6	47	10		
A1003100622	HFD 1006.06 BASE-X		ZX Universal	KUD 1006	10	6	6	40	10		
A1003121022	HFD 1210.12 BASE-X		ZX Universal	KUD 1210	12	10	6	51	5		
A1003133022	HFF 0313.03 BASE-X		ZX Universal	RBF 0313	3	13	3	40	10		
A1003001022	HFF 0616.06 BASE-X		ZX Universal	RBF 0616	6	16	6	50	10		
A1003003022	HFF 0620.06 BASE-X		ZX Universal		6	20	6	60	10		
A1003000622	HFF 1020.10 BASE-X		ZX Universal	RBF 1020	10	20	6	60	10		
A10031225022	HFF 1225.12 BASE-X		ZX Universal	RBF 1225	12	25	6	65	5		
A1004033022	HFG 0313.03 BASE-X		ZX Universal	SPG 0313	3	13	3	40	10		
A1004051322	HFG 0513.05 BASE-X		ZX Universal	SPG 0513	5	13	3	43	10		
A1004002022	HFG 0620.06 BASE-X		ZX Universal	SPG 0620	6	20	6	60	10		
A1004102022	HFG 1020.10 BASE-X		ZX Universal	SPG 1020	10	20	6	60	10		
A10041225022	HFG 1225.12 BASE-X		ZX Universal	SPG 1225	12	25	6	65	5		
A1004123022	HFG 1230.12 BASE-X		ZX Universal	SPG 1230	12	30	6	65	5		
A1004123022	HFL 1230.12 BASE-X		ZX Universal	KEL 1230	12	30	6	70	2.8	14°	5
A1005031322	HFM 0313.03 BASE-X			ZX Universal	SXM 0313	3	13	3	40		14°
A1005051022	HFM 0510.05 BASE-X	ZX Universal		SXM 0510	5	10	6	50		16°	10
A1005102022	HFM 0620.06 BASE-X	ZX Universal		SXM 0620	6	20	6	60		17°	10
A10051225022	HFM 1225.12 BASE-X	ZX Universal		SXM 1225	12	25	6	65		20°	5

Recommended for:  Steel  Cast metal  Stainless steel  Inconel

## ZX Universal burr with imperial-sized shank



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

Product number	Description	Shape	Col.	Series & Part No.	Ø mm	L mm	Ø inch	L inch	Flute condition		
A500103062214	HFA 0620.06 BASE-X		ZX Universal	ZFA 0620	6	20	1/4"	80	10		
A500103062214	HFA 1020.06 BASE-X		ZX Universal	ZFA 1020	10	20	1/4"	80	10		
A5001122562214	HFA 1225.06 BASE-X		ZX Universal	ZFA 1225	12	25	1/4"	85	5		
A5000361962214	HFC 0618.06 BASE-X		ZX Universal	WFC 0618	6	18	1/4"	50	10		
A500036382214	HFC 0620.06 BASE-X		ZX Universal	WFC 0620	6	20	1/4"	50	10		
A5000302062214	HFC 1020.06 BASE-X		ZX Universal	WFC 1020	10	20	1/4"	80	10		
A5000122562214	HFC 1225.06 BASE-X		ZX Universal	WFC 1225	12	25	1/4"	85	5		
A5000100962214	HFD 1008.06 BASE-X		ZX Universal	KLD 1008	10	8	1/4"	40	10		
A5000121062214	HFD 1210.06 BASE-X		ZX Universal	KLD 1210	12	10	1/4"	51	5		
A5010083062214	HFF 0620.06 BASE-X		ZX Universal	—	6	20	1/4"	80	10		
A5010102062214	HFF 1020.06 BASE-X		ZX Universal	BBF 1020	10	20	1/4"	80	10		
A5010122562214	HFF 1225.06 BASE-X		ZX Universal	BBF 1225	12	25	1/4"	85	5		
A500400062214	HFG 0620.06 BASE-X		ZX Universal	SPG 0620	6	20	1/4"	80	10		
A5004102062214	HFG 1020.06 BASE-X		ZX Universal	SPG 1020	10	20	1/4"	80	10		
A5004122562214	HFG 1225.06 BASE-X		ZX Universal	SPG 1225	12	25	1/4"	85	5		
A500412262214	HFG 1226.06 BASE-X		ZX Universal	SPG 1226	12	26	1/4"	70	5		
Product number	Description	Shape	Col.	Series & Part No.	Ø mm	L mm	Ø inch	L inch	Flute condition		
A500772062214	HFL 1226.06 BASE-X		ZX Universal	KEL 1226	12	30	1/4"	70	2.5 1/4"	5	
A5005261962214	HFM 0618.06 BASE-X		ZX Universal	ERM 0618	6	18	1/4"	50	—	10"	10
A5005102062214	HFM 1020.06 BASE-X		ZX Universal	ERM 1020	10	20	1/4"	40	—	27"	10
A5005122562214	HFM 1225.06 BASE-X		ZX Universal	ERM 1225	12	25	1/4"	45	—	28"	5

## 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 S8    Set HM ALU S3    Set HM ALU S6

★ ★ ☆

Product number	Description	Mat.	Stück/ Set	Content 1 per pack	Part number
A10390010	Set HM STEEL S3	Z7 Steel	3	10 parts: HFA 0313 HFC 0613 HFG 0313 HFF 0313	HFC 0313 HFD 0303 HFM 0613
A10390000	Set HM STEEL S6	Z7 Steel	6	10 parts: HFA 0616 HFC 1225 HFG 1210 HFF 0620	HFC 0616 HFD 0605 HFM 1225
A10390020	Set HM INOX S8	202 Incol Steel	8	10 parts: HFA 0618 HFC 1225 HFG 0618 HFF 1225	HFC 0618 HFD 1210 HFM 0618
A10390050	Set HM ALU S3	Z9 Alu	3	5 parts: HFA 0313 HFF 0313	HFC 0313 HFG 0313
A10390050F	Set HM ALU S6	Z9 Alu	6	5 parts: HFA 0616 HFF 0618	HFC 0616 HFD 0605 HFM 0610



## 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 cone cut for high performance



FS S3 BASE-X    ★ ★ ☆

Product number	Description	Mat.	Stück/ Set	Content 1 per pack	Part number
A10390053	FS S3 BASE-X	ZX Universal	3	5 parts: HFA 0313 HFF 0313	HFC 0313 HFG 0313 HFD 0303
A10390056	FS S6 BASE-X	ZX Universal	6	5 parts: HFA 1225 HFF 1225	HFC 1225 HFD 1225 HFM 1210

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 max. inner 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
- machine construction
- aerospace industry
- general engineering

Differential drill, radius mill, chamfer-end mill, (flat) mill, profile mill

Available upon request



## 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	Shape		Application
	<b>MFX</b> Cylindrical			<b>MFL</b> Conical round nose	
	<b>MFC</b> Cylindrical round nose			<b>MFS</b> Conical pointed nose	
	<b>MFD</b> Spherical			<b>MFS</b> inverted cone	
	<b>MFE</b> Oval			<b>MF</b> Miniature burr, shank 3 mm	
	<b>MFG</b> Arch pointed nose			<b>ME</b> Miniature burr, shank 3 mm	
	<b>MFR</b> Flare			<b>BUR</b> with internal thread	
	<b>MFX</b> Club				

## CUTS

	FL	Properties	FR
	21	Coarse cut for soft materials	40
	22	Robust single cut for high stock removal	41
	23	Medium single cut	50/51
	25	Very fine single cut for high-quality surfaces	51

## RECOMMENDED APPLICATIONS

## Three steps to your perfect burr made from HSS

## 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	Change interval (mm)	Machining	Cut	Recommended cutting speed, (m/min)
Steel, cast steel	up to 600	coarse	23	50-100
		medium	23	100-200
		fine	25	50-300
	600 to 1,200	coarse	22	50-100
		medium	23	100-300
		fine	25	50-200
Non-ferrous metal	up to 400	coarse	21	300-300
		medium	22	150-300
Plastic and wood	20 to 400	coarse	21	300-300
		fine	22	150-300

## MACHINING

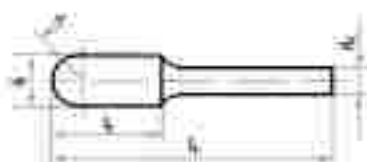


## STEP 3

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

		Recommended cutting speed $v_c$ (m/min)					
		10	100	100	300	500	800
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
	15	1,000	2,000	4,000	5,000	7,000	8,000
	20	1,000	2,000	3,000	4,000	5,000	6,000
	25	1,000	2,000	2,000	3,000	4,000	5,000
	30	1,000	1,000	2,000	3,000	4,000	4,000
	35	1,000	1,000	2,000	2,000	3,000	3,000
	40	—	1,000	1,000	2,000	2,000	3,000
			Speed (rpm)				

# Z1 HSS burr



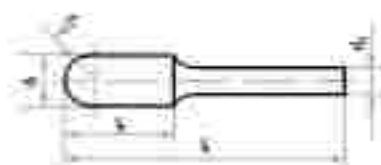
★★☆

► accurate cut for soft materials

Product number	Description	Shape	D	L	L <sub>1</sub>	L <sub>2</sub>	Flute diameter
A12001225001	MFA 1225.06		25	12	25	6	25
A12001625001	MFA 1625.06		25	16	25	6	25
A120006198010001	MFAC 0619.80		25	6	18	4	50
A120012258010001	MPA0 1225.06		25	12	25	6	25
A120016254010001	MPA0 1625.06		25	16	25	6	25
A12018020001	MFC 0802.06		25	8	20	6	20
A12010050001	MFC 0505.06		25	5	50	4	30
A12011225001	MFC 1125.06		25	12	25	6	25
A12000006001	MFD 0007.06		25	8	7	6	20
A12051225001	MFD 1210.06		25	12	10	4	20
A12051014001	MFD 1014.06		25	10	14	6	20
A12051220001	MFE 1220.06		25	12	20	6	20
A12051625001	MFE 1625.06		25	16	25	4	20
A12000010001	MFG 0010.06		25	8	18	6	30
A12061220001	MFG 1220.06		25	12	20	4	20
A12061230001	MFG 1230.06		25	12	30	6	20
A12061630001	MFG 1630.06		25	16	30	6	20
A12031030001	MFL 1030.06		25	10	30	4	20
A12020010001	MFM 0010.06		25	4	18	4	50
A12031230001	MFM 1230.06		25	12	30	4	20
A120412338010001	MFN0 1213.06		25	12	13	4	50

Product list (continued) | Milling | HSS | Burr




**Z2 HSS burr**


\* indicated single cut for high stock removal

★★☆☆

Part number	Description	Shape	D <sub>h</sub>	L <sub>h</sub> mm	L <sub>h</sub> mm	L <sub>h</sub> mm	L <sub>h</sub> mm	Part number	
A1200016002	MFA 0610.06		22	8	16	8	56	10	
A1200013002	MFA 1013.06		22	10	13	6	55	10	
A1200125002	MFA 1225.06		22	12	25	8	65	5	
A1200125002	MFA 1025.06		22	10	25	8	65	5	
A12000160030001	MFA5 0616.06		22	6	16	6	56	10	
A12000130030001	MFA5 1013.06		22	10	13	6	55	10	
A12001250030001	MFA5 1225.06		22	12	25	8	65	5	
A12001250030001	MFA5 1025.06		22	10	25	8	65	5	
A12000120002	MFC 0620.06			22	6	20	6	60	10
A1200050002	MFC 0850.06			22	8	50	8	90	10
A12001225002	MFC 1225.06	22		12	25	6	75	5	
A12004000030001	MFC 0404.06	22		4.5	4	8	60	10	
A1201060002	MFD 0605.06		22	6	5	8	60	10	
A1201060002	MFD 0610.06		22	6	7	8	60	10	
A1201101002	MFD 1009.06		22	10	9	8	60	10	
A1201101002	MFD 1014.06		22	10	14	8	60	5	
A1200013002	MFC 0619.06		22	6	19	6	58	10	
A12001220002	MFC 1220.06		22	12	20	6	60	5	
A12001220002	MFC 1220.06		22	12	20	6	70	5	
A12001030002	MFC 1030.06		22	10	30	6	70	5	
A12000120002	MFK 0620.06		22	6	20	6	60	10	
A12001220002	MFK 1220.06		22	12	20	8	70	5	
A12010020002	MFL 1020.06		22	10	20	8	60	10	
A1201030002	MPL 1030.06		22	10	30	6	70	5	
A1200010002	MFM 0610.06		22	6	10	6	58	10	
A1200020002	MFM 1020.06		22	10	20	6	60	10	
A12001220002	MFM 1220.06		22	12	20	8	70	5	

Recommended for Part finish Burr Material

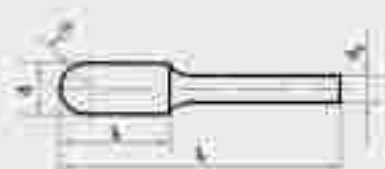


Product number	Description	Shape	Cd	φ mm	L mm	φ <sub>1</sub> mm	L <sub>1</sub> mm	Peak condition
A12020010003	MFM 0415.06		23	6	18	6	58	10
A12020020003	MFM 0625.06		23	8	26	6	60	10
A12021002003	MFM 1020.06		23	10	30	6	60	10
A12021225003	MFM 1225.06		23	12	25	6	65	5
A12021238003	MFM 1230.06		23	12	38	6	70	5
A12041228003	MFN 1230.06		23	12	38	6	70	5
A12041212003	MFN 1212.06		23	12	13	6	33	5
A120412130030001	MFNS 1213.06		23	12	13	6	33	5
A120412380030001	MFNS 1238.06		23	12	38	6	70	5

Recommended for:



## Z5 HSS burr



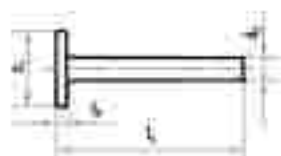
• very fine single cut for high quality surfaces

★★☆☆

Product number	Description	Shape	Cd	φ mm	L mm	φ <sub>1</sub> mm	L <sub>1</sub> mm	Peak condition
A12000304006	MFA 004.06		25	3	4.5	6	60	10
A12000607006	MFA 007.06		25	6	7	6	60	10
A12001225006	MFA 1225.06		25	12	25	6	65	5
A12000180050001	MFA5 0414.06		25	6	18	6	36	10
A1200620000	MFC 0020.06		25	6	20	6	60	10
A22001225006	MFC 1225.06		25	12	25	6	65	5
A12000800006	MFD 0012.06		25	8	7	6	60	10
A12001010006	MFD 1009.06		25	10	8	6	60	10
A12001230006	MFD 1230.06		25	12	30	6	70	5
A12001830006	MFD 1830.06		25	18	38	6	70	5
A12033030006	MFL 1830.06		25	18	38	6	70	5
A12040303006	MFM 0303.06		25	3	3	6	60	10
A12040600006	MFM 0600.06		25	6	6	6	60	10

Recommended for:

## Z5 HSS miniature burr



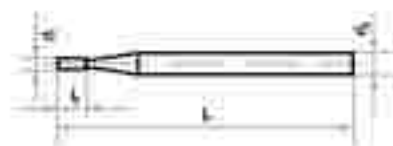
- Shank diameter: 2 mm
- very fine single cut for high quality surfaces

★★★

Product number	Description	Shape	CM	d mm	L mm	L <sub>c</sub> mm	L <sub>1</sub> mm	Part number
A123606705	MF 017		25	4	2,8	3	40	10
A1236067905	MF 019		25	6	4,2	3	41	10
A1236068105	MF 021		25	8	5,5	3	40	10
A12360683105	MF 022		25	6	6	3	40	10
A12360683905	MF 029		25	8	8	3	45	10
A1237069005	MF 040		25	1,6	2,8	3	40	10
A1237069105	MF 041		25	2,2	4	3	41	10
A1237069205	MF 042		25	3,2	5,8	3	40	10
A1237069305	MF 043		25	4	7	3	44	10
A1237069405	MF 044		25	5	8,2	3	46	10
A1237069505	MF 045		25	6	10,5	3	46	10
A1237069705	MF 047		25	8	14	3	46	10
A1238069805	MF 048		25	1,4	1,5	3	38	10
A1238069905	MF 049		25	2,2	2,1	3	39	10
A1238080005	MF 050		25	3,2	3	3	40	10
A1238080105	MF 051		25	4	3,8	3	41	10
A1238080205	MF 052		25	5	4,8	3	42	10
A1238080305	MF 053		25	6	5,8	3	43	10
A1238080405	MF 054		25	7	6,7	3	44	10
A1238080505	MF 055		25	8	7,7	3	45	10
A1239080705	MF 057			25	7	10	3	42
A1239081305	MF 072		25	7	10	3	40	10
A1239081405	MF 074		25	6	10	3	42	10
A1239081505	MF 075		25	7	12	3	44	10
A1239086405	MF 064		25	8	2	3	39	10
A1239086505	MF 065		25	10	2,5	3	40	10
A1239086605	MF 066		25	12	3	3	40	5
A1239086705	MF 067		25	14	3,5	3	41	5
A1240087005	MF 088		25	8	2	3	39	10
A1240087005	MF 070		25	12	2,8	3	40	5
A1240087105	MF 071		25	14	2	3	40	5
A1241087205	MF 072		25	6	1	3	38	10
A1241087305	MF 073		25	8	1	3	39	10
A1241087405	MF 074		25	10	1	3	39	10

www.komet.com




**Z3 + Z5 HSS miniature burr**


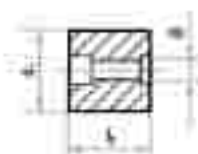
• shank diameter: 0 mm

★ ★ ☆

Product number	Designation	Image	D <sub>h</sub>	α <sub>1</sub> °	L <sub>h</sub> mm	α <sub>2</sub> °	L <sub>h</sub> mm	Stock length
A12000204025	MFA 0304.06		25	3	4.5	8	60	10
A1200020405	MFA 0032.06		25	8	3	8	60	10
A12000303803	MFD 0303.06		25	3	3	8	60	10
A12050303803000	MFD 0303.06		25	15	3	8	60	10
A12040303805	MFN 0303.06		25	3	3	8	60	10
A12040303805	MFN 0606.06		25	6	6	8	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 MFK have an additional end cut.



Product number	Description	Shape	D <sub>h</sub>	Ø mm	L mm	W Thread	Point radius
A12200310002	MFA 3030.10		27	30	30	M30	2
A12202710003	MFA 2075.08		23	22	15	M8	2
A122030301020001H	MFK 3030.10		27	30	30	M30	2
A122002100030001H	MFK 2215.08		23	22	15	M8	2
A12525271001	MFD 2522.10		21	25	21	M10	2
A12525271002	MFD 2522.10		22	25	21	M10	2
A1252010003	MFD 2010.08		23	20	18	M8	2
A12520271203	MFD 2026.12		23	30	18	M12	2
A12205371203	MFE 2535.12		23	25	35	M12	2
A12205551201	MFD 3555.12		21	35	35	M12	2
A122720551001	MFH 2055.10		21	20	55/95	M10	2
A122720551002	MFH 2055.10		22	20	55/95	M10	2
A122320551001	MFL 2055.10		21	20	55	M10	2
A12225401003	MFM 2540.10		23	25	40	M10	2

Inventory list:  Stock  Alternative  Available  Phased



## 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 25 33



Set MF 25 36



Set MF 23/25 36



Product number	Description	Qty	Shank Ø mm	Content 1 per part	Part number	
A123900010	Set MF 25 33	25	3	30 parts: MF 307 MF 305 MF 304 MF 314	MF 313 MF 308 MF 301 MF 303 MF 302	3
A12390003	Set MF 25 36	25	6	30 parts: MFA 0616 MFD 0403 MFG 1230 MFM 0818	MFA 1225 MFD 1215 MFK 1230	3
A12390004	Set MF 23/25 36	23/25	6	23 parts: MFA 0616 MFC 1325 MFE 1331 MFG 1230 MFM 0818 MFN 1230  25 parts: MFA 0304 MFM 0808	MFA 1013 MFD 0807 MFE 1625 MFK 1230 MFM 1230  MFA 0607 MFK 0303	3

Recommended for:

**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.



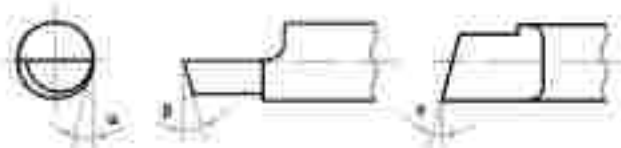
### ENGRAVING CUTTER FROM LUKAS

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 feed angles			Recommended cutting speed in V, m/min	Recommended feed rate in V, mm/min
	$\alpha$	$\beta$	$\gamma$		
Cast material, cast steel	25°	15°	5°	80 - 100	0.04 - 0.10
Steel up to 500 N/mm <sup>2</sup>	25°	15°	5°	120 - 150	0.05 - 0.20
Steel above 500 N/mm <sup>2</sup>	25°	15°	5°	50 - 70	0.04 - 0.08
Brass, aluminium	30°	10°	5°	200 - 400	0.05 - 0.15
Plastic, reinforced and non-reinforced	35°	15°	5°	200 - 300	0.25 - 0.35



# PERFECT ENGRAVINGS WITH

# LUKAS ENGRAVING CUTTERS

MADE TO LAST



#### Note on the listed dimensions:

- as semi-finished cutting edge with 0.1 mm tolerance
- optional: process halving with tolerance of ± 0.02 mm (10% surcharge)
- optional: relief grinding 0.5% surcharge
- optional: finished cut on request

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

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



## Engraving cutters made from solid carbide

★★☆☆

Product number	Description	Shape	Flute	d, mm	L, mm	L <sub>2</sub> , mm	Flute condition
A1330408012	HGA 04.040			4	40	6	1
A1330409012	HGA 04.060			4	60	6	1
A1330410012	HGA 06.070			6	70	8	1
A1330411012	HGA 08.100			8	100	12	1
A1330412012	HGA 10.100			10	100	14	1
A1330413012	HGA 12.100			12	100	16	1
A1330413042	HGA 03.040			3	40	6	1
A1330413042	HGA 04.060			4	60	6	1
A1330413042	HGA 06.070			6	70	8	1
A1330413042	HGA 08.080			8	80	8	1
A1330418071	HGS 03.040			3	40	15	1
A1330418071	HGS 04.060			4	60	20	1
A1330418071	HGS 05.050			5	50	22	1

Recommended for: Steel Alloys Cast material Plastic/Wood





# DRILLING

## PRECISE DRILLING AND SECURE ANCHORING

THE H2B DRILLS HOLES ACCURATELY AND TO SIZE IN VERTICALLY-PERFORATED AND AIR BRICKS

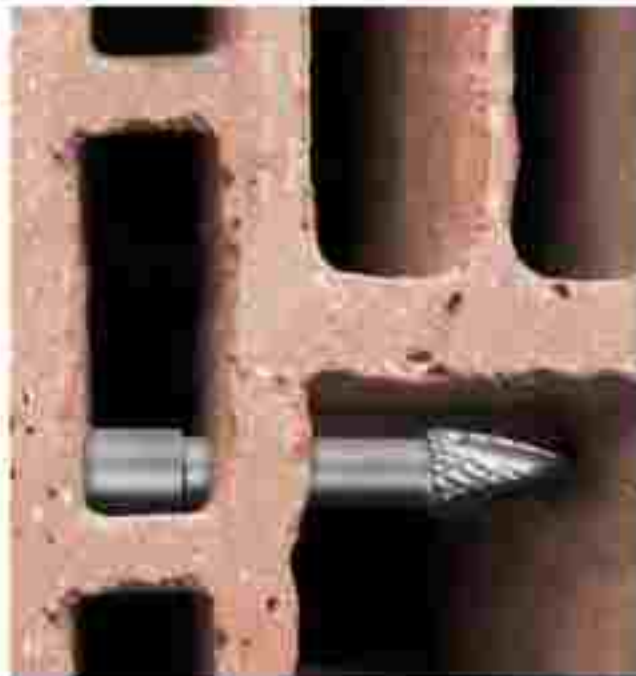
### HIGHLY VERSATILE

The H2B 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 H2B 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 H2B makes drilling into this type of brick no longer problematic. In contrast to conventional drills, the H2B does not damage the bricks' inner bars, which often leads to substantially reduced anchoring strength. The H2B tool is also suitable for drilling into glazed tiles.

### LONG-LIFE AND EASY TO USE

The LUKAS H2B 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

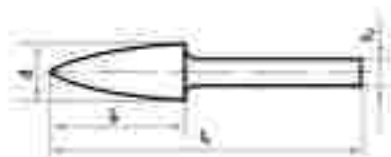
When drilling without impact, the drill gently rotates into the porous material thanks to its special profile.





## HZB special drill with SDS-plus shank **NEW**

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



★★★

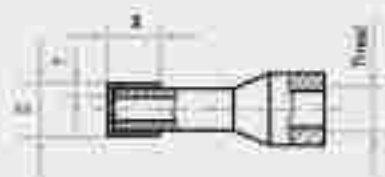
Product number	Description	d mm	L mm	d <sub>1</sub> mm	L <sub>1</sub> mm	Point material
A100406129000016	HZB 0613.10.27	6	13	10	203	1
A100406088800016	HZB 0820.06.27	8	20	6	105	1
A100410000000016	HZB 1020.10.27	10	20	10	200	1
A100414301200016	HZB 1430.12.27	14	30	12	250	1

Documented by: Hilti (Germany) GmbH



## Diamond dry drills

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



★★★

Product number	Description	Diameter D mm	Segment length X mm	Segment width T mm	Thread	P. rpm	Point material
A34520066315013	DTB 06	6	0	3.0	M14	12,000	1
A34520088335013	DTB 08	8	0	3.0	M14	12,000	1
A34520106315013	DTB 10	10	0	3.0	M14	12,000	1
A34520126315013	DTB 12	12	0	3.8	M14	12,000	1
A34520146315013	DTB 14	14	0	3.0	M14	12,000	1
A34520166315013	DTB 16	16	0	3.0	M14	12,000	1
A34520186315013	DTB 18	18	0	3.0	M14	12,000	1
A34520206315013	DTB 20	20	0	3.0	M14	12,000	1
A34520226315013	DTB 22	22	0	3.8	M14	12,000	1
A34520246315013	DTB 24	24	0	3.0	M14	12,000	1
A34520266315013	DTB 26	26	0	3.0	M14	12,000	1
A34520286315013	DTB 28	28	0	3.0	M14	12,000	1
A34520306315013	DTB 30	30	0	3.0	M14	12,000	1
A34520326315013	DTB 32	32	0	3.8	M14	12,000	1
A34520346315013	DTB 34	34	0	3.0	M14	12,000	1
A34520366315013	DTB 36	36	0	3.0	M14	12,000	1
A34520386315013	DTB 38	38	0	3.0	M14	12,000	1
A34520406315013	DTB 40	40	0	3.0	M14	12,000	1
A34520426315013	DTB 42	42	0	3.0	M14	12,000	1
A34520446315013	DTB 44	44	0	3.0	M14	12,000	1
A34520466315013	DTB 46	46	0	3.0	M14	12,000	1
A34520486315013	DTB 48	48	0	3.0	M14	12,000	1
A34520506315013	DTB 50	50	0	3.0	M14	12,000	1
A34520526315013	DTB 52	52	0	3.0	M14	12,000	1
A34520546315013	DTB 54	54	0	3.0	M14	12,000	1
A34520566315013	DTB 56	56	0	3.0	M14	12,000	1
A34520586315013	DTB 58	58	0	3.0	M14	12,000	1
A34520606315013	DTB 60	60	0	3.0	M14	12,000	1

Documented by: Hilti (Germany) GmbH



## 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

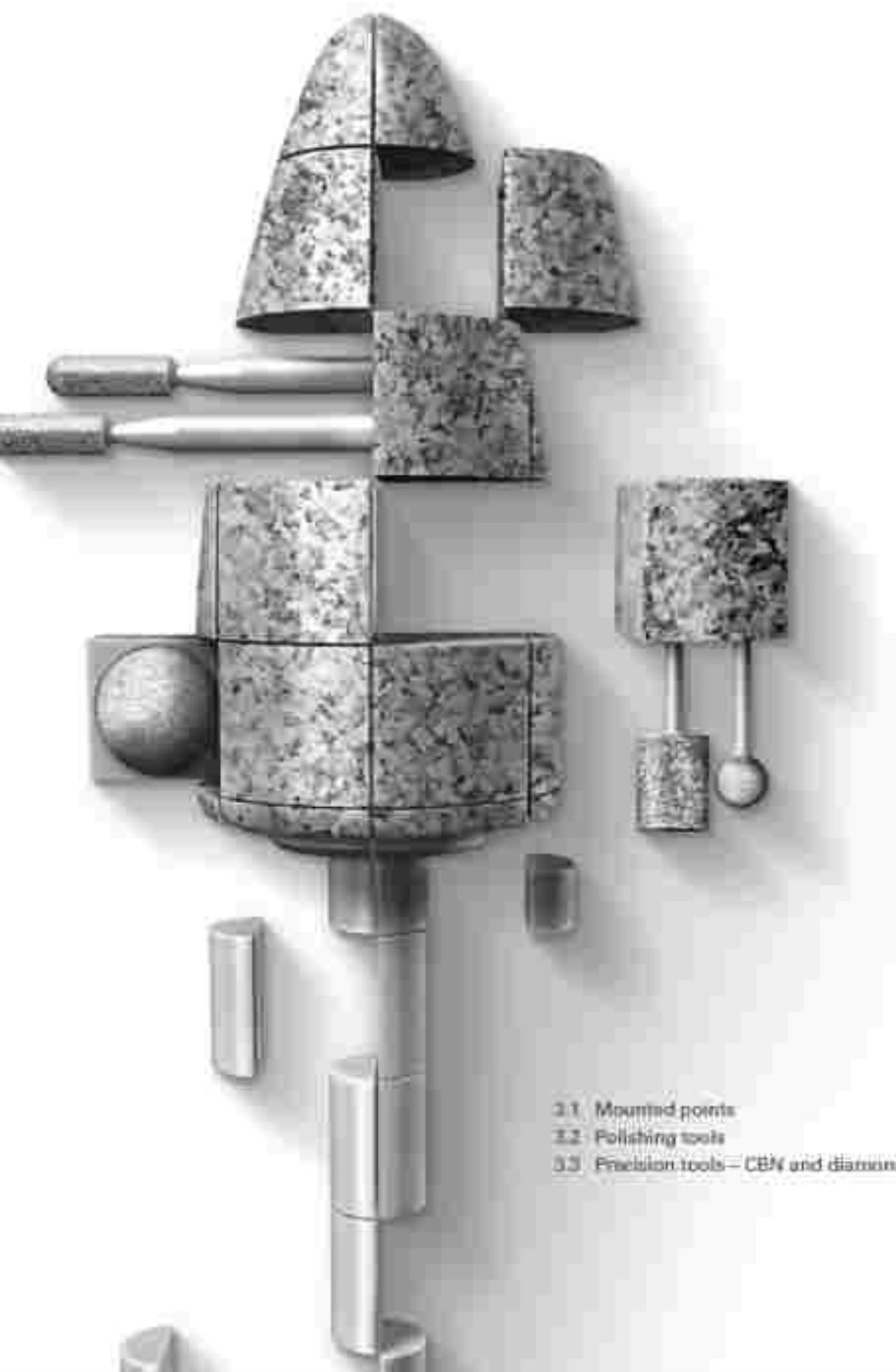
Product number	Description	DR	Content	Part number
A11E30002E	HGWB Set	8.8 - 1.3 E	4 core drill bits (Ø 33, 51, 63 and 73 mm) Including base plate, carbide center point and hexagonal shank (SW9)	1

Recommended for: ● Glass/Ceramic/metal ● Fast/Slow









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

# GRINDING AND POLISHING

(with bonded tools)

66–86

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, letting, 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.



## 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  
aluminum oxide

● ● ●



**EKR**  
Pink aluminum oxide

● ● ●



**EKW**  
White aluminum oxide

● ● ●



**EKD**  
Dark red  
aluminum oxide

● ● ●



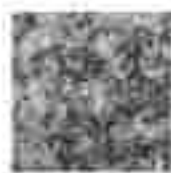
**EKbr**  
Pink aluminum oxide,  
type brown

● ● ●



**MX**  
Mixture EKR/NK

● ● ●



**HK**  
Mixture EKW/EK

● ● ●



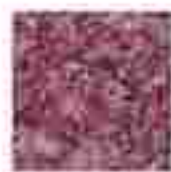
**HKD**  
Mixture EKW/EKD

● ● ●



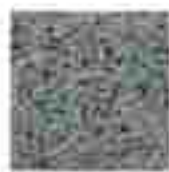
**MKD**  
Mixture NK/EKD

● ● ●



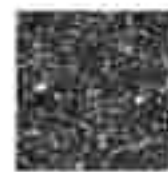
**RKD**  
Mixture of dark red and  
pink aluminum oxide

● ● ●



**SIC-ALU**  
Green silicon carbide

● ● ●



**SICdki**  
Dark silicon carbide

● ● ●



**NDW**  
Mixture of regular  
aluminum oxide, dark  
red aluminum oxide  
and white microcrystal  
aluminum oxide

● ● ●



**CERAMIC**  
Ceramic grain  
and monocrystal  
aluminum oxide

● ● ●



**HDK**  
Mixture of spherical  
aluminum 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.



## 40 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
6	36	80	240
8	40	90	250
10	44	100	260
12	48	110	270
15	54	120	280
18	60	130	290
20	64	140	300
22	70	150	320
24	76	160	340
26	80	170	360
28	84	180	380
30	90	190	400
32	96	200	420
34	100	210	440
36	106	220	460
38	112	230	480
40	118	240	500
42	124	250	520
44	130	260	540
46	136	270	560
48	142	280	580
50	148	290	600
52	154	300	620
54	160	310	640
56	166	320	660
58	172	330	680
60	178	340	700
62	184	350	720
64	190	360	740
66	196	370	760
68	202	380	780
70	208	390	800
72	214	400	820
74	220	410	840
76	226	420	860
78	232	430	880
80	238	440	900
82	244	450	920
84	250	460	940
86	256	470	960
88	262	480	980
90	268	490	1000

## 41 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.

softest bond	very soft	soft	medium	hard	very hard	hardest bond
A	E	H	L	P	T	X
B	F	I	M	Q	V	Y
C	G	J	N	R	W	Z
D	-	K	O	S	-	-

## 42 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

## III IMPREGNATION (OPTIONAL)

Impregnation can improve the grinding properties of all vitrified bonds, especially for processing certain steels:

- **Ls** – 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

Type	Material	Grain size mm	Material												
			Al	AlSi	AlCu	AlMg	AlMgSi	AlNi	AlTi	AlZn	AlZnMg	AlZnMgCu			
29-31	EKR Pink aluminum oxide	approx. 20-25													
33	EEWtr White aluminum oxide type brown	approx. 25-40													
33/34	RKO Dark red and pink aluminum oxide	approx. 30-50													
34	NR-5A soft Regular aluminum oxide iron- and sulphur-free	approx. 40-50													
37	NR-5A hard Regular aluminum oxide	approx. 40-50													
38	NR White aluminum oxide and regular aluminum oxide	approx. 40-50													
39	NR Pink aluminum oxide and regular aluminum oxide	approx. 35-50													
34	NDW Dark red aluminum oxide, regular and microcrystal aluminum oxide	approx. 10-30													
39	Ceramic Ceramic grain and microcrystal aluminum oxide	approx. 30-50													
75	EEW White aluminum oxide	approx. 20-35													
76	ERBr Pink aluminum oxide, type brown	approx. 40-50													
77	SiC-ALU Green silicon carbide	approx. 25-40													
80	HON Spherical aluminum oxide	approx. 5-20													



## TECHNICAL INFORMATION

## Speeds for grinding tools



		Recommended cutting speed (v <sub>c</sub> , m/min)							
		5	10	20	30	40	50	60	80
Tool diameter (mm)	3	47,700	95,500	191,000	286,500	382,000	477,500	601,600	763,800
	2	31,800	63,700	127,300	191,000	254,600	318,300	401,600	525,300
	1.5	21,900	43,700	87,500	143,300	191,000	238,200	300,600	382,000
	1	14,600	29,200	58,400	114,400	152,800	191,000	240,600	305,600
	0.8	11,700	23,400	47,000	71,000	95,500	120,200	150,400	191,000
	0.6	8,800	17,600	35,200	52,500	70,000	88,300	111,300	142,800
	0.5	7,000	14,000	28,000	44,100	58,800	75,500	95,600	122,500
	0.4	5,600	11,200	22,400	35,000	46,000	58,800	74,500	95,600
	0.3	4,800	9,600	19,200	29,000	38,200	48,700	60,700	76,400
	0.2	3,800	7,600	15,300	22,900	30,500	38,200	48,100	61,000
	0.15	3,000	6,000	11,900	17,900	23,900	30,000	37,600	47,000
	0.1	2,400	4,800	9,500	14,300	19,100	24,300	30,500	38,200
	0.08	1,900	3,800	7,600	11,300	15,300	19,700	24,600	30,800
	0.06	1,400	2,800	5,600	8,500	11,700	15,300	19,300	24,500
	0.05	1,200	2,400	4,800	7,300	9,500	12,300	15,600	19,700
	0.04	1,000	1,900	3,800	5,700	7,600	9,800	12,500	15,900

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.

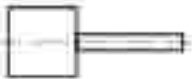







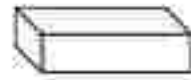


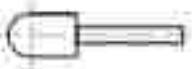

Our products are delivered with a safety ticket, as shown below, which indicates the maximum permitted speed for a certain overhang length (open shank length).

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

<b>MULTILINGUAL PRODUCT DESIGNATION</b>	Schleifkörper keramisch Brouleur / Mousse keramisch Mounted points - vitrified Mousse cerámicas Mousse vitrifiées Sliemse spoorje ceramisch	 ★★★	<b>PRODUCT LINE</b>								
<b>PRODUCT NUMBER AND PRODUCT SPECIFICATION</b>	A200002032602 ZY 2032-08 EKR 32 N V4	Menge / YPE 20  EN 12413	<b>SAFETY STANDARD</b>								
<b>TECHNICAL INFORMATION</b>	<table border="1"> <tr> <td>U<sub>sp</sub> (m/s)</td> <td>(1000) rpm</td> </tr> <tr> <td>16</td> <td>45.800</td> </tr> <tr> <td>18</td> <td>34.800</td> </tr> <tr> <td>20</td> <td>29.700</td> </tr> </table>  <p>LUKAS GROUP, Zehnighe Straat 110, Heerlenweg 144, 6201 KJ, NL          Servicecenter Straat 1, 3716B Dordrecht          Made in Germany</p>	U <sub>sp</sub> (m/s)	(1000) rpm	16	45.800	18	34.800	20	29.700	E41488310 	<b>SERIAL NUMBER</b>
U <sub>sp</sub> (m/s)	(1000) rpm										
16	45.800										
18	34.800										
20	29.700										
			<b>EAN CODE</b>								

## SHAPE

## Summary of available shapes

Shape		Shape		Shape	
	<b>ZY</b> Cylindrical, type 1		<b>KU</b> Spherical		Miniature mounted points
	<b>ZY2</b> Cylindrical, type 2		<b>TD</b> Cup		<b>SE</b> Taper-sided grinding wheel
	<b>WRS</b> Cylindrical pointed nose		<b>KE</b> Conical round nose		<b>RU</b> Sharpening stones
	<b>SP</b> Arch pointed nose		American shape A		
	<b>WR</b> Cylindrical round nose		American shape B		

## 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.







## Ceramic mounted point

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



★★★

Product number	Description	Shape	Quality	D mm	T mm	L mm	Part container
A2000029077	ZY 2205.03		Ceramic 80 L V10	2	5	3 x 30	30
A2000030077	ZY 2306.03		Ceramic 80 L V10	3	6	3 x 30	30
A2000040877	ZY 0408.03		Ceramic 80 L V10	4	8	3 x 30	30
A2000051077	ZY 0510.03		Ceramic 80 L V10	5	10	3 x 30	30
A2000061377	ZY 0613.03		Ceramic 80 L V10	6	13	3 x 30	30
A2000081877	ZY 0818.06		Ceramic 80 L V10	10	20	6 x 40	20
A2000132577	ZY 1325.06		Ceramic 40 L V10	11	25	6 x 40	20
A2000163277	ZY 1632.06		Ceramic 40 L V10	16	32	6 x 40	20
A2000203677	ZY 2032.06		Ceramic 40 L V10	20	32	6 x 40	20
A2013010077	ZV1 1301.03			Ceramic 80 L V10	13	3	3 x 30
A2002000677	SP 0306.03		Ceramic 80 L V10	3	6	3 x 30	20
A2002001077	SP 0510.03		Ceramic 80 L V10	5	10	3 x 30	30
A2002001677	SP 0616.03		Ceramic 80 L V10	6	16	3 x 30	20
A20020132077	SP 1320.06		Ceramic 80 L V10	13	20	6 x 40	20
A2010040477	KU 0404.03		Ceramic 80 L V10	4	4	3 x 30	20
A2010060677	KU 0606.03		Ceramic 80 L V10	6	6	3 x 30	20
A2010101077	KU 1010.06		Ceramic 40 L V10	10	10	6 x 40	20
A2010131377	KU 1313.06		Ceramic 40 L V10	13	13	6 x 40	20
A20150163277	KE 1632.06			Ceramic 40 L V10	16	32	6 x 40

 EX-10002 (40 x 40 x 40 mm)  
 (40 x 40 x 40 mm)


## Ceramic mounted point assortment

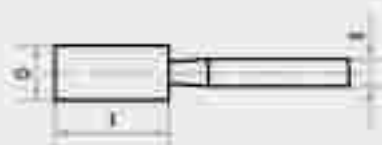
- maximum sharpness and hardness with ceramic self-sharpening effect
- 5 different shapes for fast tool changes, in specialist retail packaging
- impressive tool life
- high and fast removal rate, especially on hardened surfaces, scale, hard coatings and reinforced weld seams



★★★

Product number	Description	Stock alternative (yes)	Quality	Content	Part container
A204800057771	Assortment Ceramic	6	Ceramic	5 parts: ZY 1000, ZY 1632, SP 1320, KU 1313, KE 1632	1

## NOW mounted point



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

★★★

Product number	Description	Shape	Quality	D mm	L mm	D2 mm	Pack contents
A20000036833	ZY 0368.03		NOW 100 CU VTS	3	6	3 x 58	20
A20000036833001	ZY 0368.03		NOW 100 CU VTS	3	6	3 x 30	20
A20000040833	ZY 0408.03		NOW 100 CU VTS	4	8	3 x 58	20
A20000040833001	ZY 0408.03		NOW 100 CU VTS	4	8	3 x 30	20
A20000061033	ZY 0610.03		NOW 100 CU VTS	6	10	3 x 50	20
A20000061033001	ZY 0610.03		NOW 100 CU VTS	6	10	3 x 38	20
A20000081033	ZY 0810.03		NOW 100 CU VTS	8	10	3 x 50	20
A20000081033001	ZY 0810.03		NOW 100 CU VTS	8	10	3 x 38	20
A20000101033	ZY 1010.03		NOW 100 CU VTS	10	13	3 x 50	20
A20000101033001	ZY 1010.03		NOW 100 CU VTS	10	13	3 x 38	20
A2000001053	SP 0510.03		NOW 100 CU VTS	5	10	3 x 50	20
A2000001053001	SP 0510.03		NOW 100 CU VTS	5	10	3 x 38	20
A2000008053	SP 0810.03		NOW 100 CU VTS	8	10	3 x 50	20
A2000008053001	SP 0810.03		NOW 100 CU VTS	8	10	3 x 38	20
A20000101053001	WR 1013.03		NOW 100 CU VTS	10	13	3 x 30	20
A20000101053	WR 1013.03		NOW 100 CU VTS	10	13	3 x 50	20
A2010004043001	KU 0404.03		NOW 100 CU VTS	4	4	3 x 30	20
A20100040433	KU 0404.03		NOW 100 CU VTS	4	4	3 x 50	20
A2010006033	KU 0606.03		NOW 100 CU VTS	6	6	3 x 50	20
A201000803001	KU 0808.03		NOW 100 CU VTS	8	8	3 x 30	20
A2010008033	KU 0808.03		NOW 100 CU VTS	8	8	3 x 50	20

Recommended for: 3-2000

## NOW 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 aluminum oxide mixture for hardened and unhardened tool steels
- high-quality combination of aluminum oxide types for efficiently grinding unhardened tool steels

★★★

Product number	Description	Quality	Outer diameter mm	Content 1 per pack	Pack contents
A20000002333	Assortment 10	NOW	3 x 30	10 points: ZY 0408 ZY 1013 KU 0404 WR 1013	ZY 0610 SP 0510 KU 0606 ZY 0810 SP 0810 KU 0808 1

Recommended for: 3-2000









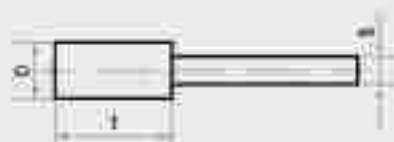
# THE SPECIALIST FOR ALUMINIUM

PROCESS EVEN THE SOFTEST MATERIALS WITHOUT SMEARING OR CLOGGING

EX-10001 (40) 40.000.000  
EX-10002 (40) 40.000.000



## SIC-ALU mounted point



• special quality for grinding aluminium.

★★★

Product number	Description	Shape	Quality	Ø mm	T mm	Ø x L mm	Post conditions	
A20000040018A	ZY 0400.02		GC-ALU 80V27W	4	8	5 x 30	20	
A20000050018A	ZY 0510.03		GC-ALU 80V27W	5	10	5 x 30	20	
A20000060018A	ZY 0610.03		GC-ALU 80V27W	6	10	5 x 30	20	
A20000080018A	ZY 0810.03		GC-ALU 80V27W	8	10	5 x 30	20	
A20000100018A	ZY 1010.03		GC-ALU 80V27W	10	10	5 x 30	20	
A20000150018A	ZY 1510.06		GC-ALU 80V27W	10	15	5 x 40	20	
A20000200018A	ZY 2020.06		GC-ALU 80V27W	10	20	5 x 40	20	
A20000300018A	ZY 3030.06		GC-ALU 80V27W	13	30	5 x 40	20	
A20000330018A	ZY 3330.06		GC-ALU 80V27W	13	32	5 x 40	20	
A20000400018A	ZY 4040.06		GC-ALU 80V27W	16	40	5 x 40	20	
A20000500018A	ZY 5050.06		GC-ALU 80V27W	16	50	5 x 40	20	
A20000700018A	ZY 7070.06		GC-ALU 80V27W	20	70	5 x 40	20	
A20000750018A	ZY 7575.06		GC-ALU 80V27W	20	75	5 x 40	20	
A20000900018A	ZY 9090.06		GC-ALU 80V27W	25	90	5 x 40	20	
A20001000018A	ZY 1000.06		GC-ALU 80V27W	25	100	5 x 40	20	
A20001200018A	ZY 1200.06		GC-ALU 80V27W	30	120	5 x 40	20	
A20001400018A	ZY 1400.06		GC-ALU 80V27W	40	140	5 x 40	20	
A20150000018A	KE 1632.06			GC-ALU 80V27W	16	32	5 x 40	20
A20150040018A	KE 2040.06			GC-ALU 80V27W	20	40	5 x 40	20



## QUALITIES AND PROPERTIES

# Mounted points for machining steel and cast steel



**EKR**  
Pink aluminum 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
- Fetting
- Rough grinding of weld seams
- Finish grinding of weld seams
- Deburring



**EKWbr**  
White aluminum oxide, type brown



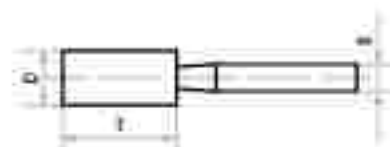
### INDUSTRIES

- 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 aluminum oxide
- extremely hard and sharp for a long tool life
- also cuts harder materials efficiently

Product number	Description	Shape	Quality	D mm	T mm	h mm	Flank condition
A3000004002	ZY 0104.02		EKR 150 N V4	1.5	4	3 x 30	20
A3000003002	ZY 0205.02		EKR 120 N V4	2	6	3 x 30	20
A300000205020001	ZY 0315.03		EKR 120 N V4	2.5	6	3 x 30	20
A30000030002	ZY 0305.02		EKR 100 N V4	3	6	3 x 30	20
A30000030020001	ZY 0305.03		EKR 120 QJ V4	3	6	3 x 30	20
A30000030002	ZY 0305.06		EKR 150 N V4	3	6	6 x 40	20

Recommended fit: -

Product number	Description	Shape	Quantity	D mm	T mm	W mm	Price unit/box
A2000040802	ZY 0408.02		ER 80 N V4	4	8	3 x 30	20
A2000040830001	ZY 0408.03		ER 100 CU V8	4	8	3 x 30	20
A2000040902	ZY 0409.06		ER 80 N V4	4	8	6 x 40	20
A2000051020	ZY 0510.03		ER 80 N V4	5	10	3 x 30	20
A2000051030001	ZY 0510.03		ER 80/100 CU V4	5	10	3 x 30	20
A2000051060	ZY 0510.06		ER 80 N V4	5	10	6 x 40	20
A2000061010	ZY 0610.03		ER 80 N V4	6	10	3 x 30	20
A2000061050	ZY 0610.06		ER 80 N V4	6	10	6 x 40	20
A2000061030	ZY 0610.03		ER 80 N V4	6	10	3 x 30	20
A2000061050/0001	ZY 0610.03		ER 8000 CU V4	6	10	3 x 30	20
A2000061060	ZY 0610.06		ER 80 N V4	6	10	6 x 40	20
A2000061630	ZY 0616.03		ER 80 N V4	8	16	3 x 30	20
A2000061660	ZY 0616.06		ER 80 N V4	8	16	6 x 40	20
A2000062060	ZY 0620.06		ER 80 N V4	8	20	6 x 40	20
A2000061000	ZY 1010.03		ER 80 N V4	10	10	3 x 30	20
A2000061060	ZY 1010.06		ER 80 N V4	10	10	6 x 40	20
A2000061100	ZY 1011.03		ER 80 N V4	10	13	3 x 30	20
A2000061100	ZY 1011.06		ER 80 N V4	10	13	6 x 40	20
A2000062060	ZY 1020.06		ER 80 N V4	10	20	6 x 40	20
A2000062080/0001	ZY 1020.06		ER 40 CU V4	10	20	6 x 40	20
A2000062260	ZY 1022.06		ER 80 N V4	10	22	6 x 40	20
A2000062000/0001	ZY 1022.06		ER 40 CU V4	10	22	6 x 40	20
A2000060400	ZY 1040.06		ER 80 N V4	10	40	6 x 40	20
A2000061300	ZY 1313.03		ER 46 N V4	13	13	3 x 30	20
A2000061300	ZY 1313.06		ER 46 N V4	13	13	6 x 40	20
A2000061200	ZY 1320.06		ER 46 N V4	13	20	6 x 40	20
A2000061250	ZY 1325.06		ER 46 N V4	13	25	6 x 40	20
A2000063200	ZY 1332.06		ER 46 N V4	13	32	6 x 40	20
A2000061800	ZY 1616.06		ER 46 N V4	16	16	6 x 40	20
A2000062000	ZY 1620.06		ER 46 N V4	16	20	6 x 40	20
A2000062200	ZY 1622.06		ER 46 N V4	16	22	6 x 40	20
A2000060400	ZY 1640.16		ER 46 N V4	16	40	6 x 40	20
A2000062000	ZY 2020.06		ER 36 N V4	20	20	6 x 40	20
A2000062500	ZY 2025.06		ER 36 N V4	20	25	6 x 40	20
A2000062500	ZY 2025.06		ER 36 N V4	20	30	6 x 40	20
A2000060400	ZY 2040.06		ER 36 N V4	20	40	6 x 40	20
A2000062500	ZY 2520.06		ER 36 N V4	25	20	6 x 40	20
A2000062500	ZY 2525.06		ER 36 N V4	25	25	6 x 40	20
A2000062500	ZY 2532.06		ER 36 N V4	25	32	6 x 40	20
A2000062000	ZY 3220.06		ER 30 N V4	32	20	6 x 40	20
A2000062000	ZY 3232.06		ER 30 N V4	32	32	6 x 40	20
A2000063000	ZY 3040.06		ER 30 N V4	32	40	6 x 40	20
A2000060000	ZY 4020.06		ER 30 N V4	40	20	6 x 40	20
A2000060400	ZY 4040.06		ER 30 N V4	40	40	6 x 40	20
A2000062000	ZY 5020.06		ER 30 N V4	50	20	6 x 40	20
A2010100300	ZY 1303.03		ER 80 N V4	13	3	3 x 30	20
A2010100300	ZY 1303.06		ER 80 N V4	13	3	6 x 40	20
A2010100400	ZY 1604.03		ER 80 N V4	16	4	3 x 30	20
A2010100400	ZY 1604.06		ER 80 N V4	16	4	6 x 40	20



Product number	Designation	Shape	Density	Ø mm	T mm	H mm	Flank condition
A201302006302	ZY2 2006.02		EKR 60 N V4	25	6	5 x 25	20
A201303006601	ZY2 2006.06		EKR 60 N V4	25	6	5 x 40	20
A2013020063001	ZY2 2006.06		EKR 46 CU V4	25	6	5 x 40	20
A201303506602	ZY2 2506.06		EKR 60 N V4	25	6	5 x 40	20
A201302510601	ZY2 2510.06		EKR 38 N V4	25	10	5 x 40	20
A201303206601	ZY2 3206.06		EKR 46 N V4	32	6	5 x 40	20
A201304010602	ZY2 4010.06		EKR 30 N V4	40	10	5 x 40	20
A201302206602	ZY2 2010.06		EKR 30 N V4	30	10	5 x 40	20
A200402025601	WKS 2025.06		EKR 60 N V4	25	25	5 x 40	20
A200200006001	SP 0206.01		EKR 100 N V4	3	6	3 x 30	20
A200200010301	SP 0510.01		EKR 20 N V4	3	10	3 x 30	20
A200200010601	SP 0510.06		EKR 20 N V4	3	10	5 x 40	20
A200200016301	SP 0616.01		EKR 60 N V4	6	16	3 x 30	20
A200200016601	SP 0616.06		EKR 60 N V4	6	16	5 x 40	20
A200201010601	SP 1010.06		EKR 60 N V4	10	20	5 x 40	20
A200201320601	SP 1320.06		EKR 46 N V4	13	20	5 x 40	20
A200202020601	SP 2020.06		EKR 38 N V4	20	22	5 x 40	20
A201000000001	KU 0000.01		EKR 60 N V4	6	6	3 x 30	20
A2010000000001	KU 0000.01		EKR 60/100 CU V4	6	6	3 x 30	20
A201000000002	KU 0000.06	EKR 60 N V4	6	6	5 x 40	20	
A201000000003	KU 0000.01	EKR 60 N V4	6	6	3 x 30	20	
A201000000004	KU 0000.06	EKR 60 N V4	6	6	5 x 40	20	
A201001000001	KU 1010.01	EKR 60 N V4	10	10	3 x 30	20	
A201001000002	KU 1010.06	EKR 60 N V4	10	10	5 x 40	20	
A201001010301	KU 1313.01	EKR 46 N V4	13	13	3 x 30	20	
A201001010601	KU 1313.06	EKR 46 N V4	13	13	5 x 40	20	
A201001016601	KU 1616.06	EKR 46 N V4	16	16	5 x 40	20	
A201002000001	KU 2020.06	EKR 38 N V4	20	20	5 x 40	20	
A2010020000001	KU 2020.06	EKR 60 P V21	20	20	5 x 40	20	
A201002525601	KU 2525.06	EKR 38 N V4	25	25	5 x 40	20	
A201003200001	KU 3232.06	EKR 30 N V4	32	32	5 x 40	20	
A200000000001	TO 2020.06	EKR 60 N V4	20	20	5 x 40	20	
A200002524001	TO 2524.06	EKR 60 N V4	25	24	5 x 40	20	
A200003229001	TO 3229.06	EKR 60 N V4	32	29	5 x 40	20	
A200004036001	TO 4036.06	EKR 60 N V4	40	36	5 x 40	20	
A201001632001	KE 1632.06	EKR 46 N V4	16	32	5 x 40	20	
A201001640001	KE 1640.06	EKR 46 N V4	16	40	5 x 40	20	
A201002032001	KE 2032.06	EKR 38 N V4	20	32	5 x 40	20	
A201002040001	KE 2040.06	EKR 38 N V4	20	40	5 x 40	20	
A201002070001	KE 2570.06	EKR 38 N V4	25	70	5 x 40	20	

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## EKR mounted point assortment



Assortment 5 tool



Assortment 14



Assortment 36



Assortment 46

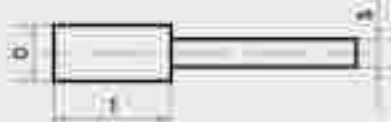
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Product number	Description	Quantity	Block dimension mm	Number of parts	Part number
A204800050291	Assortment 5 tool	EKR	ø	5 parts: ZY 1832.06 EKR 46 NV4 ZY 2525.06 EKR 36 NV4 WRS 2025.06 EKR 50 NV4 KJ 2525.06 EKR 36 NV4 KE 1832.06 EKR 46 NV4	1
A204700001402	Assortment 14	EKR	3 x 30	14 parts: ZY 0305                   ZY 0306                   ZY 0408 ZY 0510                   ZY 0610                   ZY 0810 ZY 0916                   ZY 1010                   ZY 1013 ZY 1313                   KJ 0906                   ZY2 1303 ZY2 1604                   ZY2 2006	1
A306800003802	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
A306800003902	Assortment 46	EKR	6 x 40	46 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 1832                   ZY2 2006                   ZY 2020 ZY 2025                   ZY 2032                   ZY 2040 ZY2 2506                   ZY2 2510                   ZY 2520 ZY 2525                   ZY 2532                   ZY2 3208 ZY 3206                   ZY 3232                   ZY2 4010 ZY 4020                   SP 0518                   SP 1020 SP 1320                   SP 2032                   KE 1632 KE 1840                   KE 2032                   KE 2040 KJ 1010                   KJ 1313                   KJ 1616 KJ 2020                   KJ 2525                   KJ 3232	1

# WHITE ALUMINIUM OXIDE, TYPE BROWN

EFFICIENTLY GRIND STEEL, CAST STEEL AND TEMPERED STEELS

## EKWor 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	L mm	Per unit
A200000209312	ZY 0209.03		EKWor 120 GIPV7	2	5	3 x 30	20
A200000306312	ZY 0306.03		EKWor 100 GIPV7	3	6	3 x 30	20
A200000408312	ZY 0408.03		EKWor 80 GIPV7	4	8	3 x 30	20
A200000510312	ZY 0510.03		EKWor 60 GIPV7	5	10	3 x 30	20
A200000612312	ZY 0612.03		EKWor 50 GIPV7	6	10	3 x 30	20
A200000816312	ZY 0816.03		EKWor 40 GIPV7	8	10	3 x 30	20
A200000918312	ZY 0918.03		EKWor 30 GIPV7	9	16	3 x 30	20
A200001020312	ZY 1020.03		EKWor 20 GIPV7	10	10	3 x 30	20
A200001125312	ZY 1125.03		EKWor 16 GIPV7	11	13	3 x 30	20
A200001230312	ZY 1230.03		EKWor 12 GIPV7	12	20	6 x 40	20
A200001336312	ZY 1336.03		EKWor 10 GIPV7	13	22	6 x 40	20
A200001442312	ZY 1442.03		EKWor 8 GIPV7	14	15	3 x 30	20
A200001548312	ZY 1548.03		EKWor 6 GIPV7	15	20	6 x 40	20
A200001654312	ZY 1654.03	EKWor 4 GIPV7	16	22	6 x 40	20	
A200001866312	ZY 1866.03	EKWor 3 GIPV7	18	32	6 x 40	20	
A200002088312	ZY 2088.03	EKWor 2 GIPV7	20	40	6 x 40	20	
A201001904112	ZY2 1904.03		EKWor 60 GIPV7	16	4	3 x 30	20
A201002006112	ZY2 2006.03		EKWor 60 GIPV7	20	6	3 x 30	20
A201002006312	KU 0606.03		EKWor 60 GIPV7	6	6	3 x 30	20
A201002007112	KU 0607.03		EKWor 60 GIPV7	6	8	3 x 30	20
A201002007312	KU 0607.03		EKWor 60 GIPV7	10	10	3 x 30	20
A201002008112	KU 0608.03		EKWor 40 GIPV7	20	20	6 x 40	20

Recommended fit: H7/g6



## QUALITIES AND PROPERTIES

# Mounted points for machining non-rusting steels



### R&D

Mixture of dark red and pink aluminum oxide



### NK-BA SOFT

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



## 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.

## INDUSTRIES

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

## PROCESSING EXAMPLES

- Rough and finish grinding
- Deburring
- Fitting
- Finishing weld joints
- Surface finishing

## 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.

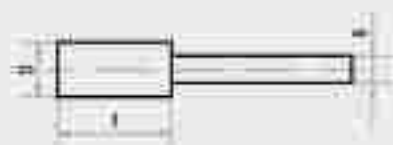








## NK soft mounted point



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

★★★

Product number	Description	Shape	Quality	Ø mm	T mm	L mm	Part contents
A20000132627W	ZY 1332.06		NK 24 N BA soft	13	32	6 x 40	30
A200001632627W	ZY 1632.06		NK 24 N BA soft	16	32	6 x 40	30
A200002040627W	ZY 2040.06		NK 24 N BA soft	20	40	6 x 40	30
A200002040627W	ZY 2040.06		NK 24 N BA soft	20	40	6 x 40	30
A200002532627W	ZY 2532.06		NK 24 N BA soft	25	32	6 x 40	30
A200002532627W	ZY 2532.06		NK 24 N BA soft	25	32	6 x 40	30
A200004020627W	ZY 4020.06		NK 24 N BA soft	40	20	6 x 40	30
A200005020627W	ZY 5020.06		NK 24 N BA soft	50	20	6 x 40	30
A20130250627	ZY2 2506.06		NK 24 N BA soft	25	6	6 x 40	30
A20130400627	ZY2 4006.06		NK 24 N BA soft	40	10	6 x 40	30
A201304010627W	ZY2 4010.06		NK 24 N BA soft	40	10	6 x 40	30
A201305010627W	ZY2 5010.06		NK 24 N BA soft	50	6	6 x 40	30
A201305010627W	ZY2 5010.06		NK 24 N BA soft	50	10	6 x 40	30
A201305010627	ZY2 5010.06		NK 24 N BA soft	50	10	6 x 40	30
A201305010627	ZY2 5010.06		NK 24 P BA soft	50	10	6 x 40	30
A20110252627	KJ 2525.06		NK 24 N BA soft	25	25	6 x 40	30

 EX-0002 (40) 40 x 10 x 10  
 (1) (1) (1) (1) (1)


## NK BA mounted point assortment

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



★★★

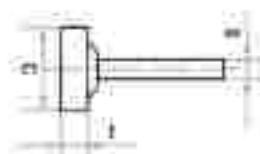
Product number	Description	Quality	Stock number size	Content 1 per pack	Part contents	
A20420004627W1	Assortment Box	NK BA	6	4 parts: ZY 1332.06 NK 24 N BA soft ZY 4006.06 NK 24 N BA soft	ZY 2040.06 NK 24 N BA soft KJ 2525.06 NK BK 24 N BA soft	1





## 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	Quantity	D mm	L mm	H mm	Peak condition
A20000101027	ZY 1020.06		NK 46 QU BA hard	10	20	6 x 40	20
A200001012627	ZY 1031.06		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
A200001020627	ZY 1120.06		NK 46 QU BA hard	13	20	6 x 40	20
A200001032627	ZY 1131.06		NK 46 QU BA hard	13	32	6 x 40	20
A200001061627	ZY 1620.06		NK 34 QU BA hard	16	20	6 x 40	20
A200001063627	ZY 1631.06		NK 34 QU BA hard	16	32	6 x 40	20
A200001040627	ZY 1640.06		NK 34 QU BA hard	16	40	6 x 40	20
A200001020627	ZY 2020.06		NK 24 QU BA hard	20	20	6 x 40	20
A200001032627	ZY 2031.06		NK 24 QU BA hard	20	32	6 x 40	20
A200001040627	ZY 2040.06		NK 24 QU BA hard	20	40	6 x 40	20
A200001040627	ZY 2040.06		NK 34 QU BA hard	20	40	6 x 40	20
A200002525627	ZY 2525.06		NK 24 QU BA hard	25	25	6 x 40	20
A200002532627	ZY 2531.06		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 3231.06		NK 24 QU BA hard	32	32	6 x 40	20
A200003250627	ZY 3250.06		NK 24 QU BA hard	32	50	6 x 40	20
A200004020627	ZY 4020.06		NK 24 QU BA hard	40	20	6 x 40	20
A200004030627	ZY 4030.06		NK 24 QU BA hard	40	30	6 x 40	20
A200004040627	ZY 4040.06		NK 24 QU BA hard	40	40	6 x 40	20
A200005013627	ZY 5013.06	NK 24 QU BA hard	50	13	6 x 40	20	
A200005020627	ZY 5020.06	NK 24 QU BA hard	50	20	6 x 40	20	
A200005020627	ZY 5020.06	NK 34 QU BA hard	50	20	6 x 40	20	
A200005025627	ZY 5025.06	NK 34 QU BA hard	50	25	6 x 40	20	
A201102510627	ZY 2510.06	NK 24 QU BA hard	25	10	6 x 40	20	
A201103200627	ZY 3200.06	NK 24 QU BA hard	32	8	6 x 40	20	
A201104010627	ZY 4010.06	NK 24 QU BA hard	40	10	6 x 40	20	
A201105004627	ZY 5004.06	NK 24 QU BA hard	50	4	6 x 40	20	
A201105006627	ZY 5006.06	NK 24 QU BA hard	50	6	6 x 40	20	
A201105010627	ZY 5010.06	NK 24 QU BA hard	50	10	6 x 40	20	
A201105010627	ZY 5010.06	NK 34 QU BA hard	50	10	6 x 40	20	
A6011060066270006	ZY 6006.06	NK 24 QU BA hard	60	6	6 x 40	20	
A201107510627	ZY 7510.06	NK 24 QU BA hard	75	10	6 x 40	20	

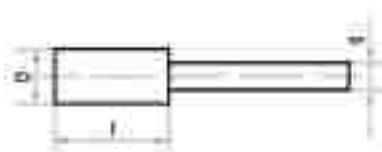


# REMOVE LARGE BURRS, SPRUES AND RISERS

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 economical working with maximum force

★★★

Part number	Description	Shape	Quality	D mm	L mm	W mm	Part quantity
A20001632423	ZY 1632.06		HK 30 NV13	16	32	6 x 40	20
A20002002633	ZY 2032.06		HK 30 NV13	20	32	6 x 40	20
A20002040623	ZY 2040.06		HK 30 NV13	20	40	6 x 40	20
A20002533633	ZY 2532.06		HK 30 NV13	25	32	6 x 40	20
A20004020623	ZY 4030.06		HK 30 NV13	40	30	6 x 40	20
A20004025633	ZY 4025.06		HK 2470 PV4	40	25	6 x 40	20
A20006010623	ZY3 6010.06		HK 30 NV13	60	10	6 x 40	20
A20003040623	XE 3050.06		HK 30 NV13	32	50	6 x 40	20

Standard Not available In stock



## ROUGH GRINDING THE ERGONOMIC WAY

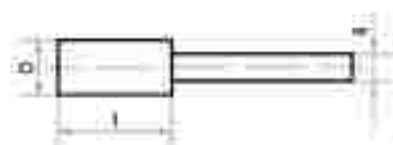
LUKAS MOUNTED POINTS FOR CAST MATERIAL RUN PARTICULARLY SMOOTHLY

EX-10012 (4x3) 40x10x10  
(11/16x3/8x3/8)



### 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	L mm	R mm	Peak condition
A200001020010	ZY 1020.00		MK 40 NV10	10	20	0 x 40	20
A200001032010	ZY 1032.00		ME 30 NV10	16	32	0 x 40	20
A200001040010	ZY 1040.00		MK 30 NV10	10	40	0 x 40	20
A200002020010	ZY 2020.00		ME 30 NV10	20	20	0 x 40	20
A200002032010	ZY 2032.00		MK 30 NV10	20	32	0 x 40	20
A200002040010	ZY 2040.00		MK 30 NV10	20	40	0 x 40	20
A200002532010	ZY 2532.00		ME 30 NV10	25	32	0 x 40	20
A200003220010	ZY 3220.00		MK 30 NV10	32	20	0 x 40	20
A200003232010	ZY 3232.00		MK 30 NV10	32	32	0 x 40	20
A200003240010	ZY 3240.00		MK 30 NV10	32	40	0 x 40	20
A200004020010	ZY 4020.00		ME 30 NV10	40	20	0 x 40	20
A200004040010	ZY 4040.00		MK 30 NV10	40	40	0 x 40	20
A200005025010	ZY 5025.00		MK 20 NV10	50	25	0 x 40	20
A20104010010	ZY2 4010.00			ME 30 NV10	40	10	0 x 40
A20101013010	KE 1030.00		MK 30 NV10	10	32	0 x 40	20
A20102020010	KE 2030.00		MK 30 NV10	20	32	0 x 40	20
A20102040010	KE 2040.00		MK 30 NV10	20	40	0 x 40	20

Recommended by



## QUALITIES AND PROPERTIES

# Mounted points for grinding plastic and rubber



**HOK**  
Spherical  
aluminum 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 bold odour and smearing.

### INDUSTRIES

- Rubber processing
- Plastic processing

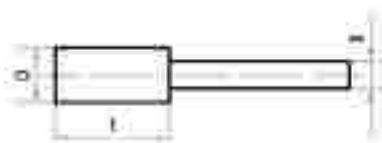
### PROCESSING EXAMPLES

- 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



★★★

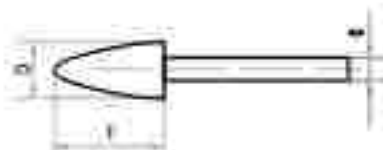
• specialist for machining rubber and plastic

Product number	Description	Shape	Quality	D mm	T mm	H mm	Flank condition
A20202025420	ZY 3025.06		HOK II-3VB	20	25	6 x 40	20
A20204420620	ZY 4025.06		HOK II-3VB	40	25	6 x 40	20
A20002525420	KU 2525.06		HOK II-3VB	25	25	6 x 40	20
A20003030620	KU 3030.06		HOK II-3VB	30	30	6 x 40	20

Recommended belt Plastic roller



## Mounted point American shape B



★★☆

Product number	Description	Shape	Quality	D mm	T mm	L mm	T mm	W mm	Pack. contents
A206801618302	841 1818.02		ERN 6090 CU V4	50	50	18	18	3 x 30	20
A20680162202	852 1818.02		ERN 40 CU V4	30	34	10	20	3 x 30	20
A206800814302	852 0814.02		ERN 6030 CU V4	5/16	50	8	16	3 x 30	20

841 1818.02  
 852 1818.02  
 852 0814.02

## Miniature mounted point



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

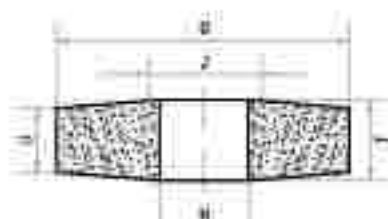
★★☆

Product number	Description	Shape	Quality	D mm	T mm	L mm	T mm	W mm	Pack. contents
A202900011202	01		ERN 100 N V4	8	2	3 x 30	20		
A202900011311	01		ERN 100 M V16	8	2	3 x 30	20		
A202900012302	02		ERN 60 N V4	8	3	3 x 30	20		
A202900012311	02		ERN 40 M V16	8	3	3 x 30	20		
A202900013302	03		ERN 100 N V4	8	2	3 x 30	20		
A202900013311	03		ERN 100 M V16	8	2	3 x 30	20		
A202900014302	04		ERN 100 N V4	4	1	3 x 30	20		
A202900015302	05		ERN 80 N V4	5	3	3 x 30	20		
A202900015311	05		ERN 80 M V16	5	3	3 x 30	20		
A202900016302	06		ERN 80 N V4	3/16	6	3 x 30	20		
A202900017302	07		ERN 100 N V4	25/8	2.5	3 x 30	20		
A202900018302	08		ERN 100 N V4	1.58	3	3 x 30	20		





## Taper-sided grinding wheel



• grinding wheel as per ISO 003-12  
m SI-4 shape

★★☆

Product number	Description	Grain	D mm	d mm	H mm	H1 mm	J mm	Flax (mm)
A203000200310001	SE4 08030.36	HK 24 M BA soft	80	20	16	16	25	10
A20300020030002	SE4 08030.36	HK 16 F BA hard	80	20	16	16	25	10
A20300020030003	SE4 08030.30	HK 24 M BA soft	80	20	16	20	25	10
A20300020030004	SE4 08030.30	HK 16 F BA hard	80	20	16	20	25	10

Recommended for: Steel material Iron/Steel



### SAFETY ADVICE

This tool must be used with a flange as per DIN 69034.

## Sharpening stones



RU 1 - 4 particularly suitable for:

- profiling
  - sharpening
  - dressing
- of bonded grinding and polishing tools

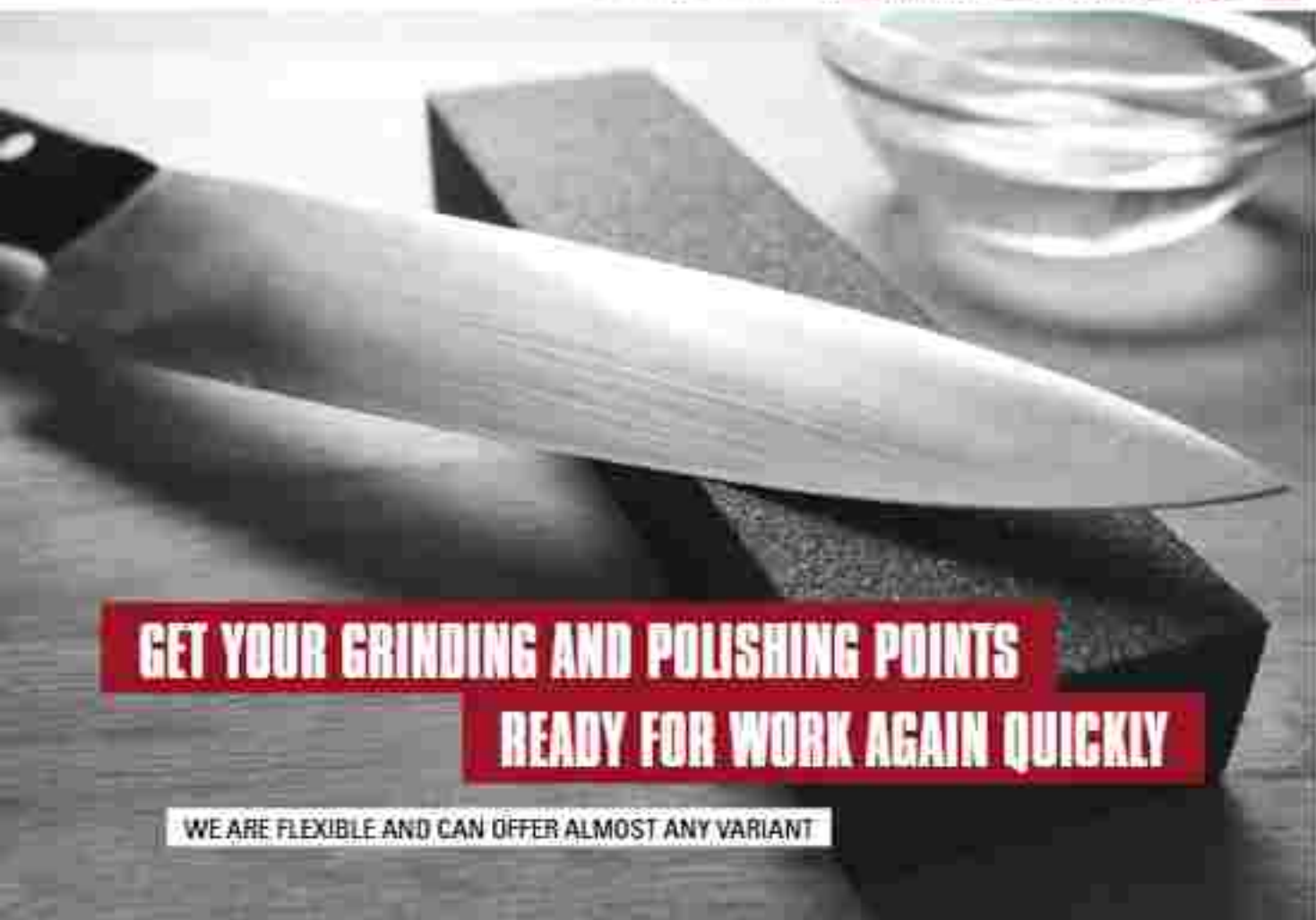
★★☆

Product number	Description	Grain	L mm	B mm	C mm	Flax (mm)
A204300000118	RU 1	SEGR 80 O V23/ green - fine	50	25	15	5
A204300000132	RU 1	SEGR 24 O V23/ dark - coarse	50	25	15	5
A204300000218	RU 2	SEGR 80 O V23/ green - fine	100	30	15	5
A204300000222	RU 2	SEGR 24 O V23/ dark - coarse	100	30	15	5
A204300000318	RU 3	SEGR 80 O V23/ green - fine	100	50	25	5
A204300000322	RU 3	SEGR 24 O V23/ dark - coarse	100	50	25	5
A204300000418	RU 4	SEGR 80 O V23/ green - fine	150	50	25	5
A204300000422	RU 4	SEGR 24 O V23/ dark - coarse	150	50	25	5

Recommended for: Steel material Iron/Steel

Product number	Description	L mm	B mm	C mm	Flax (mm)	
A204300000518	RU 5	EGW 100 E (B V40)	150	25	14.5	5
A204300000550	RU 8	EGW 100 E (B 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




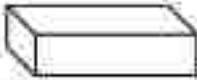
These sharpening stones feature an extremely sharp and rough abrasive grain, delivering perfect results in combination with a hard vitrified bond. This means you can get your grinding and polishing points back in working order in no time. The sharpening stone is ideal for profiling, sharpening, opening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

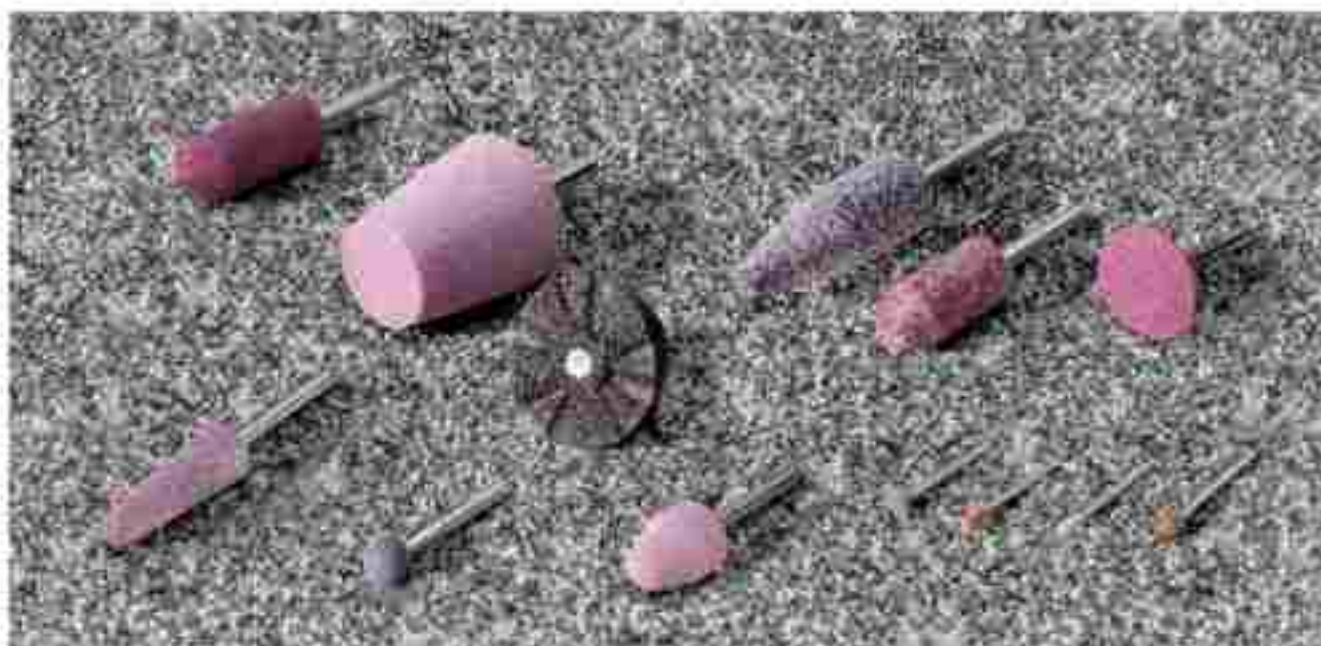
Here you can find various sharpening stone variants. Simply let us know which dimensions you need.

Shape	Length mm	Width mm	Height mm
	25	15	5-30
	44	25	18-30
	40	10	5-30
	50	25	18-35
	90	20	20-35
	100	30	18-35
	100	50	18-35
	120	10	5-35
	150	25	18-35
	150	30	18-35
	200	50	18-35
 rebound	250	10	20-35
	150	15	5-35



## CUSTOMIZED PRODUCTION

# Grinding wheels specially developed for your application

**TAILOR-MADE GRINDING WHEELS**

We can also provide you with customised grinding wheels:

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

**YOUR CUSTOM PRODUCTION REQUEST**

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

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



## 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.

Group	Properties
P1	Polishing points consist of a hard rubber bonding with size 300 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 to grit sizes 46 to 200. These tools are perfect for creating polished to dash-free mirror 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). Area 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, rubbing points, rolls for roller brushes, polishing wheels and grinding discs. The hardness of the polyurethane bonding (PU) can be divided into seven grades, from soft to hard, with abrasive grit sizes of SiC 24 to F1200. This makes the tools suitable for many different uses, including large 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 MWI 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			mm	mm
	hard	medium	soft		
Mirror finish	P6 Polyurethane	P4 Polyurethane	P3 Felt and paste	200	100
			P2 Soft rubber	100	
Soft gloss	P5 Rubber with fibre reinforcement	P4 Polyurethane	P3 Felt and paste	100	50
				P7 Soft elastomer	
Dark and light gloss	P1 Hard rubber	P5 Rubber with fibre reinforcement	P3 Felt and paste	50	25
				P2 Soft rubber	
Matting	P1 Hard rubber	P5 Rubber with fibre reinforcement	P3 Felt and paste	25	12
				P2 Soft rubber	
Polishing	P1 Hard rubber	P5 Rubber with fibre reinforcement	P3 Felt and paste	12	6
				P2 Soft rubber	

## TECHNICAL INFORMATION






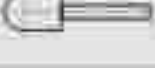
## Speeds for polishing tools

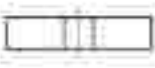


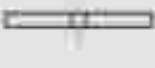


		Recommended cutting speed $v_c$ (m/min)										
		2	3	4	5	6	8	10	12	15	20	
Polishing group (normal)	Tool diameter (mm)	4	8,500	23,000	38,000	47,000	35,000	35,000	35,000	35,000	35,000	35,000
		6	6,000	15,000	25,000	31,000	50,000	63,000	79,000	101,000	158,000	158,000
Tool diameter (mm)	8	4,700	11,000	18,000	23,000	38,000	47,000	59,000	76,000	119,000	119,000	
	10	3,800	8,500	15,000	19,000	30,000	38,000	47,000	61,000	95,000	95,000	
	12	2,700	5,900	9,500	11,900	19,000	23,000	29,000	38,000	59,000	59,000	
	15	1,900	4,700	7,600	9,500	15,000	19,000	23,000	30,000	47,000	47,000	
	20	1,500	3,800	6,000	7,600	12,000	15,000	19,000	24,000	38,000	38,000	
	25	1,100	2,800	4,700	5,900	9,000	11,000	14,000	18,000	28,000	28,000	
	30	900	2,300	3,800	4,700	7,600	9,500	11,500	15,000	23,000	23,000	
	35	700	1,900	3,000	3,800	6,000	7,600	9,500	12,000	19,000	19,000	
	40	500	1,200	2,000	2,500	4,000	5,000	6,300	8,100	12,200	12,200	
	50	300	900	1,500	1,900	3,000	3,800	4,700	6,000	9,500	9,500	
	75	200	600	1,000	1,200	2,000	2,500	3,100	4,000	6,300	6,300	
	100	100	400	700	900	1,500	1,900	2,300	3,000	4,700	4,700	
	150	100	300	600	700	1,200	1,500	1,900	2,400	3,800	3,800	

**⚠** 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 to following grinding groups
	P1, P2, P3, P5, P6
	P1, P2
	P1, P2, P3
	P2, P3, P5, P6
	P2, P3, P5
	P1, P2

Shape	Available to following grinding groups
	P2, P6
	P6
	P4
	P3
	P7
	P6

## POLISHING GROUP P1

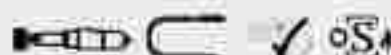
## Hard-rubber polishing points



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 clog and have a long and efficient tool life when used with moderate pressure.

## P1 polishing point



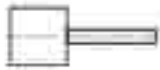




- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel
- manufactured as per DIN 62170

★★

Product number	Description	Shape	D mm	L mm	D <sub>2</sub> mm	L <sub>2</sub> mm	Pack quantity
A260004083	P12Y 040L03		4	8	3	30	20
A260005181	P12Y 051L03		5	10	3	30	20
A260006181	P12Y 061L03		6	10	3	30	20
A260007181	P12Y 071L03		7	10	3	30	20
A260008181	P12Y 081L03		8	10	3	30	20
A260009182	P12Y 091L06		8	16	6	40	10
A260100216	P12Y 082L06		8	20	6	40	10
A260001081	P12Y 101L03		10	10	3	30	20
A260001123	P12Y 101L03		10	13	3	30	20
A260001182	P12Y 101L03		10	18	3	30	20
A260010206	P12Y 102L06		10	20	6	40	10
A260001313	P12Y 131L03		13	13	3	30	20
A260001313	P12Y 131L03		13	18	3	30	20
A260010206	P12Y 132L06		13	20	6	40	10

200000416 200000416 200000416 200000416



Product number	Description	Shape	D mm	T mm	S mm	L <sub>1</sub> mm	Post condition
A2600161E3	P1ZY 161M.03		16	16	3	30	20
A2600162E3	P1ZY 162M.06		16	20	3	40	10
A2600163E3	P1ZY 163E.06		16	32	3	40	10
A2600202E3	P1ZY 202M.06		20	20	3	40	10
A2600203E3	P1ZY 203E.06		20	32	3	40	10
A2600462E3	P1ZY 462M.06		46	20	3	40	10
A2601130E3	P1ZY 130E.03		13	3	3	36	20
A2601140E3	P1ZY 140E.03		16	3	3	30	20
A2601200E3	P1ZY 200E.03		20	3	3	30	20
A2601310E3	P1ZY 310E.06		32	10	3	40	10
A2601632E3	P1KS 163E.06		16	32	3	40	10
A260200E3	P1KU 000E.03		8	8	3	30	20
A260210E3	P1KU 101E.06		16	16	3	30	10
A260212E3	P1KS 203E.06		20	32	3	40	10

EX-0012 (A260163E3)



### P1 polishing points assortment

- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel
- manufactured as per DIN 6170
- ready for any polishing challenge
- 54 different shapes for fast tool changes



★★★

Product number	Description	Content 1 per pack					Post condition
A260014	Assortment 114	14 parts: P1ZY 040E.03 P1ZY 101E.03 P1ZY 131E.03	P1ZY 051E.03 P1ZY 101E.03 P1ZY 164E.03	P1ZY 061E.02 P1ZY 101E.03 P1ZY 161E.03	P1ZY 071E.03 P1ZY 130E.03 P1ZY 200E.03	P1ZY 081E.03 P1ZY 131E.03	1





Product number	Description	Shape	Ø mm	D mm	T mm	B mm	L mm	Part code
A261001329088	P2ZY 1320.06		80	13	20	6	40	10
A261001329110	P2ZY 1320.06		120	13	20	6	40	10
A261001329130	P2ZY 1320.06		220	13	20	6	40	10
A261001329150	P2ZY 1320.06		290	13	20	6	40	10
A261001616120	P2ZY 1616.03		130	16	18	3	40	20
A261001620080	P2ZY 1620.06		80	16	20	6	40	10
A261001620120	P2ZY 1620.06		120	16	20	6	40	10
A261001620200	P2ZY 1620.06		220	16	20	6	40	10
A261001620280	P2ZY 1620.06		380	16	20	6	40	10
A261001620400	P2ZY 1620.06		400	16	20	6	40	10
A261001620600	P2ZY 1620.06		600	16	20	6	40	10
A261001633080	P2ZY 1633.06		80	16	32	6	40	10
A261001633110	P2ZY 1633.06		120	16	32	6	40	10
A261001633200	P2ZY 1633.06		220	16	32	6	40	10
A261002020040	P2ZY 2020.06		40	20	20	6	40	10
A261002020080	P2ZY 2020.06		80	20	20	6	40	10
A261002020110	P2ZY 2020.06		120	20	20	6	40	10
A261002020210	P2ZY 2020.06		220	20	20	6	40	10
A261002020280	P2ZY 2020.06		380	20	20	6	40	10
A261002032110	P2ZY 2032.06		120	20	32	6	40	10
A261002032200	P2ZY 2032.06		220	20	32	6	40	10
A261002032280	P2ZY 2032.06		380	20	32	6	40	10
A261003220110	P2ZY 3220.06		120	32	20	6	40	10
A261003232110	P2ZY 3232.06		120	32	32	6	40	10
A261003232200	P2ZY 3232.06	280	32	32	6	40	10	
A261004020110	P2ZY 4020.06	120	40	20	6	40	10	
A261001329170	P2SP 1320.06		120	13	20	6	40	10
A261002020210	P2SP 2020.06		220	20	32	6	40	10
A261500801120	P2KU 0806.01		120	8	8	3	30	20
A261500803400	P2KU 0806.01		400	8	8	3	30	20
A261500803600	P2KU 0806.01		600	8	8	3	30	20
A261501010120	P2KU 1010.01		120	10	10	3	30	20
A261501160120	P2KU 1016.06		120	16	10	6	40	10
A261501160200	P2KU 1016.06		220	16	10	6	40	10
A2617025100120	P2ZY 2510.06		120	25	10	6	40	10
A2617032100110	P2ZY 3210.06		120	32	10	6	40	10
A2617032100210	P2ZY 3210.06		220	32	10	6	40	10
A2617040100120	P2ZY 4010.06		120	40	10	6	40	10
A2618016330120	P2WH 1632.06		120	16	32	6	40	10
A261801020080	P2KE 0020.06		80	10	20	6	40	10
A261801020120	P2KE 1020.06		120	10	20	6	40	10



## POLISHING GROUP P3

**Excellent results all the way to a mirror finish**

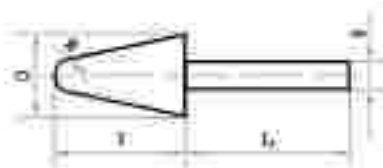
LUKAS felt polishing points are available in two qualities:

- 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 6 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 press and injection moulds, drawing, press and cutting tools, dies, bearings, spindles, rolls, gauges, etc.

## P3 polishing point



- perfect for polishing highly complex shapes
- manufactured in per DIN 6970

★★☆

Product Number	Description	Shape	Quality	D mm	T mm	L <sub>1</sub> mm	L <sub>2</sub> mm	H mm	Part quantity	
A3700008103	P32Y 0810.03		H3	8	10	3	40	—	20	
A3700008103	P32Y 0810.03		H3	8	10	3	40	—	20	
A3700010123	P32Y 1012.03		H3	10	12	3	38	—	20	
A3700010158	P32Y 1015.08		H3	10	15	6	30	—	10	
A3700012153	P32Y 1215.03		H3	12	15	3	40	—	20	
A3700012208	P32Y 1220.08		H3	12	20	6	40	—	10	
A3700016208	P32Y 1620.08		H3	16	20	6	40	—	10	
A3700020258	P32Y 2025.08		H3	20	25	6	30	—	10	
A3700025308	P32Y 2530.08		H3	25	30	6	40	—	10	
A3700030408	P32Y 3040.08		H3	30	40	6	40	—	10	
A3701006103	P3SP 0610.03		H3	6	10	3	40	—	20	
A3701006103	P3SP 0610.03		H3	6	10	3	40	—	20	
A3701006123	P3SP 1012.03		H3	10	12	3	40	—	20	
A3701006158	P3SP 1015.08		H3	10	15	6	40	—	10	
A3701012208	P3SP 1220.08		H3	12	20	6	40	—	10	
A3701020258	P3SP 2025.08		H3	20	25	6	40	—	10	
A3701025308	P3SP 2530.08		H3	25	30	6	40	—	10	
A3701030408	P3SP 3040.08		H3	30	40	6	40	—	10	
A370300603	P3KJ 0603.03			H3	6	5.5	3	38.5	—	20
A370300603	P3KJ 0603.03			H3	6	5.5	3	38.5	—	20
A370301003	P3KJ 1003.03	H3		10	6	3	41	—	20	
A370301038	P3KJ 1008.08	H3		10	6	6	41	—	10	
A370301238	P3KJ 1218.08	H3		12	11	6	38	—	10	
A370302038	P3KJ 2018.08	H3		20	16	6	41	—	10	
A3705010123	P3KE 1012.03		H3	10	12	3	38	2.5	20	
A3705010158	P3KE 1015.08		H3	10	15	6	40	2.5	10	
A3705020258	P3KE 2025.08		H3	20	25	6	40	3.5	10	
A3705025308	P3KE 2530.08		H3	25	30	6	40	4.5	10	
A3705030408	P3KE 3040.08		H3	30	40	6	40	5.5	10	
A37000061000001	P32Y 0610.01			H3-S	6	10	3	40	—	20
A37000081000001	P32Y 0810.01	H3-S		8	10	3	40	—	20	
A37000101200001	P32Y 1012.01	H3-S		10	12	3	38	—	20	
A37000101500001	P32Y 1015.01	H3-S		10	15	6	40	—	10	
A37000121500001	P32Y 1215.01	H3-S		12	15	3	40	—	20	
A37000122000001	P32Y 1220.01	H3-S		12	20	6	40	—	10	
A37000162000001	P32Y 1620.01	H3-S		16	20	6	40	—	10	
A37000202500001	P32Y 2025.01	H3-S		20	25	6	40	—	10	

## Felt polishing wheel, shape S1



★★☆

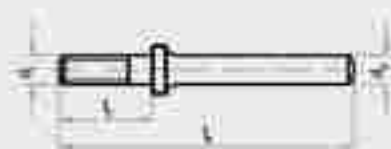
Product number	Description	Quality	D mm	L mm	H mm	Part quantity
A375004050	P3S1 40H.06	M2	40	10	6	10
A375005050	P3S1 50H.06	M2	50	10	6	10
A375006050	P3S1 60H.06	M2	60	20	6	10
A375007550	P3S1 75H.06	M2	75	10	6	10
A375008050	P3S1 80H.06	M2	80	20	6	10

Recommended use: Resin Wheel Steel Cast iron/Al Stainless Aluminum

EX-10012 (40) 40x10x6 (10) (10x10x10)



## Arbors for felt polishing wheels



Delivery includes the following for each arbor:

- two washers, Ø 10 mm
- two washers, Ø 30 mm
- and one hex nut.

★★☆

Product number	Description	R mm	L mm	Q mm	L mm	D <sub>max</sub> mm	Part quantity
A1630780	ASB 780	M6	20	6	62	2000	5
A1630791	ASB 791	M6	30	6	75	2000	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, brass, brass and copper

★★★

Product number	Description	Quality	Grain size	Grain size (µm)	Content (g)	Part number
A3760120	SP-1	medium	SiC 120	88-126	350	1
A3760180	SP-2	fine	SiC 180	35-88	350	1
A3760320	SP-3	very fine	SiC 320	20-40	350	1

## 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 (µm)	Colour	Content (g)	Part number
A341012010	EP-001	Super-EP	1	blue	10	1
A341012010	EP-002	Super-EP	3	green	10	1
A341012010	EP-003	Super-EP	6	yellow	10	1
A3410120410	EP-004	Super-EP	9	red	10	1
A3410120510	EP-005	Super-EP	15	light brown	10	1



## 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

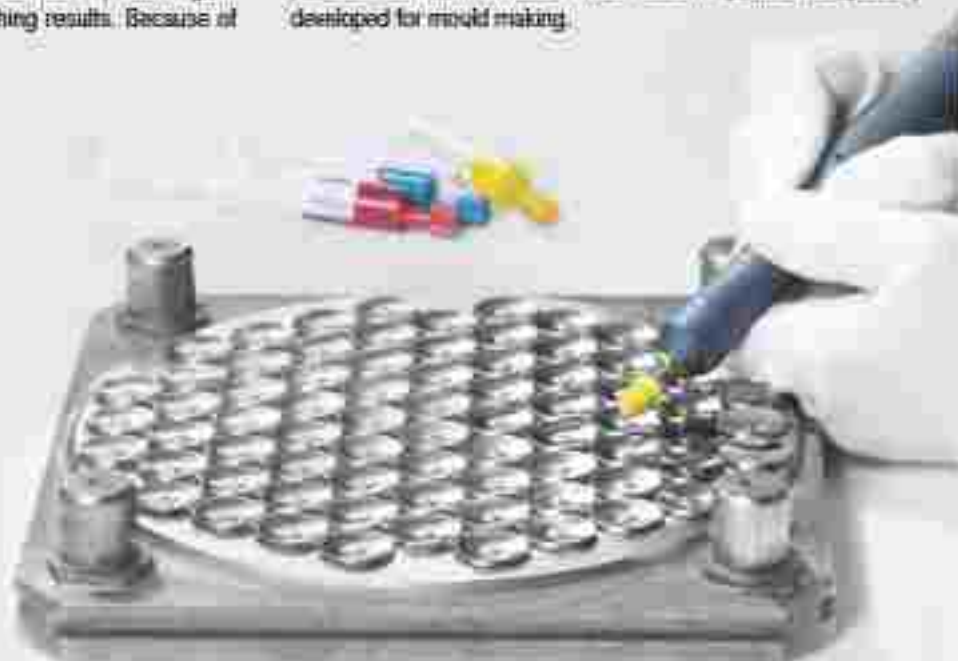
its agglomerate-free production and high viscosity – which can be gradually diluted with water, oil or alcohol – our diamond paste is also ideal for use in machines. The paste was specially developed for mould making.

#### 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



EX-00010-001-001-001-001

### Monocrystalline diamond pastes



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



Product number	Description	Quality	Grain size in µm	Colour	Content g	Pack contents
A341010105	E-001	Super-E	1	blue	5	1
A341010110	E-001	Super-E	1	blue	10	1
A341010200	E-002	Super-E	2	green	5	1
A341010210	E-002	Super-E	2	green	10	1
A341010305	E-003	Super-E	3	yellow	5	1
A341010310	E-003	Super-E	3	yellow	10	1
A341010405	E-004	Super-E	4	red	5	1
A341010410	E-004	Super-E	4	red	10	1
A341010505	E-005	Super-E	15	light brown	5	1
A341010510	E-005	Super-E	15	light brown	10	1

Recommended for:  Bench tool  Hand  Car mounted  Drives

## 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-raking.

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

## STEP 1

Select the required shape and size (see product tables)

## STEP 2

Choose the required 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
orange	EKW 80 soft
dark orange	EKW 80 hard
pale red	EKW 150 soft
red	EKW 150 hard
light brown	EKW 240 soft
brown	EKW 240 hard

## Polishing sticks, flat



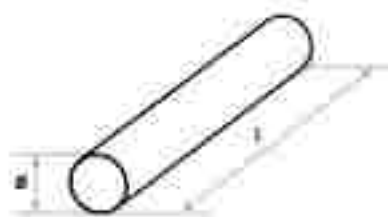
★★○

- perfect for manual polishing
- further sizes available on request

Description	H mm	B mm	L mm	Part number
PA5F 0612.070	6	12	70	18
PA5F 0612.140	6	12	140	10
PA5F 0618.070	6	18	70	18
PA5F 0618.140	6	18	140	10
PA5F 0618.210	6	18	210	18
PA5F 1020.070	10	20	70	18
PA5F 1020.140	10	20	140	10
PA5F 1020.210	10	20	210	18
PA5F 1020.280	10	20	280	18



## Polishing sticks, round



- perfect for manual polishing
- further sizes available on request

★★☆

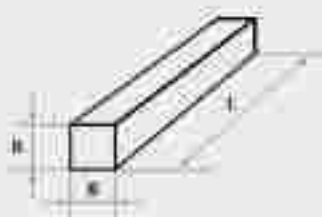
Description	Diameter size	L mm	Pack contents
P4GR 0006.070	6	70	10
P4GR 0006.140	6	140	10
P4GR 0010.070	10	70	10
P4GR 0010.140	10	140	10
P4GR 0010.210	10	210	10
P4GR 0012.070	12	70	10
P4GR 0012.140	12	140	10
P4GR 0012.210	12	210	10
P4GR 0012.280	12	280	10
P4GR 0015.070	15	70	10
P4GR 0015.140	15	140	10
P4GR 0015.210	15	210	10
P4GR 0015.280	15	280	10

Recommended use: Insulated Dried Care needed Destructive Abrasive

EX-10002 (4x2) (4x2) (4x2) (4x2)



## Polishing sticks, square



- perfect for manual polishing
- further sizes available on request

★★☆

Description	H mm	B mm	L mm	Pack contents
P4SV 0004.070	4	4	70	10
P4SV 0004.140	4	4	140	10
P4SV 0010.070	10	10	70	10
P4SV 0010.140	10	10	140	10
P4SV 0010.210	10	10	210	10
P4SV 0012.140	12	12	140	10
P4SV 0012.210	12	12	210	10
P4SV 0015.070	15	15	70	10
P4SV 0015.140	15	15	140	10
P4SV 0015.210	15	15	210	10
P4SV 0015.280	15	15	280	10

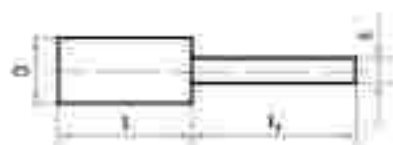
Recommended use: Insulated Dried Care needed Destructive Abrasive






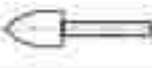



## P5 polishing points



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

★★★

Product reference	Designation	Shape	Ø (mm)	Ø (mm)	Y (mm)	Ø (mm)	Y (mm)	Pick (mm)
A36200400390	PSZY 0400.03		80	4	8	3	30	20
A36200400720	PSZY 0400.03		120	4	8	3	30	20
A36200510300	PSZY 0510.03		80	5	10	3	30	20
A36200510710	PSZY 0510.03		120	5	10	3	30	20
A36200610300	PSZY 0610.03		80	6	10	3	30	20
A36200610710	PSZY 0610.03		120	6	10	3	30	20
A36200810300	PSZY 0810.03		80	8	10	3	30	20
A36200810710	PSZY 0810.03		120	8	10	3	30	20
A36200816040	PSZY 0816.06		40	8	16	6	30	10
A36200816080	PSZY 0816.06		60	8	16	6	30	10
A36200816120	PSZY 0816.06		120	8	16	6	40	10
A36200100300	PSZY 1010.03		80	10	10	3	30	20
A36200100710	PSZY 1010.03		120	10	10	3	30	20
A36200102000	PSZY 1020.06		40	10	20	6	40	10
A36200102080	PSZY 1020.06		60	10	20	6	40	10
A362001020120	PSZY 1020.06		120	10	20	6	40	10
A36200113310	PSZY 1313.03		120	13	13	3	30	20
A36200131600	PSZY 1316.03		80	13	16	3	30	20
A36200132000	PSZY 1320.06	40	13	20	6	40	10	
A362001320120	PSZY 1320.06	120	13	20	6	40	10	
A36200162000	PSZY 1620.06	40	16	20	6	40	10	
A362001620120	PSZY 1620.06	120	16	20	6	40	10	
A362001832040	PSZY 1832.06	40	18	32	6	40	10	
A362001832080	PSZY 1832.06	60	18	32	6	40	10	
A362003232080	PSZY 3232.06	80	32	32	6	40	10	
A367001032600	PSPP 2032.06		80	20	32	6	40	10
A362100000390	PSKV 0000.03		80	8	8	3	30	20

EX-0001640-PS-0001 (01/10/2016)

## 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.



## 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.

## PG CG polishing points



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

★★★

Product number	Description	Quantity per tin	Type/finish result	D mm	L mm	H mm	$K_{\text{max}}$ grit	Part number
A29300130003E39	PEZY 1320.00	EKW 60 SHF CG	extra coarse	13	30	3	112500	10
A29300130004E38	PEZY 1320.20	EKW 120 SHF CG	coarse	13	30	3	112500	10
A29300160004E38	PEZY 1620.00	EKW 60 SHF CG	extra coarse	16	30	6	30,400	10
A48300160004E38	PEZY 1620.00	EKW 120 SHF CG	coarse	16	30	6	30,400	10
A48300200206E38	PEZY 2020.00	EKW 60 SHF CG	extra coarse	20	30	6	75,300	10
A29300200004E38	PEZY 2020.00	EKW 120 SHF CG	coarse	20	30	6	75,300	10
A29300300300E38	PEZY 3030.00	EKW 60 SHF CG	extra coarse	30	30	6	50,000	10
A48300300300E38	PEZY 3030.00	EKW 120 SHF CG	coarse	30	30	6	50,000	10







## 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 tool 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.





## PGPT 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	V mm	V <sub>1</sub> mm	Contacts per pack	Pack contents
A6700023	PGPT 125 (flat) SET		PGPT	125	22.23	4.800	2.700	P150, 340, 400, 800	1
A6700024	PGPT 125 (shaped) SET		PGPT	125	22.23	4.800	2.700	P150, 340, 400, 800	1

EX-100116-01 (1/1/2019)



## PGPT polishing discs

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



★★★

Product number	Description	Shape	Quality	Type	D mm	H mm	V mm	V <sub>1</sub> mm	Pack contents
A671612515014	PGPT 125 (flat)		SIC 150 MP	medium	125	22.23	4.800	2.700	5
A6716125150400	PGPT 125 (flat)		SIC 150 MW	medium	125	22.23	4.800	2.700	5
A6716125124014	PGPT 125 (flat)		SIC 240 MW	fine	125	22.23	4.800	2.700	5
A671612540014	PGPT 125 (flat)		SIC 400 WP	very fine	125	22.23	4.800	2.700	5
A671612580014	PGPT 125 (flat)		SIC 800 WP	ultra-fine	125	22.23	4.800	2.700	5
A671712515014	PGPT 125 (shaped)		SIC 150 MP	medium	125	22.23	4.800	2.700	5
A6717125124014	PGPT 125 (shaped)		SIC 240 MW	fine	125	22.23	4.800	2.700	5
A671712540014	PGPT 125 (shaped)		SIC 400 WP	very fine	125	22.23	4.800	2.700	5
A671712580014	PGPT 125 (shaped)		SIC 800 WP	ultra-fine	125	22.23	4.800	2.700	5
A6717125130014	PGPT 125 (shaped)		SIC 1300 WP	ultra-fine	125	22.23	4.800	2.700	5









## Polishing wheel, shape SE1



These polishing wheels are available from stock with a soft to very hard bonding in grit sizes 40 to 400. Further qualities in grit sizes 0 to 1,200 are available as special tools.

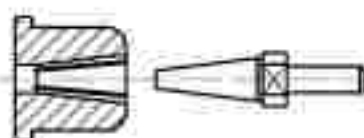
Product number	Description	Quantity per box	D (mm)	T (mm)	B (mm)	v <sub>max</sub> (m/s)	Peak condition
A2910000000041	PESE1 0602E B.06	SIC 48 MWP	60	6	6	4,300	1
A2910000000061	PESE1 0602E B.06	SIC 150 MWP	60	6	6	4,300	1
A2910100000041	PESE1 10010 B.25	SIC 30 MWP	100	10	25	3,800	1
A2910100000021	PESE1 10010 B.25	SIC 40 MWP	100	20	25	3,800	1
A2910100000041	PESE1 10010 B.25	SIC 48 MWP	100	20	25	3,800	1
A29101000200091	PESE1 10020 B.25	SIC 150 MWP	100	20	25	3,400	1
A29101000200091	PESE1 10020 B.25	SIC 400 MWP	100	20	25	3,400	1
A29101250100041	PESE1 12510 B.25	SIC 48 MWP	125	10	25	3,000	1
A29101250100061	PESE1 12510 B.25	SIC 150 MWP	125	10	25	3,000	1
A29101250200041	PESE1 12520 B.25	SIC 60 MWP	125	20	25	2,800	1
A29101250200021	PESE1 12520 B.25	SIC 150 MWP	125	20	25	2,800	1
A2910150100001	PESE1 15010 B.25	SIC 150 MWP	150	10	25	2,500	1
A2910150100069	PESE1 15010 B.25	SIC 300 GHP	150	10	25	4,000	1
A2910150100009	PESE1 15015 B.20	SIC 120 GHP	150	15	20	4,000	1
A29101500200040	PESE1 15020 B.25	SIC 60 WP	150	20	25	2,800	1
A29101500200041	PESE1 15020 B.25	SIC 88 MWP	150	20	25	2,500	1
A29101500200081	PESE1 15020 B.25	SIC 150 MWP	150	20	25	2,500	1
A29101500250021	PESE1 15025 B.20	SIC 46 MWP	150	25	20	2,500	1
A29101500250040	PESE1 15025 B.25	SIC 80 WP	150	25	25	2,000	1
A29101500250021	PESE1 15025 B.25	SIC 100 MWP	150	25	25	2,500	1
A29101500250014	PESE1 15025 B.20	SIC 240 MP	150	25	20	3,100	1
A29102000250041	PESE1 20025 B.25	SIC 30 MWP	200	25	25	1,800	1
A29102000250061	PESE1 20025 B.25	SIC 100 MWP	200	25	25	1,800	1

EX-10001402-000-0001 (1/1/2019/0001)



## Mounting system for polishing wheels

The mounting system for D11 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.



Product number	Description	Content	Peak condition
A681088001	Mounting system MCA x K25	Plastic sleeve (MCA) and mounting mandrel with 1 mm slant (K25)	1

## MARBLING MADE EASY

CONSISTENTLY HIGH PERFORMANCE FROM START TO FINISH

## Marbling point

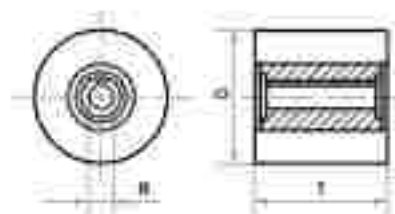


- cylindrical marbling point
- LUKAS marbling points let you marble non-tasting steels, aluminium and non-ferrous metal (quartz, opal, crystal). The marbling points do not clog with abrasive dust and their abrasive capability is retained all the way to the plastic cap.

★★☆

Product number	Description	Quantity/kit size	D mm	T mm	H mm	L <sub>1</sub> mm	Flow (gpm)	Part number
A25000300300021	PERMA ZY 2030.00	SIC 40 MWP	20	30	6	35	3,500	1
A25000300300021	PERMA ZY 3030.00	SIC 40 MWP	30	30	6	35	6,500	1
A25000400300046	PERMA ZY 4030.00	SIC 40 MWP	40	30	6	35	4,700	1
A25000500300046	PERMA ZY 5030.00	SIC 40 MWP	50	30	6	35	3,800	1
A25000600300034	PERMA ZY 6030.00	SIC 60 MP	50	30	6	35	3,800	1
A25000800300046	PERMA ZY 8030.00	SIC 40 MWP	60	30	6	35	3,100	1

## PGPW polishing roll



- PGPW 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	Quantity/kit size	D mm	T mm	H mm	Flow (gpm)	Part number
A29400001000041	PGPW 10000	SIC 60 MWP	100	50	18	3,000	1
A29400001000011	PGPW 100100	SIC 34 MWP	100	100	18	3,000	1
A29400001000020	PGPW 100200	SIC 40 WP	100	100	18	3,000	1
A29400001000021	PGPW 100300	SIC 40 MWP	100	100	18	3,000	1
A29400001000040	PGPW 100300	SIC 80 WP	100	100	18	3,000	1
A29400001000041	PGPW 100300	SIC 80 MWP	100	100	18	3,000	1

## 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.

EX-10001403-001-001 (10/10/2016)



## Polishing wheel and lens made from soft elastomer



★★★

Product number	Description	Quality	Shape	D mm	T mm	H mm	Pack contents
A295000010007	P7-122	SGCR 240		22	35	1.8	100
A29500005047	P7-123	SGCR 240		22	3.4	1.8	100

Recommended for:  Steel  Tool  Aluminium  Cast metal  Titanium



## Assortment of small soft elastomer polishing points



- The small polishing points have a shank diameter of 2.25 mm.

★★★

Product number	Description	Quality	Content	Shank mm	Pack contents
A295110150207	PPSml 130-15	SGCR 240	12 parts	2.25	1
A295120150207	PPSol 130-15	SGCR 400	12 parts	2.25	1

Recommended for:  Steel  Tool  Aluminium  Cast metal  Titanium







## 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

ISO	FEPA	FEPA size (µm)	US Standard Mesh
0 46	0 46	38-45	325/400
0 54	0 54	45-53	270/325
0 64	0 64	53-63	230/270
0 75	0 75	63-75	200/230
0 91	0 91	75-90	170/200
0 107	0 107	90-106	140/170
0 126	0 126	106-125	120/140
0 151	0 151	125-150	100/120
0 181	0 181	150-180	80/100
0 212	0 212	180-212	70/80
0 251	0 251	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 LIJKAS 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



★★

Product number	Description	Shape	Grain size	D mm	T mm	E mm	L mm	Flank condition	
A3403350128	DS 01003		Ø 128	1	2	3	40	1	
A3403351128	DS 01504		Ø 128	1.5	3	3	40	1	
A3403352128	DS 02005		Ø 128	2	5	3	40	1	
A3403353128	DS 02506		Ø 128	2.5	5	3	40	1	
A3403354128	DS 03006		Ø 128	3	5	3	40	1	
A340335512801	DS 03506		Ø 128	3.5	5	3	40	1	
A3403356128	DS 04006		Ø 128	4	5	3	40	1	
A340335712801	DS 04506		Ø 128	4.5	5	3	40	1	
A3403358128	DS 05006		Ø 128	5	8	3	40	1	
A3403359128	DS 06007		Ø 128	6	7	3	40	1	
A3403360128	DS 08010		Ø 128	8	10	6	30	1	
A3403361128	DS 10010		Ø 128	10	10	6	30	1	
A3403362128	DS 12015		Ø 128	12	15	8	30	1	
A3403380128	DSK 01020			Ø 128	2	-	3	40	1
A3403381128	DSK 02020			Ø 128	3	-	3	40	1
A3403382128	DSK 04040	Ø 128		4	-	3	40	1	
A3403383128	DSK 06060	Ø 128		6	-	3	40	1	
A3403384128	DSK 08080	Ø 128		8	-	3	40	1	
A3403385128	DSK 08080	Ø 128		8	-	6	30	1	

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





★★

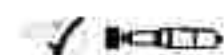
• Cylindrical diamond mounted point

Product number	Description	Grain size	D mm	T mm	E mm	L mm	Flank condition
A340202305128	DSH 02103	Ø 128	2.3	3	2	75	1
A340202307128	DSH 02304	Ø 128	2.5	4	2	75	1
A340204305128	DSH 04305	Ø 128	4.3	5	4	75	1
A340206307128	DSH 06307	Ø 128	6.3	7	6	75	1
A340208310128	DSH 08310	Ø 128	8.3	10	8	75	1
A340210310128	DSH 10310	Ø 128	10.3	10	10	75	1


**CBN mounted point, electro-plated**


★★☆

Product number	Description	Shape	Dimension	D mm	L mm	d mm	L <sub>1</sub> mm	Part catalogue	
A34023090126	CG 0100E		Ø 126	1	3	3	40	1	
A34023091126	CS 0110E		Ø 126	1.5	3	3	40	1	
A34023092126	CG 0200E		Ø 126	2	3	3	40	1	
A34023093126	CS 0250E		Ø 126	2.5	3	3	40	1	
A34023094126	CG 0300E		Ø 126	3	3	3	40	1	
A3402309412001	CS 0350E		Ø 126	3.5	3	3	40	1	
A34023095126	CS 0400E		Ø 126	4	3	3	40	1	
A3402309512001	CS 0450E		Ø 126	4.5	3	3	40	1	
A34023096126	CS 0500E		Ø 126	5	3	3	40	1	
A34023097126	CS 0600E		Ø 126	6	7	3	40	1	
A34023098126	CS 0800E		Ø 126	8	10	3	50	1	
A34023099126	CS 1000E		Ø 126	10	10	3	60	1	
A34023090126	CS 1200E		Ø 126	12	10	3	60	1	
A34023090526	CGE 020			Ø 126	3	—	3	40	1
A34023091126	CGE 030			Ø 126	3	—	3	40	1
A34023091126	CGE 040			Ø 126	4	—	3	40	1
A34023091126	CGE 050	Ø 126		5	—	3	40	1	
A34023094126	CGE 060	Ø 126		6	—	3	40	1	
A34023095126	CGE 080	Ø 126		8	—	3	50	1	

EX-10012 (40) 400 40001  
(1) (1) (1) (1) (1)
**Diamond file for manual filing machines, electro-plated**


★★☆

Product number	Description	Shape	Shape	Color size	Cross section mm	L <sub>1</sub> mm	L <sub>2</sub> mm	Part catalogue
A34002122126	DF 3122		flat	D 126	4 x 1	15	50	1
A34002130126	DF 3130		round	D 126	4	15	50	1







# GRINDING AND POLISHING

(with flexible tools)

MANUFACTURING  
MATERIALS

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	216–236
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 fleeces. 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 (AK), 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 FEM 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.**






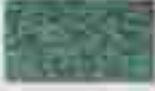

Do not apply too much pressure when using LUKAS grinding tools: excessive pressure does not improve the performance, and will instead result in premature wear. Even if the chip removal is unsatisfactory, you do not apply more pressure. Use a coarser grain instead to prevent unnecessary tool wear and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

Color	Properties	Application areas/ material	Available as	Page
	<b>RR</b> Abrasive cloth Regular aluminum oxide	very tough abrasive, high resistance	forged steel, malleable steel, grey cast iron, carbon steel, ductile iron, steel castings, steel hand, zinc die castings, non-ferrous metals, wood	Lamellar flap discs 94 95 Mounted flap wheels 165-170 172-174 192-193 Flap wheels Flap mills 90 Abrasive bands 188-189 201-204 207/208 Abrasive rolls Abrasive sleeves 205 Abrasive discs 228 229 Fibre discs 231-233 236-239
	<b>RRS</b> Abrasive cloth Regular aluminum oxide with active abrasive surface layer	very tough abrasive, high resistance	chrome-nickel and other non-rusting steels, duplex steels, titanium and titanium alloys, heat-resistant steel	Mounted flap wheels Abrasive discs 110 201
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resistant 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, 146 151-152 154-155 157/158 206 Abrasive bands 197 Abrasive discs 218, 224 227
	<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 198 219
	<b>ZRS</b> Abrasive cloth Zirconia alumina with active abrasive surface layer	with M-backing 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 138-152 140
	<b>MRS</b> Abrasive cloth Regular aluminum oxide with active abrasive surface layer	excellent removal rate with long tool life	ceramic and heat-resistant steels, plastics, aluminium and non-ferrous metals	Abrasive cups 212/213
	<b>BC</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 Mounted flap wheels Abrasive discs 147 171 223, 224

Color	Properties	Application and/or material	Available in	Page
	<b>Ceramic</b> Abrasive cloth Ceramic grain	excellent removal rate without grain embedding, particularly stable thanks to reinforced backing, cool cutting	non-rusting steels, nickel alloys	Lamellar flap discs Mounted flap wheels of abrasive cloth Abrasive bands Abrasive rolls Abrasive caps Abrasive discs Flap discs 140 141 142 144 196 206 208 216 218
	<b>Ceramic</b> Abrasive cloth Ceramic grain	excellent removal rate without grain embedding, particularly stable thanks to reinforced backing, cool cutting	steel, cast- and acid-resistant steel	Lamellar flap discs 141 144 152
	<b>PG</b> Reinforced abrasive cloth with ceramic grain	excellent removal rate and fast life thanks to wet sharpening ceramic grain	iron, steel, hardened/tempered surfaces	Compact grinding discs Lamellar flap discs 130 136
	<b>NK</b> Abrasive flocco Regular aluminum oxide	polishing effect with the fibre structure, consistent results thanks to continuous exposure of new abrasive particles	chromium nickel alloys and other non-rusting steels, zinc die castings, non-ferrous metals, wood	Mounted flap wheels Mounted flap wheels Flap rolls Flap rolls 126/127 129 134 - 137 148 151
	<b>SK</b> Abrasive flocco Silicon carbide	polishing effect with the fibre structure, consistent results thanks to continuous exposure of new abrasive particles	titanium and titanium alloys, steel and steel plating, zirconium and aluminum alloys, plastics	Mounted flap wheels Mounted flap wheels Flap rolls Semi-flexible grinding disc 117 121 134 - 136 150 149
	<b>Z</b> Abrasive flocco Zirconia alumina	polishing effect with the fibre structure, improved aggressiveness	chromium nickel alloys and other stainless steels, zinc die castings, non-ferrous metals	Mounted flap wheels 125
	<b>TF</b> Abrasive flocco/cloth Regular aluminum oxide reinforced flocco	with the combination inverted flap wheels, the abrasive cloth and flocco flaps wear more evenly, improved removal rate	ideal for surface finishing of steel metal products made from non-rusting steel such as stainless steel coils and containers	Mounted flap wheels Flap rolls 135 132
	<b>A</b> Mounted flap wheels Flap rolls	the combination with abrasive cloth enhances the grinding effect	chromium nickel alloys and other stainless steels, zinc die castings, non-ferrous metals, wood	Lamellar flap discs Mounted flap wheels Mounted flap wheels Flap rolls 141 129 137 142/143
	<b>C</b> Abrasive flocco/cloth Silicon carbide	the combination with abrasive cloth enhances the grinding effect	titanium and titanium alloys, steel and steel plating, zirconium and aluminum alloys, plastics	Lamellar flap discs Mounted flap wheels Mounted flap wheels 141 136 137
	<b>AS</b> Polymeric flocco	impregnated with aggressive abrasive grain	removal of paint and adhesives, cement and concrete mortars, denesting, cleaning and polishing a wide variety of surfaces, grinding and coating of wood	Flap disc Grinding wheel 225/247 248



## 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
- fitting
- 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 shedding 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.

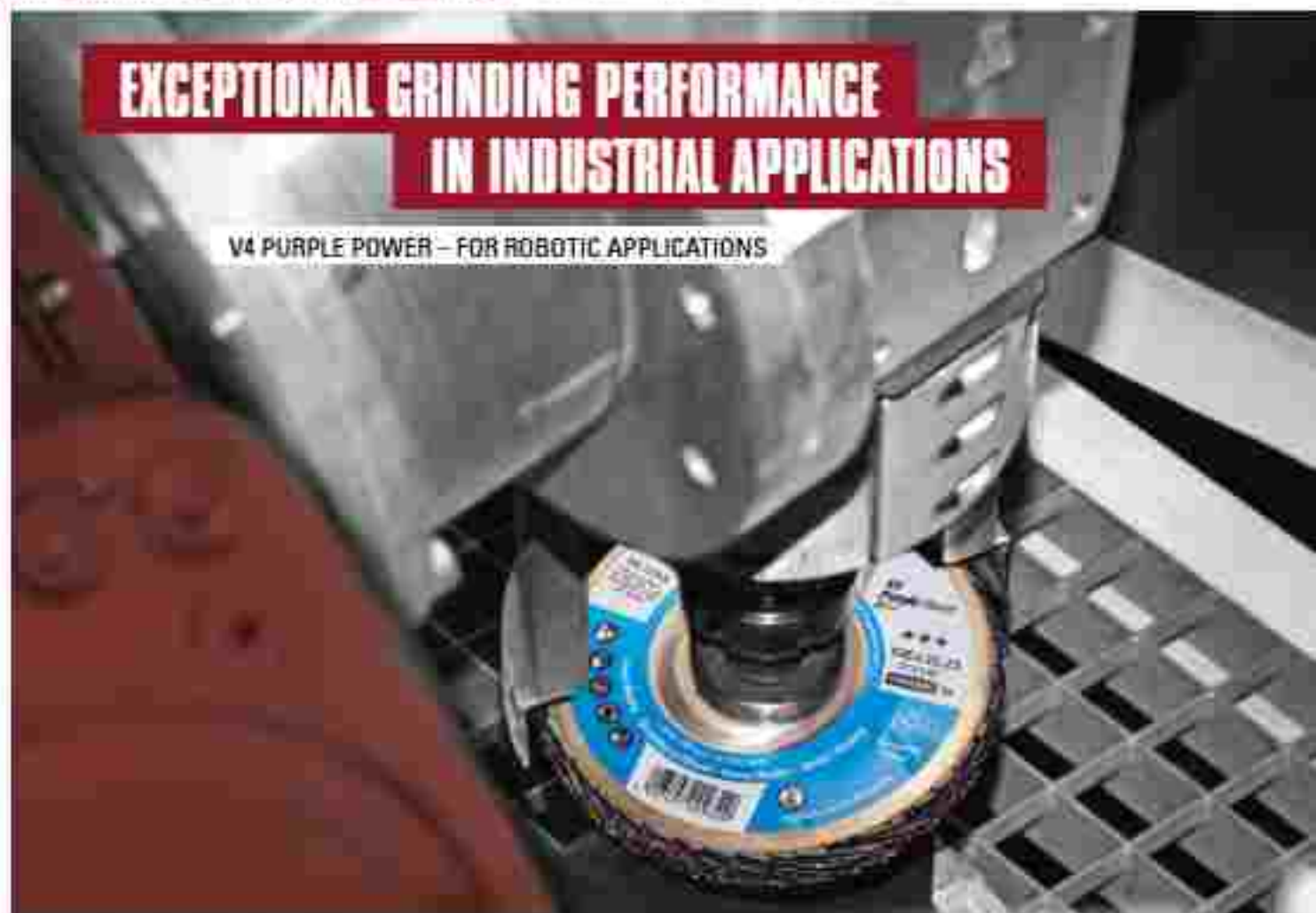






# EXCEPTIONAL GRINDING PERFORMANCE IN INDUSTRIAL APPLICATIONS

V4 PURPLE POWER – FOR ROBOTIC APPLICATIONS

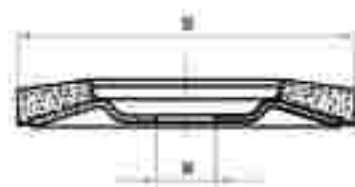


As a highly aggressive grinding tool, the V4 Purple Power is designed to be used on powerful angle grinders. On robots and automatic grinders, this grinding disc shows what it's capable of. It achieves unique performance values, combined with a long tool life for impressive efficiency.

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, iron, 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

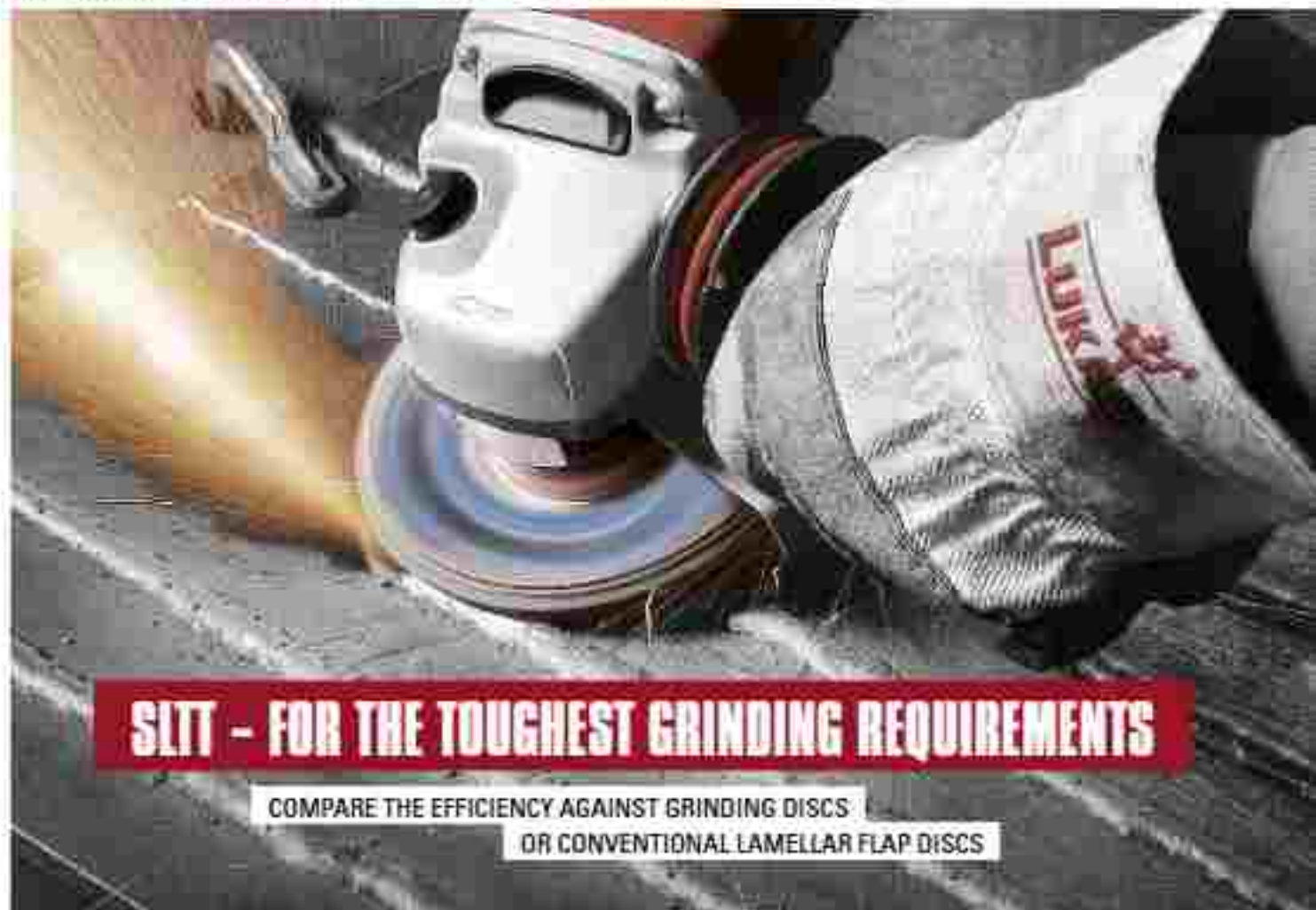
★★★

Product Number	Description	Tool	Ø min.	Ø max.	Flap type	Part number
A374012503600475	V4 Purple Power 125	Ceramic 38	125	23.23	12,300	5

■ Recommended for use ■ Steel ■ Cast iron ■ Titanium ■ Cast material







## 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.

**PROPERTIES**

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



**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.

**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.

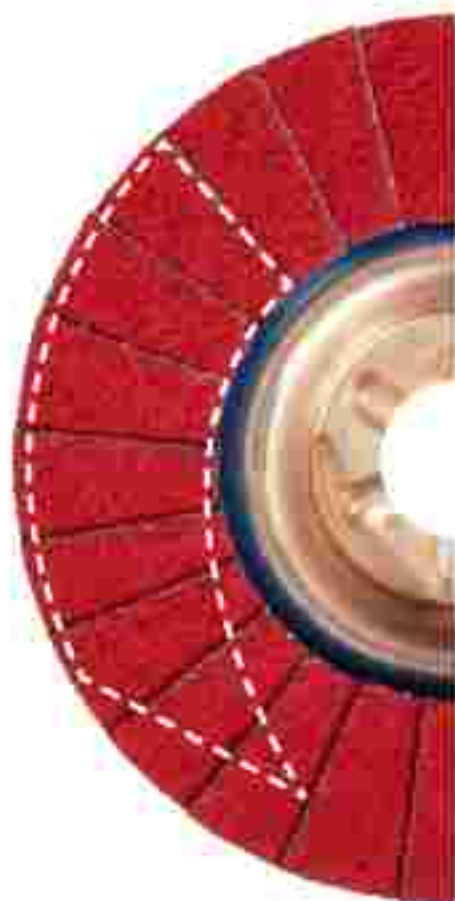


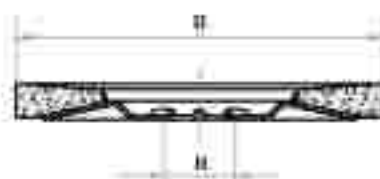
Photo: LUKAS/STB

**THE FOUR SLTT VERSIONS**



Heavy Duty Ceramic abrasive disc	Blue Z-Flap abrasive disc	Hybrid/Polishing Diamond abrasive disc	Black ZC abrasive disc
<ul style="list-style-type: none"> <li>• developed for the most demanding and toughest grinding applications</li> <li>• especially suited 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 grinding 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 tool, shop's steel plate, Herculite 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>• optimized 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	W mm	H mm	Max. rotational speed
A2720115040005E	SLTT 115	Ceramic 40	115	22.23	13.300	10
A2720115040005E	SLTT 115	Ceramic 60	115	22.23	13.300	10
A2720125040005EA	SLTT 125	Ceramic 40	125	22.23	12.200	10
A2720125040005E	SLTT 125	Ceramic 60	125	22.23	12.200	10
A272015040005E	SLTT 150	Ceramic 40	150	22.23	10.200	10
A272017040005E	SLTT 170	Ceramic 40	170	22.23	8.500	10
A272017040005E	SLTT 170	Ceramic 60	170	22.23	8.500	10

## SLTT Inox lamellar flap discs

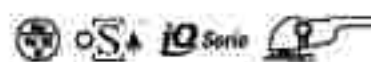


- tabs back plate for machining stainless steel
- no glazing or heating of the flaps
- equally efficient for edge and surface applications
- free of iron, sulphur and chlorine

★★★

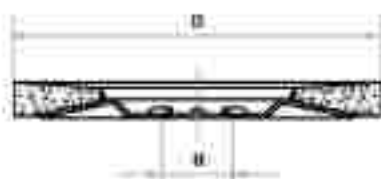
Product number	Description	Grit	D mm	W mm	H mm	Max. rotational speed
A2720115040004E	SLTT 115	Z-Power 40	115	22.23	13.300	10
A2720115040004E	SLTT 115	Z-Power 60	115	22.23	13.300	10
A2720125040004EA	SLTT 125	Z-Power 40	125	22.23	12.200	10
A2720125040004E	SLTT 125	Z-Power 60	125	22.23	12.200	10
A272015040004E	SLTT 150	Z-Power 40	150	22.23	10.200	10
A272017040004E	SLTT 170	Z-Power 40	170	22.23	8.500	10
A272017040004E	SLTT 170	Z-Power 60	170	22.23	8.500	10





## SLT HybridPerfection<sup>ceramics</sup> lamellar flap discs NEW

- the professional tool for the toughest jobs on steel, ship's steel plate, firebox steel, radial bored alloys and titanium
- achieves impressively high stock removal rates when 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	V <sub>max</sub> (rpm)	Peak velocity
A27201150400044	HybridPerfection 115	Ceramic4x 40	115	22.25	13,300	90
A27201150600044	HybridPerfection 115	Ceramic4x 60	115	22.25	13,300	90
A27301250400044	HybridPerfection 125	Ceramic4x 40	125	22.25	12,200	90
A27301250600044	HybridPerfection 125	Ceramic4x 60	125	22.25	12,200	90

Recommended for:  Steel/Steel  Steel  Titanium  Cast iron/Al  Titanium  Plastic/Steel

**UNBEATABLE ON STEEL: THE NEW LUKAS HYBRIDPERFECTION**  
Thanks to its innovative Ceramco 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.

HYBRIDPERFECTION  
SLT HybridPerfection



## SLT steel lamellar flap discs



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

★★★

Product number	Description	Grit	D mm	H mm	V <sub>max</sub> (rpm)	Peak velocity
A27201150400085	SLT 115	2X 40	115	22.25	13,300	90
A27201150600085	SLT 115	2X 60	115	22.25	13,300	90
A27201250400085A	SLT 125	2X 40	125	22.25	12,200	90
A27201250600085	SLT 125	2X 60	125	22.25	12,200	90
A27301150400085	SLT 150	2X 40	150	22.25	10,200	90
A27301150600085	SLT 150	2X 60	150	22.25	10,200	90
A27201700400085	SLT 170	2X 40	170	22.25	8,500	90
A27201700600085	SLT 170	2X 60	170	22.25	8,500	90

Recommended for:  Steel/Steel  Steel  Titanium  Cast iron/Al  Titanium  Plastic/Steel  Titanium



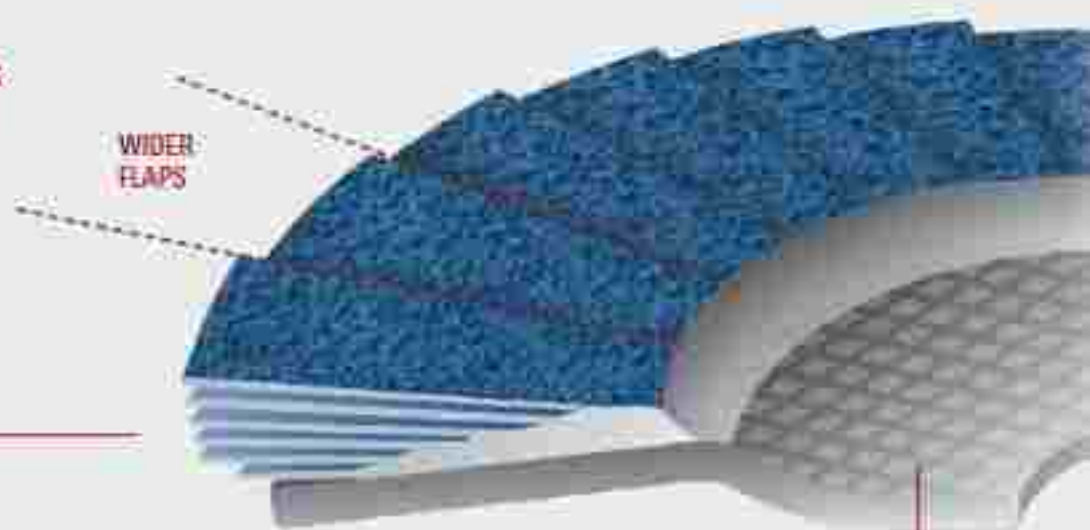
## THE V2 POWER – FOR UNIVERSAL USE

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



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.

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.

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.

**PROPERTIES**

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

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

**APPLICATION**

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



• Exceptional grinding performance

**THE FIVE V2 POWER VERSIONS**



<b>XL300</b> Coarse abrasive cloth	<b>Heavy Duty</b> Coarse abrasive cloth	<b>3mm</b> V2 Power abrasive cloth	<b>2mm</b> V2 abrasive cloth	<b>AS1</b> DC abrasive cloth
<ul style="list-style-type: none"> <li>• perform the toughest machining jobs and spark less grinding</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 steels</li> <li>• no spalling 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>• optimized for universal applications 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 CRFP and GFRP</li> </ul>

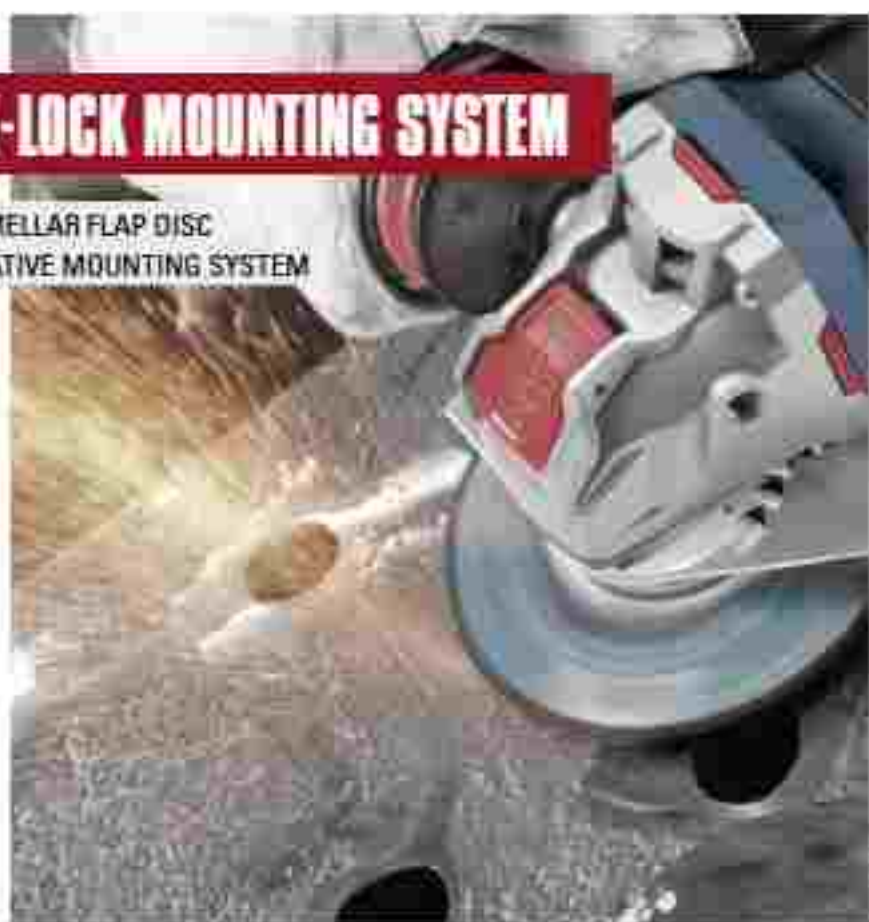
## V2 POWER WITH X-LOCK MOUNTING SYSTEM

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

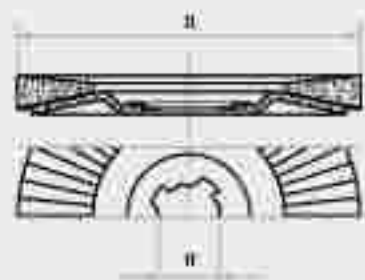
### MOUNTING GRINDING DISCS HAS NEVER BEEN SO EASY

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.



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



- the professional tool for the toughest jobs on steel, ship's steel plate, Flarox steel, nickel-based alloys and titanium
- achieves impressively high stock removal rates when rough grinding steel, edging and removing of welds
- toolless 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	Max. rpm	Price indicator
A67441250401844	V2 Power 125	Ceramic 40	125	X-LOCK/22.23	12,200	10
A6744125061844	V2 Power 125	Ceramic 60	125	X-LOCK/22.23	12,200	10
A67441250401885	V2 Power 125	ZK 40	125	X-LOCK/22.23	12,200	10
A6744125061885	V2 Power 125	ZK 60	125	X-LOCK/22.23	12,200	10





# HEAVY DUTY FOR HANDLING THE TOUGHEST JOBS

FOR THE MOST DEMANDING MACHINING REQUIREMENTS FOR UNIVERSAL USE

REPRODUCED WITH PERMISSION



## V2 Power Heavy Duty lamellar flap disc



- especially robust for edge grinding, gearhob and tapered chisel, scale surfaces or coated surfaces
- free of iron, sulphur and chlorine

★★★

Product number	Description	Grit	D mm	H mm	Max. speed rpm	Max. thickness
A27441150401402	V2 Power 115	Ceramic 40	115	22.25	11,300	10
A27441150401404	V2 Power 115	Ceramic 80	115	22.25	11,300	10
A27441250401402	V2 Power 125	Ceramic 40	125	22.25	12,200	10
A27441250401404	V2 Power 125	Ceramic 80	125	22.25	12,200	10
A2744170401402	V2 Power 170	Ceramic 40	170	22.25	8,500	10
A2744170401404	V2 Power 170	Ceramic 80	170	22.25	8,500	10
A2744230401402	V2 Power 230	Ceramic 40	230	22.25	6,600	10

Recommended for: Resin-bonded Steel Stainless Aluminum Cast iron Plastic/Steel

## V2 Power Inox lamellar flap disc



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

★★★

Product number	Description	Grit	D mm	H mm	$V_{max}$ rpm	Flap thickness
A274415240144E	V2 Power 115	Z-Power 40	115	22.25	12,300	10
A274415260144E	V2 Power 115	Z-Power 60	115	22.25	12,300	10
A274412540144E	V2 Power 125	Z-Power 40	125	22.25	12,300	10
A274412560144E	V2 Power 125	Z-Power 60	125	22.25	12,300	10
A274417540144E	V2 Power 178	Z-Power 40	178	22.25	8,500	10
A274417560144E	V2 Power 178	Z-Power 60	178	22.25	8,500	10

## 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	$V_{max}$ rpm	Flap thickness
A274410040144E	V2 Power 100	ZK 40	100	16.00	15,300	10
A274410060144E	V2 Power 100	ZK 60	100	16.00	15,300	10
A274411540144E	V2 Power 115	ZK 40	115	22.25	13,300	10
A274411560144E	V2 Power 115	ZK 60	115	22.25	13,300	10
A274412540144E-A	V2 Power 125	ZK 40	125	22.25	12,300	10
A274412560144E	V2 Power 125	ZK 60	125	22.25	12,300	10
A274417540144E	V2 Power 178	ZK 40	178	22.25	8,500	10
A274417560144E	V2 Power 178	ZK 60	178	22.25	8,500	10
A274420040144E	V2 Power 230	ZK3 40	230	22.25	6,900	5



## MACHINING STATE-OF-THE-ART MATERIALS

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

REPRODUCED WITH PERMISSION



### 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	SiC	Ø mm	H mm	W mm	Peak rotation
A27441150401434	V2 Power T15	SiC 40	115	22.23	13,300	10
A27441250361434	V2 Power T25	SiC 38	125	22.23	12,200	10
A27441250401434	V2 Power T35	SiC 40	125	22.23	12,200	10
A27441700341434	V2 Power T15	SiC 24	178	22.23	8,500	10
A27441700361434	V2 Power T25	SiC 26	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 SUTflex 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, de-rusting, fettling and smoothening

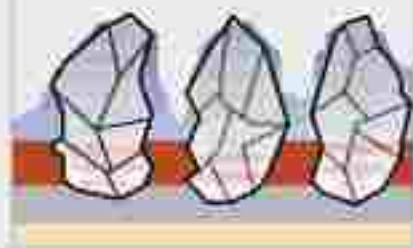


#### FLEXIBLE FLAP ARRANGEMENT

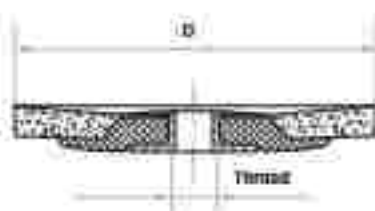


#### ABRASIVE CLOTH

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



## SLTflex Ceramic lamellar flap disc



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

★★★

Product number	Description	Grit	D mm	Thickness	Max. rpm	Flap condition
A77711504070	SLTflex 115	Ceramic 40	115	M14	13,300	10
A77711506070	SLTflex 115	Ceramic 60	115	M14	13,300	10
A77712504170	SLTflex 125	Ceramic 40	125	M14	12,200	10
A77712506170	SLTflex 125	Ceramic 60	125	M14	12,200	10

 GRINDING AND POLISHING  
 - apply manual app -

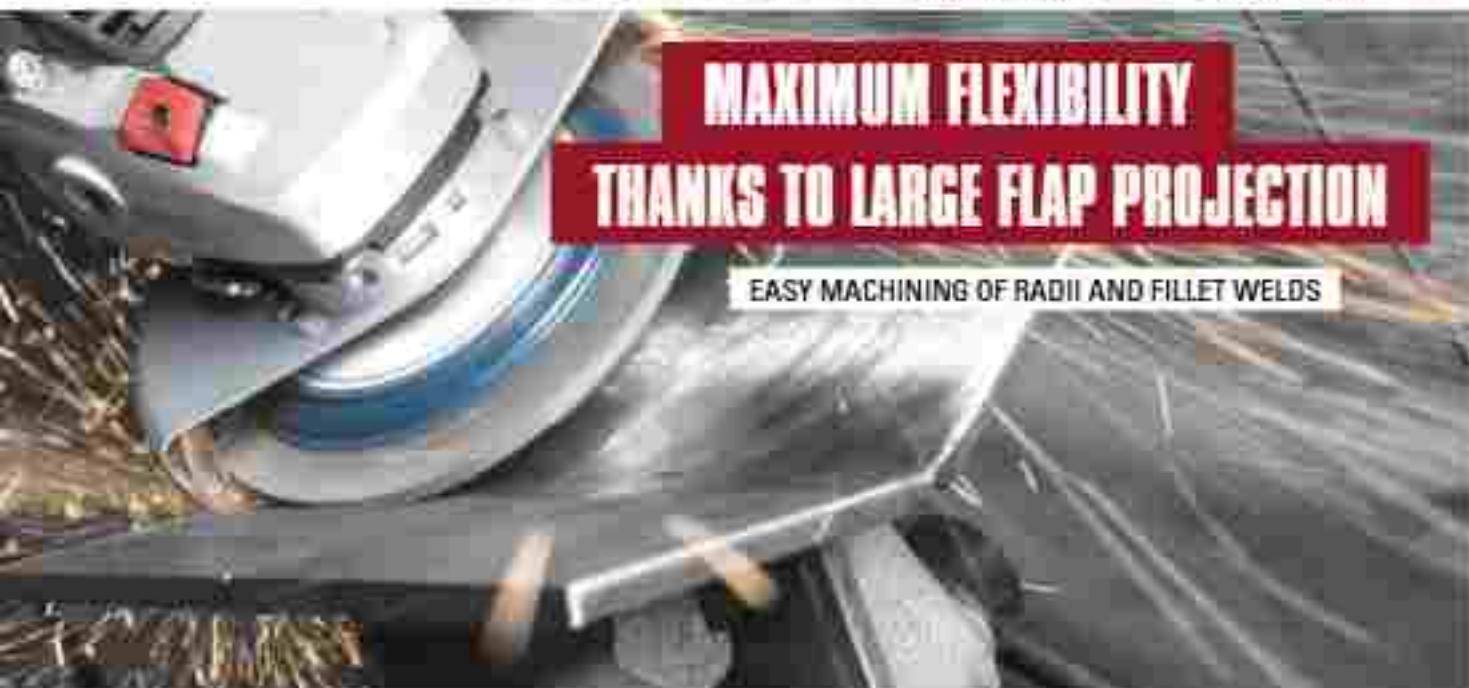
## SLTflex super flexible lamellar flap disc



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

★★★

Product number	Description	Grit	D mm	Thickness	Max. rpm	Flap condition
A77201004018	SLTs-flex 100	ZKS 40	100	M10	12,300	10
A77201006018	SLTs-flex 100	ZKS 60	100	M10	12,300	10
A77201008018	SLTs-flex 100	ZKS 80	100	M10	12,300	10
A67201104018	SLTs-flex 115	ZKS 40	115	M14	13,300	10
A67201106018	SLTs-flex 115	ZKS 60	115	M14	13,300	10
A67201108018	SLTs-flex 115	ZKS 80	115	M14	13,300	10
A67201204018	SLTs-flex 125	ZKS 40	125	M14	12,200	10
A67201206018	SLTs-flex 125	ZKS 60	125	M14	12,200	10
A67201208018	SLTs-flex 125	ZKS 80	125	M14	12,200	10
A77201704018	SLTs-flex 178	ZKS 40	178	M14	8,500	10
A77201706018	SLTs-flex 178	ZKS 60	178	M14	8,500	10
A77201708018	SLTs-flex 178	ZKS 80	178	M14	8,500	10

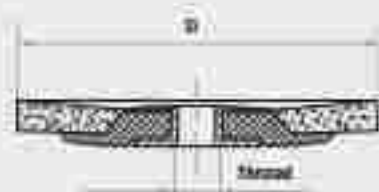


# MAXIMUM FLEXIBILITY THANKS TO LARGE FLAP PROJECTION

EASY MACHINING OF RADII AND FILLET WELDS



## SLTflex lamellar flap disc



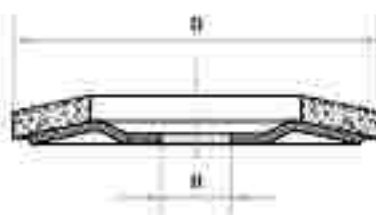
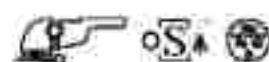
- for machining radii and fillet welds
- high flexibility thanks to the large flap projection less interference from backing plate!
- easy tool changing (backing pad and clamping nut are not required)
- long tool life

★★★

Product number	Description	GR	Ø mm	Mount	R <sub>max</sub> µm	Flap numbers
A2270504018	SLTflex 110	ZK 40	110	M14	11,300	10
A22801504018	SLTflex 110	ZK 40	110	S8°	11,300	10
A22711100018	SLTflex 115	ZK 60	115	M14	11,300	10
A22811100018	SLTflex 115	ZK 60	115	S8°	11,300	10
A2270506018	SLTflex 110	ZK 80	110	M14	11,300	10
A22811108018	SLTflex 110	ZK 80	110	S8°	11,300	10
A227111512018	SLTflex 115	ZK 120	115	M14	11,300	10
A228111512018	SLTflex 115	ZK 120	115	S8°	11,300	10
A22712504018	SLTflex 125	ZK 40	125	M14	12,200	10
A22812504018	SLTflex 125	ZK 40	125	S8°	12,200	10
A22712506018	SLTflex 125	ZK 60	125	M14	12,200	10
A22812506018	SLTflex 125	ZK 60	125	S8°	12,200	10
A22712508018	SLTflex 125	ZK 80	125	M14	12,200	10
A22812508018	SLTflex 125	ZK 80	125	S8°	12,200	10
A22712512018	SLTflex 125	ZK 120	125	M14	12,200	10
A22812512018	SLTflex 125	ZK 120	125	S8°	12,200	10



## SLTR Control lamellar flap disc

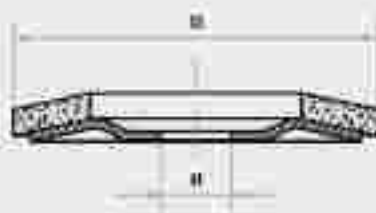


★★★

- 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	Max speed	Flap thickness
A27461120401400	SLTR 115 Control	ZK 40 INOX	115	22,23	13,300	10
A27461150401400	SLTR 115 Control	ZK 80 INOX	115	22,23	13,300	10
A27461152001400	SLTR 115 Control	ZK 80 INOX	115	22,23	13,300	10
A27461250401400	SLTR 125 Control	ZK 40 INOX	125	22,23	12,200	10
A27461250601400	SLTR 125 Control	ZK 60 INOX	125	22,23	12,200	10
A27461250801400	SLTR 125 Control	ZK 80 INOX	125	22,23	12,200	10

## SLTZ lamellar flap disc



★★★

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

Product number	Description	Grit	D mm	H mm	Max speed	Flap thickness
A27261150401410	SLTZ 115	ZKS 40	115	22,23	13,300	10
A27261150801410	SLTZ 115	ZKS 80	115	22,23	13,300	10
A27261152001410	SLTZ 115	ZKS 80	115	22,23	13,300	10
A27261250401410	SLTZ 125	ZKS 40	125	22,23	12,200	10
A27261250601410	SLTZ 125	ZKS 60	125	22,23	12,200	10
A27261250801410	SLTZ 125	ZKS 80	125	22,23	12,200	10



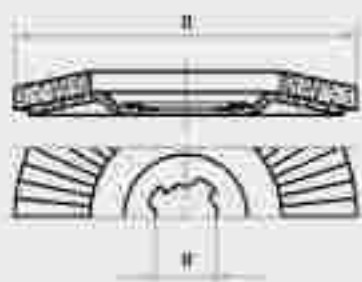




**TOOL CHANGING IN NO TIME AT ALL**

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

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



- effortless tool changing in no time at all
- ideal for deburring, fitting, dressing, smoothing and weld seam machining
- always remains sharp throughout the tool life thanks to its multi-layer coating
- good price-to-performance ratio thanks to the rectangular flap

★★★

Product number	Description	Call	D mm	H mm	$v_m$ rpm	Tool quantity
A6718125041085	SLTR 125	ZK 40	125	X-LOCK/22.25	12,200	10
A67181250611085	SLTR 125	ZK 40	125	X-LOCK/22.25	12,300	10
A67181250811085	SLTR 125	ZK 40	125	X-LOCK/22.25	12,200	10

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OSASLTR X-LOCK

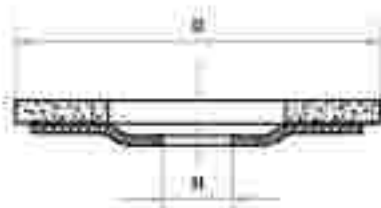
OSASLTR X-LOCK





## SLTD/SLTR lamellar flap disc, zirconia alumina

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



★★★

Product number	Description	Size	Grinding	D mm	H mm	Flap mm	Flap thickness	
A271515040140E	SLTD 115	ZK 40		115	22.23	13.300	10	
A271515050140E	SLTD 115	ZK 60		115	22.23	13.300	10	
A271515080140E	SLTD 115	ZK 80		115	22.23	13.300	10	
A271515040140E	SLTD 125	ZK 40		125	22.23	13.300	10	
A271515060140E	SLTD 125	ZK 60		125	22.23	13.300	10	
A271515080140E	SLTD 125	ZK 80		125	22.23	13.300	10	
A271515090140E	SLTD 125	ZK 90		125	22.23	13.300	10	
A271515090140E	SLTD 125	ZK 120		125	22.23	13.300	10	
A271515040140E	SLTD 170	ZK 40		170	22.23	8.500	10	
A271515040140E	SLTD 170	ZK 60		170	22.23	8.500	10	
A271515040140E	SLTD 170	ZK 80		170	22.23	8.500	10	
A271515040140E	SLTD 170	ZK 120		170	22.23	8.500	10	
A271810040142E	SLTR 100	ZK 40			100	16.00	15.300	10
A271810060142E	SLTR 100	ZK 60			100	16.00	15.300	10
A271810080142E	SLTR 100	ZK 80	100		16.00	15.300	10	
A271815080140E	SLTR 115	ZK 36	115		22.23	13.300	10	
A271815040140E	SLTR 115	ZK 40	115		22.23	13.300	10	
A271815060140E	SLTR 115	ZK 60	115		22.23	13.300	10	
A271815080140E	SLTR 115	ZK 80	115		22.23	13.300	10	
A271815120140E	SLTR 115	ZK 120	115		22.23	13.300	10	
A271815080140E	SLTR 125	ZK 36	125		22.23	13.300	10	
A271815040140E	SLTR 125	ZK 40	125		22.23	13.300	10	
A271815060140E	SLTR 125	ZK 60	125		22.23	13.300	10	
A271815080140E	SLTR 125	ZK 80	125		22.23	13.300	10	
A271815120140E	SLTR 125	ZK 120	125		22.23	13.300	10	
A271815040141E	SLTR 150	ZK 40	150		22.23	10.200	10	
A271815060141E	SLTR 150	ZK 60	150		22.23	10.200	10	
A271815080141E	SLTR 150	ZK 80	150		22.23	10.200	10	
A271815090140E	SLTR 170	ZK 36	170		22.23	8.500	10	
A271815040140E	SLTR 170	ZK 40	170		22.23	8.500	10	
A271815060140E	SLTR 170	ZK 60	170		22.23	8.500	10	
A271815080140E	SLTR 170	ZK 80	170		22.23	8.500	10	



# EFFICIENTLY MACHINE WELD SEAMS WITH REGULAR ALUMINIUM OXIDE

EASY TO USE, MINIMUM VIBRATION AND HIGH CRACK RESISTANCE

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



- the good alternative to grinding discs
- for deburring, fettling, dressing, smoothening and weld seam modaring
- good price-to-performance ratio thanks to the rectangular flap
- always remains sharp throughout the tool life thanks to the multi-layer coating
- good fibre locking

★★★

Product number	Description	Grit	Drawing	D mm	H mm	$r_{max}$ mm	Flap thickness
A2715152001400	SLTD 115	NK 60		115	22.23	13.300	10
A2715152001400	SLTD 115	NK 80		115	22.23	13.300	10
A2718125001400	SLTR 115	NK 40		115	22.23	13.300	10
A2718125001400	SLTR 115	NK 60		115	22.23	13.300	10
A2718125001400	SLTR 115	NK 80		115	22.23	13.300	10
A2718125001400	SLTR 115	NK 120		115	22.23	13.300	10
A2718125001400	SLTR 125	NK 40		125	22.23	12.200	10
A2718125001400	SLTR 125	NK 60		125	22.23	12.200	10
A2718125001400	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 iron Aluminum



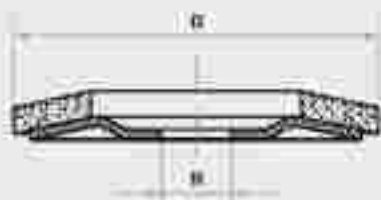
## THE ECONOMICAL BASE-X

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, descaling, 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	Gr	Drawing	D mm	H mm	Flap Open	Flap position		
A27151150401525	SLTO 115 BASE-X	2X 40		115	22.25	13,300	90		
A27151150601525	SLTO 115 BASE-X	2X 60		115	22.25	13,300	90		
A27151150801525	SLTO 115 BASE-X	2X 80		115	22.25	13,300	90		
A27151151201525	SLTO 115 BASE-X	2X 120		115	22.25	13,300	90		
A27151250401525	SLTO 125 BASE-X	2X 40			125	22.25	12,200	90	
A27151250601525	SLTO 125 BASE-X	2X 60			125	22.25	12,200	90	
A27151250801525	SLTO 125 BASE-X	2X 80			125	22.25	12,200	90	
A27151251201525	SLTO 125 BASE-X	2X 120			125	22.25	12,200	90	
A27181150401525	SLTR 115 BASE-X	2X 40				115	22.25	13,300	90
A27181150601525	SLTR 115 BASE-X	2X 60				115	22.25	13,300	90
A27181150801525	SLTR 115 BASE-X	2X 80	115			22.25	13,300	90	
A27181151201525	SLTR 115 BASE-X	2X 120	115			22.25	13,300	90	
A27181250401525	SLTR 125 BASE-X	2X 40	125			22.25	12,200	90	
A27181250601525	SLTR 125 BASE-X	2X 60	125			22.25	12,200	90	
A27181250801525	SLTR 125 BASE-X	2X 80	125	22.25		12,200	90		
A27181251201525	SLTR 125 BASE-X	2X 120	125	22.25		12,200	90		
A27181780401525	SLTR 178 BASE-X	2X 40	178	22.25		8,500	90		
A27181780601525	SLTR 178 BASE-X	2X 60	178	22.25		8,500	90		
A27181780801525	SLTR 178 BASE-X	2X 80	178	22.25	8,500	90			
A27181781201525	SLTR 178 BASE-X	2X 120	178	22.25	8,500	90			

Recommended for: Steel Cast steel Cast iron Stainless steel







# 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 recessed abrasives (polyester-based) and active abrasive surface layer
- ideal for machining stainless steel
- for deburring, fitting, descaling, 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

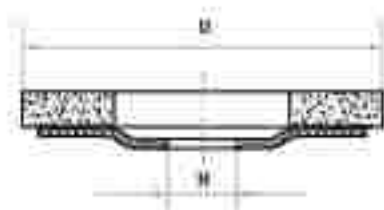
★★★★

Product number	Description	Size	D mm	H mm	Weight (kg)	Flap thickness
A27021150400177	SLTC 115	ZKS 38	115	22.25	13,300	10
A27021150600177	SLTC 115	ZKS 40	115	22.25	13,300	10
A27021150500177	SLTC 115	ZKS 50	115	22.25	13,300	10
A27021150600177	SLTC 115	ZKS 48	115	22.25	13,300	10
A27021150800177	SLTC 115	ZKS 80	115	22.25	13,300	10
A17021250400177	SLTC 125	ZKS 40	125	22.25	12,200	10
A27021250000177	SLTC 125	ZKS 60	125	22.25	12,200	10
A27021250000177	SLTC 125	ZKS 80	125	22.25	12,200	10



## SLTM NAWARFLEX® lamellar flap disc

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



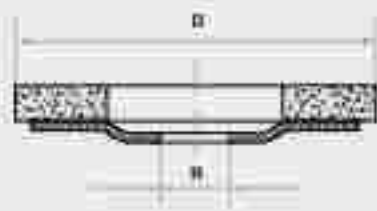
★★☆

Product number	Description	Quality	Grit	D mm	H mm	R <sub>max</sub> µm	Flap condition
A2713151040140	SLTM YFS	A10410	NK 100/80	115	22.23	5.300	10
A2713151300140	SLTM YFS	A106150	NK 100/150	115	22.23	5.300	10
A2713151020140	SLTM YFS	A107040	NK 200/40	115	22.23	5.300	10
Recommended use for applications: <span style="color:blue">●</span> Steel <span style="color:red">●</span> Cast iron <span style="color:yellow">●</span> Plastic <span style="color:orange">●</span> Aluminum <span style="color:green">●</span> Titanium							
A2713152040141	SLTM YFS	C20410	SC 100/110	115	22.23	5.300	10
A2713152060141	SLTM YFS	C206150	SC 100/150	115	22.23	5.300	10
A2713152020141	SLTM YFS	C202040	SC 200/40	115	22.23	5.300	10
Recommended use for applications: <span style="color:orange">●</span> Aluminum <span style="color:yellow">●</span> Plastic <span style="color:green">●</span> Titanium <span style="color:blue">●</span> Steel <span style="color:red">●</span> Cast iron <span style="color:purple">●</span> Copper							



## SLTV NAWARFLEX® lamellar flap disc

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



★★☆

Product number	Description	Quality	Grit	D mm	H mm	R <sub>max</sub> µm	Flap condition
A2722151040130	SLTV YFS	A104	NK 100	115	22.23	5.300	10
A2722151000130	SLTV YFS	A100	NK 150	115	22.23	5.300	10
A2722151020130	SLTV YFS	A102	NK 200	115	22.23	5.300	10
Recommended use for applications: <span style="color:green">●</span> Steel <span style="color:red">●</span> Cast iron <span style="color:yellow">●</span> Plastic <span style="color:orange">●</span> Aluminum <span style="color:blue">●</span> Titanium							
A2722152000130	SLTV YFS	C200	SC 100	115	22.23	5.300	10
A2722152020130	SLTV YFS	C202	SC 200	115	22.23	5.300	10
A2722153001530	SLTV YFS	Z300	ZK 100	115	22.23	5.300	10
A2722153021530	SLTV YFS	Z302	ZK 200	115	22.23	5.300	10
Recommended use for applications: <span style="color:orange">●</span> Aluminum <span style="color:yellow">●</span> Plastic <span style="color:green">●</span> Titanium <span style="color:blue">●</span> Steel <span style="color:red">●</span> Cast iron							



# 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.

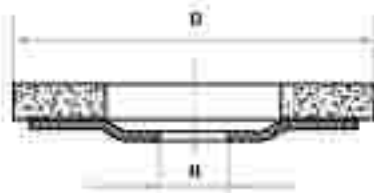
The LUKAS polishing tool range with its huge variety of different shapes allows you to choose the most suitable polishing tools for your specific fine machining (fine and ultra-fine grinding) or polishing requirements. This means that with our tools you can work in an extremely economical and especially 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 116 and 119!



## SLTP polishing disc



- color - very efficient for light skimming, clearing from weld seams and surface advancement
- The fibre-like 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/structure	Max. rpm	Part numbers
A27947523	SLTP 115 M	115	22.25	medium	8.300	5
A21803543	SLTP 115 W	115	22.25	soft	8.300	5

Recommended for: Steel Stainless Cast iron Non-ferrous 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 stacked 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

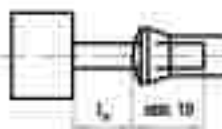
These tools are specially designed for use with non-rusting materials. The abrasive fleece with its reinforced backing guarantees even wear of the abrasive fleece and cloth flaps. Please pay attention to the rotating direction of the tool!

#### Application examples

- Smoothing
- Surface grinding
- Demisting
- Finishing
- Fetting
- Beveling
- Deburring

#### SPEED

The stated maximum permissible speeds apply for a maximum open shaft length  $L_s$  of 20 mm.



#### Application examples

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

#### Application examples

- Cleaning
- Finishing
- Demisting
- Roughing
- Pre-grinding

Quality	Abrasive particle	GV	Surface
A104	Regular aluminium oxide	NK 100	medium
A106	Regular aluminium oxide	NK 120	fine
A107	Regular aluminium oxide	NK 200	very fine
C204	Silicon carbide	SIC 100	medium
C206	Silicon carbide	SIC 180	fine
C207	Silicon carbide	SIC 200	very fine
C208	Silicon carbide	SIC 400	ultra-fine
Z204	Zirconia-alumina	ZK 100	medium
Z206	Zirconia-alumina	ZK 180	fine
Z207	Zirconia-alumina	ZK 200	very fine

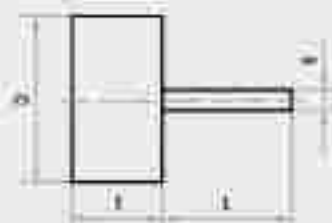




## CERAMIC MOUNTED FLAP WHEELS FROM LUKAS FOR THE MOST PRECISE APPLICATIONS

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 smooth grinding, deburring, finishing and bonding

★★★

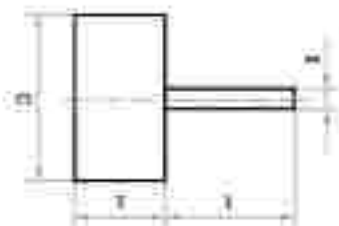
Product number	Description	Grd	Ø mm	T mm	d mm	L mm	V <sub>max</sub> m/s	V <sub>max</sub> rpm	Use condition
A2214020206080	SFL 02020.08	Ceramic 80	20	20	6	40	20,000	38,200	10
A2214020206120	SFL 02020.08	Ceramic 120	20	20	6	40	20,000	38,200	10
A2214020106080	SFL 03010.08	Ceramic 80	30	10	6	40	16,000	25,400	10
A2214020106120	SFL 03010.08	Ceramic 80	30	10	6	40	16,000	25,400	10
A2214020106120	SFL 03010.08	Ceramic 120	30	10	6	40	16,000	25,400	10
A2214040206080	SFL 04020.08	Ceramic 80	40	20	6	40	12,000	18,100	10
A2214040206080	SFL 04020.08	Ceramic 80	40	20	6	40	12,000	18,100	10
A2214040206120	SFL 04020.08	Ceramic 120	40	20	6	40	12,000	18,100	10
A2214060106080	SFL 06015.08	Ceramic 80	60	15	6	40	8,000	12,700	10
A2214060106120	SFL 06015.08	Ceramic 120	60	15	6	40	8,000	12,700	10
A2214060206080	SFL 06030.08	Ceramic 80	60	30	6	40	8,000	12,700	10
A2214060206080	SFL 06030.08	Ceramic 80	60	30	6	40	8,000	12,700	10
A2214060206120	SFL 06030.08	Ceramic 120	60	30	6	40	8,000	12,700	10

Recommended for:





- good tool life on different materials for rough and fine grinding
- regular aluminum oxide for cost effective applications
- used as a handheld tool, ideal for straightening, deforming, fitting, deburring, surface grinding, texturing and bowling



## SFL mounted flap wheel



Product number	Designation	Grit	T mm	T inch	H mm	H inch	SP mm	SP inch	Tool length
A220001003800	SFL 01010.03	NK 80	10	3/8	3	40	24,000	35,000	10
A22000100120	SFL 01010.03	NK 120	10	3/8	3	40	24,000	35,000	10
A220001001100	SFL 01010.03	NK 150	10	3/8	3	40	24,000	35,000	10
A220001003240	SFL 01010.03	NK 240	10	3/8	3	40	24,000	35,000	10
A2200010053000	SFL 01015.03	NK 80	15	5/8	3	40	24,000	35,000	10
A2200015103000	SFL 01510.03	NK 80	15	5/8	3	40	24,000	35,000	10
A2200015100150	SFL 01510.03	NK 150	15	5/8	3	40	24,000	35,000	10
A2200015100000	SFL 01510.04	NK 80	15	5/8	4	40	24,000	35,000	10
A2200015150000	SFL 01515.03	NK 80	15	5/8	3	40	24,000	35,000	10
A2200015150120	SFL 01515.03	NK 120	15	5/8	3	40	24,000	35,000	10
A2200015151150	SFL 01515.03	NK 150	15	5/8	3	40	24,000	35,000	10
A2200020004120	SFL 02005.06	NK 120	20	5/8	4	40	20,000	30,200	10
A2200020003000	SFL 02005.03	NK 80	20	5/8	3	40	20,000	30,200	10
A2200020001200	SFL 02010.03	NK 120	20	5/8	3	40	20,000	30,200	10
A220002000150	SFL 02010.03	NK 150	20	5/8	3	40	20,000	30,200	10
A2200020003500	SFL 02010.03	NK 350	20	5/8	3	40	20,000	30,200	10
A2200020000000	SFL 02010.06	NK 80	20	5/8	4	40	20,000	30,200	10
A2200020000120	SFL 02010.06	NK 120	20	5/8	4	40	20,000	30,200	10
A2200020150000	SFL 02015.06	NK 80	20	5/8	4	40	20,000	30,200	10
A2200020150000	SFL 02015.06	NK 120	20	5/8	4	40	20,000	30,200	10
A2200020150000	SFL 02015.06	NK 150	20	5/8	4	40	20,000	30,200	10
A2200020150240	SFL 02015.06	NK 240	20	5/8	4	40	20,000	30,200	10
A2200020200000	SFL 02020.06	NK 80	20	5/8	4	40	20,000	30,200	10
A2200020200000	SFL 02020.06	NK 90	20	5/8	4	40	20,000	30,200	10
A2200020201150	SFL 02025.03	NK 120	25	5/8	3	40	16,000	18,000	10
A2200025100000	SFL 02510.03	NK 80	25	5/8	3	40	16,000	18,000	10
A2200025100120	SFL 02510.03	NK 120	25	5/8	3	40	16,000	18,000	10
A2200025100150	SFL 02510.03	NK 150	25	5/8	3	40	16,000	18,000	10
A2200025100000	SFL 02510.04	NK 80	25	5/8	4	40	16,000	18,000	10
A2200025100120	SFL 02510.06	NK 120	25	5/8	4	40	16,000	18,000	10
A2200025150000	SFL 02515.04	NK 80	25	5/8	4	40	16,000	18,000	10
A2200025150120	SFL 02515.06	NK 120	25	5/8	4	40	16,000	18,000	10
A2200025150110	SFL 02515.06	NK 150	25	5/8	4	40	16,000	18,000	10
A2200025200000	SFL 02520.04	NK 80	25	5/8	4	40	16,000	18,000	10
A2200025200120	SFL 02520.06	NK 120	25	5/8	4	40	16,000	18,000	10
A2200025215000	SFL 02525.06	NK 80	25	5/8	4	40	16,000	18,000	10
A2200025250150	SFL 02525.06	NK 150	25	5/8	4	40	16,000	18,000	10
A2200030050000	SFL 03015.03	NK 80	30	5/8	3	40	14,000	16,000	10
A2200030050000	SFL 03015.03	NK 80	30	5/8	3	40	14,000	16,000	10





Product number	Description	Gr	D mm	F mm	S mm	L mm	HP	HP	HP
A220040208040	SFL 04020.06	NK 40	40	20	6	40	12,000	19,100	10
A220040208060	SFL 04020.06	NK 60	40	20	6	40	12,000	19,100	10
A220040208080	SFL 04020.06	NK 80	40	20	6	40	12,000	19,100	10
A220040208120	SFL 04020.06	NK 120	40	20	6	40	12,000	19,100	10
A220040208150	SFL 04020.06	NK 150	40	20	6	40	12,000	19,100	10
A220040208240	SFL 04020.06	NK 240	40	20	6	40	12,000	19,100	10
A220040208320	SFL 04020.06	NK 320	40	20	6	40	12,000	19,100	10
A220040208400	SFL 04020.06	NK 400	40	20	6	40	12,000	19,100	10
A220040208600	SFL 04020.06	NK 600	40	20	6	40	12,000	19,100	10
A220040208800	SFL 04020.06	NK 800	40	20	6	40	12,000	19,100	10
A220050208060	SFL 05020.06	NK 60	50	18	6	40	9,000	15,300	10
A220050208080	SFL 05020.06	NK 80	50	18	6	40	9,000	15,300	10
A220050208100	SFL 05020.06	NK 100	50	18	6	40	9,000	15,300	10
A220050208120	SFL 05020.06	NK 120	50	18	6	40	9,000	15,300	10
A220050208150	SFL 05020.06	NK 150	50	18	6	40	9,000	15,300	10
A220050208240	SFL 05020.06	NK 240	50	18	6	40	9,000	15,300	10
A220050208320	SFL 05020.06	NK 320	50	18	6	40	9,000	15,300	10
A220050208400	SFL 05020.06	NK 400	50	18	6	40	9,000	15,300	10
A220050208600	SFL 05020.06	NK 600	50	18	6	40	9,000	15,300	10
A220050208800	SFL 05020.06	NK 800	50	18	6	40	9,000	15,300	10
A2200502081000	SFL 05020.06	NK 1000	50	18	6	40	9,000	15,300	10
A2200502081200	SFL 05020.06	NK 1200	50	18	6	40	9,000	15,300	10
A2200502081500	SFL 05020.06	NK 1500	50	18	6	40	9,000	15,300	10
A2200502082400	SFL 05020.06	NK 2400	50	18	6	40	9,000	15,300	10
A2200502083200	SFL 05020.06	NK 3200	50	18	6	40	9,000	15,300	10
A2200502084000	SFL 05020.06	NK 4000	50	18	6	40	9,000	15,300	10
A2200502086000	SFL 05020.06	NK 6000	50	18	6	40	9,000	15,300	10
A2200502088000	SFL 05020.06	NK 8000	50	18	6	40	9,000	15,300	10
A22005020810000	SFL 05020.06	NK 10000	50	18	6	40	9,000	15,300	10
A220060208060	SFL 06020.06	NK 60	60	16	6	40	8,000	13,700	10
A220060208080	SFL 06020.06	NK 80	60	16	6	40	8,000	13,700	10
A220060208100	SFL 06020.06	NK 100	60	16	6	40	8,000	13,700	10
A220060208140	SFL 06020.06	NK 140	60	16	6	40	8,000	13,700	10
A220060208160	SFL 06020.06	NK 160	60	16	6	40	8,000	13,700	10
A220060208200	SFL 06020.06	NK 200	60	16	6	40	8,000	13,700	10
A220060208240	SFL 06020.06	NK 240	60	16	6	40	8,000	13,700	10
A220060208320	SFL 06020.06	NK 320	60	16	6	40	8,000	13,700	10
A220060208400	SFL 06020.06	NK 400	60	16	6	40	8,000	13,700	10
A220060208600	SFL 06020.06	NK 600	60	16	6	40	8,000	13,700	10
A220060208800	SFL 06020.06	NK 800	60	16	6	40	8,000	13,700	10
A2200602081000	SFL 06020.06	NK 1000	60	16	6	40	8,000	13,700	10



Product number	Description	Gr	D mm	T mm	B mm	L mm	Wt g	Wt lb	Per. condition
A22006000120	SFL 06030.06	NK 120	60	20	6	40	0.000	12,700	10
A22006000150	SFL 06030.06	NK 150	60	20	6	40	0.000	12,700	10
A22006000240	SFL 06030.06	NK 240	60	20	6	40	0.000	12,700	10
A22006000320	SFL 06030.06	NK 320	60	20	6	40	0.000	12,700	10
A2200600040	SFL 06030.06	NK 40	60	30	6	40	0.000	12,700	10
A2200600060	SFL 06030.06	NK 60	60	30	6	40	0.000	12,700	10
A2200600080	SFL 06030.06	NK 80	60	30	6	40	0.000	12,700	10
A2200600100	SFL 06030.06	NK 100	60	30	6	40	0.000	12,700	10
A2200600120	SFL 06030.06	NK 120	60	30	6	40	0.000	12,700	10
A2200600150	SFL 06030.06	NK 150	60	30	6	40	0.000	12,700	10
A2200600240	SFL 06030.06	NK 240	60	30	6	40	0.000	12,700	10
A2200600320	SFL 06030.06	NK 320	60	30	6	40	0.000	12,700	10
A220060040	SFL 06040.06	NK 40	60	40	6	40	0.000	12,700	10
A220060060	SFL 06040.06	NK 60	60	40	6	40	0.000	12,700	10
A220060080	SFL 06040.06	NK 80	60	40	6	40	0.000	12,700	10
A220060100	SFL 06040.06	NK 100	60	40	6	40	0.000	12,700	10
A220060150	SFL 06040.06	NK 150	60	40	6	40	0.000	12,700	10
A220060240	SFL 06040.06	NK 240	60	40	6	40	0.000	12,700	10
A220060320	SFL 06040.06	NK 320	60	40	6	40	0.000	12,700	10
A22006040	SFL 06050.06	NK 40	60	50	6	40	0.000	8,500	10
A22006060	SFL 06050.06	NK 60	60	50	6	40	0.000	8,500	10
A22006080	SFL 06050.06	NK 80	60	50	6	40	0.000	8,500	10
A220060100	SFL 06050.06	NK 100	60	50	6	40	0.000	8,500	10
A220060150	SFL 06050.06	NK 150	60	50	6	40	0.000	8,500	10
A220060240	SFL 06050.06	NK 240	60	50	6	40	0.000	8,500	10
A220080150	SFL 08015.06	NK 60	80	15	6	40	0.000	3,500	10
A220080160	SFL 08015.06	NK 60	80	15	6	40	0.000	3,500	10
A220080170	SFL 08015.06	NK 120	80	15	6	40	0.000	3,500	10
A220080180	SFL 08015.06	NK 240	80	15	6	40	0.000	3,500	10
A220080190	SFL 08015.06	NK 320	80	15	6	40	0.000	3,500	10
A220080200	SFL 08020.06	NK 60	80	20	6	40	0.000	3,500	10
A220080210	SFL 08020.06	NK 60	80	20	6	40	0.000	3,500	10
A220080220	SFL 08020.06	NK 120	80	20	6	40	0.000	3,500	10
A220080230	SFL 08020.06	NK 240	80	20	6	40	0.000	3,500	10
A220080240	SFL 08020.06	NK 320	80	20	6	40	0.000	3,500	10
A220080300	SFL 08030.06	NK 60	80	30	6	40	0.000	3,500	10
A220080310	SFL 08030.06	NK 60	80	30	6	40	0.000	3,500	10
A220080320	SFL 08030.06	NK 120	80	30	6	40	0.000	3,500	10
A220080330	SFL 08030.06	NK 240	80	30	6	40	0.000	3,500	10
A220080340	SFL 08030.06	NK 320	80	30	6	40	0.000	3,500	10
A220080400	SFL 08040.06	NK 60	80	40	6	40	0.000	3,500	10
A220080410	SFL 08040.06	NK 60	80	40	6	40	0.000	3,500	10
A220080420	SFL 08040.06	NK 120	80	40	6	40	0.000	3,500	10
A220080430	SFL 08040.06	NK 240	80	40	6	40	0.000	3,500	10
A220080440	SFL 08040.06	NK 320	80	40	6	40	0.000	3,500	10
A220080450	SFL 08040.06	NK 40	80	50	6	40	0.000	2,500	10
A220080460	SFL 08040.06	NK 60	80	50	6	40	0.000	2,500	10
A220080470	SFL 08040.06	NK 80	80	50	6	40	0.000	2,500	10
A220080480	SFL 08040.06	NK 120	80	50	6	40	0.000	2,500	10
A220080490	SFL 08040.06	NK 240	80	50	6	40	0.000	2,500	10
A220080500	SFL 08040.06	NK 320	80	50	6	40	0.000	2,500	10
A220080510	SFL 08040.06	NK 40	80	60	6	40	0.000	2,500	10
A220080520	SFL 08040.06	NK 60	80	60	6	40	0.000	2,500	10
A220080530	SFL 08040.06	NK 120	80	60	6	40	0.000	2,500	10
A220080540	SFL 08040.06	NK 240	80	60	6	40	0.000	2,500	10
A220080550	SFL 08040.06	NK 320	80	60	6	40	0.000	2,500	10
A220080560	SFL 08040.06	NK 40	80	70	6	40	0.000	2,500	10
A220080570	SFL 08040.06	NK 60	80	70	6	40	0.000	2,500	10
A220080580	SFL 08040.06	NK 120	80	70	6	40	0.000	2,500	10
A220080590	SFL 08040.06	NK 240	80	70	6	40	0.000	2,500	10
A220080600	SFL 08040.06	NK 320	80	70	6	40	0.000	2,500	10
A220080610	SFL 08040.06	NK 40	80	80	6	40	0.000	2,500	10
A220080620	SFL 08040.06	NK 60	80	80	6	40	0.000	2,500	10
A220080630	SFL 08040.06	NK 120	80	80	6	40	0.000	2,500	10
A220080640	SFL 08040.06	NK 240	80	80	6	40	0.000	2,500	10
A220080650	SFL 08040.06	NK 320	80	80	6	40	0.000	2,500	10
A220080660	SFL 08040.06	NK 40	80	90	6	40	0.000	2,500	10
A220080670	SFL 08040.06	NK 60	80	90	6	40	0.000	2,500	10
A220080680	SFL 08040.06	NK 120	80	90	6	40	0.000	2,500	10
A220080690	SFL 08040.06	NK 240	80	90	6	40	0.000	2,500	10
A220080700	SFL 08040.06	NK 320	80	90	6	40	0.000	2,500	10
A220080710	SFL 08040.06	NK 40	80	100	6	40	0.000	2,500	10
A220080720	SFL 08040.06	NK 60	80	100	6	40	0.000	2,500	10
A220080730	SFL 08040.06	NK 120	80	100	6	40	0.000	2,500	10
A220080740	SFL 08040.06	NK 240	80	100	6	40	0.000	2,500	10
A220080750	SFL 08040.06	NK 320	80	100	6	40	0.000	2,500	10
A220080760	SFL 08040.06	NK 40	80	110	6	40	0.000	2,500	10
A220080770	SFL 08040.06	NK 60	80	110	6	40	0.000	2,500	10
A220080780	SFL 08040.06	NK 120	80	110	6	40	0.000	2,500	10
A220080790	SFL 08040.06	NK 240	80	110	6	40	0.000	2,500	10
A220080800	SFL 08040.06	NK 320	80	110	6	40	0.000	2,500	10
A220080810	SFL 08040.06	NK 40	80	120	6	40	0.000	2,500	10
A220080820	SFL 08040.06	NK 60	80	120	6	40	0.000	2,500	10
A220080830	SFL 08040.06	NK 120	80	120	6	40	0.000	2,500	10
A220080840	SFL 08040.06	NK 240	80	120	6	40	0.000	2,500	10
A220080850	SFL 08040.06	NK 320	80	120	6	40	0.000	2,500	10
A220080860	SFL 08040.06	NK 40	80	130	6	40	0.000	2,500	10
A220080870	SFL 08040.06	NK 60	80	130	6	40	0.000	2,500	10
A220080880	SFL 08040.06	NK 120	80	130	6	40	0.000	2,500	10
A220080890	SFL 08040.06	NK 240	80	130	6	40	0.000	2,500	10
A220080900	SFL 08040.06	NK 320	80	130	6	40	0.000	2,500	10
A220080910	SFL 08040.06	NK 40	80	140	6	40	0.000	2,500	10
A220080920	SFL 08040.06	NK 60	80	140	6	40	0.000	2,500	10
A220080930	SFL 08040.06	NK 120	80	140	6	40	0.000	2,500	10
A220080940	SFL 08040.06	NK 240	80	140	6	40	0.000	2,500	10
A220080950	SFL 08040.06	NK 320	80	140	6	40	0.000	2,500	10
A220080960	SFL 08040.06	NK 40	80	150	6	40	0.000	2,500	10
A220080970	SFL 08040.06	NK 60	80	150	6	40	0.000	2,500	10
A220080980	SFL 08040.06	NK 120	80	150	6	40	0.000	2,500	10
A220080990	SFL 08040.06	NK 240	80	150	6	40	0.000	2,500	10
A220081000	SFL 08040.06	NK 320	80	150	6	40	0.000	2,500	10

 PRODUCT LISTING  
 10/2024 (Rev. 01/24)



## SFL Base-X mounted flap wheel

- for rough and fine grinding of many different materials
- used as a handhold tool, good for smoothing, deburring, fitting, deburring, surface grinding, texturing and beveling
- good price-to-performance ratio with regular aluminum oxide



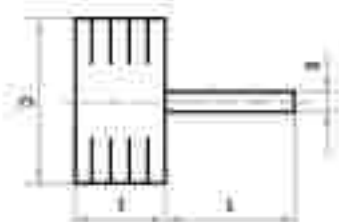
★☆☆

Product number	Description	Gr	D mm	T mm	B mm	L mm	SP	W. type	Peak condition
A22003070660	SFL 03070.06	NK 60	30	10	6	40	10,000	10,000	20
A22003070680	SFL 03070.08	NK 80	30	10	6	40	10,000	10,000	20
A220030706120	SFL 03070.06	NK 120	30	10	6	40	10,000	10,000	20
A220030706150	SFL 03070.06	NK 150	30	10	6	40	10,000	10,000	20
A220040150800	SFL 04015.08	NK 80	40	15	6	40	12,000	10,100	20
A220040150120	SFL 04015.08	NK 120	40	15	6	40	12,000	10,100	20
A220040150150	SFL 04015.08	NK 150	40	15	6	40	12,000	10,100	20
A220040200800	SFL 04020.08	NK 80	40	20	6	40	12,000	10,100	20
A220040200120	SFL 04020.08	NK 120	40	20	6	40	12,000	10,100	20
A220040200150	SFL 04020.08	NK 150	40	20	6	40	12,000	10,100	20
A220050200800	SFL 05020.08	NK 80	50	20	6	40	0,000	15,300	20
A220050200120	SFL 05020.08	NK 120	50	20	6	40	0,000	15,300	20
A220050200150	SFL 05020.08	NK 150	50	20	6	40	0,000	15,300	20
A220050300800	SFL 05030.08	NK 80	50	30	6	40	0,000	15,300	20
A220050300120	SFL 05030.08	NK 120	50	30	6	40	0,000	15,300	20
A220050300150	SFL 05030.08	NK 150	50	30	6	40	0,000	15,300	20
A220060300800	SFL 06030.08	NK 80	60	30	6	40	0,000	12,700	20
A220060300120	SFL 06030.08	NK 120	60	30	6	40	0,000	12,700	20
A220060300150	SFL 06030.08	NK 150	60	30	6	40	0,000	12,700	20



## SFB slotted flap wheel

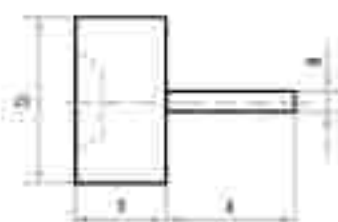
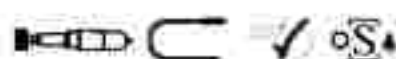
- slotted flaps for greater flexibility
- adapts itself perfectly to the contours of the workpiece
- used as a handhold tool, suitable for smoothing, deburring, fitting, deburring, surface grinding, texturing and beveling



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Product number	Description	Gr	D mm	T mm	B mm	L mm	SP	W. type	Peak condition
A220040200800	SFB 04020.08	NK 80	40	20	6	40	12,000	10,100	10
A220050200800	SFB 05020.08	NK 80	50	20	6	40	0,000	15,300	10
A220050300120	SFB 05030.08	NK 120	50	30	6	40	0,000	15,300	10
A220060300800	SFB 06030.08	NK 80	60	30	6	40	0,000	12,700	10
A220060300120	SFB 06030.08	NK 120	60	30	6	40	0,000	12,700	10

## SFT mounted flap wheel with recess



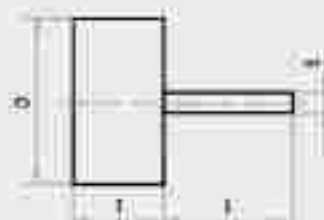
- mounted flap wheels with recess: optimized for face and peripheral grinding
- used as a handhold tool, suitable for smoothing, chamfering, fettling, deburring, surface grinding, texturing and beveling
- for rough and fine grinding of many different materials

★★★

Product number	Description	Grit	D mm	T mm	H mm	L mm	$V_c$ (m/min)	$V_s$ (m/min)	Flap condition
A210004039000	SFT 04030.06	NK 60	40	30	6	40	12,000	10,100	10
A210004039000	SFT 04030.06	NK 80	40	30	6	40	12,000	10,100	10
A210004039150	SFT 04030.06	NK 150	40	30	6	40	12,000	10,100	10

GRINDING AND POLISHING - APP MANUAL APP

## SFT mounted flap wheel for stainless steel



- regular aluminum oxide with active abrasive surface layer
- optimized for use on stainless steel
- used as a handhold tool, suitable for smoothing, chamfering, fettling, deburring, surface grinding, texturing and beveling

★★☆

Product number	Description	Grit	D mm	T mm	H mm	L mm	$V_c$ (m/min)	$V_s$ (m/min)	Flap condition
A220030001120	SFE 03010.03	NKE 120	30	10	3	40	14,000	12,000	10
A220030001040	SFE 03010.06	NKE 60	30	10	6	40	14,000	25,400	10
A220030001000	SFE 03010.00	NKE 00	30	10	0	40	14,000	25,400	10
A220030001150	SFE 03010.06	NKE 150	30	10	6	40	14,000	25,400	10
A220040058800	SFE 04015.06	NKE 60	40	15	6	40	12,000	10,100	10
A220040058800	SFE 04015.06	NKE 80	40	15	6	40	12,000	10,100	10
A220040058730	SFE 04015.06	NKE 120	40	15	6	40	12,000	10,100	10
A220060020000	SFE 06020.00	NKE 00	60	20	0	40	9,000	12,700	10
A220060020000	SFE 06020.00	NKE 60	60	20	0	40	9,000	12,700	10
A220060020100	SFE 06020.00	NKE 120	60	20	0	40	9,000	12,700	10
A220080020000	SFE 08020.00	NKE 00	80	20	0	40	6,000	8,500	10
A220080020000	SFE 08020.00	NKE 60	80	20	0	40	6,000	8,500	10



# 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

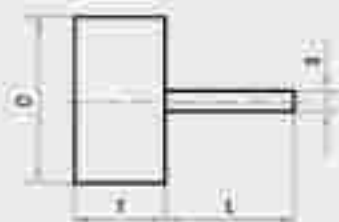
Machining high-tech materials used in the aerospace industry, such as aluminium, titanium, nickel-based alloys or composite materials, requires high-tech tools of the utmost reliability. LUKAS tools for the aerospace industry, e.g. with silicon carbide, can handle the most demanding requirements for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



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



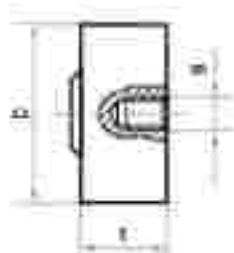
## SFC mounted flap wheel, silicon carbide



Product number	Description	Grit	D mm	r mm	H mm	L mm	$V_c$ (m/s)	$v$ (m/s)	Flap width
A2202101010080	SFC 00910 08	SIC 80	30	10	6	40	16,000	25,400	10
A2202101010150	SFC 00910 08	SIC 150	30	10	6	40	16,000	25,400	10
A2202101010600	SFC 04015 06	SIC 80	40	15	6	45	12,000	19,100	10
A2202101010800	SFC 04015 08	SIC 80	60	30	6	40	8,000	12,700	10
A2202101010120	SFC 04015 08	SIC 120	60	30	6	40	8,000	12,700	10
A2202101010120	SFC 04015 08	SIC 150	60	30	6	40	8,000	12,700	10

■ Aluminium ■ Titanium ■ Steel/Construction material ■ Plastic/Steel ■ Bronze ■ Inconel/Steel ■ Steel ■ Cast material

## SFI mounted flap wheel with internal thread

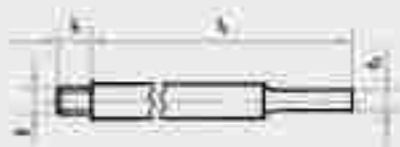


- machine difficult to reach areas with the suitable long Shank
- thread connection for fast tool changing
- used as a handhold tool, suitable for smoothing, chamfering, beveling, deburring, surface grinding, tootharing and bevelling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adaptor (see below)

★★☆

Product number	Description	Code	D mm	T mm	H Thread	V max rpm	P max rpm	matching tool adaptor	Part number
A2307030000130	SFI 03000.M4	NK 120	30	5	M4	14,000	10,000	WAZH 0404	10
A2307030000130	SFI 03010.M4	NK 120	30	10	M4	14,000	10,000	WAZH 0407	10
A2307030000150	SFI 03000.M4	NK 150	30	10	M4	10,000	10,000	WAZH 0407	10
A2307040000000	SFI 04005.M6	NK 80	40	15	M6	10,000	10,000	WAZH 0600	10
A2307040000130	SFI 04005.M6	NK 120	40	15	M6	10,000	10,000	WAZH 0600	10
A2307050000000	SFI 05000.M6	NK 80	50	20	M6	7000	2500	WAZH 0612	10

## Tool adapters for SFI mounted flap wheels



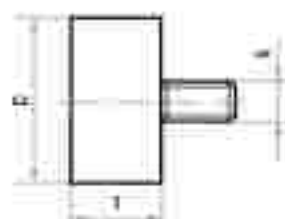
★★☆

Product number	Description	L mm	L1 mm	H Thread	L mm	Part number
A3E300404	WAZH 0404	6	88	M4	4	1
A3E300407	WAZH 0407	8	88	M4	7	1
A3E300600	WAZH 0600	8	100	M6	8	1
A3E300612	WAZH 0612	8	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 smoothing, descaling, fettling, deburring, surface grinding, texturing and bowling
- for rough and fine grinding of many different materials
- The specified maximum permissible speeds only apply when using the matching tool adapter (see below)



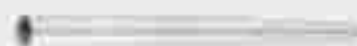
★★★

Product number	Description	Grit	D mm	L mm	Thread	$v_{max}$ rpm	$n_{max}$ rpm	Peak load time
A220001000150	SFA 0100 ME	NE 150	15	5	M5	10,000	10,000	10
A220001000240	SFA 0100 ME	NE 240	15	5	M5	10,000	10,000	10
A2200000005150	SFA 0200 ME	NE 150	20	5	M5	10,000	10,000	10
A2200000005240	SFA 0200 ME	NE 240	20	5	M5	10,000	10,000	10
A2200000005120	SFA 0300 ME	NE 120	30	5	M5	10,000	10,000	10
A2200000005150	SFA 0300 ME	NE 150	30	5	M5	10,000	10,000	10
A2200000005240	SFA 0300 ME	NE 240	30	5	M5	10,000	10,000	10

Recommended for:  Rough/Finish  Wheel  Abrasive  Chisel/Grind  Plan/Block  Hammer



## Tool adapter for SFA mounted flap wheels



★★★

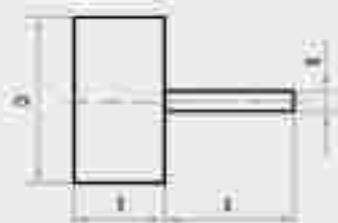
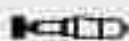
Product number	Description	D mm	L mm	Thread	Peak load time
A30000500	WADA 05	6	100	M5	1



# 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 flywheels
- machining bores in turbine blades
- versatile special applications

★★★

Product number	Description	Size	D mm	T mm	d mm	L mm	Max. rpm	Max. width
A225010104100	MFS 011010.06	NK 150	15	10	6	40	10,000	10
A2250101045000	MFS 011015.06	NK 150	15	15	6	50	10,000	10
A2250101500150	MFS 011501.06	NK 150	15	30	6	40	10,000	10
A225010150015000	MFS 011501.06	NK 150	15	30	6	100	10,000	10
A225020104150	MFS 02010.06	NK 150	20	10	6	40	10,000	10
A2250200415000	MFS 02010.06	NK 150	20	10	6	100	10,000	10
A225020300150	MFS 02030.06	NK 150	20	30	6	40	10,000	10
A22502030015000	MFS 02030.06	NK 150	20	30	6	100	10,000	10
A225025104150	MFS 02510.06	NK 150	25	10	6	40	10,000	10
A22502510415000	MFS 02510.06	NK 150	25	10	6	100	10,000	10
A225025304150	MFS 02530.06	NK 150	25	30	6	40	10,000	10
A22502530415000	MFS 02530.06	NK 150	25	30	6	100	10,000	10



### SAFETY INFORMATION

To safely use mini flap wheels with a long stem, 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

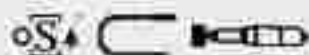
## READY FOR EVERY WORK SCENARIO

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.



## SFV mounted flap wheel, zirconia alumina

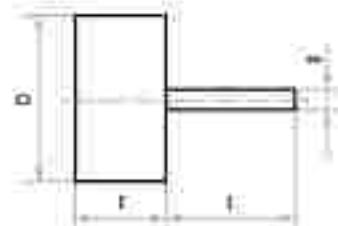
- achieves especially high stock removal rates on hard and tough materials such as stainless steel and a long tool life
- manufactured with zirconia alumina for extreme hardness and sharpness
- used as a handhold tool, ideal for matt finishing, satin-matt finishing, polishing, clearing or final finishing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



★★★

Product number	Description	Quality	Dia	D max	T max	W max	L max	P max	R max	Tool material
AZ1000010030	SFV 0300.06	Z100	2K 180	30	10	6	40	10,000	14,000	10
AZ2000020030	SFV 04020.06	Z100	2K 180	40	20	6	40	2,000	14,000	10
AZ2000010030	SFV 0200.06	Z100	2K 180	50	10	6	40	6,000	11,000	10
AZ1000000020	SFV 0000.06	Z100	2K 180	60	30	6	40	5,000	3,000	10
AZ1000000030	SFV 0050.06	Z100	2K 180	80	50	6	40	4,000	2,000	10

# SFV mounted flap wheel, regular aluminium oxide



- used as a handhold tool, ideal for rust finishing, scale-rust finishing, polishing, skiving or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working

★★★

Product number	Description	Quality	Grit	D mm	L mm	d mm	l mm	P <sub>max</sub> mm <sup>2</sup>	P <sub>min</sub> mm <sup>2</sup>	Flap thickness
A220300304104	SFV 03020.04	A104	NK 100	30	20	8	40	10,000	14,000	10
A220300404107	SFV 03040.04	A107	NK 200	30	40	8	40	10,000	14,000	10
A2203040304104	SFV 04020.04	A104	NK 100	40	20	8	40	1500	14,000	10
A2203040304104	SFV 04020.04	A104	NK 100	40	20	8	40	1500	14,000	10
A2203040304107	SFV 04020.04	A107	NK 200	40	20	8	40	1500	14,000	10
A2203040304104	SFV 04030.04	A104	NK 100	40	30	8	40	1500	14,000	10
A2203040304104	SFV 04030.04	A104	NK 100	40	30	8	40	1500	14,000	10
A2203040304107	SFV 04030.04	A107	NK 200	40	30	8	40	1500	14,000	10
A2203050104104	SFV 05010.04	A104	NK 100	50	10	8	40	6,000	11,000	10
A2203050304104	SFV 05030.04	A104	NK 100	50	30	8	40	6,000	11,000	10
A2203050304104	SFV 05030.04	A104	NK 100	50	30	8	40	6,000	11,000	10
A2203050304107	SFV 05030.04	A107	NK 200	50	30	8	40	6,000	11,000	10
A2203050304104	SFV 05030.04	A104	NK 100	50	30	8	40	6,000	11,000	10
A2203050304104	SFV 05030.04	A104	NK 100	50	30	8	40	6,000	11,000	10
A2203050404107	SFV 05040.04	A107	NK 200	50	40	8	40	6,000	11,000	10
A2203050504104	SFV 05050.04	A104	NK 100	50	50	8	40	6,000	11,000	10
A2203050504104	SFV 05050.04	A104	NK 100	50	50	8	40	6,000	11,000	10
A2203050504107	SFV 05050.04	A107	NK 200	50	50	8	40	6,000	11,000	10
A2203050504104	SFV 05050.04	A104	NK 100	50	50	8	40	6,000	11,000	10
A2203060404104	SFV 06040.04	A104	NK 100	60	40	8	40	5,000	9,000	10
A2203060404104	SFV 06040.04	A104	NK 100	60	40	8	40	5,000	9,000	10
A2203060404107	SFV 06040.04	A107	NK 200	60	40	8	40	5,000	9,000	10
A2203060504104	SFV 06050.04	A104	NK 100	60	50	8	40	5,000	9,000	10
A2203060504104	SFV 06050.04	A104	NK 100	60	50	8	40	5,000	9,000	10
A2203060504107	SFV 06050.04	A107	NK 200	60	50	8	40	5,000	9,000	10
A2203060404104	SFV 06040.04	A104	NK 100	60	40	8	40	4,000	7,000	10
A2203060404104	SFV 06040.04	A104	NK 100	60	40	8	40	4,000	7,000	10
A2203060504104	SFV 06050.04	A104	NK 100	60	50	8	40	4,000	7,000	10
A2203060504104	SFV 06050.04	A104	NK 100	60	50	8	40	4,000	7,000	10
A2203060504107	SFV 06050.04	A107	NK 200	60	50	8	40	4,000	7,000	10

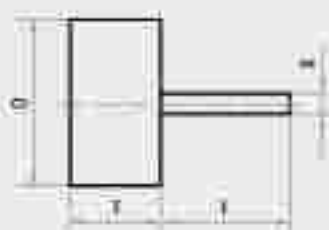
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 for more info





## SFV mounted flap wheel, silicon carbide

- mounted flap wheels with silicon carbide (ideally suited for machining aluminum and aluminum 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 rust finishing, scale rust finishing, polishing, cleaning or final finishing of workpiece surfaces
- adapts itself perfectly to uneven surfaces for cost-efficient working



★★★

Product number	Designation	Quality	Grit	D mm	T mm	d mm	L mm	Flap spec.	Max. rpm	Peak condition
A2203000153207	SFV 03015.00	C207	SiC 200	22	15	7	40	10.000	14.000	10
A2203000209206	SFV 04020.00	C206	SiC 180	40	20	6	40	7500	14.000	10
A2203000306207	SFV 04030.00	C207	SiC 200	40	20	6	40	7500	14.000	10
A2203000306207	SFV 04030.00	C207	SiC 200	40	20	6	40	7500	14.000	10
A2203000306204	SFV 05030.00	C204	SiC 100	50	20	6	40	6.000	11.000	10
A2203000306206	SFV 05030.00	C206	SiC 180	50	20	6	40	6.000	11.000	10
A2203000306207	SFV 05030.00	C207	SiC 200	50	20	6	40	6.000	11.000	10
A2203000306207	SFV 05030.00	C207	SiC 200	50	20	6	40	6.000	11.000	10
A2203000404207	SFV 06040.00	C207	SiC 200	60	40	6	40	6.000	11.000	10
A2203000404204	SFV 06040.00	C204	SiC 100	60	40	6	40	5.000	9.000	10
A2203000404206	SFV 06040.00	C206	SiC 180	60	40	6	40	5.000	9.000	10
A2203000404207	SFV 06040.00	C207	SiC 200	60	40	6	40	5.000	9.000	10
A2203000404204	SFV 06040.00	C204	SiC 100	60	40	6	40	5.000	9.000	10
A2203000404206	SFV 06040.00	C206	SiC 180	60	40	6	40	5.000	9.000	10
A2203000404207	SFV 06040.00	C207	SiC 200	60	40	6	40	5.000	9.000	10
A2203000506204	SFV 08050.00	C204	SiC 100	80	50	6	40	4.000	7.000	10
A2203000506206	SFV 08050.00	C206	SiC 180	80	50	6	40	4.000	7.000	10
A2203000506207	SFV 08050.00	C207	SiC 200	80	50	6	40	4.000	7.000	10

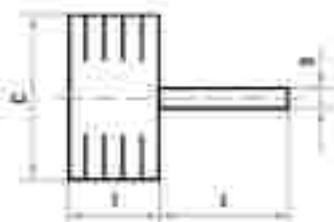
Recommended for: ■ Aluminum ■ Titanium ■ Steel ■ Cast iron ■ Stainless steel ■ Inconel

Special quality for the aerospace industry



## SFA mounted fleece discs

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



★★★

Product number	Designation	Quality	Grit	D mm	T mm	d mm	L mm	Flap spec.	Max. rpm	Peak condition
A2223001506204	SFA 06050.00	A104	NK 100	60	50	6	40	5.000	9.000	10
A2223001506206	SFA 06050.00	A106	NK 180	60	50	6	40	5.000	9.000	10
A2223001506207	SFA 06050.00	A107	NK 200	60	50	6	40	5.000	9.000	10
A2223001506204	SFA 08050.00	A104	NK 100	80	50	6	40	4.000	7.000	10
A2223001506206	SFA 08050.00	A106	NK 180	80	50	6	40	4.000	7.000	10
A2223001506207	SFA 08050.00	A107	NK 200	80	50	6	40	4.000	7.000	10

Recommended for: ■ Steel ■ Cast iron ■ Aluminum ■ Cast iron ■ Titanium ■ Inconel

# COMBINATION OF ABRASIVE FLEECE AND ABRASIVE CLOTH

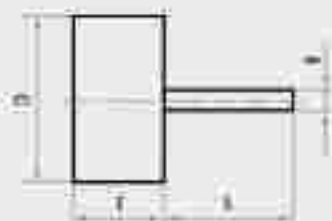
## GREATER STABILITY FOR SUSTAINED USAGE



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 handhold power tools and, thanks to their stability, are ideally suited for cleaning, derusting, surface preparation, texturing and rough grinding.

## 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 handhold tool, ideal for the cleaning, derusting, surface preparation, texturing and rough grinding of workpiece surfaces

★★★

Product number	Description	Code	D mm	T mm	B mm	L mm	P mm	P <sub>max</sub> mm	Flap count
AZ204040200120	SFM 04020.06	TF 12000	40	20	8	40	2,500	14,000	10
AZ204050200120	SFM 04020.01	TF 12000	50	30	8	40	5,000	3,000	10
A7204000200120	SFM 00000.06	TF 12000	60	50	8	40	4,000	1000	10
AZ204050400120	SFM 00000.06	TF 120/100	60	40	8	40	4,000	1000	10



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

- for continuous working
- used as a handheld tool, ideal for the clearing, descaling, surface preparation, finishing and roughening of workplace surfaces

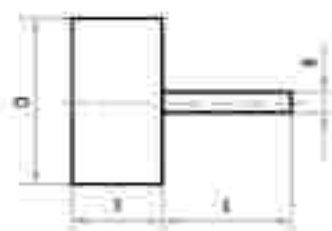


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Product number	Description	Code	Grain	D mm	T mm	L mm	R mm	kg	kg	kg
A2204030300104	SFM 03030.06	A10400	NK 100/60	30	30	6	40	10,000	14,000	10
A2204040200104	SFM 04020.06	A10400	NK 100/60	40	20	6	40	1500	14,000	10
A2204040200100	SFM 04020.05	A100150	NK 180/150	40	20	6	40	1500	14,000	10
A2204040200107	SFM 04020.06	A100140	NK 280/140	40	20	6	40	1500	14,000	10
A2204040300104	SFM 04030.06	A10400	NK 100/60	60	30	6	40	1500	14,000	10
A2204040300100	SFM 04030.06	A100150	NK 180/150	60	30	6	40	1500	14,000	10
A2204040300107	SFM 04030.06	A100140	NK 280/140	60	30	6	40	1500	14,000	10
A2204050200104	SFM 05020.06	A10400	NK 100/60	50	20	6	40	2,000	11,000	10
A2204050200100	SFM 05020.06	A100150	NK 180/150	50	20	6	40	2,000	11,000	10
A2204050200106	SFM 05020.06	A100150	NK 180/150	50	30	6	40	2,000	11,000	10
A2204050200107	SFM 05020.06	A100140	NK 280/140	50	30	6	40	2,000	11,000	10
A2204050400104	SFM 05040.06	A10400	NK 100/60	50	40	6	40	2,000	11,000	10
A2204050400100	SFM 05040.06	A100150	NK 180/150	50	40	6	40	2,000	11,000	10
A2204060200104	SFM 06020.06	A10400	NK 100/60	60	20	6	40	3,000	9,000	10
A2204060200100	SFM 06020.06	A100150	NK 180/150	60	20	6	40	3,000	9,000	10
A2204060200107	SFM 06020.06	A100140	NK 280/140	60	20	6	40	3,000	9,000	10
A2204060400104	SFM 06040.06	A10400	NK 100/60	60	40	6	40	3,000	9,000	10
A2204060400100	SFM 06040.06	A100150	NK 180/150	60	40	6	40	3,000	9,000	10
A2204060400107	SFM 06040.06	A100140	NK 280/140	60	40	6	40	3,000	9,000	10
A2204060500104	SFM 06050.06	A10400	NK 100/60	60	50	6	40	3,000	9,000	10
A2204060500100	SFM 06050.06	A100150	NK 180/150	60	50	6	40	3,000	9,000	10
A2204080400104	SFM 08040.06	A10400	NK 100/60	80	40	6	40	2,000	7,000	10
A2204080400100	SFM 08040.06	A100150	NK 180/150	80	40	6	40	2,000	7,000	10
A2204080400107	SFM 08040.06	A100140	NK 280/140	80	40	6	40	2,000	7,000	10
A2204080500104	SFM 08050.06	A10400	NK 100/60	80	50	6	40	2,000	7,000	10
A2204080500100	SFM 08050.06	A100150	NK 180/150	80	50	6	40	2,000	7,000	10
A2204080500107	SFM 08050.06	A100140	NK 280/140	80	50	6	40	2,000	7,000	10



## 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, de-rusting, preparation, finishing and rough of workpiece surfaces

Product number	Description	Quantity	Gr.	D mm	L mm	H mm	L mm	$v_{max}$ m/min	$n_{max}$ rpm	Part numbers
A2204040206304	SFM 04020 DE	C20400	SiC 100/80	40	20	6	40	1500	14,000	10
A2204040206306	SFM 04020 DE	C206150	SiC 100/150	40	20	6	40	1500	14,000	10
A2204040206304	SFM 04030 DE	C20400	SiC 100/80	40	30	6	40	1500	14,000	10
A2204040206306	SFM 04030 DE	C206150	SiC 100/150	40	30	6	40	1500	14,000	10
A2204040206307	SFM 04030 DE	C207240	SiC 300/240	40	30	6	40	1500	14,000	10
A2204050206304	SFM 05020 DE	C20400	SiC 100/80	50	20	6	40	6,000	11,000	10
A2204050206306	SFM 05020 DE	C206150	SiC 100/150	50	20	6	40	6,000	11,000	10
A2204050206304	SFM 05030 DE	C20400	SiC 100/80	50	30	6	40	5,000	3,000	10
A2204050206306	SFM 05030 DE	C206150	SiC 100/150	50	30	6	40	5,000	3,000	10
A2204050206307	SFM 05030 DE	C207240	SiC 300/240	50	30	6	40	5,000	3,000	10
A2204060506304	SFM 06050 DE	C20400	SiC 100/80	60	50	6	40	4,000	7,000	10
A2204060506306	SFM 06050 DE	C206150	SiC 100/150	60	50	6	40	4,000	7,000	10

## 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

NK 60

Bore 12

DESCRIPTION

GRIT

BORE (Ø)

## 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.



### LSL, flap wheel of abrasive cloth with thread

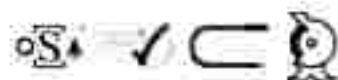


- fits on commercially available angle grinders and is used in place of mounted flap wheels with shanks
- can be used without a clamping nut
- ideal for reworking weld seams on stainless steels
- ideal for derusting, removing paint and annealing lacquers, reworking welding seams and for grinding work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

★★★

Product Number	Description	Qty	D (mm)	T (mm)	Thread	Flap type	Flap (µm)	Flap (mm)	Flap (mm)
A22801252000A0	LSL 12500	NK 40	125	20	M14	500	12,000	5	
A22801252000A0001	LSL 12500	NK 40	125	20	5/8"	500	12,000	5	
A2280125200000	LSL 12500	NK 80	125	20	M14	500	12,000	5	
A2280125200000001	LSL 12500	NK 80	125	20	5/8"	500	12,000	5	
A2280125200000	LSL 12500	NK 20	125	20	M14	500	12,000	5	
A2280125200000001	LSL 12500	NK 20	125	20	5/8"	500	12,000	5	
A2280125200120	LSL 12500	NK 120	125	20	M14	500	12,000	5	
A228012520010001	LSL 12500	NK 100	125	20	5/8"	500	12,000	5	

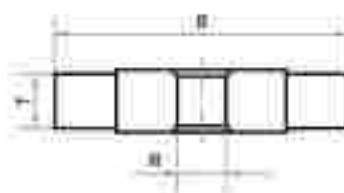




## LSL flap wheel of abrasive cloth

INDIVIDUAL CUSTOMER SOLUTIONS

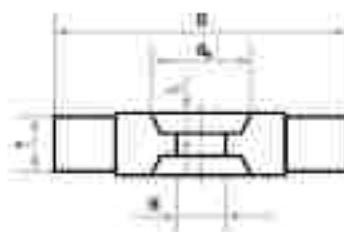
- for cleaning, deburring, chamfering, surface preparation, forming and roughening
- Other dimensions, forms or qualities are available on request. Available diameters 60 mm to max. 400 mm
- A sample order for this LUKAS custom solution can be found on page 561
- $v_{max}$  30 m/s in handheld use
- $v_{max}$  50 m/s in stationary use
- Free form applies for stationary use



★★☆☆

Description	Code	D mm	T mm	H mm	Weight (kg)	P (g/m²)	W (mm)	Min. order quantity
LSL 125025	NK 60	125	25	13-16-20	4,500	1800	25	
LSL 125025	NK 80	125	25	13-16-20	4,500	1900	25	
LSL 125025	NK 120	125	25	13-16-20	4,500	2600	25	
LSL 125025	NK 150	125	25	13-16-20	4,500	3800	25	
LSL 125025	NK 240	125	25	13-16-20	4,500	2600	25	

\*minimum order quantity



Description	Code	D mm	T mm	H mm	Weight (kg) with center hole	Weight (kg) with outer hole	P (g/m²)	W (mm)	Min. order quantity
LSL 150060	NK 60	150	50	13-16-20	47	38	3,000	6,300	25
LSL 150060	NK 80	150	50	13-16-20	47	38	3,000	6,300	25
LSL 150060	NK 120	150	50	13-16-20	47	38	2,800	6,300	25
LSL 150060	NK 150	150	50	13-16-20	47	38	2,800	6,300	25
LSL 150060	NK 240	150	50	13-16-20	47	38	1,900	6,300	25
LSL 160060	NK 60	165	50	13-16-20	47	38	3,400	5,700	25
LSL 160060	NK 80	165	50	13-16-20	47	38	2,400	5,700	25
LSL 160060	NK 120	165	50	13-16-20	47	38	2,400	5,700	25
LSL 160060	NK 150	165	50	13-16-20	47	38	2,400	5,700	25
LSL 160060	NK 240	165	50	13-16-20	47	38	2,400	5,700	25
LSL 200025	NK 60	200	25	20-25-32	71	50	2,800	4,700	25
LSL 200025	NK 80	200	25	20-25-32	71	50	2,800	4,700	25
LSL 200025	NK 120	200	25	20-25-32	71	50	2,800	4,700	25
LSL 200025	NK 150	200	25	20-25-32	71	50	2,800	4,700	25
LSL 200025	NK 240	200	25	20-25-32	71	50	2,800	4,700	25
LSL 200050	NK 60	200	50	20-25-32	71	50	2,800	4,700	25
LSL 200050	NK 80	200	50	20-25-32	71	50	2,800	4,700	25
LSL 200050	NK 120	200	50	20-25-32	71	50	2,800	4,700	25
LSL 200050	NK 150	200	50	20-25-32	71	50	2,800	4,700	25
LSL 200050	NK 240	200	50	20-25-32	71	50	2,800	4,700	25

\*minimum order quantity

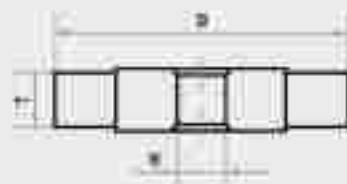
# LUKAS FLAP WHEEL MADE OF ABRASIVE FLEECE

ADAPTED TO HANDLE YOUR SPECIFIC CHALLENGES



## LSV, flap wheel of abrasive fleece

INDIVIDUAL CUSTOMER SOLUTIONS



- for most finishing, semi finishing, polishing, smoothing and final surface finishing
- Other structures, boxes or qualities in 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 five LUKAS custom solutions can be found on page 141
- $v_{max}$  25 m/s

★★★

Designation	Quality	Grit	Type	Ø mm	T mm	H mm	Min. rpm	Max. rpm	MCO* pcs
LSV 100050	A104 W	NK 100	soft	100	52	13-16-20	3.000	6.000	25
LSV 100050	A106 W	NK 100	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	SC 100	soft	100	52	13-16-20	3.000	6.000	25
LSV 100050	C206 W	SC 100	soft	100	50	13-16-20	3.000	6.000	25
LSV 100050	C207 W	SC 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	SC 100	medium	100	52	13-16-20	3.000	6.000	25
LSV 100050	C206 M	SC 100	medium	100	50	13-16-20	3.000	6.000	25
LSV 100050	C207 M	SC 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	52	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	SC 100	hard	100	50	13-16-20	3.000	6.000	25
LSV 100050	C206 H	SC 180	hard	100	50	13-16-20	3.000	6.000	25
LSV 100050	C207 H	SC 280	hard	100	52	13-16-20	3.000	6.000	25

\*maximum order quantity





Description	Quantity	Dist.	Type	D mm	T mm	H mm	number of teeth outer Ø, mm	number of teeth inner Ø, mm	K rpm	P rpm	MOQ* pcs.
LEV 150050	A104 W	NK 100	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A106 W	NK 180	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A107 W	NK 280	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E204 W	EC 100	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E206 W	EC 180	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E207 W	EC 280	soft	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A104 M	NK 100	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A106 M	NK 180	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A107 M	NK 280	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E204 M	EC 100	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E206 M	EC 180	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E207 M	EC 280	medium	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A104 H	NK 100	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A106 H	NK 180	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	A107 H	NK 280	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E204 H	EC 100	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E206 H	EC 180	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 150050	E207 H	EC 280	hard	150	50	13-16-20	47	38	2,000	4,000	25
LEV 160050	A104 W	NK 100	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A106 W	NK 180	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A107 W	NK 280	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E204 W	EC 100	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E206 W	EC 180	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E207 W	EC 280	soft	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A104 M	NK 100	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A106 M	NK 180	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A107 M	NK 280	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E204 M	EC 100	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E206 M	EC 180	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E207 M	EC 280	medium	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A104 H	NK 100	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A106 H	NK 180	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	A107 H	NK 280	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E204 H	EC 100	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E206 H	EC 180	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 160050	E207 H	EC 280	hard	160	50	13-16-20	47	38	1,900	3,800	25
LEV 200025	A104 W	NK 100	soft	200	25	20-25-32	71	60	1,500	3,000	25
LEV 200025	A106 W	NK 180	soft	200	25	20-25-32	71	60	1,500	3,000	25
LEV 200025	A107 W	NK 280	soft	200	25	20-25-32	71	60	1,500	3,000	25
LEV 200025	E204 W	EC 100	soft	200	25	20-25-32	71	60	1,500	3,000	25
LEV 200025	E206 W	EC 180	soft	200	25	20-25-32	71	60	1,500	3,000	25
LEV 200025	E207 W	EC 280	soft	200	25	20-25-32	71	60	1,500	3,000	25

\*Minimum order quantity

\*Minimum order quantity





Description	Quantity	Code	Type	D mm	T mm	M mm	Material on back of flap	Material on back of roll	W mm	H mm	MOQ
LSV 200025	A104 M	NK 100	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 M	NK 180	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 M	NK 300	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 M	SC 100	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 M	SC 180	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 M	SC 280	medium	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A104 H	NK 100	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A106 H	NK 180	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	A107 H	NK 300	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C204 H	SC 100	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C206 H	SC 180	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200025	C207 H	SC 280	hard	300	25	20-25-32	71	10	1,500	3,000	25
LSV 200050	A104 W	NK 100	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A106 W	NK 180	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A107 W	NK 300	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C204 W	SC 100	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C206 W	SC 180	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C207 W	SC 280	soft	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A104 M	NK 100	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A106 M	NK 180	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A107 M	NK 300	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C204 M	SC 100	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C206 M	SC 180	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C207 M	SC 280	medium	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A104 H	NK 100	hard	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A106 H	NK 180	hard	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	A107 H	NK 300	hard	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C204 H	SC 100	hard	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C206 H	SC 180	hard	300	50	20-25-32	71	10	1,500	3,000	25
LSV 200050	C207 H	SC 280	hard	300	50	20-25-32	71	10	1,500	3,000	25

Download the app  
 for more info

\*Minimum order quantity



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

INDIVIDUAL CUSTOMER SOLUTIONS

- for cleaning, dimpling, surface preparation, texturing and occuring
- Other dimensions, holes or qualities are available on request. Available diameters: 80 mm to max. 400 mm
- A sample order for this ILMAS custom solution can be found on page 101.
- $v_{max}$  30 m/s



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Description	Quality	Gr.	D mm	T mm	H mm	$P_{min}$ rpm	$P_{max}$ rpm	Stock pcs.
LSM 08010	A10410	NK 10010	80	50	10-13-16	2,000	2,600	25
LSM 08050	A106150	NK 100150	80	50	10-13-16	2,000	2,600	25
LSM 08020	A107240	NK 200240	80	50	10-13-16	2,000	2,600	25
LSM 08050	C20490	SC 10090	80	50	10-13-16	2,000	2,600	25
LSM 08050	C206150	SC 100150	80	50	10-13-16	2,000	2,600	25
LSM 08050	C207240	SC 200240	80	50	10-13-16	2,000	2,600	25

Minimum order quantity



Description	Quality	Gr.	D mm	T mm	H mm	Mounting hole diameter $\phi$ mm	Mounting hole diameter $\phi$ mm	$P_{min}$ rpm	$P_{max}$ rpm	Stock pcs.
LSM 15010	A10410	NK 10010	150	50	13-16-20	47	18	2,000	4,000	25
LSM 15050	A106150	NK 100150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 15020	A107240	NK 200240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 15050	C20490	SC 10090	150	50	13-16-20	47	18	2,000	4,000	25
LSM 15050	C206150	SC 100150	150	50	13-16-20	47	18	2,000	4,000	25
LSM 15050	C207240	SC 200240	150	50	13-16-20	47	18	2,000	4,000	25
LSM 16010	A10410	NK 10010	160	50	13-16-20	47	18	1,500	3,000	25
LSM 16050	A106150	NK 100150	160	50	13-16-20	47	18	1,500	3,000	25
LSM 16020	A107240	NK 200240	160	50	13-16-20	47	18	1,500	3,000	25
LSM 16050	C20490	SC 10090	160	50	13-16-20	47	18	1,500	3,000	25
LSM 16050	C206150	SC 100150	160	50	13-16-20	47	18	1,500	3,000	25
LSM 16050	C207240	SC 200240	160	50	13-16-20	47	18	1,500	3,000	25
LSM 20010	A10410	NK 10010	200	50	20-25-32	71	18	1,500	3,000	25
LSM 20050	A106150	NK 100150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 20020	A107240	NK 200240	200	50	20-25-32	71	18	1,500	3,000	25
LSM 20050	C20490	SC 10090	200	50	20-25-32	71	18	1,500	3,000	25
LSM 20050	C206150	SC 100150	200	50	20-25-32	71	18	1,500	3,000	25
LSM 20050	C207240	SC 200240	200	50	20-25-32	71	18	1,500	3,000	25

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 smoothly-sanding 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 the LUKAS custom solution can be found on page 161.

★★☆

Designation	Quality	Link	Surface	D mm	T mm	H mm	N mm	n <sub>min</sub>	n <sub>opt</sub>	MOQ* pcs.
FRV 200050	A104	NK 100	medium	200	50	20-25-32	1,400	1,900	25	
FRV 200053	A106	NK 120	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	1,900	1,900	25	
FRV 250050	A106	NK 120	fine	250	50	20-25-32	1,900	1,900	25	
FRV 250050	A107	NK 280	very fine	250	50	20-25-32	1,900	1,900	25	
FRV 300050	A104	NK 100	medium	300	50	20-25-32	900	1,200	25	
FRV 300050	A106	NK 120	fine	300	50	20-25-32	900	1,200	25	
FRV 300050	A107	NK 280	very fine	300	50	20-25-32	900	1,200	25	

\*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
- Demisting
- 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
- Demisting
- surface preparation
- Texturing
- Roughening

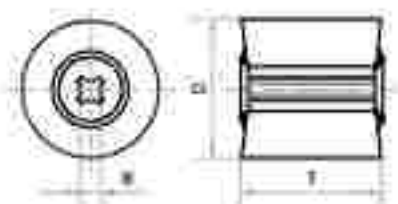
### LWF, SINUS ABRASIVE ROLL MADE OF ABRASIVE FLEECE FOR CONDITIONING MACHINES

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

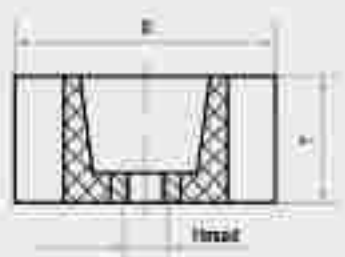


- for cleaning, deburring, desludging, surface preparation, texturing and roughening
- for conditioning machines

★★★

Product number	Description	Grit	D mm	T mm	H mm	Flap type	Flap type	Part number
A2280102500040	LWL 100050	NK 40	100	50	10	1	2,700	4,000
A2280102500050	LWL 100050	NK 60	100	50	10	1	2,700	4,000
A2280102500060	LWL 100050	NK 80	100	50	10	1	2,700	4,000
A22801001000040	LWL 100100	NK 40	100	100	10	1	2,700	4,000
A22801001000050	LWL 100100	NK 60	100	100	10	1	2,700	4,000
A22801001000060	LWL 100100	NK 80	100	100	10	1	2,700	4,000

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



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

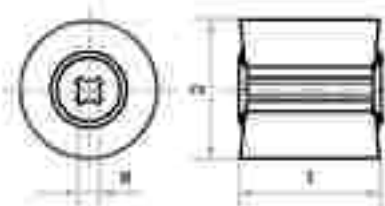
★★★

Product number	Description	Grit	D mm	T mm	Thread	Flap type	Flap type	Part number
A2280105000040	LWL 100050	NK 60	100	50	M14	1	2,700	4,000
A2280105000050	LWL 100050	NK 80	100	50	M14	1	2,700	4,000



## LWV, flap roll made of abrasive fleece

- fits on conditioning machines
- use of fibre fleeces makes it elastic
- adapts itself to the shape of the workpiece
- for rust finishing, semi-rust finishing, polishing, smoothing and final finishing of workpiece surfaces



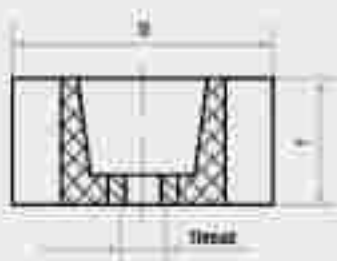
★ ★ ☆

Product number	Description	Quality	Grit	D mm	T mm	H mm	P <sub>1</sub> g/g	P <sub>2</sub> g/g	Part. condition
A228X00500104	LWV 10050	A104	NK 100	100	50	10	2,300	4,000	2
A228X00500106	LWV 10050	A106	NK 100	100	50	10	2,300	4,000	2
A228X00500107	LWV 10050	A107	NK 200	100	50	10	2,300	4,000	2
A228X001000104	LWV 100100	A104	NK 100	100	100	10	2,300	4,000	1
A228X001000106	LWV 100100	A106	NK 100	100	100	10	2,300	4,000	1
A228X001000107	LWV 100100	A107	NK 200	100	100	10	2,300	4,000	1



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

- fits on commercially available angle grinders
- use of fibre fleeces makes it elastic
- adapts itself to the shape of the workpiece
- for rust finishing, semi-rust finishing, polishing, smoothing and final finishing of workpiece surfaces

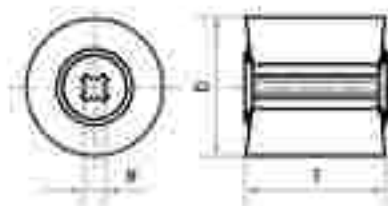


★ ★ ☆

Product number	Description	Grit	D mm	T mm	Thread	P <sub>1</sub> g/g	P <sub>2</sub> g/g	Part. condition
A228100501104	LWV 10050	A 104	100	50	M14	2,300	4,000	2
A228100501106	LWV 10050	A 106	100	50	M14	2,300	4,000	2
A228100501107	LWV 10050	A 107	100	50	M14	2,300	4,000	2



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

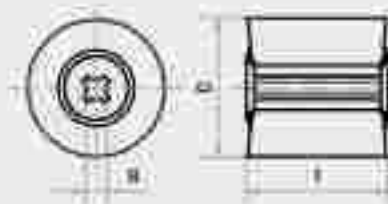


- for conditioning machines
- due to its highly robust abrasive fleece made of TF material, this recessed flap wheel wears evenly
- perfect for continuous working
- ideal for machining the surfaces of sheet metal products made from stainless steel, such as sinks and containers
- for cleaning, deburring,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

★★★

Product number	Description	Grade	D mm	T mm	H mm	P <sub>in</sub> (g/ft <sup>2</sup> )	P <sub>out</sub> (g/ft <sup>2</sup> )	Per. (min/rev)
A2281024000130	LWM 100100	TF 120/80	100	100	10	2,800	6,000	1

## 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, chamfering, surface preparation, finishing and roughening

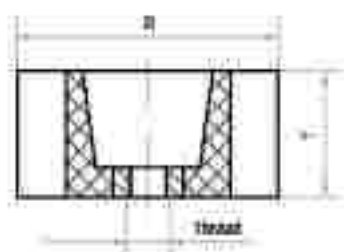
★★☆

Product number	Description	Grade	Gr. (K)	D mm	T mm	H mm	P <sub>in</sub> (g/ft <sup>2</sup> )	P <sub>out</sub> (g/ft <sup>2</sup> )	Per. (min/rev)
A228101500104	LWM 100550	A104/80	NK 100/80	100	50	10	2,800	6,000	2
A228101500106	LWM 100550	A106/150	NK 100/150	100	50	10	2,800	6,000	2
A228101500107	LWM 100550	A107/340	NK 280/340	100	50	10	2,800	6,000	2
A228101000104	LWM 100100	A104/80	NK 100/80	100	100	10	2,800	6,000	1
A228101000106	LWM 100100	A106/150	NK 180/150	100	100	10	2,800	6,000	1
A228101000107	LWM 100100	A107/340	NK 280/340	100	100	10	2,800	6,000	1



## 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, chamfering, surface preparation, texturing and roughening



★★★

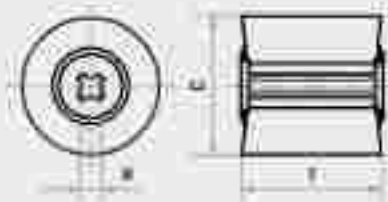
Product number	Description	Quality	Grit	D mm	T mm	Thread	P <sub>max</sub> rpm	P <sub>min</sub> rpm	Part number
A22810210104	LWM 100050	A10450	NK 100/50	100	50	M14	2,900	4,000	3
A22810210106	LWM 100050	A106104	NK 180/150	100	55	M14	2,900	4,000	3

Recommended use for:  Steel  Cast iron  Aluminum  Titanium



## LWF, sinus abrasive roll with abrasive fleece

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



★★★

Product number	Description	Quality	Grit	D mm	T mm	H mm	P <sub>max</sub> rpm	P <sub>min</sub> rpm	Part number
A2291001000104	LWF 100100	A104	NK 120	100	100	13	2,900	3,800	1
A2291001000106	LWF 100100	A106	NK 180	100	100	13	2,900	3,800	1

Recommended use for:  Steel  Cast iron  Aluminum  Titanium

Product number	Description	Quality	Grit	D mm	T mm	H mm	P <sub>max</sub> rpm	P <sub>min</sub> rpm	Part number
A2291001000206	LWF 100100	C206	SPC 400	100	50	13	2,900	3,800	2
A2291001000208	LWF 100100	C208	SPC 400	100	100	13	2,900	3,800	1

Recommended use for:  Steel  Cast iron  Aluminum  Titanium



## 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 overheat cut-off

▶ Former technical details can be found on page 307.

#### Properties:

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

#### With the appropriate tool perfect for:

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

★★★

Product number	Description	Max. speed (rpm)	Power consumption (W)	Roll max. Ø (mm)	Roll width (mm)	Roll length (mm)	Part location
A339560M1310	EM 1310	1,300 - 3,050	1,900	120	100	40	9

For use with LUKAS tools		Dimension	Catalogue page
LUKAS	ES pointing roll	100 x 50 mm, 100 x 100 mm	107
	SBTY abrasive band rolls	100 x 100 mm	109
	LW/LWV/LWM/LWF abrasive flap rolls	100 x 50 mm, 100 x 100 mm	130-133



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 186–190

**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 staple) 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	L mm	Pack contents
A34003030040	SBZY 03030	Ceramic 40	30	30	50
A34003030050	SBZY 03030	Ceramic 50	30	30	50
A34004030040	SBZY 04030	Ceramic 40	40	30	50
A34004030050	SBZY 04030	Ceramic 50	40	30	50
A34004030060	SBZY 04030	Ceramic 60	40	30	50
A34006030040	SBZY 06030	Ceramic 40	60	30	25
A34006030050	SBZY 06030	Ceramic 50	60	30	25

Recommended for:  Steel  Cast iron  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

★★★

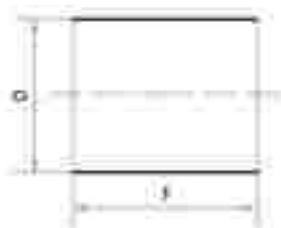
Product number	Description	Grit	D mm	L mm	Pack contents
A341103030030	SBZY 10030	Z-Power 30	30	30	50
A341103030050	SBZY 10030	Z-Power 50	30	30	50
A341103030060	SBZY 10030	Z-Power 60	30	30	50
A341104030040	SBZY 10030	Z-Power 40	40	30	50
A341104030050	SBZY 10030	Z-Power 50	40	30	50
A341104030060	SBZY 10030	Z-Power 60	40	30	50
A341106030030	SBZY 10030	Z-Power 30	60	30	25
A341106030050	SBZY 10030	Z-Power 50	60	30	25
A341106030060	SBZY 10030	Z-Power 60	60	30	25

Recommended for:  Steel  Cast iron  Titanium





## SBZY regular aluminium oxide abrasive band, cylindrical shape



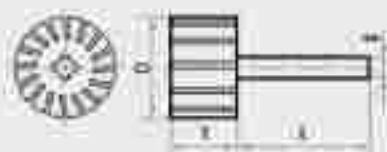
- Regular aluminium oxide has good tool life when used on structural steel and for rough grinding.
- For cleaning, light deburring, refining, surface and contour grinding as well as fine grinding.
- In combination with mandrels for use with straight grinders or machines with flexible shafts.
- ▶ The matching mandrels can be found on page 259.

★★

Product number	Description	Size	D mm	L mm	Part. quantity
A34000010150	SBZY 0010	NK 150	8	10	50
A34000101000	SBZY 0100	NK 80	10	10	50
A34000101500	SBZY 0100	NK 150	10	10	50
A340001010040	SBZY 0100	NK 240	10	10	50
A340001010020	SBZY 0100	NK 320	10	10	50
A340001010000	SBZY 0100	NK 60	10	10	50
A340001020150	SBZY 0100	NK 150	10	20	50
A340001020140	SBZY 0100	NK 240	10	20	50
A340001020120	SBZY 0100	NK 320	10	20	50
A340001110000	SBZY 01210	NK 80	12	10	50
A340001210150	SBZY 01210	NK 150	12	10	50
A340001210080	SBZY 01210	NK 80	12	13	50
A340001212120	SBZY 01210	NK 120	12	13	50
A340001012140	SBZY 01210	NK 240	12	13	50
A340001225080	SBZY 01225	NK 80	12	25	50
A340001225150	SBZY 01225	NK 150	12	25	50
A340001225240	SBZY 01225	NK 240	12	25	50
A340001225320	SBZY 01225	NK 320	12	25	50
A340001225080	SBZY 01225	NK 80	12	25	50
A340001225150	SBZY 01225	NK 150	12	25	50
A340001510060	SBZY 01510	NK 60	15	10	50
A340001510080	SBZY 01510	NK 80	15	10	50
A340001510150	SBZY 01510	NK 150	15	10	50
A340001510240	SBZY 01510	NK 240	15	10	50
A340001510320	SBZY 01510	NK 320	15	10	50
A340001510040	SBZY 01530	NK 40	15	30	50
A340001530050	SBZY 01530	NK 50	15	30	50
A340001530080	SBZY 01530	NK 80	15	30	50
A340001530080	SBZY 01530	NK 80	15	30	50
A340001530080	SBZY 01530	NK 80	15	30	50
A340001530120	SBZY 01530	NK 120	15	30	50
A340001530150	SBZY 01530	NK 150	15	30	50
A340001530240	SBZY 01530	NK 240	15	30	50
A340001530270	SBZY 01530	NK 320	15	30	50
A340001530500	SBZY 01530	NK 60	15	25	50
A340001025000	SBZY 01525	NK 80	18	25	50
A340001025150	SBZY 01525	NK 150	18	25	50
A34000210150	SBZY 02110	NK 150	22	10	50
A340002110240	SBZY 02110	NK 240	22	10	50
A340002110320	SBZY 02110	NK 320	22	10	50
A340002200140	SBZY 02220	NK 50	22	20	50
A34000220060	SBZY 02220	NK 60	22	20	50

Product number	Description	Gr	D mm	T mm	Page thickness
A34002220080	SBZY 0220	NK 80	22	20	50
A34002220150	SBZY 0220	NK 150	22	20	50
A34002220240	SBZY 0220	NK 240	22	20	50
A34002220320	SBZY 0220	NK 320	22	20	50
A34002525040	SBZY 02525	NK 40	25	25	50
A34002525080	SBZY 02525	NK 80	25	25	50
A34002525080	SBZY 02525	NK 80	25	25	50
A34002525150	SBZY 02525	NK 150	25	25	50
A34003030040	SBZY 03030	NK 40	30	20	50
A34003030050	SBZY 03030	NK 50	30	20	50
A34003030080	SBZY 03030	NK 80	30	20	50
A34003030150	SBZY 03030	NK 150	30	20	50
A34003030240	SBZY 03030	NK 240	30	20	50
A34003030320	SBZY 03030	NK 320	30	20	50
A3400303040	SBZY 03030	NK 40	30	30	50
A3400303050	SBZY 03030	NK 50	30	30	50
A3400303060	SBZY 03030	NK 60	30	30	50
A3400303080	SBZY 03030	NK 80	30	30	50
A34003030150	SBZY 03030	NK 150	30	30	50
A34003030240	SBZY 03030	NK 240	30	30	50
A34003030320	SBZY 03030	NK 320	30	30	50
A3400303040	SBZY 03030	NK 40	30	25	50
A3400303050	SBZY 03030	NK 50	30	25	50
A3400303060	SBZY 03030	NK 60	30	25	50
A3400303080	SBZY 03030	NK 80	30	25	50
A34004530040	SBZY 04530	NK 40	45	30	50
A34004530050	SBZY 04530	NK 50	45	30	50
A34004530080	SBZY 04530	NK 80	45	30	50
A34004530080	SBZY 04530	NK 80	45	30	50
A34004530150	SBZY 04530	NK 150	45	30	50
A34004530240	SBZY 04530	NK 240	45	30	50
A34004530320	SBZY 04530	NK 320	45	30	50
A34005125040	SBZY 05125	NK 40	51	25	50
A34005125080	SBZY 05125	NK 80	51	25	50
A34005125080	SBZY 05125	NK 80	51	25	50
A34005125150	SBZY 05125	NK 150	51	25	50
A34006030040	SBZY 06030	NK 40	60	30	50
A34006030050	SBZY 06030	NK 50	60	30	50
A34006030080	SBZY 06030	NK 80	60	30	50
A34006030080	SBZY 06030	NK 80	60	30	50
A34006030150	SBZY 06030	NK 150	60	30	50
A34007530040	SBZY 07530	NK 40	75	30	50
A34007530080	SBZY 07530	NK 80	75	30	50
A34007530080	SBZY 07530	NK 80	75	30	50
A34007530150	SBZY 07530	NK 150	75	30	50
A34010040040	SBZY 10040	NK 40	100	40	25
A34010040060	SBZY 10040	NK 60	100	40	25
A34010040080	SBZY 10040	NK 80	100	40	25
A34010040150	SBZY 10040	NK 150	100	40	25

## STZY hard abrasive band mandrel, cylindrical shape

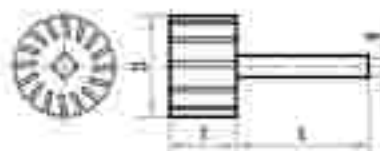


The stated maximum permissible speeds apply for a maximum overhang length  $l_0$  of 30 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆☆

Product number	Description	Type	D mm	l mm	B mm	L mm	$v_{max}$ rpm	Part quantity
A250001001	STZY 01010.00	hard	10	10	5	25	54,000	5
A250001005	STZY 01010.00	hard	10	10	6	40	50,000	5
A2500010206	STZY 01020.00	hard	10	20	6	40	50,000	5
A2500012106	STZY 01210.00	hard	12	10	6	40	46,500	5
A2500012132	STZY 01213.00	hard	12	13	2.25	40	24,000	6
A2500012256	STZY 01225.00	hard	12	25	6	40	46,500	5
A2500013256	STZY 01325.00	hard	13	25	6	40	44,000	5
A2500015106	STZY 01510.00	hard	15	10	6	40	38,000	5
A2000015306	STZY 01530.00	hard	15	30	6	40	38,000	6
A2500016256	STZY 01625.00	hard	16	25	6	40	38,000	5
A2500022106	STZY 02210.00	hard	22	10	6	40	28,000	5
A2500022206	STZY 02220.00	hard	22	20	6	40	28,000	5
A2500021256	STZY 02125.00	hard	25	25	6	40	22,500	5
A2500030206	STZY 03020.00	hard	30	20	6	40	19,000	5
A2500030306	STZY 03030.00	hard	30	30	6	40	18,000	5
A2500030256	STZY 03025.00	hard	30	25	6	40	15,000	5
A25000413060001	STZY 04130.00	hard	45	30	6	40	13,000	5
A2500051256	STZY 05125.00	hard	51	25	6	40	9,200	5
A25000621060001	STZY 06210.00	hard	60	30	6	40	6,500	5
A2500063060	STZY 06300.00	hard	60	30	6	40	6,500	5
A25000753060001	STZY 07530.00	hard	75	30	6	40	6,500	7

## STZY soft abrasive band mandrel, cylindrical shape



The stated maximum permissible speeds apply for a maximum overhang length  $l_0$  of 30 mm. The maximum permissible speed must be calculated separately for other overhang lengths!

★★☆☆

Product number	Description	Type	D mm	l mm	B mm	L mm	$v_{max}$ rpm	Part quantity
A250008101	STZY 08100.00	soft	8	10	3	40	42,500	5
A2500012256	STZY 01225.00	soft	12	25	6	40	25,500	5
A2500015306	STZY 01530.00	soft	15	30	6	40	25,000	5
A2500022206	STZY 02220.00	soft	22	20	6	40	19,000	5
A2500030206	STZY 03020.00	soft	30	20	6	40	12,500	5
A2500030106	STZY 03010.00	soft	30	10	6	40	12,500	5
A25000413060001	STZY 04130.00	soft	45	30	6	40	13,000	6
A25000621060001	STZY 06210.00	soft	60	30	6	40	6,500	5
A25000630600001	STZY 06300.00	soft	60	30	6	40	6,500	5
A25000648000001	STZY 06480.00	soft	100	40	6	40	4,900	7



## 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 grooves or modulus with flexible shafts



★★☆

Product number	Description	Grit	D mm	T mm	Part location
A3000303000	SBZY 03030	NK 03	30	30	50
A30003030120	SBZY 03030	NK 120	30	30	50
A30003030150	SBZY 03030	NK 150	30	30	50
A30004030130	SBZY 04030	NK 130	40	30	50
A30004030150	SBZY 04030	NK 150	40	30	50



### STZY soft abrasive band mandrel, cylindrical shape

The stated maximum permissible speeds apply for a maximum overhang length  $L_o$  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	$V_{max}$ (rpm)	Part location
A25003050E	STZY 03030.0E	soft	30	30	6	40	0,500	3
A25004030E	STZY 04030.0E	soft	40	30	6	40	0,380	5
A25006030E	STZY 06030.0E	soft	60	30	6	40	0,260	5
A25007530E	STZY 07530.0E	soft	75	30	6	40	0,200	3
A25020040E	STZY 10040.0E	soft	100	40	6	40	0,160	2

## SBKE regular aluminum oxide abrasive band, conical shape

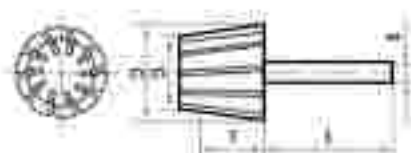


- tapered for grinding on hard-to-reach areas
- For rough grinding: regular aluminum oxide has good tool life when used on structural steel and ensures cost effective machining
- for cleaning, light deburring, refining, surface and contour grinding as well as fine grinding
- in combination with abrasive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

★★☆

Product number	Designation	Grit	H mm	T mm	R <sub>1</sub> mm	Price (approx.)
A300002063040	SBKE 02063	NK 40	20	63	14	58
A300002063040	SBKE 02063	NK 50	20	63	14	58
A300002063060	SBKE 02063	NK 80	20	63	14	58
A300002063150	SBKE 02063	NK 150	20	63	14	58
A300002930040	SBKE 02930	NK 40	29	30	22	58
A300002930050	SBKE 02930	NK 50	29	30	22	58
A300002930060	SBKE 02930	NK 60	29	30	22	58
A300002930080	SBKE 02930	NK 80	29	30	22	58
A300002930150	SBKE 02930	NK 150	29	30	22	58
A300003480040	SBKE 03480	NK 40	36	60	22	58
A300003480050	SBKE 03480	NK 50	36	60	22	58
A300003480060	SBKE 03480	NK 60	36	60	22	58
A300003480080	SBKE 03480	NK 80	36	60	22	58
A300003480150	SBKE 03480	NK 150	36	60	22	58

## 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	Designation	Type	H mm	T mm	S mm	R mm	L mm	R <sub>2</sub> mm	Price (approx.)
A2500000636	STKE 00063.06	hard	20	63	6	14	40	21,000	5
A2500000306	STKE 00030.06	hard	29	30	6	22	40	21,300	5
A2500000486	STKE 00048.06	hard	36	60	6	22	40	21,500	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 aluminum 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

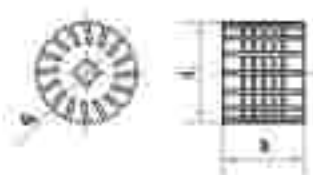


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Product number	Description	Grit	D mm	L mm	Part quantity
A24001010086	SBZY 10090	AK 80	100	100	6
A24001010090	SBZY 10090	AK 80	100	100	6
A24001010092	SBZY 10090	AK 120	100	100	6
A24001010095	SBZY 10090	AK 150	100	100	6



## STWS soft abrasive band mandrel, cylindrical shape



The 19 mm size has five 5 mm keyways

★★☆☆

Product number	Description	Type	A mm	B mm	Max. C mm	H mm	Part quantity
A250101000	STWS 10090	soft	100	100	70	2,000	1



## LINISHING BELTS FROM LUKAS

BEST RESULTS TOGETHER WITH THE MATCHING LUKAS POWER TOOL

### SBL finishing belt



★★★

- can be used on our AMH 30 (15A) pneumatic belt grinder
- operating speed: 20 m/s

Product number	Description	Grit	R mm	Length mm	Backing	Pack quantity
A3000130350600	SBL1	NK 60	13	305	robustly flexible	100
A3000130350800	SBL1	NK 80	13	305	robustly flexible	100
A3000130351200	SBL1	NK 120	13	305	robustly flexible	100

### Belt grinder, insulated



#### Technical details:

- length: approx. 325 mm
- height: approx. 115 mm
- weight: approx. 0.90 kg
- drive: Vario motor

► Further technical details can be found on page 303.

★★★

#### Included with the machine:

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

#### Special accessories:

- collets for 3, 3 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"
- belt arm in various dimensions (length, width and roll diameter) available from stock

Product number	Description	Video	Min. speed (rpm)	Power consumption	Air consumption (max. flow volume)	Permitted speed of feed (m/min)	Standard tool size (mm)	Pack quantity
A300130715	AMH 30 E2H	Lower	30.000	0,3	0,45	20	6	1



## 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
- Fetting

## 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 fitting of small workpieces
- generous 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	L mm	d mm	W g/m <sup>2</sup>	Matching abrasive roll carrier	Price indicator
A24030038800001	SRZY 6038	Ceramic 60	6	38	3	34,000	SRTR 3063-03 or SRTR 3063-06	50
A24030038800001	SRZY 9038	Ceramic 90	6	38	3	34,000	SRTR 3063-03 or SRTR 3063-06	50
A240300388100001	SRZY 9038	Ceramic 120	6	38	3	34,000	SRTR 3063-03 or SRTR 3063-06	50
A24030038800001	SRZY 1038	Ceramic 60	10	38	3	34,000	SRTR 3070-06	50
A24030038800001	SRZY 1038	Ceramic 90	10	38	3	34,000	SRTR 3070-06	50
A240300388100001	SRZY 1038	Ceramic 120	10	38	3	34,000	SRTR 3070-06	50
A24030038800001	SRZY 1238	Ceramic 60	12	38	3	34,000	SRTR 3075-06	50
A24030038800001	SRZY 1238	Ceramic 90	12	38	3	34,000	SRTR 3075-06	50
A240300388100001	SRZY 1238	Ceramic 120	12	38	3	34,000	SRTR 3075-06	50



# MULTI-LAYER ABRASIVE COATING WOUND IN A CYLINDRICAL FORM

ACHIEVE AN EXCEPTIONAL TOOL LIFE WITH LUKAS ABRASIVE ROLLS



## SRZY regular aluminium oxide abrasive roll, cylindrical

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

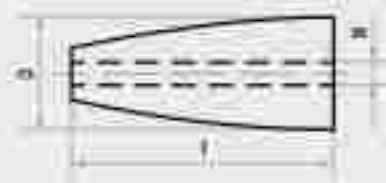


★★☆☆

Product number	Description	Grit	D mm	L mm	t mm	P <sub>max</sub> (psi)	Matching abrasive roll mandrels	Part number
A24030M25000	SRZY 0625	NK 00	6	25	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M25150	SRZY 0625	NK 150	6	25	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M30000	SRZY 0630	NK 00	6	30	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M30150	SRZY 0630	NK 150	6	30	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M351000	SRZY 1025	NK 50	10	25	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M350000	SRZY 1025	NK 00	10	25	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M35150	SRZY 1025	NK 150	10	25	3	24,000	SRTM 3063.03 or SRTM 3063.06	50
A24030M300050	SRZY 1030	NK 50	10	30	3	24,000	SRTM 3070.06	50
A24030M300000	SRZY 1030	NK 00	10	30	3	24,000	SRTM 3070.06	50
A24030M30150	SRZY 1030	NK 150	10	30	3	24,000	SRTM 3070.06	50
A24030M35050	SRZY 1325	NK 50	13	25	3	24,000	SRTM 3063.06	50
A24030M350000	SRZY 1325	NK 00	13	25	3	24,000	SRTM 3063.06	50
A24030M35150	SRZY 1325	NK 150	13	25	3	24,000	SRTM 3063.06	50
A24030M30050	SRZY 1330	NK 50	13	30	3	24,000	SRTM 3070.06	50
A24030M300000	SRZY 1330	NK 00	13	30	3	24,000	SRTM 3070.06	50
A24030M30150	SRZY 1330	NK 150	13	30	3	24,000	SRTM 3070.06	50
A24030M300500	SRZY 2030	NK 50	20	30	5	16,000	SRTM 5085.06	50
A24030M300000	SRZY 2030	NK 00	20	30	5	16,000	SRTM 5085.06	50
A24030M30150	SRZY 2030	NK 150	20	30	5	16,000	SRTM 5085.06	50
A24030M300500	SRZY 2035	NK 50	20	35	5	16,000	SRTM 5085.06	50
A24030M300000	SRZY 2035	NK 00	20	35	5	16,000	SRTM 5085.06	50

Recommended for: Steel ● Cast iron ● Titanium ● Aluminum ● Inconel ● Stainless steel ● Titanium

## SRKE regular aluminum oxide abrasive roll, conical

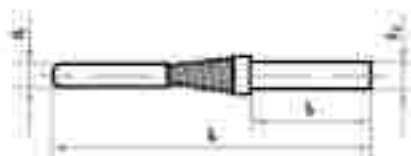


- for deburring, cleaning or finishing of small workpieces
  - tapered for grinding hard-to-reach areas
  - regular aluminum oxide has good tool life when used on structural steel, when rough grinding, and ensures cost-effective machining
  - generous amount of abrasive coating due to the large, cylindrically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

★★☆

Product number	Description	Grit	D mm	L mm	R mm	Wt. g/roll	Matching abrasive roll carrier	Price indicator
A240401025050	SRKE 1025	NK 50	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.04	50
A240401025080	SRKE 1025	NK 80	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.04	50
A240401025150	SRKE 1025	NK 150	10	25	3	24,000	SRTR 3063.03 or SRTR 3063.04	50
A240401125050	SRKE 1225	NK 50	12	25	3	24,000	SRTR 3063.03	50
A240401125080	SRKE 1225	NK 80	12	25	3	24,000	SRTR 3063.03	50
A240401125150	SRKE 1225	NK 150	12	25	3	24,000	SRTR 3063.03	50
A240401138050	SRKE 1338	NK 50	13	38	3	24,000	SRTR 3070.03	50
A240401138080	SRKE 1338	NK 80	13	38	3	24,000	SRTR 3070.03	50
A240401138150	SRKE 1338	NK 150	13	38	3	24,000	SRTR 3070.03	50
A240401163050	SRKE 1638	NK 50	16	38	3	16,900	SRTR 3070.03	50
A240401163080	SRKE 1638	NK 80	16	38	3	16,900	SRTR 3070.03	50
A240401163150	SRKE 1638	NK 150	16	38	3	16,900	SRTR 3070.03	50
A240402050038	SRKE 2050	NK 38	20	50	5	16,900	SRTR 3085.03	50
A240402050052	SRKE 2050	NK 50	20	50	5	16,900	SRTR 3085.03	50
A240402050080	SRKE 2050	NK 80	20	50	5	16,900	SRTR 3085.03	50
A240402050150	SRKE 2050	NK 150	20	50	5	16,900	SRTR 3085.03	50

## SRTM abrasive roll mandrel



★★☆

Product number	Description	Grit	D mm	L mm	R mm	Wt. g/roll	Price indicator
A32030130001	SRTM 3063.03	300	3	64	3	27	5
A32030160001	SRTM 3063.03	300	3	64	6	27	5
A32030160001	SRTM 3070.03	300	3	70	6	25	5
A32030160001	SRTM 3085.03	300	3	85	6	25	5

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

# LUKAS abrasive caps and mandrels

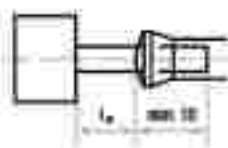
Our abrasive caps and sleeves consist of high-quality abrasive cloth and are manufactured to fit perfectly on our corresponding mandrels. We offer a large assortment of tools with the corresponding mandrel for various applications.

## 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
<p style="text-align: center;">★★★</p> <div style="text-align: center;">  </div> <p>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.</p>	<p style="text-align: center;">★★☆</p> <div style="text-align: center;">  </div> <p>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, aluminum and non-ferrous metals. The surface layer with active abrasive additives enables enhanced stock removal rate and a longer tool life.</p>



## 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 regrounding 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 REGROUNDING

### 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.

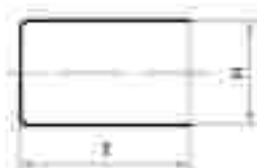
### THE SELF-SHARPENING EFFECT

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



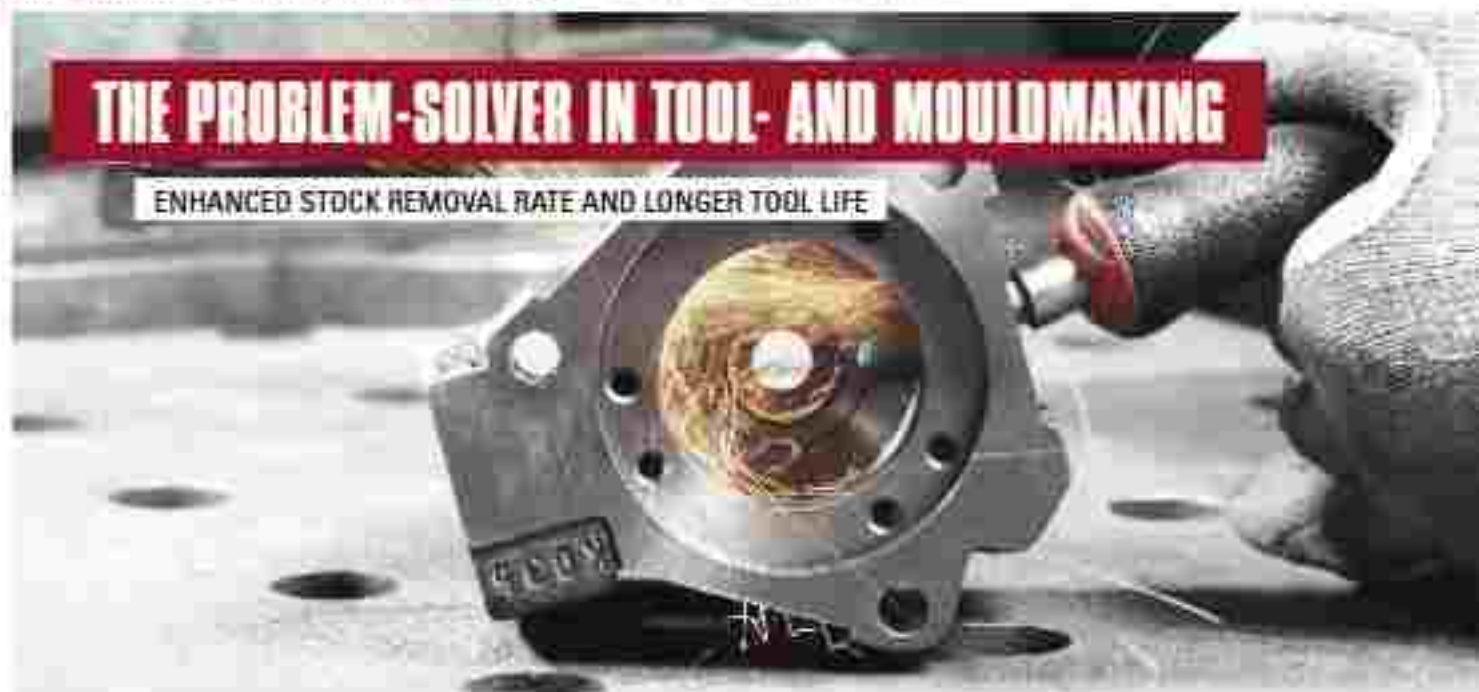
★★★

Product number	Description	Shape	Grit	H mm	T mm	Flank width	
A21J0852080	SKWR 0511		Ceramic 80	5	11	100	
A21J0852110	SKWR 0511		Ceramic 150	5	11	100	
A21J0872080	SKWR 0713		Ceramic 80	7	13	100	
A21J0872110	SKWR 0713		Ceramic 150	7	13	100	
A21J0892080	SKWR 1015		Ceramic 80	10	15	100	
A21J0892110	SKWR 1015		Ceramic 150	10	15	100	
A21J0912080	SKWR 1318		Ceramic 80	13	18	100	
A21J0912110	SKWR 1318		Ceramic 150	13	18	100	
A21J0962080	SKWR 1626		Ceramic 80	16	26	100	
A21J0962110	SKWR 1626		Ceramic 150	16	26	100	
A21J1051180	SKKE 0515		Ceramic 80	5	15	100	
A21J1051110	SKKE 0515		Ceramic 150	5	15	100	
A21J112080	SKKE 1125		Ceramic 80	11	25	100	
A21J112110	SKKE 1125		Ceramic 150	11	25	100	
A21J1162080	SKKE 1633		Ceramic 80	16	33	100	
A21J1162110	SKKE 1633		Ceramic 150	16	33	100	
A21J2274080	SKKE 2140		Ceramic 80	21	40	100	
A21J2274110	SKKE 2140		Ceramic 150	21	40	100	
A21J2051080	SKZY 0510			Ceramic 80	5	10	100
A21J2051110	SKZY 0510			Ceramic 150	5	10	100
A21J2071080	SKZY 0712	Ceramic 80		7	12	100	
A21J2071110	SKZY 0712	Ceramic 150		7	12	100	
A21J2091080	SKZY 1015	Ceramic 80		10	15	100	
A21J2091110	SKZY 1015	Ceramic 150		10	15	100	
A21J20131080	SKZY 1317	Ceramic 80		13	17	100	
A21J2013110	SKZY 1317	Ceramic 150		13	17	100	
A21J20161080	SKZY 1626	Ceramic 80		16	26	100	
A21J2016110	SKZY 1626	Ceramic 150		16	26	100	
A21J20152080	SKWK 0511		Ceramic 80	5	11	100	
A21J20152110	SKWK 0511		Ceramic 150	5	11	100	
A21J2067080	SKWK 0713		Ceramic 80	7	13	100	
A21J20672110	SKWK 0713		Ceramic 150	7	13	100	
A21J20102080	SKWK 1015		Ceramic 80	10	15	100	
A21J20102110	SKWK 1015		Ceramic 150	10	15	100	
A21J20132080	SKWK 1318		Ceramic 80	13	18	100	
A21J20132110	SKWK 1318		Ceramic 150	13	18	100	
A21J20162080	SKWK 1626		Ceramic 80	16	26	100	
A21J20162110	SKWK 1626		Ceramic 150	16	26	100	



# 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 aluminate beds 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

★★☆

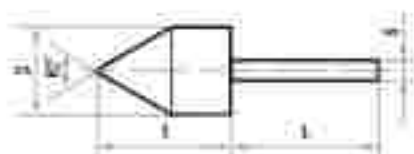
Product number	Description	Shape	Grit	H mm	L mm	Part quantity
A21020051080	SKZYS 1010		NKS 80	5	10	100
A21000011150	SKZYS 1010		NKS 150	5	10	100
A21020051220	SKZYS 1010		NKS 320	5	10	100
A21030011080	SKZYS 1012		NKS 80	3	12	100
A21030011090	SKZYS 1012		NKS 80	3	12	100
A21030011150	SKZYS 1012		NKS 150	3	12	100
A21030011320	SKZYS 1012		NKS 320	3	12	100
A2102010080	SKZYS 1015		NKS 80	10	15	100
A2102010150	SKZYS 1015		NKS 150	10	15	100
A21020101320	SKZYS 1015		NKS 320	10	15	100
A2102013080	SKZYS 1317		NKS 80	13	17	100
A21020131000	SKZYS 1317		NKS 80	13	17	100
A21020131150	SKZYS 1317		NKS 150	13	17	100
A21020131320	SKZYS 1317		NKS 320	13	17	100
A21020161060	SKZYS 1626		NKS 60	16	26	100
A21020161080	SKZYS 1626		NKS 80	16	26	100
A21020161150	SKZYS 1626	NKS 150	16	26	100	
A21020161320	SKZYS 1626	NKS 320	16	26	100	
A21030052080	SKWRS 0311		NKS 80	5	11	100
A21030052150	SKWRS 0411		NKS 150	5	11	100
A21030052320	SKWRS 0511		NKS 320	5	11	100

Recommended for: Superfined Fine Coarse Very coarse



Product Number	Description	Shape	Gr	H mm	T mm	Flank chamfer	
A21020072000	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	
A21020102000	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	
A21020132000	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	
A21020162000	SKWRS 1626		NKS 60	16	26	100	
A21020162150	SKWRS 1626		NKS 150	16	26	100	
A21020162320	SKWRS 1626		NKS 320	16	26	100	
A21020052000	SKWRS 0511			NKS 60	5	11	100
A21020052080	SKWRS 0511	NKS 80		5	11	100	
A21020052150	SKWRS 0511	NKS 150		5	11	100	
A21020052320	SKWRS 0511	NKS 320		5	11	100	
A21020073000	SKWRS 0713	NKS 60		7	13	100	
A21020073080	SKWRS 0713	NKS 80		7	13	100	
A21020073150	SKWRS 0713	NKS 150		7	13	100	
A21020073320	SKWRS 0713	NKS 320		7	13	100	
A21020102000	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	
A21020132000	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	
A21020162000	SKWRS 1626	NKS 60	16	26	100		
A21020162080	SKWRS 1626	NKS 80	16	26	100		
A21020162150	SKWRS 1626	NKS 150	16	26	100		
A21020162320	SKWRS 1626	NKS 320	16	26	100		
Product Number	Description	Shape	Gr	H mm	T mm	-R mm	Flank chamfer
A2102251000	SKRES 0515		NKS 60	5	25	2	25
A2102251700	SKRES 0515		NKS 150	5	25	2	25
A2102112000	SKRES 1125		NKS 60	11	25	5	25
A2102112000	SKRES 1125		NKS 80	11	25	5	25
A2102112150	SKRES 1125		NKS 150	11	25	5	25
A2102162000	SKRES 1632		NKS 60	16	32	25	25
A2102162000	SKRES 1632		NKS 80	16	32	25	25
A2102162150	SKRES 1632		NKS 150	16	32	25	25
A2102274000	SKRES 2140		NKS 60	21	40	8.5	25
A2102274000	SKRES 2140		NKS 80	21	40	8.5	25
A2102274150	SKRES 2140		NKS 150	21	40	8.5	25

## Abrasive cap mandrel



★★☆

Product number	Description	Shape	D mm	L mm	Shank diameter x length mm	$v_m$ rpm	Part quantity		
A2S000511	GTZY 0510		5	10	1/8" x 25	95,000	5		
A2S000513	GTZY 0510		5	10	3 x 25	95,000	5		
A2S000713	GTZY 0713		7	13	3 x 25	95,000	5		
A2S000911	GTZY 1015		10	15	1/8" x 25	45,000	5		
A2S000913	GTZY 1015		10	15	3 x 25	45,000	5		
A2S001113	GTZY 1317		13	17	3 x 25	35,000	5		
A2S001413	GTZY 1620		16	20	3 x 25	18,000	5		
A2S001616	GTZY 1620		16	20	6 x 40	20,000	5		
A2S000521	GTWR 0511			5	11	1/8" x 25	95,000	5	
A2S000523	GTWR 0511			5	11	3 x 25	95,000	5	
A2S000721	GTWR 0713	7		13	1/8" x 25	95,000	5		
A2S000723	GTWR 0713	7		13	3 x 25	95,000	5		
A2S000921	GTWR 1015	10		15	1/8" x 25	45,000	5		
A2S000923	GTWR 1015	10		15	3 x 25	45,000	5		
A2S001123	GTWR 1319	13		19	3 x 25	35,000	5		
A2S001423	GTWR 1620	16		20	1/8" x 25	18,000	5		
A2S001621	GTWR 1620	16		20	3 x 25	18,000	5		
A2S001626	GTWR 1620	16		20	6 x 40	20,000	5		
A2S000531	GTWK 0511		5	11	1/8" x 25	95,000	5		
A2S000533	GTWK 0511		5	11	3 x 25	95,000	5		
A2S000733	GTWK 0713		7	13	3 x 25	95,000	5		
A2S000931	GTWK 1015		10	15	3 x 25	45,000	5		
A2S001331	GTWK 1319		13	19	3 x 25	35,000	5		
A2S001631	GTWK 1620		16	20	3 x 25	18,000	5		
A2S001636	GTWK 1620		16	20	6 x 40	20,000	5		
Product number	Description		Shape	D mm	L mm	R mm	Shank diameter x length mm	$v_m$ rpm	Part quantity
A2S000511	GTKE 0515			5	15	3	1/8" x 40	95,000	5
A2S000513	GTKE 0515			5	15	3	3 x 25	50,000	5
A2S000516	GTKE 0515	5		15	3	6 x 40	95,000	5	
A2S001120	GTKE 1125	11		25	5	6 x 40	60,000	5	
A2S001620	GTKE 1625	16		32	25	6 x 40	30,000	5	
A2S002040	GTKE 2140	21		40	18.5	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:



## WS abrasive cap assortment

- consists of 640 abrasive caps and 23 mandrels
- box outer dimensions: 372 x 188 x 40 mm



★★★

Product number	Description	Quantity	Content	Part number		
A21000005201	WS 45 WS	50 pieces 100 per pack 50 per pack 20 per pack 10 pieces	Abrasive caps, grain #60-100 SKKES 0515 SKZYS 0510 SKZYS 0712 SKZYS 1015 SKKES 1125	SKWKS 0511 SKWKS 0713 SKWKS 1015	7	
		23 pieces 10 per pack 13 per pack	Abrasive caps, grain #60-80 SKWKS 1015 SKZYS 1317 SKWKS 1626	SKWKS 1319 SKWKS 1626		
		2 per pack 1 per pack	Mandrels, shape 7 mm GTZY 0510 GTWV 0733 GTZY 1015 GTWV 1318	GTWK 0511 GTWK 0713 GTWK 1015 GTWK 1319		GTZY 0712 GTZY 1317
		1 per pack	Mandrels, shape 6 mm GTKE 0515 GTKE 1020	GTKE 1125 GTWV 1626 GTWV 1626		

Recommended | See this | Add | Abrasive | Car wheel | Photo/Word



## 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 218–226.

**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 226/229.

**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.






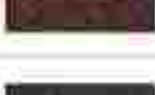


## PSG ABRASIVE DISCS

## 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.

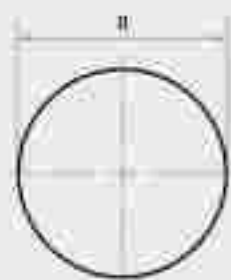
You will find all abrasive discs from the PSG range in the following overview. Read through the properties and application details of the different workpiece materials to find the right quality to meet your requirements.

Quality	Properties	Application recommendations	Page
 <b>NK</b> Abrasive cloth Regular aluminum oxide	very tough abrasive, high resistance	universal grinding and deburring	220
 <b>NRE</b> Abrasive cloth Regular aluminum oxide with reinforced backing material	very tough abrasive, high resistance	The reinforcement makes these discs suitable for the toughest demands and bending.	221
 <b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resistant grain with high pressure resistance	ideal for Hastelloy, Inconel, non-rusting steel and metals that are difficult to machine	218
 <b>Z-Plus</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	218
 <b>Ceramic</b> Abrasive cloth Ceramic grain	excellent stock removal rate without grain chattering, particularly suited 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 aluminum (aerospace industry). Plastics and composites can also be processed.	224
 <b>Abrasive flocco</b> Regular aluminum oxide coarse/fine			
 <b>Abrasive flocco</b> Regular aluminum oxide medium/fine 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
 <b>Abrasive flocco</b> Regular aluminum oxide fine/bleu			

# 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, steel and hard coatings, titanium alloys and reinforced weld seams can be machined quickly

► The matching tool carriers can be found on page 222.

★★★

Product number	Description	Quality/grit size	D mm	P <sub>max</sub> µm	Matching abrasive disc carrier	Peak volume
<b>NEW</b> A3379025080458	PSG 025	Ceramic 36	25	38,000	GTC 025	100
<b>NEW</b> A3379005000458	PSG 025	Ceramic 60	25	38,000	GTC 025	100
<b>NEW</b> A3379025080458	PSG 025	Ceramic 80	25	38,000	GTC 025	100
<b>NEW</b> A3379001300458	PSG 025	Ceramic 120	25	38,000	GTC 025	100
A3379030080458	PSG 030	Ceramic 36	30	25,000	GTC 030	100
A3379030080458	PSG 030	Ceramic 60	30	25,000	GTC 030	100
A3379030080458	PSG 030	Ceramic 80	30	25,000	GTC 030	100
A33790301300458	PSG 030	Ceramic 120	30	25,000	GTC 030	100
A3379050080458	PSG 050	Ceramic 36	50	25,000	GTC 038 and GTC 050	100
<b>NEW</b> A3379050080458	PSG 050	Ceramic 60	50	25,000	GTC 038 and GTC 050	100
A3379050080458	PSG 050	Ceramic 80	50	25,000	GTC 038 and GTC 050	100
A3379050080458	PSG 050	Ceramic 90	50	25,000	GTC 038 and GTC 050	100
A3379050080458	PSG 050	Ceramic 90	50	25,000	GTC 038 and GTC 050	100
A33790501300458	PSG 050	Ceramic 120	50	25,000	GTC 038 and GTC 050	100
A3379075080458	PSG 075	Ceramic 36	75	20,000	GTC 075	50
A3379075080458	PSG 075	Ceramic 60	75	20,000	GTC 075	50
A3379075080458	PSG 075	Ceramic 80	75	20,000	GTC 075	50
A33790751300458	PSG 075	Ceramic 120	75	20,000	GTC 075	50

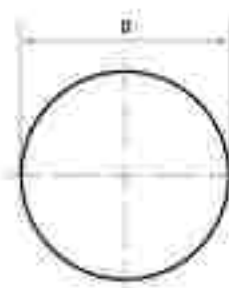
Navigation icons: Home, Back, Forward, Search, Close





## 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.



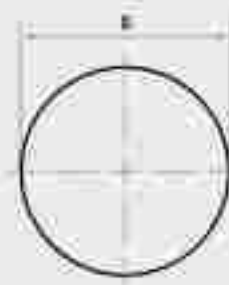
★★

Product number	Description	Quantity per disc	D mm	R mm	Working abrasive disc carrier	Part number
A3377030000458	PSG 038	Z-Power 38	38	25,000	GTC 038	100
A33770380000458	PSG 038	Z-Power 60	38	25,000	GTC 038	100
A33770300000458	PSG 038	Z-Power 80	38	25,000	GTC 038	100
A33770300000458	PSG 038	Z-Power 120	38	25,000	GTC 038	100
A33770300000458	PSG 050	Z-Power 38	51	25,000	GTC 038 and GTC 050	100
A33770500000458	PSG 050	Z-Power 60	51	25,000	GTC 038 and GTC 050	100
A33770500000458	PSG 050	Z-Power 80	51	25,000	GTC 038 and GTC 050	100
A33770700000458	PSG 075	Z-Power 38	76	20,000	GTC 075	50
A33770700000458	PSG 075	Z-Power 60	76	20,000	GTC 075	50
A33770700000458	PSG 075	Z-Power 80	76	20,000	GTC 075	50
A33770751208458	PSG 075	Z-Power 120	76	20,000	GTC 075	50



## 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.

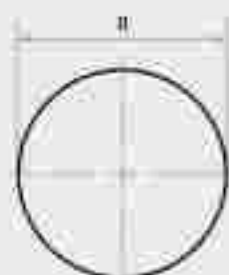


★★

Product number	Description	Quantity per disc	D mm	R mm	Working abrasive disc carrier	Part number
A33530750000458	PSG 025	ZK 40	25	18,000	GTC 025	100
A33530750000458	PSG 025	ZK 60	25	18,000	GTC 025	100
A33530380000458	PSG 038	ZK 38	38	25,000	GTC 038	100
A33530380000458	PSG 038	ZK 60	38	25,000	GTC 038	100
A33530500000458	PSG 050	ZK 38	51	25,000	GTC 038 and GTC 050	100
A33530500000458	PSG 050	ZK 60	51	25,000	GTC 038 and GTC 050	100
A33530500000458	PSG 050	ZK 80	51	25,000	GTC 038 and GTC 050	100
A33530700000458	PSG 075	ZK 38	76	20,000	GTC 075	50
A33530700000458	PSG 075	ZK 60	76	20,000	GTC 075	50



## 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 222.

★★★

Product number	Description	Coarsegrit size	D mm	h mm	Mounting diameter (disc center)	Post position
A33510200600458	PSG 000	NK 60	18	47,000	GTC 020	300
A33510200800458	PSG 000	NK 80	18	47,000	GTC 020	300
A33510201200458	PSG 000	NK 120	18	47,000	GTC 020	300
A33510250200458	PSG 025	NK 25	25	38,000	GTC 025	300
A33510250400458	PSG 025	NK 40	25	38,000	GTC 025	300
A33510250800458	PSG 025	NK 80	25	38,000	GTC 025	300
A33510251200458	PSG 025	NK 120	25	38,000	GTC 025	300
A33510300200458	PSG 038	NK 38	38	25,000	GTC 038	300
A33510300400458	PSG 038	NK 40	38	25,000	GTC 038	300
A33510300800458	PSG 038	NK 80	38	25,000	GTC 038	300
A33510301200458	PSG 038	NK 120	38	25,000	GTC 038	300
A33510500200458	PSG 050	NK 38	51	25,000	GTC 038 and GTC 050	300
A33510500400458	PSG 050	NK 40	51	25,000	GTC 038 and GTC 050	300
A33510500800458	PSG 050	NK 80	51	25,000	GTC 038 and GTC 050	300
A33510501200458	PSG 050	NK 120	51	25,000	GTC 038 and GTC 050	300
A33510600200458	PSG 060	NK 100	51	25,000	GTC 038 and GTC 060	300
A33510600400458	PSG 060	NK 140	51	25,000	GTC 038 and GTC 060	300
A33510700600458	PSG 075	NK 60	76	20,000	GTC 075	50
A33510700800458	PSG 075	NK 80	76	20,000	GTC 075	50
A33510701200458	PSG 075	NK 120	76	20,000	GTC 075	50

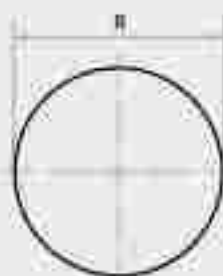
## CAN ALSO HANDLE EDGES

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 alumina trihydrate and reinforced backing material
- The reinforcement makes these discs suitable for the toughest applications and handling
- fitted with a "quick lock" - fastened to the respective carrier by a small twist
- ▶ The matching tool carriers can be found on page 223.



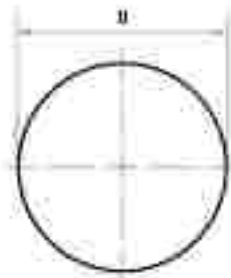
★★★

Product number	Description	Designated size	D mm	R mm	Matching abrasive disc carrier	Flap marking
A3352075000458	PSG 025	NKE 60	25	38,000	GTO 025	100
A3352025000458	PSG 025	NKE 88	25	38,000	GTO 025	100
A3352051200458	PSG 025	NKE 120	25	38,000	GTO 025	100
A3352001000458	PSG 025	NKE 180	25	38,000	GTO 025	100
A3352052000458	PSG 025	NKE 240	25	38,000	GTO 025	100
A3352038000458	PSG 038	NKE 60	38	25,000	GTO 038	100
A3352038000458	PSG 038	NKE 88	38	25,000	GTO 038	100
A3352001000458	PSG 038	NKE 120	38	25,000	GTO 038	100
A3352050000458	PSG 050	NKE 36	51	25,000	GTO 038 and GTO 050	100
A3352050000458	PSG 050	NKE 60	51	25,000	GTO 038 and GTO 050	100
A3352050000458	PSG 050	NKE 88	51	25,000	GTO 038 and GTO 050	100
A3352051200458	PSG 050	NKE 120	51	25,000	GTO 038 and GTO 050	100
A3352050000458	PSG 050	NKE 180	51	25,000	GTO 038 and GTO 050	100
A3352052000458	PSG 050	NKE 240	51	25,000	GTO 038 and GTO 050	100
A3352075000458	PSG 075	NKE 60	38	30,000	GTO 075	50

Recommended for: Steel, Cast iron, Plastic/Wood, Non-ferrous, 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 tool
- The matching tool carriers can be found on page 222.

★★★

Product number	Designation	Quality / grit size	D mm	Area cm <sup>2</sup>	Matching carrier (see page 222)	Per carrier
A33740250040458	PSG 025	F coarse	25	15,000	GTC 025	50
A33740250010458	PSG 025	F medium	25	15,000	GTC 025	50
A33740300010458	PSG 030	F fine	30	10,000	GTC 030	50
A33740300040458	PSG 030	F coarse	30	10,000	GTC 030	50
A33740300010458	PSG 030	F medium	30	10,000	GTC 030	50
A33740500010458	PSG 050	F fine	50	2,500	GTC 030 and GTC 050	50
A33740500040458	PSG 050	F coarse	50	2,500	GTC 030 and GTC 050	50
A33740500010458	PSG 050	F medium	50	2,500	GTC 030 and GTC 050	50
A33740750010458	PSG 075	F fine	75	5,000	GTC 075	25
A33740750040458	PSG 075	F coarse	75	5,000	GTC 075	25
A33740750010458	PSG 075	F medium	75	5,000	GTC 075	25
A3350300040458	PSG 030	V coarse	30	10,000	GTC 030	50
A3350300010458	PSG 030	V medium	30	10,000	GTC 030	50
A3350300010458	PSG 030	V fine	30	10,000	GTC 030	50
A3350500040458	PSG 050	V coarse	50	8,000	GTC 030 and GTC 050	50
A3350500010458	PSG 050	V medium	50	8,000	GTC 030 and GTC 050	50
A3350500010458	PSG 050	V fine	50	8,000	GTC 030 and GTC 050	50

PSG and VPSG are trademarks of the PSG Group.





PSR ABRASIVE DISCS

# Quality and applications

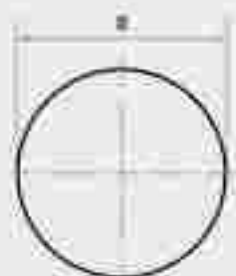
LIKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LIKAS are ideal for many industries, applications and requirements, and therefore offer you a

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.

Color	Properties	Application area / machining	Page	
	<b>ZK</b> Abrasive cloth Zirconia alumina	exceptionally resistant grain with high pressure resistance	ideal for finishing, Inconel, stainless steel and metals that are difficult to machine	224
	Abrasive discs Regular aluminum oxide coarse / brown	jointing 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 discs Regular aluminum oxide medium / red-brown			
	Abrasive discs Regular aluminum oxide fine / black			

PSR abrasive discs are available in a mobile app.

## PSR self-clamping zirconia alumina abrasive disc



- made from abrasive cloth with zirconia alumina
- ideal for finishing, Inconel, stainless steel and metals that are to machine
- with a plastic thread - fastened to the respective carrier by a small tool
- ▶ The matching tool carrier can be found on page 227

★★★

Product number	Description	Quantity / unit	Ø mm	Max. RPM	Matching abrasive disc carrier	Part number
A33E350019045E	PSR 35E	ZK 36	51	25,000	GTR 03E and GTR 04E	100
A33E350000045E	PSR 05E	ZK 05	51	25,000	GTR 03E and GTR 05E	100
A33E350008045E	PSR 05E	ZK 05	51	25,000	GTR 03E and GTR 05E	100
A33E350120045E	PSR 05E	ZK 120	51	25,000	GTR 03E and GTR 05E	100
A33E350000045E	PSR 075	ZK 36	76	20,000	GTR 075	50
A33E350008045E	PSR 075	ZK 05	76	20,000	GTR 075	50
A33E350000045E	PSR 075	ZK 05	76	20,000	GTR 075	50

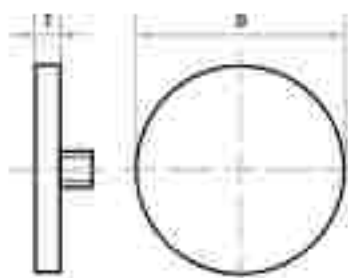
Recommended for: ● Inconel ● Steel ● Cast material ● Titanium





## 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.



★★

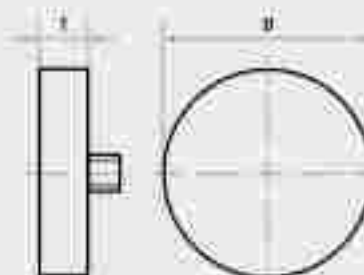
Product number	Description	Quality of size	D mm	T mm	P <sub>max</sub> /grit	Matching abrasive disc carrier	Part number
A3370000020458	PSR 030	P medium	30	4	50.000	GTR 030	50
A3375000040458	PSR 030	P fine	30	4	10.000	GTR 030	50
A337500004045H	PSR 030	P coarse	51	4	7.500	GTR 030 and GTR 050	50
A3375000020458	PSR 050	P medium	51	4	7.500	GTR 030 and GTR 050	50
A337500005045H	PSR 050	P fine	51	4	7.500	GTR 030 and GTR 050	50
A33750750040458	PSR 075	P coarse	76	4	5.000	GTR 030, GTR 050 and GTR 075	25
A3375075005045H	PSR 075	P fine	76	4	5.000	GTR 030, GTR 050 and GTR 075	25
A3375075000458	PSR 075	P medium	76	4	5.000	GTR 030, GTR 050 and GTR 075	25



## PSR self-clamping abrasive disc, wide abrasive fleece

NEW

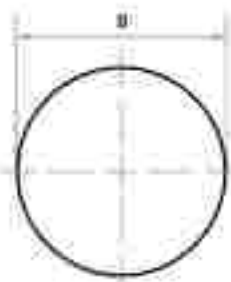
- ideal for removing rust or paint, scratches and pre-grinding marks
- V version with wide and coarse abrasive fleece
- improvement of surface quality
- with a plastic thread - fastened to the respective carrier by a small twist
- ▶ The matching tool carrier can be found on page 227.



★★

Product number	Description	Quality of size	D mm	T mm	P <sub>max</sub> /grit	Matching abrasive disc carrier	Part number
A3370000040458	PSR 050	V coarse	51	12	4.000	GTR 030 and GTR 050	50
A3370000020458	PSR 050	V medium	51	10	8.000	GTR 030 and GTR 050	50
A3370000050458	PSR 050	V fine	51	8	8.000	GTR 030 and GTR 050	50

## STLG self-clamping lamellar flap disc



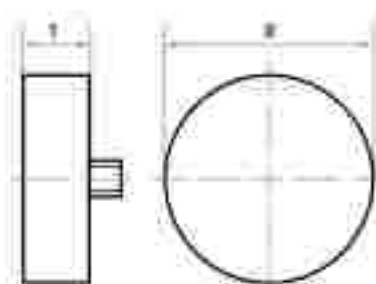
- excellent machining performance
- good grip even at low contact pressure
- long tool life (compared to surface grinding discs)
- flap projection
- elastic
- perfectly suitable for use with robots
- with a plastic thread - fastened to the respective carrier by a small screw

★★☆

Product number	Description	Car	D mm	B mm	Grain	Machining abrasive direction	Flap contact
A3331000040E23	SLTG 050 R	ZK 40	50	10,000	GTR 030.06	10	
A3331000050E23	SLTG 050 R	ZK 40	50	10,000	GTR 025.06	10	
A3331000080E23	SLTG 050 R	ZK 80	50	10,000	GTR 030.06	10	
A3331001200E23	SLTG 050 R	ZK 120	50	10,000	GTR 030.06	10	
A333100040E23	SLTG 065 R	ZK 40	65	14,700	GTR 050.06	10	
A333100060E23	SLTG 065 R	ZK 60	65	14,700	GTR 050.06	10	
A333100080E23	SLTG 065 R	ZK 80	65	14,700	GTR 050.06	10	
A3331075040E23	SLTG 075 R	ZK 40	75	12,200	GTR 050.06	10	
A3331075060E23	SLTG 075 R	ZK 60	75	12,700	GTR 050.06	10	
A3331075080E23	SLTG 075 R	ZK 80	75	12,700	GTR 050.06	10	
A3331075120E23	SLTG 075 R	ZK 120	75	12,700	GTR 050.06	10	


**ASVR self-clamping flap disc** NEW

- the all-rounder for removing point, adhesive residue and rust, as well as clearing and polishing a wide variety of surface materials
- made of excellent 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

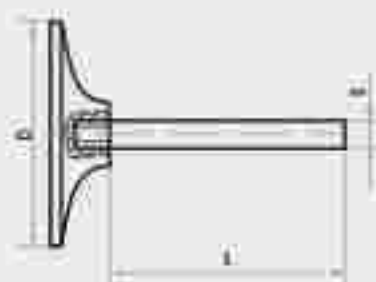


★★☆☆

Product number	Description	D mm	H mm	L mm	Working strokes per minute	Part number
A2290500002	ASVR 50H	51	16	15,500	GTR 051.00	10


**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	Strokes per min	Part number
A2360030000048	GTR 030.00	medium	33	40	8	10,000	1
A2360050000048	GTR 050.00	medium	45	40	8	25,000	1
A2360075000048	GTR 075.00	medium	75	40	8	20,000	1



**PSK ABRASIVE DISCS**

# Quality and applications

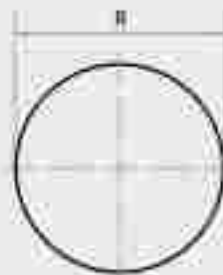
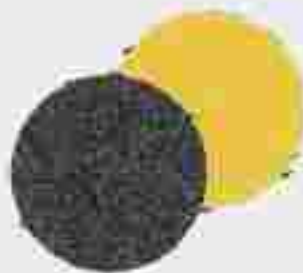
LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a very wide selection.

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.

Image	Quality	Properties	Application recommendations	Page
	<b>Al<sub>2</sub>O<sub>3</sub></b> Abrasive cloth Regular aluminum oxide	very tough abrasive, high efficiency	universal grinding and deburring	229
	<b>SiC</b> Abrasive cloth Silicon carbide	minimum heat accumulation, special quality for the aviation industry	ideal for machining titanium, titanium alloys and aluminum (aerospace industry). Plastics and composites can also be processed.	238

 GRINDING AND POLISHING  
 - application tips -

## PSK adhesive silicon carbide abrasive disc



- no heat accumulation
- ideal for machining titanium and titanium alloys, aluminum (aviation industry), as well as plastics and composites
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- ▶ The matching tool carrier can be found on page 238

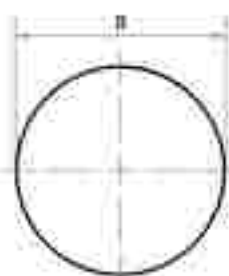
★ ★ ☆

Product number	Description	Grit	Disc size	Peak accuracy
A230501800	PSK 018	SiC 80	21	100
A230501120	PSK 018	SiC 120	21	100
A230501080	PSK 030	SiC 80	33	100
A230501120	PSK 030	SiC 120	33	100
A230501200	PSK 045	SiC 120	48	100

Recommended by:



## PSK adhesive regular aluminium oxide abrasive disc

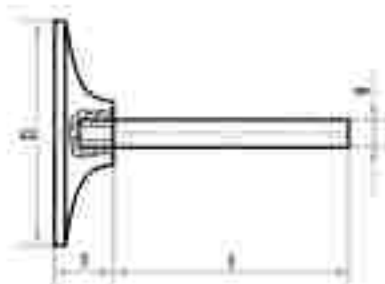


- for universal grinding and deburring
- Adhesive: After removing the film, these abrasive discs are easily stuck to the respective carrier.
- ▶ The matching tool carrier can be found on page 220.

★ ★

Product number	Description	Code	Ø mm	Flank allowance
AZ300018080	PSK 018	NK 60	21	100
AZ300018080	PSK 018	NK 80	21	100
AZ300018120	PSK 018	NK 120	21	100
AZ300018150	PSK 018	NK 150	21	100
AZ300018180	PSK 018	NK 180	21	100
AZ300018240	PSK 018	NK 240	21	100
AZ300030060	PSK 030	NK 60	33	100
AZ300030080	PSK 030	NK 80	33	100
AZ300030120	PSK 030	NK 120	33	100
AZ300030150	PSK 030	NK 150	33	100
AZ300030180	PSK 030	NK 180	33	100
AZ300030240	PSK 030	NK 240	33	100
AZ300045080	PSK 045	NK 80	48	100
AZ300045100	PSK 045	NK 100	48	100
AZ300045120	PSK 045	NK 120	48	100
AZ300045150	PSK 045	NK 150	48	100
AZ300045180	PSK 045	NK 180	48	100
AZ300045240	PSK 045	NK 240	48	100
AZ300060060	PSK 060	NK 60	63	100
AZ300060080	PSK 060	NK 80	63	100
AZ300060120	PSK 060	NK 120	63	100
AZ300060150	PSK 060	NK 150	63	100
AZ300075080	PSK 075	NK 80	78	100
AZ300075080	PSK 075	NK 80	78	100
AZ300075120	PSK 075	NK 120	78	100
AZ300075150	PSK 075	NK 150	78	100

## GTK abrasive disc carrier for adhesive abrasive discs



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

★★☆

Product number	Description	D mm	d mm	T mm	L mm	$n_{max}$ rpm	Flank condition
A258301836001	GTK 018.03	18	3	11	30	20,000	5
A258303000001	GTK 030.01	30	3	12	20	12,500	5
A258303000001	GTK 030.06	30	6	12	40	12,500	5
A258304000001	GTK 040.06	40	6	11	40	10,000	5
A258306000001	GTK 060.06	60	6	13	40	8,000	5
A258307500001	GTK 075.06	75	6	15	40	6,000	2







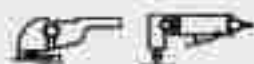
## PSH ABRASIVE DISCS

# Quality and applications

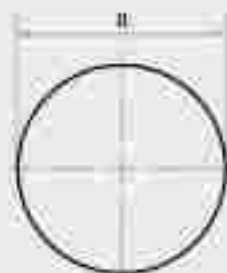
LUKAS offers you the right abrasive for every job – tailored to your requirements and the materials you want to machine. The high-quality abrasives from LUKAS are ideal for many industries, applications and requirements, and therefore offer you a

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/working	Page
 <b>NK</b> Abrasive discs Regular aluminium oxide	very high abrasive, high resistance	universal grinding and deburring	231 – 232
 Abrasive discs Regular aluminium oxide coarse/brown	priming 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 discs Regular aluminium oxide medium/red brown			
 Abrasive discs Regular aluminium oxide fine/green			



## PSH self-fixing regular aluminium oxide abrasive disc



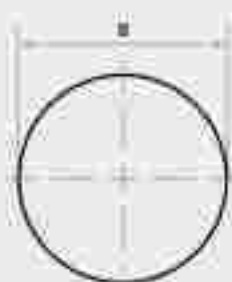
- suitable for the universal machining of both flat and concave surfaces
- with Velox material for fast tool changes
- ▶ The matching tool carrier can be found on page 332.



Product number	Description	Grit	Ø mm	Thickness mm
A330018050	PSH 018	NK 60	20	100
A330018080	PSH 018	NK 80	20	100
A330018120	PSH 018	NK 120	20	100
A330018150	PSH 018	NK 150	20	100
A330018180	PSH 018	NK 180	20	100
A330018240	PSH 018	NK 240	20	100
A330018320	PSH 018	NK 320	20	100
A330020080	PSH 020	NK 80	33	100
A330020120	PSH 020	NK 120	33	100
A330020150	PSH 020	NK 150	33	100
A330020180	PSH 020	NK 180	33	100
A330020240	PSH 020	NK 240	33	100

Recommended for: Smoothed Dead Dark material Plastic fibres Aluminium Others



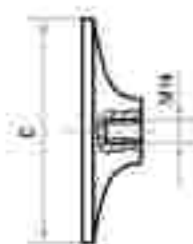

**PSH self-fixing compact grain abrasive disc**
**NEW**


- With high grain density on cutting edges thanks to compact grain – guarantees an 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	Ø mm	mm	mm	Part number
A730115200001	PSH 115	NK 00	115	4,000	4,000	50
A730115120004	PSH 115	NK 120	115	4,000	4,000	50
A730115140005	PSH 115	NK 240	115	4,000	4,000	50
A730115400006	PSH 115	NK 400	115	4,000	4,000	50
A730115600006	PSH 115	NK 600	115	4,000	4,000	50
A730115120005	PSH 115	NK 1200	115	4,000	4,000	50
A730112500005	PSH 125	NK 00	125	4,400	3,850	50
A7301125120005	PSH 125	NK 120	125	4,400	3,850	50
A7301125240005	PSH 125	NK 240	125	4,400	3,850	50
A7301125400005	PSH 125	NK 400	125	4,400	3,850	50
A7301125600005	PSH 125	NK 600	125	4,400	3,850	50
A7301125120005	PSH 125	NK 1200	125	4,400	3,850	50
A730115000005	PSH 150	NK 00	150	3,800	4,350	50
A7301150120004	PSH 150	NK 120	150	3,800	4,350	50
A7301150240005	PSH 150	NK 240	150	3,800	4,350	50
A7301150400005	PSH 150	NK 400	150	3,800	4,350	50
A7301150600005	PSH 150	NK 600	150	3,800	4,350	50
A7301150120005	PSH 150	NK 1200	150	3,800	4,350	50

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**GTHX abrasive disc carrier for self-fixing abrasive discs with thread**
**NEW**


★ ★ ☆

Product number	Description	Quantity	Ø mm	Thread	mm	Part number
A3831151004	GTHX 115	medium for Velcro discs	115	M14	4,300	1
A3831251004	GTHX 125	medium for Velcro discs	125	M14	3,500	1
A3831501004	GTHX 150	medium for Velcro discs	150	M14	4,300	1



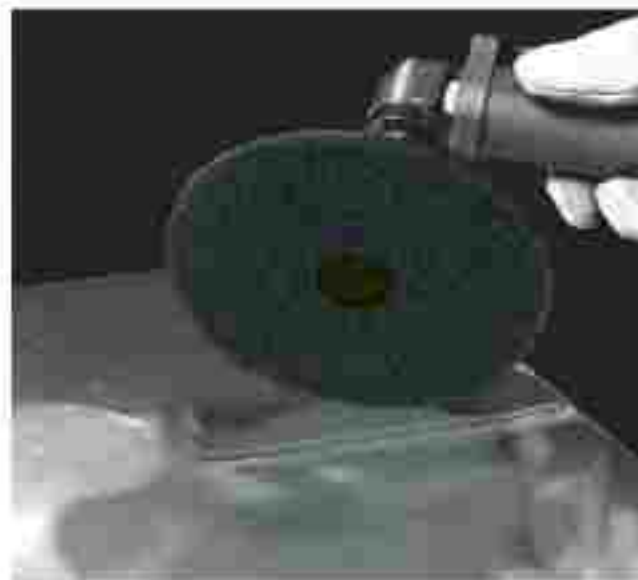
## SELF-FIXING ABRASIVE FLEECE DISCS

ATTACHMENT MADE EASY THANKS TO THE FIXING SYSTEM

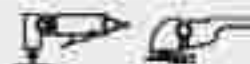
LUKAS PSH abrasive discs made of abrasive fleece are suitable for machining both flat and concave surfaces. Whether for removing rust or paint, scratches or pre-grinding marks, the polyamide material allows these discs to adapt themselves perfectly to uneven surfaces. You need less effort and time for 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



- 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	Coarsity	Ø disc	Ø hole	Weight	Pack. quantity
A338H15-00001	PSH 115	Fleece coarse	115	4,100	8,300	10
A228H15-10401	PSH 115	Fleece medium	115	4,100	8,300	10
A338H15-02701	PSH 115	Fleece very fine	115	4,100	8,300	10
A338H25-12001	PSH 125	Fleece coarse	125	3,800	7,600	10
A338H25-10401	PSH 125	Fleece medium	125	3,800	7,600	10
A228H25-14701	PSH 125	Fleece very fine	125	3,800	7,600	10


**GTH abrasive disc carrier for abrasive fleece with centering pin** NEW


► especially for PSI with centering pin on page 234

★★☆☆

Product number	Description	D mm	Thread	Flange type	Flange thickness
A25041151401	GTH 115	115	M14	E300	1
A25041251401	GTH 125	125	M14	E300	1


**GTH abrasive disc carrier for abrasive fleece**


★★☆☆

Product number	Description	D mm	Thread	Flange type	Flange thickness
A30111151001	GTH 115	115	M14	E300	1
A3011251001	GTH 125	125	M14	E300	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 centers can be found on page 241.

**★★★**

Product number	Description	Grain	Ø mm	Thick. mm	Weight (kg)	Part number
A38301150000001	FIS 115	Ceramic 20	115	22	11,300	50
A38301150000002	FIS 115	Ceramic 36	115	22	11,300	50
A38301150000003	FIS 115	Ceramic 40	115	22	11,300	50
A38301150000004	FIS 115	Ceramic 60	115	22	11,300	50
A38301150000005	FIS 115	Ceramic 80	115	22	11,300	50
A38301250000001	FIS 125	Ceramic 20	125	22	12,200	50
A38301250000002	FIS 125	Ceramic 36	125	22	12,200	50
A38301250000003	FIS 125	Ceramic 40	125	22	12,200	50
A38301250000004	FIS 125	Ceramic 60	125	22	12,200	50
A38301250000005	FIS 125	Ceramic 80	125	22	12,200	50
A38301250000006	FIS 125	Ceramic 120	125	22	12,200	50
A38301500000001	FIS 150	Ceramic 20	150	22	16,200	50
A38301500000002	FIS 150	Ceramic 36	150	22	16,200	50
A38301500000003	FIS 150	Ceramic 40	150	22	16,200	50
A38301800000001	FIS 180	Ceramic 20	180	22	8,500	50
A38301800000002	FIS 180	Ceramic 36	180	22	8,500	50
A38301800000003	FIS 180	Ceramic 40	180	22	8,500	50
A38301800000004	FIS 180	Ceramic 60	180	22	8,500	50
A38301800000005	FIS 180	Ceramic 80	180	22	8,500	50

Grinding and polishing - part 2 (page 241)



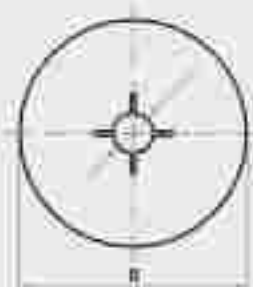
## FINE AND CONSISTENT SURFACE FINISH

LUKAS FIBRE DISCS FOR YOUR REQUIRED SURFACE RESULTS



### FIS zirconia alumina fibre disc with cross slot

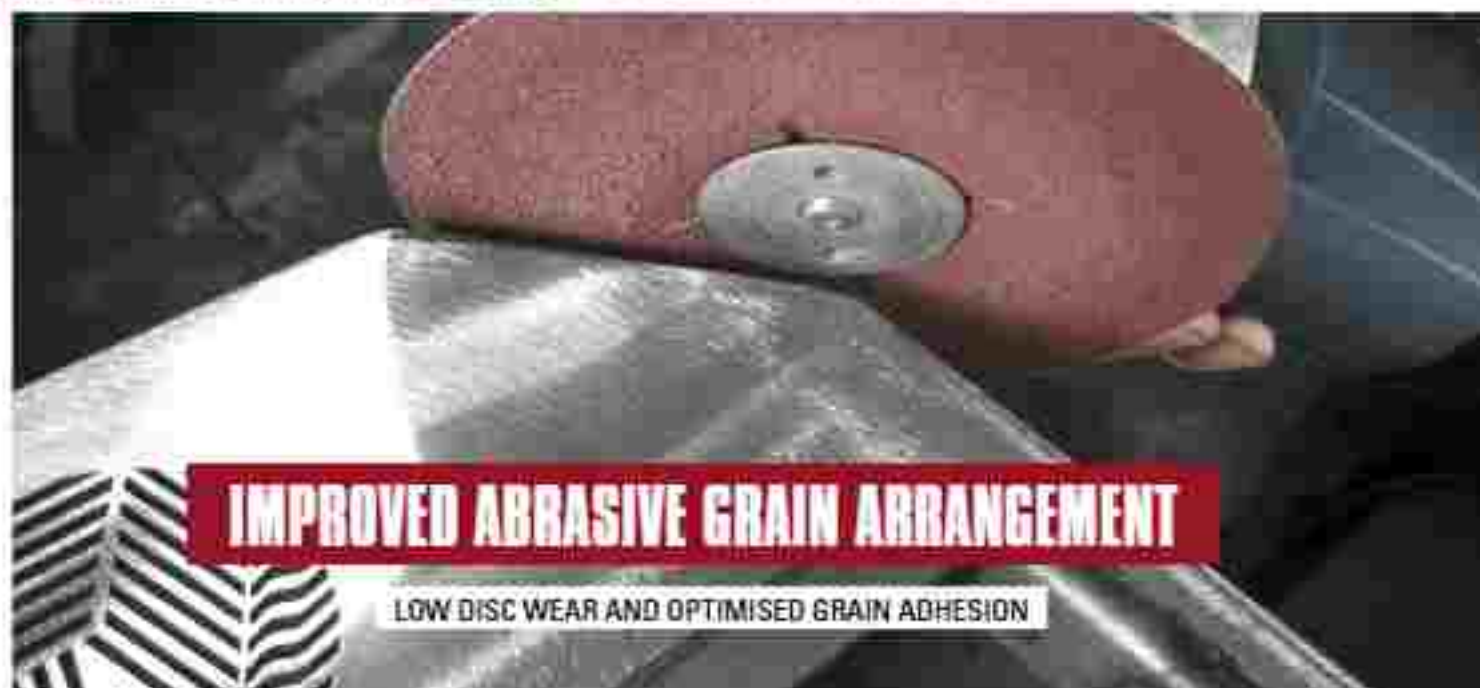
- single layer of abrasive for the toughest applications
- made of exceptionally tough zirconia alumina with high resistance to pressure
- used together with a backing pad on angle grinders
- ▶ The matching tool catalog can be found on page 241.



★★★

Product number	Description	Grain	Ø mm	Blade mm	Flap speed	Peak resistance
A3830110362	FIS 115	ZK 36	115	27	13,200	50
A3830110462	FIS 116	ZK 40	115	27	13,200	50
A3830110562	FIS 115	ZK 60	115	27	13,200	50
A3830110662	FIS 115	ZK 80	115	27	13,200	30
A3830120362	FIS 125	ZK 36	125	27	13,200	50
A3830120462	FIS 125	ZK 40	125	27	13,200	50
A3830120562	FIS 125	ZK 60	125	27	13,200	50
A3830120662	FIS 125	ZK 80	125	27	13,200	30

Recommended for  Saw/Tool  Drill  Cut/inserted  T/abrasive



## IMPROVED ABRASIVE GRAIN ARRANGEMENT

LOW DISC WEAR AND OPTIMISED GRAIN ADHESION

### 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 carrier can be found on page 241.

★★★

Product number	Description	Grain	Ø mm	Thick. mm	g/m <sup>2</sup>	Flap condition
A3830115041	FIS 115	NK 34	115	21	11,300	50
A3830115081	FIS 115	NK 36	115	27	11,300	54
A38301150411	FIS 115	NK 40	115	27	11,300	50
A38301150411	FIS 115	NK 40	115	21	11,300	50
A38301150811	FIS 115	NK 36	115	21	11,300	50
A38301151311	FIS 115	NK 120	115	21	11,300	50
A38301125041	FIS 125	NK 34	125	21	12,200	50
A3830125081	FIS 125	NK 36	125	27	12,200	54
A38301250411	FIS 125	NK 40	125	27	12,200	50
A38301250811	FIS 125	NK 36	125	21	12,200	50
A38301251801	FIS 125	NK 80	125	27	12,200	50
A3830180081	FIS 180	NK 36	180	27	10,200	50
A3830180241	FIS 180	NK 34	180	27	8,500	50
A38301800311	FIS 180	NK 36	180	21	8,500	50
A38301800401	FIS 180	NK 40	180	21	8,500	50
A38301801601	FIS 180	NK 80	180	27	8,500	50
A38301800201	FIS 180	NK 30	180	27	8,500	50

## COST-EFFECTIVE GRINDING

EXCELLENT PRICE-PERFORMANCE RATIO WITH LUKAS BASE-X



- single layer of abrasives for tough applications
- for the most consistent use
- regular aluminum oxide for cost-effective working
- used together with a backing pad on angle grinders
- ▶ The matching tool carrier can be found on page 241.



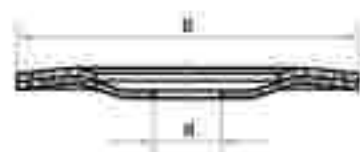
### FIS BASE-X fibre disc with cross slot



Product Number	Dimensions	Grit	Ø (mm)	Min. mm	Max. mm	Pack quantity
A783011004101	FG 115	NK 24	115	22	13,300	25
A783011003101	FG 115	NK 36	115	22	13,300	25
A783011000101	FG 115	NK 40	115	22	13,300	25
A783011006101	FG 115	NK 60	115	22	13,300	25
A783011005101	FG 115	NK 80	115	22	13,300	25
A783012004101	FG 125	NK 24	125	22	12,200	25
A783012003101	FG 125	NK 36	125	22	12,200	25
A783012000101	FG 125	NK 40	125	22	12,200	25
A783012006101	FG 125	NK 60	125	22	12,200	25
A783012005101	FG 125	NK 80	125	22	12,200	25
A7830125120101	FG 125	NK 120	125	22	12,200	25
A783010036101	FG 180	NK 36	180	22	8,500	25
A783010066101	FG 180	NK 60	180	22	8,500	25



## 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 GFRP and CFRP (e.g. for wind turbine blades)
- also very suitable for animal bones
- may only be used with backing pads
- The matching tool carriers can be found on page 243.

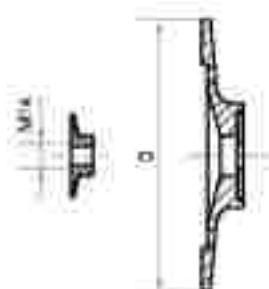
★★☆

Product number	Description	Grain	Ø mm	H mm	W mm	Flap thickness
A38351150104	SHF 115	SDC 18	115	22.21	13,300	25
A38351150144	SHF 115	SDC 24	115	22.21	13,300	25
A38351150304	SHF 115	SDC 36	115	22.21	13,300	25
A38351150604	SHF 115	SDC 60	115	22.21	13,300	25
A38351250104	SHF 125	SDC 24	125	22.21	17,300	25
A38351250304	SHF 125	SDC 36	125	22.21	17,300	25



## 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.



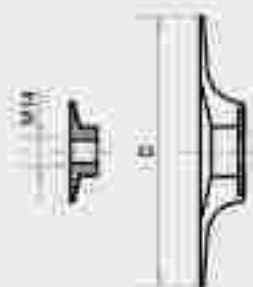
★★★

Product number	Description	Ø mm	Thread	Flange height	Stock removal
A3B11151001	STF HL	113	M14	13,200	1
A3B11251001	STF HL	125	M14	12,200	1
A3B11501001	STF HL	140	M14	10,200	1
A3B11801001	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.



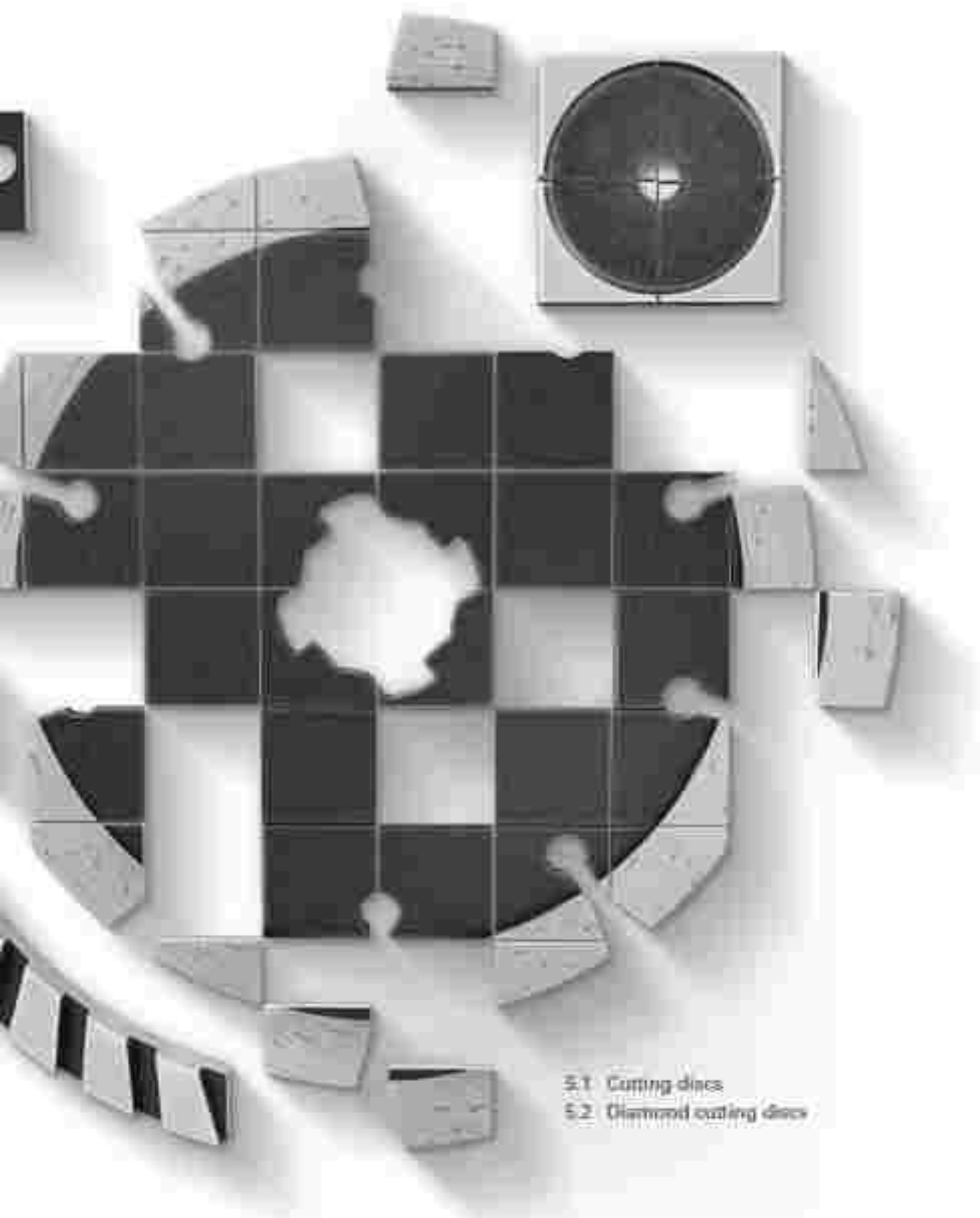
★★★

\* nuts included

Product number	Description	Ø mm	Thread	Flange height	Stock removal
A3B11151001	STF 113	113	M14	13,200	1
A3B11251001	STF 125	125	M14	12,200	1
A3B11501001	STF 140	140	M14	10,200	1
A3B11801001	STF 180	175	M14	8,500	1







- 5.1 Cutting discs
- 5.2 Diamond cutting discs

# CUTTING

- 244–250
- 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**  
Soft fibrous  
aluminum oxide



**Z**  
Zirconia alumina



**A**  
Ceramic-coated  
annealed aluminum  
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	Aluminum 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
F	S	V
L	T	Z

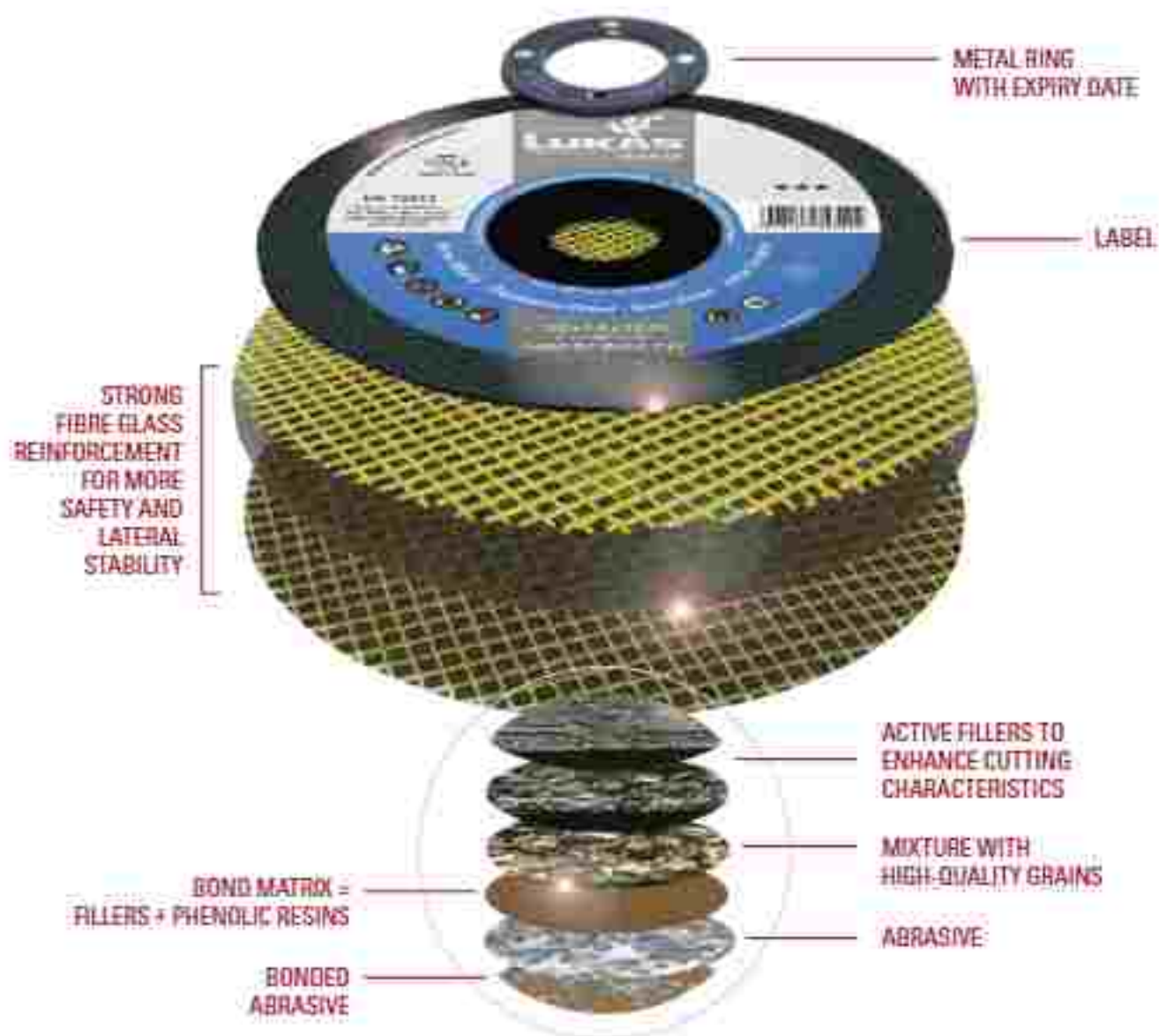
## BOND

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	75	100	125	150	175	200	225	250	275	300	350	
30 m/s	30,500	20,100	15,300	13,300	12,300	10,300	8,500	8,000	5,100	4,400	3,900		
150 m/s	38,200	25,100	18,700	16,600	16,000	13,700	10,800	9,300	6,400	5,400	4,700		



## 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

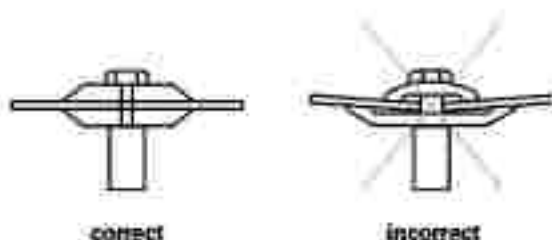
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13338

## 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 cut 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 60745-3-3:2007 and ANSI B.7.1).

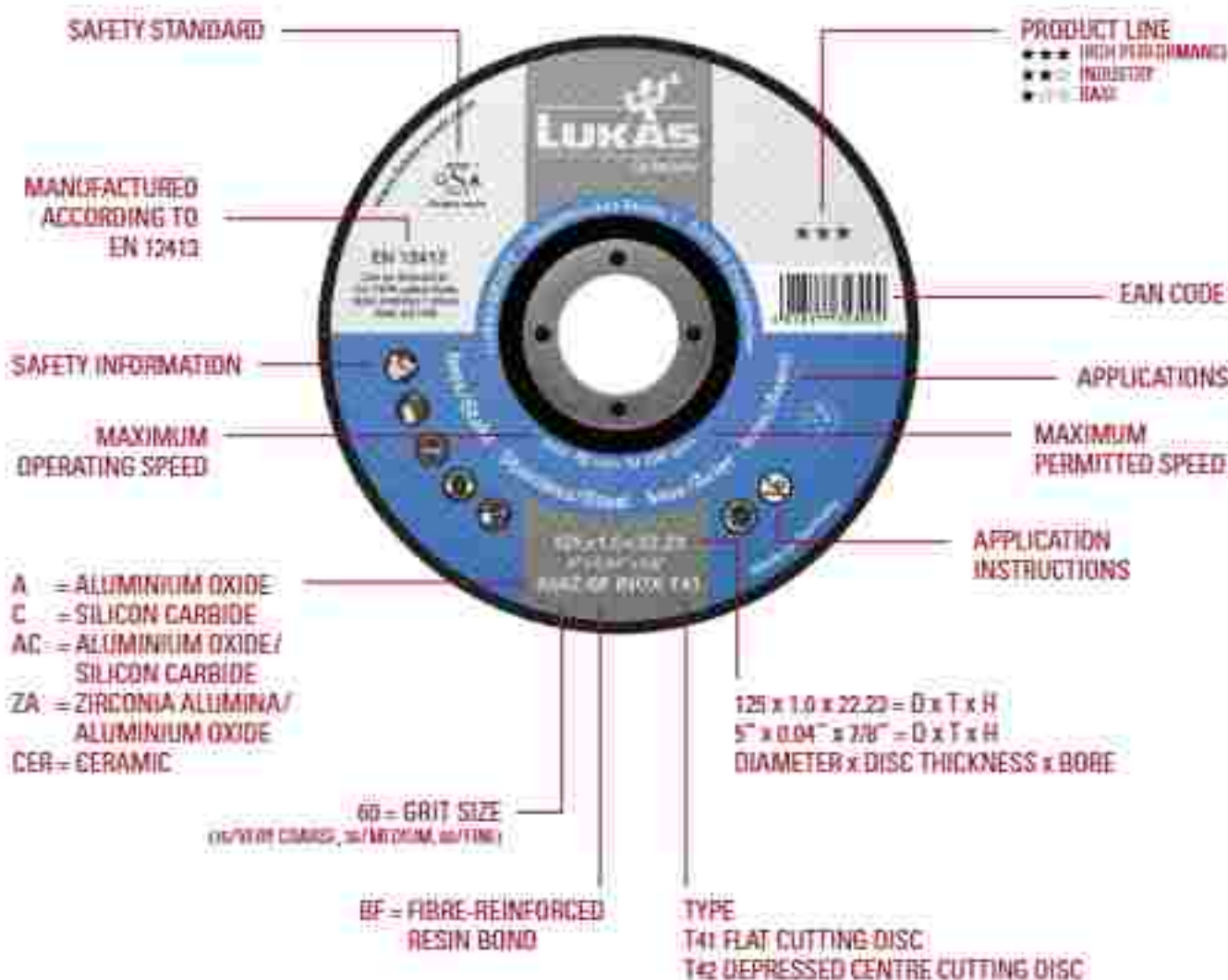


correct

incorrect

## LABELLING

## All important markings on the label

























## TYPES OF RESIN-BONDED CUTTING DISCS

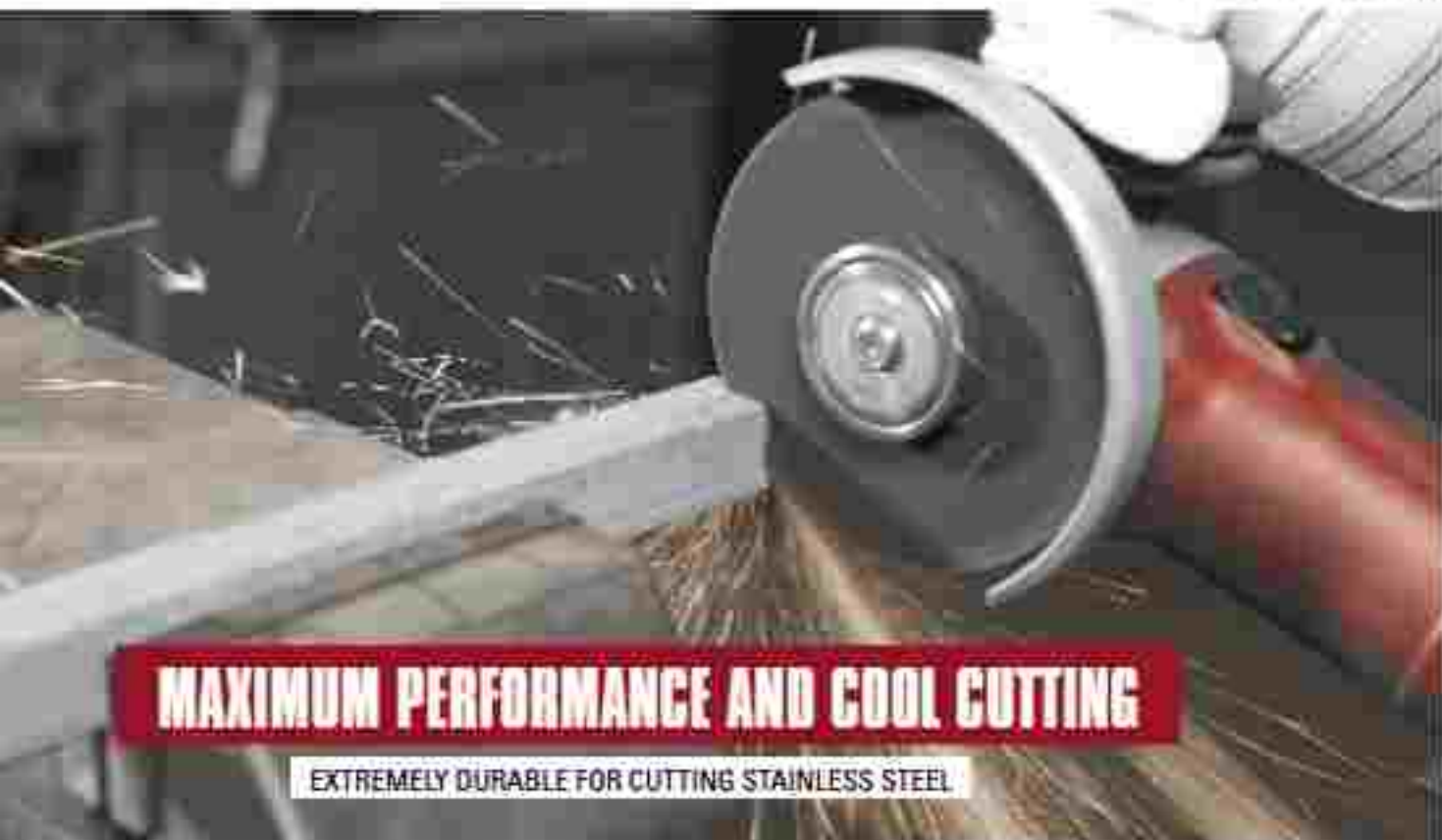
T41 Flat cutting disc	T42 Depressed centre cutting disc
<p>Cutting discs T = (0.8 mm - 4.5 mm) (USA: Type T)</p>	<p>Cutting discs T = (0.8 mm - 4.5 mm) (USA: Type T)</p>
<ul style="list-style-type: none"> <li>Available in diameters from 50 mm (2") to 230 mm (9"), for handhold use</li> <li>From 300 mm (12") to 500 mm (20") for stationary machines</li> </ul>	<ul style="list-style-type: none"> <li>Available in diameters from 36 mm (1 1/2") to 330 mm (13"), approved for handhold use</li> </ul>

AREA OF USE

# Overview of types of LUKAS cutting discs

Type	Product line	Material				
		Reinforced	Steel	Aluminium	Stone Construction material	Cast-iron Construction material
<b>Handheld cutting discs for angle grinders</b> Diameter 100 - 230 mm 	★★★	 Pages 248 - 251	 Page 255		 Pages 252 and 256	 Page 262
	★★☆	 Page 252	 Page 255	 Page 256	 Pages 252, 255 and 256	
	★☆☆	 Pages 254 and 258	 Page 255		 Pages 253, 255 and 257	
<b>Handheld cutting discs with X-LOCK system for angle grinders</b> Diameter 115 - 125 mm 	★★☆	 Page 253			 Pages 254 and 257	
<b>Stationary cutting discs</b> Diameter Larger than 230 mm  	★★★				 Page 260	 Page 261
	★★☆				 Pages 262 - 264 and 265	
	★☆☆	 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

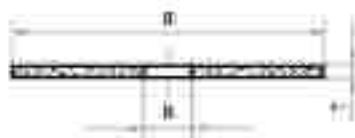
the highly-versatile cutting discs to achieve an excellent cutting performance consistently over the tool service life with little force required and least impressive durability. This reduces the frequency of tool replacement significantly – lowering tool costs.

### 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 optimized for the highest performance angle grinder
- maximum cutting performance
- little force required
- cool cutting



## Ceramic cutting disc **NEW**



★★★

Product number	Description	Quality	D mm	Y mm	H mm	D <sub>int</sub> mm	Max. RPM	Max. thickness
AT080310V9802	T41 85x1.0	CER 4BU-BF Inox	115	1.0	22.23	12.300	25	
AT080312V9802	T41 125x1.0	CER 4BU-BF Inox	125	1.0	22.23	12.200	25	
AT080310V9802	T41 250x2.0	CER 4BU-BF Inox	250	2.0	22.23	6.000	25	

Recommended for

# LUKAS CUTTING DISCS IN 3-STAR QUALITY

TOP PERFORMANCE FOR THE TOUGHEST JOBS

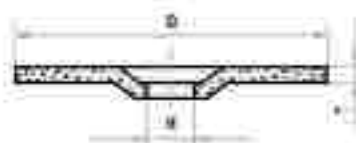
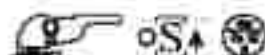
Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS cutting discs achieve the ultimate results:

The minimum wear of 3-star quality noticeably reduces odour 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 iron 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

★★★

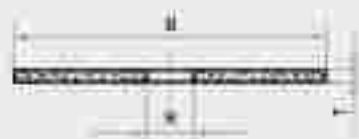
Product number	Description	Quality	D mm	T mm	H mm	v <sub>max</sub> rpm	Part number
AS115270V0802	T77 115x2.0	AGV-BF Inox COOL JOBBER	115	2.0	22.23	13,300	25
AS115270V0803	T27 115x2.0	AGV-BF Inox COOL JOBBER	115	2.0	22.23	13,300	26

Recommended use:



## Cutting disc for stainless steel

- non-, chlorine- 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 tuning



★★★

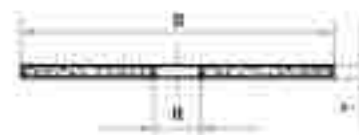
Product number	Description	Quantity	Shape	D mm	T mm	H mm	Max. rpm	Part number
AT007231V9802	141 115x1.0	A61Z-BF Inox		115	1.0	22.23	11,300	50
AT007230V9802	141 115x1.6	A61Z-BF Inox		115	1.6	22.23	11,300	50
AT007211V9802	141 115x2.5	A31Z-BF Inox		115	2.5	22.23	11,300	25
AT007233V9802	141 125x1.0	A61Z-BF Inox		125	1.0	22.23	12,300	50
AT007237V9802	141 125x1.6	A61Z-BF Inox		125	1.6	22.23	12,300	50
AT007212V9802	141 125x2.5	A31Z-BF Inox		125	2.5	22.23	12,300	25
AT007229V9802	141 150x1.2	A61Z-BF Inox		150	1.2	22.23	10,200	50
AT007247V9802	141 150x1.6	A61Z-BF Inox		150	1.6	22.23	10,200	25
AT007243V9802	141 180x1.6	A61Z-BF Inox		180	1.6	22.23	8,500	25
AT007240V9802	141 220x1.0	A61Z-BF Inox		220	2.0	22.23	6,000	25
AT007210V9802	141 220x2.5	A31Z-BF Inox	220	2.5	22.23	6,000	25	
AT007231V9801	142 115x0.8	A61Z-BF Inox		115	0.8	22.23	11,300	50
AT007217V9802	142 115x2.5	A31Z-BF Inox		115	2.5	22.23	11,300	25
AT007232V9802	142 125x0.8	A61Z-BF Inox		125	0.8	22.23	12,300	50
AT007214V9802	142 125x2.5	A31Z-BF Inox		125	2.5	22.23	12,300	25
AT007244V9802	142 150x1.2	A61Z-BF Inox		150	1.2	22.23	8,500	25
AT007240V9802	142 220x1.0	A61Z-BF Inox		220	1.0	22.23	6,000	25
AT007220V9802	142 220x2.5	A31Z-BF Inox		220	2.5	22.23	6,000	25

Recommended for:  Saw/Chisel  Drill  Hammer  Abrasive  Core/rod



## Cutting disc set

- The handy choice, it is:
- for the construction site
  - cutting discs in a metal case
  - safety pocket
  - moisture proof



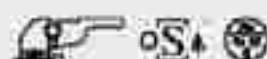
★★★

Product number	Description	Quantity	D mm	T mm	H mm	Max. rpm	Part number
AT007231V980206	141 115x1.0	A61Z-BF Inox	115	1.0	22.23	11,300	50
AT007233V980206	141 125x1.0	A61Z-BF Inox	125	1.0	22.23	12,300	50

Recommended for:  Saw/Chisel  Drill  Hammer  Abrasive  Core/rod



## Cutting disc for stainless steel

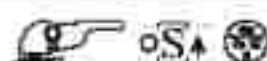


- free of zinc, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	v <sub>cut</sub> rpm	Price indicator
AT00584V9802	141 115x1.0	A60X-BF Inox		115	1.0	22.23	13,300	50
AT00584V9802	141 115x1.8	A60X-BF Inox		115	1.8	22.23	13,300	50
AT00587V9802	141 115x2.0	A36U-BF Inox		115	2.0	22.23	13,300	25
AT00584V9802	141 125x1.0	A60X-BF Inox		125	1.0	22.23	12,300	50
AT00334V9802	141 125x1.8	A60X-BF Inox		125	1.8	22.23	12,300	50
AT00587V9802	141 125x2.0	A36U-BF Inox		125	2.0	22.23	12,300	25
AT00532V9802	141 150x1.0	A40X-BF Inox		150	1.0	22.23	10,300	25
AT00130V9802	141 150x2.0	A36U-BF Inox		150	2.0	22.23	8,500	25
AT00685V9802	141 230x1.0	A60X-BF Inox		230	1.0	22.23	6,600	25
AT00102V9802	141 230x2.0	A36U-BF Inox		230	2.0	22.23	6,600	25
AT00106V9802	142 125x2.5	A36U-BF Inox		125	2.5	22.23	12,300	25
AT00527V9802	142 180x1.0	A40X-BF Inox		180	1.0	22.23	8,500	25
AT00587V9802	142 230x1.0	A60X-BF Inox		230	1.0	22.23	6,600	25
AT00446V9802	142 230x3.0	A30U-BF Inox		230	3.0	22.23	6,600	25

## Cutting disc set



- The handy choice, e.g. for the construction site
- cutting discs in a metal case
  - safely packed
  - moisture proof

★★☆

Product number	Description	Quality	D mm	T mm	H mm	v <sub>cut</sub> rpm	Price indicator
AT00584V9802U10	141 115x1.0	A60X-BF Inox	115	1.0	22.23	13,300	10
AT00584V9802U10	141 125x1.0	A60X-BF Inox	125	1.0	22.23	12,300	10



## 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.



### X-LOCK cutting disc **NEW**

- faster and simpler tool changes thanks to the latest X-LOCK system
- free of rim, chisels and ridges
- 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

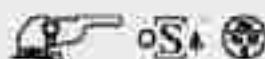


★★★

Product number	Description	Quality	D mm	T mm	H mm	Max. rpm	Part number
AT115010V980201	141 115x1.6x22.25 X-LOCK	AA10-BF Inox	115	1.6	22.25	11,300	50
AT125010V981002	141 125x1.6x23.25 X-LOCK	AA10-BF Inox	125	1.6	23.25	12,200	30

Recommended for:

## Cutting disc for stainless steel

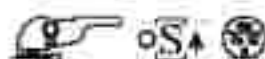


- free of iron, chlorine and sulphur
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular timing

★☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	$v_{max}$ rpm	Pack contents
A700310HVS802	141 100x1.0	A8S-BF Inox		100	1.0	16.00	15,300	50
A7004447V802	141 115x1.0	A8S-BF Inox		115	1.0	22.25	13,300	50
A7000647V802	141 115x1.6	A8T-BF Inox		115	1.6	22.25	13,300	50
A700267V802	141 125x1.0	A8S-BF Inox		125	1.0	22.25	12,300	50
A700064WV802	141 125x1.6	A8T-BF Inox		125	1.6	22.25	12,300	50
A7000100V802	141 150x1.6	A8T-BF Inox		150	1.6	22.25	10,200	25
A7000716V802	141 160x1.6	A8T-BF Inox		160	1.6	22.25	8,500	25
A700042V802	141 230x1.6	A8T-BF Inox		230	1.6	22.25	6,900	25
A700358UV802	141 230x3.0	A24/30S-BF Inox		230	3.0	22.25	6,600	25
A7001447V802	141 115x2.5	A24/30S-BF Inox		115	2.5	22.25	13,300	25
A700157V802	141 125x2.5	A24/30S-BF Inox		125	2.5	22.25	12,300	25
A7000718V802	141 170x1.8	A8T-BF Inox		170	1.8	22.25	8,500	25
A7000744V802	141 230x1.8	A8T-BF Inox		230	1.8	22.25	6,600	25
A7000431V802	141 230x2.5	A24/30S-BF Inox		230	2.5	22.25	6,600	25
A700168V802	141 230x3.0	A24/30S-BF Inox		230	3.0	22.25	6,600	25

## Cutting disc set



- The handy choice, e.g. for the construction site
- rolling discs in a metal can
  - safely packed
  - moisture proof

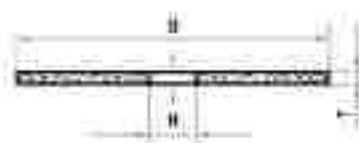
★☆☆

Product number	Description	Quality	D mm	T mm	H mm	$v_{max}$ rpm	Pack contents
A7004643V80200	141 115x1.0	A8S-BF Inox	115	1.0	22.25	13,300	10
A70031072V80200	141 125x1.0	A8S-BF Inox	125	1.0	22.25	12,300	10





- 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



★★★

Product number	Dimensions	Quality	D mm	T mm	H mm	v <sub>c</sub> (m/min)	Peak application
AT007770V9802	141 115x1.0	A6Z2-BF Steel	115	1.0	22.25	13,300	50
AT007771V9801	141 115x1.6	A6Z2-BF Steel	115	1.6	22.25	13,300	50
AT007772V9801	141 125x1.0	A6Z2-BF Steel	125	1.0	22.25	13,300	50
AT007773V9801	141 125x1.6	A6Z2-BF Steel	125	1.6	22.25	13,300	50
AT007284V9801	141 230x1.0	A6Z2-BF Steel	230	1.0	22.25	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 extensive bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



★★★

Product number	Dimensions	Quality	Shape	D mm	T mm	H mm	v <sub>c</sub> (m/min)	Peak application
AT006840V9802	141 115x1.0	A60X-BF Steel		115	1.0	22.25	13,300	50
AT003001V9802	141 115x1.6	A60X-BF Steel		115	1.6	22.25	13,300	50
AT001854V9802	141 115x2.0	A36U-BF Steel		115	2.0	22.25	13,300	25
AT006251V9802	141 125x1.0	A60X-BF Steel		125	1.0	22.25	13,300	50
AT003002V9802	141 125x1.6	A60X-BF Steel		125	1.6	22.25	13,300	50
AT001861V9802	141 125x2.0	A36U-BF Steel		125	2.0	22.25	13,300	25
AT001862V9802	141 125x2.5	A30X-BF Steel		125	2.5	22.25	12,700	25
AT003003V9802	141 150x1.6	A60X-BF Steel		150	1.6	22.25	10,200	25
AT003005V9802	141 180x1.6	A60X-BF Steel		180	1.6	22.25	8,500	25
AT001342V9802	141 180x1.0	A36U-BF Steel		180	2.0	22.25	8,500	25
AT006887V9802	141 230x1.0	A60X-BF Steel		230	1.0	22.25	6,600	25
AT001781V9802	141 230x1.6	A36U-BF Steel		230	2.0	22.25	6,600	25
AT001785V9801	141 230x1.0	A30U-BF Steel	230	1.0	22.25	6,600	25	
AT001863V9801	142 115x2.5	A36U-BF Steel		115	2.5	22.25	13,300	25
AT001865V9801	142 125x2.5	A36U-BF Steel		125	2.5	22.25	13,300	25
AT001724V9801	142 150x2.5	A30U-BF Steel		150	2.5	22.25	10,200	25
AT001750V9801	142 180x1.0	A30U-BF Steel		180	1.0	22.25	8,500	25
AT001780V9801	142 230x1.5	A30U-BF Steel		230	2.5	22.25	6,600	25

Recommended for  Steel  Cast material

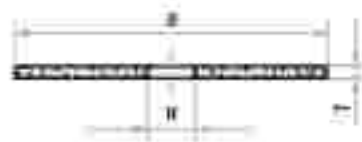
## Cutting disc for steel



- 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 angle lining

★☆☆

Product number	Description	Quality	Shape	D mm	T mm	IR mm	Max. rpm	Peak cutting
A7006440V3802	141 115x1.0	A605-BF Steel		115	1.0	22.23	13,300	50
A7000644V3802	141 115x1.2	A605-BF Steel		115	1.2	22.23	13,300	50
A7000654V3802	141 115x2.5	A3NR-BF Steel		115	2.5	22.23	13,300	25
A7006710V3802	141 125x1.0	A605-BF Steel		125	1.0	22.23	12,300	50
A7000675V3802	141 125x1.8	A6TF-BF Steel		125	1.8	22.23	12,300	50
A7000670V3802	141 125x2.5	A3NR-BF Steel		125	2.5	22.23	12,300	25
A7000707V3802	141 150x2.5	A3NR-BF Steel		150	2.5	22.23	10,200	25
A7000717V3802	141 180x1.8	A6TF-BF Steel		180	1.8	22.23	6,500	25
A7000728V3802	141 180x3.0	A3NR-BF Steel		180	3.0	22.23	6,500	25
A7000740V3802	141 230x1.8	A6TF-BF Steel		230	1.8	22.23	6,600	25
A7000867V3802	141 230x2.0	A3NT-BF Steel	230	2.0	22.23	6,600	25	
A7000250V3802	141 230x3.0	A3NR-BF Steel	230	3.0	22.23	6,600	25	
A7000829V3802	142 115x1.5	A3NR-BF Steel		115	1.5	22.23	13,300	25
A7000830V3802	142 125x2.5	A3NR-BF Steel		125	2.5	22.23	12,300	25
A7000732V3802	142 180x3.0	A3NR-BF Steel		180	3.0	22.23	6,500	25
A7000740V3802	142 230x1.8	A6TF-BF Steel		230	1.8	22.23	6,600	25
A7000754V3802	142 230x3.0	A3NR-BF Steel		230	3.0	22.23	6,600	25

**NEW** Cutting disc for machining non-ferrous metals


- easily cuts soft, light metals
- no burring when used on aluminium
- ideal combination of abrasive grit and bonding agent

★★☆

Product number	Description	Quality	D mm	T mm	IR mm	Max. rpm	Peak cutting
A7000202V3802	141 115x1.0	A30N-BF Alu	115	1.0	22.23	13,300	50
A7000160V3802	141 125x1.0	A30N-BF Alu	125	1.0	22.23	12,300	50
A7001844V3802	141 125x2.5	A36N-BF Alu	125	2.5	22.23	12,300	25
A7001780V3802	141 230x2.5	A36N-BF Alu	230	2.5	22.23	6,600	25

## 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

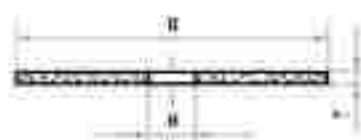
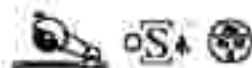


★☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	d mm	n <sub>max</sub> rpm	Peak cutting
AT115025V988201	141 115x2.5	CMS-BF Stone		115	2.5	22.23	11,300	25
AT125025V988201	141 125x2.5	CMS-BF Stone		125	2.5	22.23	12,000	25
AT180038V988201	141 180x3.0	CMS-BF Stone		180	3.0	22.23	8,500	25
AT230038V988201	141 230x3.0	CMS-BF Stone		230	3.0	22.23	6,600	25
AT115025V988202	142 115x2.5	CMS-BF Stone		115	2.5	22.23	11,300	25
AT125025V988202	142 125x2.5	CMS-BF Stone		125	2.5	22.23	12,000	25
AT230038V988202	142 230x3.0	CMS-BF Stone		230	3.0	22.23	6,600	25
AT230038V988203	142 230x3.0	CMS-BF Stone		230	3.0	22.23	6,600	25



## Stationary cutting disc for machining stainless steel

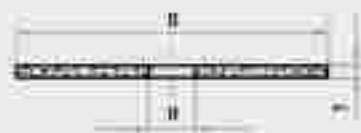


- free of iron, chlorine and sulphur
- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

★☆☆

Product number	Description	Quality	D mm	T mm	H mm	Max. rpm	Part quantity
AT810001	T41 300x3.5	A305-BF Inox	300	3.5	32.00	5,100	10
AT820010	T41 350x3.6	A305-BF Inox	350	3.6	25.40	4,400	10

## Cutting disc for machining steel



- large cutting disc for stationary and handhold use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

★☆☆

Product number	Description	Quality	D mm	T mm	H mm	Max. rpm	Part quantity
AT810052	T41 300x4.0	A340-BF	300	4.0	20.00	6,400	10
AT810055	T41 350x4.0	A340-BF	350	4.0	20.00	5,400	10
AT810057	T41 350x4.0	A340-BF	350	4.0	25.40	5,400	10



## Stationary cutting disc for machining steel



- optimized 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	$v_c$ (m/min)	Post treatment
AT010028	141 300x2.8	A365-BF Steel	300	2.8	25.40	6,400/100 m/s	10
AT001774	141 300x3.5	A307-BF Steel	300	3.5	22.23	6,400/100 m/s	30
AT001776	141 300x3.5	A307-BF Steel	300	3.5	25.40	6,400/100 m/s	10
AT010029	141 300x3.5	A307-BF Steel	300	3.5	32.00	6,400/100 m/s	10
AT000029	141 350x2.8	A365-BF Steel	350	2.8	25.40	5,400/100 m/s	10
AT000030	141 350x3.5	A307-BF Steel	350	3.5	25.40	5,400/100 m/s	30
AT000031	141 350x3.5	A307-BF Steel	350	3.5	32.00	5,400/100 m/s	10
AT010030	141 400x3.2	A365-BF Steel	400	3.2	25.40	4,700/100 m/s	5
AT010032	141 400x4.1	A307-BF Steel	400	4.1	32.00	4,700/100 m/s	5

Recommended for:  Drill  Free wheel

## 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 machines small parts
- free of iron, chrome and cadmium
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular tuning



★☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	$v_c$ (m/min)	Post treatment
AT5010009802	141 50x1.0	A465-BF Inox	50	1.0	6.0	30,500	50
AT5010009803	141 50x1.0	A465-BF Inox	50	1.0	10.0	30,500	50
AT7010009807	141 70x1.0	A465-BF Inox	70	1.0	6.0	20,100	50
AT7010009808	141 70x1.0	A465-BF Inox	70	1.0	10.0	20,100	50
AT7010009801	141 70x3.0	A465-BF Inox	70	3.0	10.0	20,100	50

Recommended for:  Drill  Free wheel

## TECHNICAL INFORMATION AND PRODUCT INFORMATION

## LUKAS diamond cutting discs

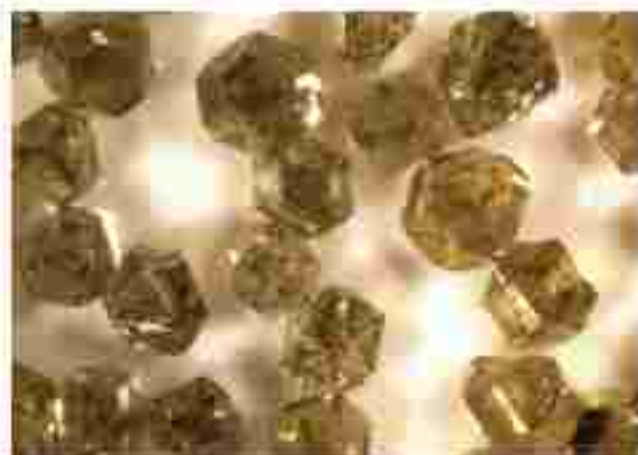
### DIAMOND

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.



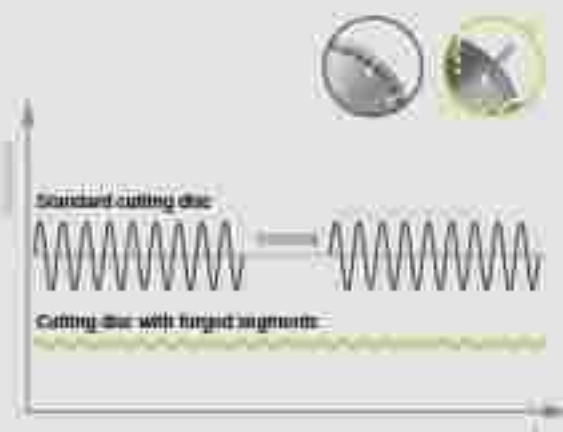
### SEGMENT GEOMETRY

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

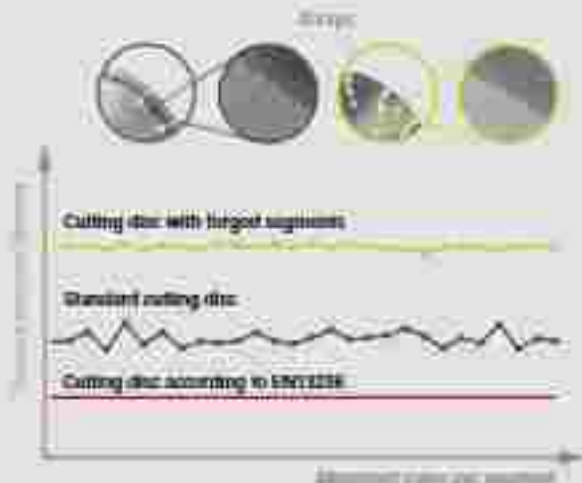
### COMPARISON OF CUTTING PROPERTIES

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.

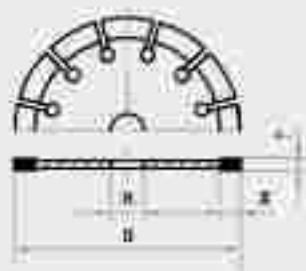
Best suitable		suitable		Tile			Other hard materials			Concrete			Building materials			Asphalt, other materials					
Page	Product	Product line	Segment length	Tile	Porcelain	Stoneware	Quartz	Granite	Other stone	Reinforced concrete	Reinforced concrete (smooth)	Concrete (smooth)	Brick, masonry	Red brick	3rd generation profile	Red brick (old)	Reinforced concrete	Asphalt	Asphalt	Asphalt	
<b>Standard cutting discs</b>																					
282	VDC		7	■	■	■				■	■	■	■	■	■	■				■	
283	LD Multi S13	★★★	13					■	■	■	■	■	■	■	■	■					
283/284	LD3 S18/ LD3 S18 X-LOCK		18				■	■		■	■	■	■	■	■	■					
284	LD7 S10	★★☆	10															■		■	
285	Turbo S10		10							■	■	■	■	■	■	■					
285	Blow Cut S10		10								■	■	■	■	■	■					
285	TCF	★☆☆	7									■	■	■	■	■					
<b>Tile cutting discs</b>																					
286	FAST CUT S10	★★★	10	■	■	■		■	■												
286/287	FLISE S7/ FLISE S7 X-LOCK	★★☆	7	■	■	■															
287	TCF	★☆☆	7	■																	

# VDC - AGGRESSIVE APPLICATION WITH EXTREME TOOL LIFE

STAYS COOL. NO DUST OR ODOURS. NO EXPIRY DATE.



## VDC diamond cutting disc



- the diamond cutting disc that revolutionized cutting cast iron
- ideal for cutting cast iron (GG, GGK), fiberglass reinforced plastics (GFRP) and reinforcement
- not suitable for high alloy materials containing nickel

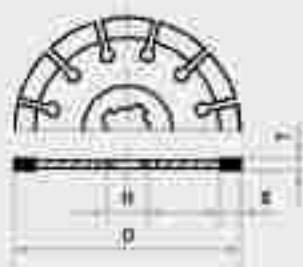
★★★

Product number	Description	D mm	Segment height h mm	Segment width l mm	D <sub>h</sub> mm	Run rpm	Peak cutting
A34801F5222	VDC 11602	116	20	2.2	22.25	13,300	1
A34801J5222	VDC 12502	125	20	2.2	22.25	12,200	1
A34801R0242	VDC 18802	188	20	2.2	22.22	6,500	1
A34801S0320	VDC 29020	235	20	3.8	22.25	4,800	1
A34803G8952	VDC 35008	356	20	3.8	22.00	4,400	1

Recommended for: ■ Steel ■ Cast iron ■ Cast steel ■ Cast iron





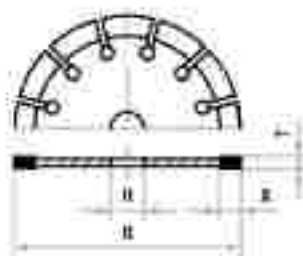

**NEW** LD3 S10 X-LOCK diamond cutting disc


- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- Tool change 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 Y mm	H mm	$v_{max}$ rpm	Price unit/box
A344121350370883	LD3 S10 X-LOCK	125	III	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

★★★

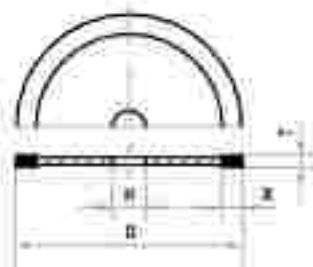
Product number	Description	D mm	Segment height X mm	Segment width Y mm	H mm	$v_{max}$ rpm	Price unit/box
A344173002210183	LD7 S10	300	II	3.2	25.4	4,400	1
A344173502210213	LD7 S10	350	II	3.2	25.4	5,500	1
A344174002210243	LD7 S10	400	II	3.5	25.4	4,800	1
A344175002210283	LD7 S10	450	II	4.0	25.4	2,700	1

Recommended for: Stone/Construction material



## TURBO S10 diamond cutting disc

- ideal for cleanly cutting construction materials or concrete
- suitable for various applications



★ ★ ☆

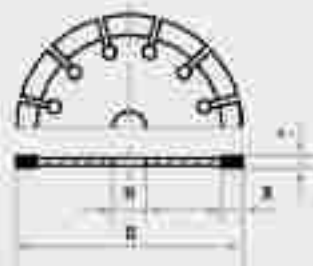
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	v <sub>max</sub> rpm	Part quantity
A34414115T100E3	TURBO S10	115	10	1.8	22.23	13,300	1
A34414125T100E3	TURBO S10	125	10	1.8	22.23	12,200	1
A34414180T100E3	TURBO S10	180	10	2.2	22.23	8,500	1
A34414230T100E3	TURBO S10	230	10	2.4	22.23	6,800	1

Recommended for: Stone/Concrete (see manual)



## Blue Cut S10 diamond cutting disc

- especially popular on construction sites
- excellent price-performance ratio



★ ☆ ☆

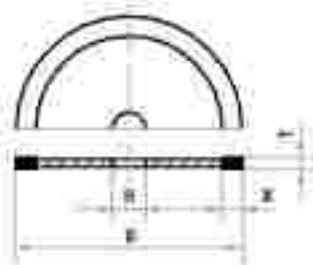
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	v <sub>max</sub> rpm	Part quantity
A34534115T100E5	Blue Cut S10	115	10	2.0	22.23	13,300	1
A34534125T100E5	Blue Cut S10	125	10	2.0	22.23	12,200	1
A34534150T100E5	Blue Cut S10	150	10	2.2	22.23	10,200	1
A34534180T100E5	Blue Cut S10	180	10	2.4	22.23	8,500	1
A34534230T100E5	Blue Cut S10	230	10	2.5	22.23	6,800	1

Recommended for: Stone/Concrete (see manual)



## TC7 diamond cutting disc

- the turbo disc for precise cutting
- great price-performance ratio

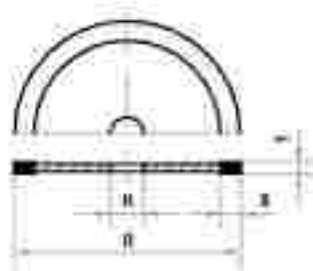


★ ☆ ☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	v <sub>max</sub> rpm	Part quantity
A34534115T077E5	TC7	115	7	2.4	22.23	10,300	1
A34534125T077E5	TC7	125	7	2.4	22.23	12,200	1
A34534230T077E5	TC7	230	7	2.2	22.23	6,800	1

Recommended for: Stone/Concrete (see manual)

## FAST CUT diamond cutting disc



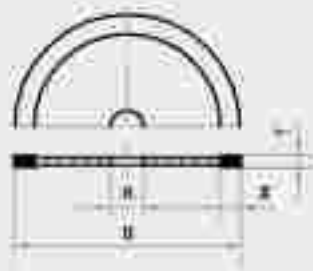
- extra thin diamond cutting disc for ceramic and fire stone applications
- cuts through the hardest tiles quickly and cleanly
- offers an extra thin segment coating and reinforced flange area

★★★

Product number	Description	D mm	Segment length X mm	Segment width Y mm	H mm	v <sub>max</sub> rpm	Part quantity
A34400110710013	FAST CUT 910	115	10	1.4	22.23	12,300	1
A34400125710015	FAST CUT 930	125	10	1.4	22.23	12,300	1

Dimensions in mm   © 2015 OS Power Tools

## FLIESE S7 diamond cutting disc



- the popular choice cutting disc for tile and ceramic
- also cuts easily through glazed ceramic

★★☆

Product number	Description	D mm	Segment length X mm	Segment width Y mm	H mm	v <sub>max</sub> rpm	Part quantity
A34411151107013	FLIESE S7	115	7	1.6	22.23	12,300	1
A34411251107013	FLIESE S7	125	7	1.6	22.23	12,300	1
A34411201107013	FLIESE S7	130	7	2.0	22.23	6,800	1

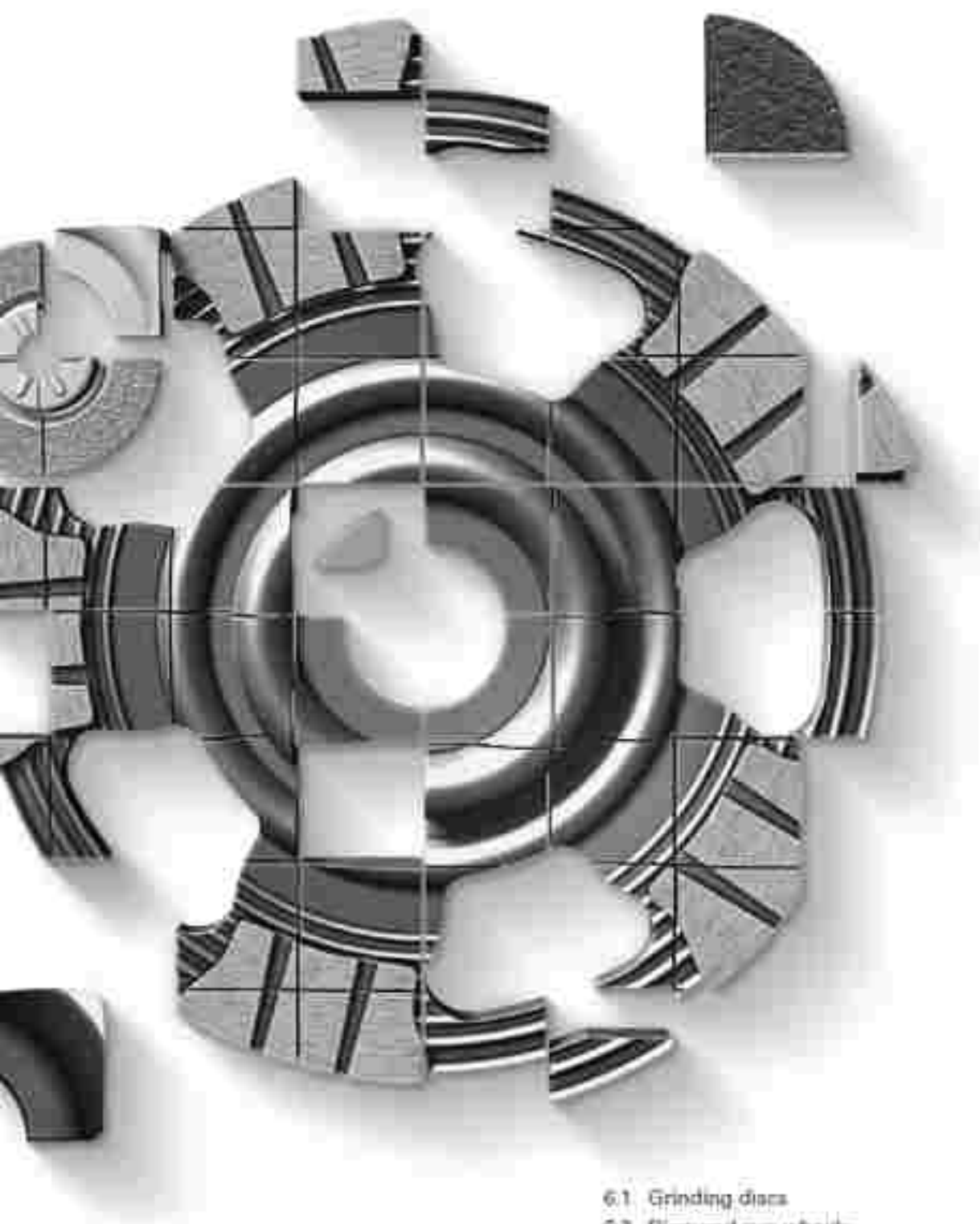
Dimensions in mm   © 2015 OS Power Tools







# ROUGH GRINDING



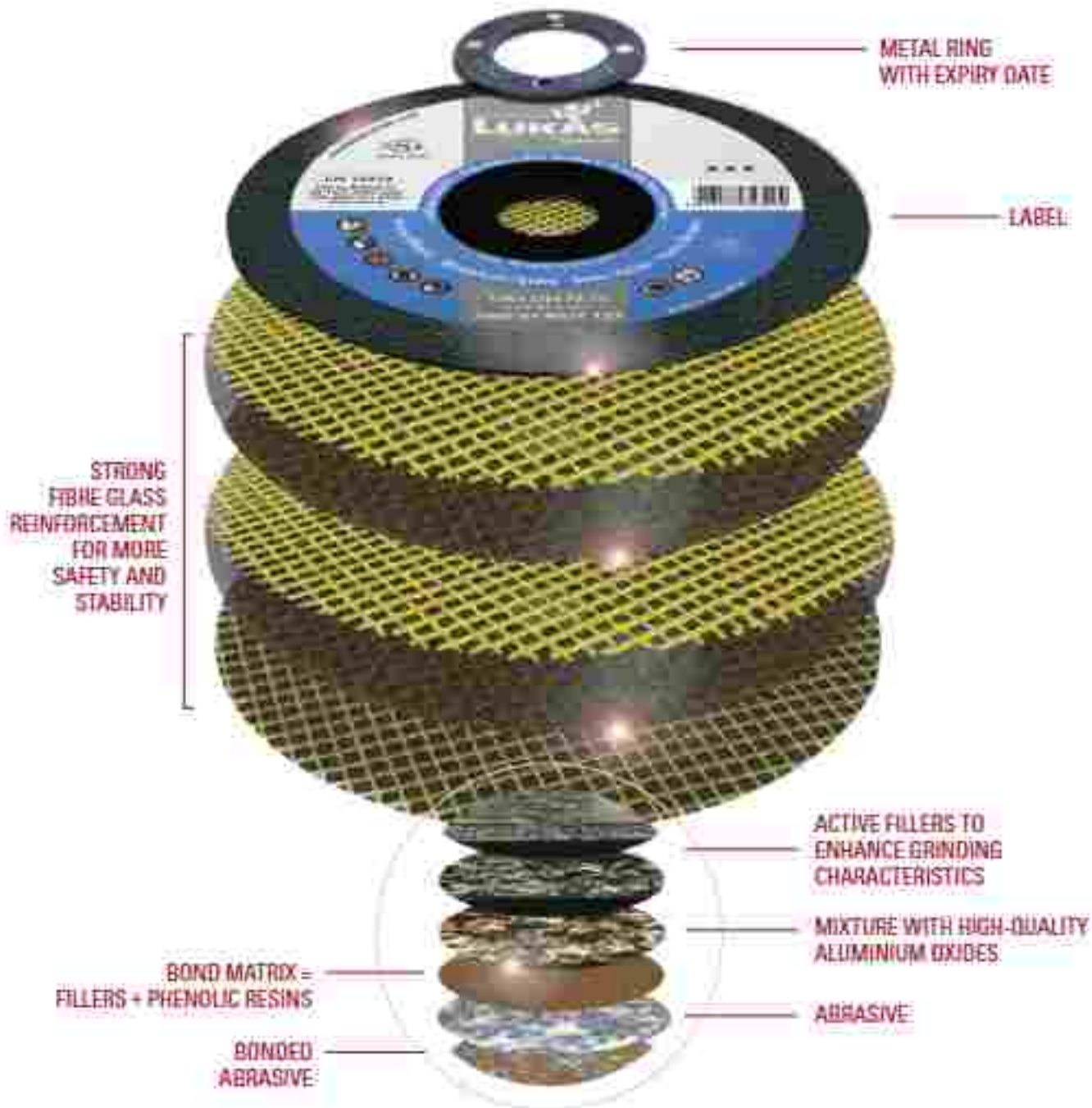
6.1 Grinding discs	270–281
6.2 Diamond cup wheels	282
6.3 Tungsten carbide granulate-tipped tools	283





## 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	75	100	125	150	175	200	250	300	350	400
100 m/s	30,500	20,100	15,300	13,300	12,200	10,700	8,500	6,800	5,100	4,400	3,800
100 m/s	36,200	25,100	19,300	16,600	14,600	12,700	10,600	8,300	6,400	5,400	4,700

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

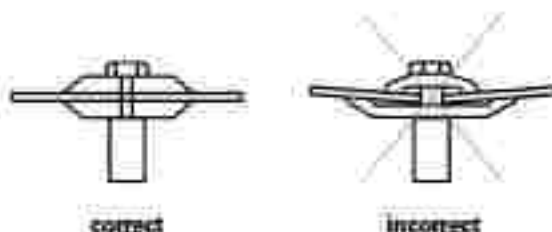
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13338

### 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 cast 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

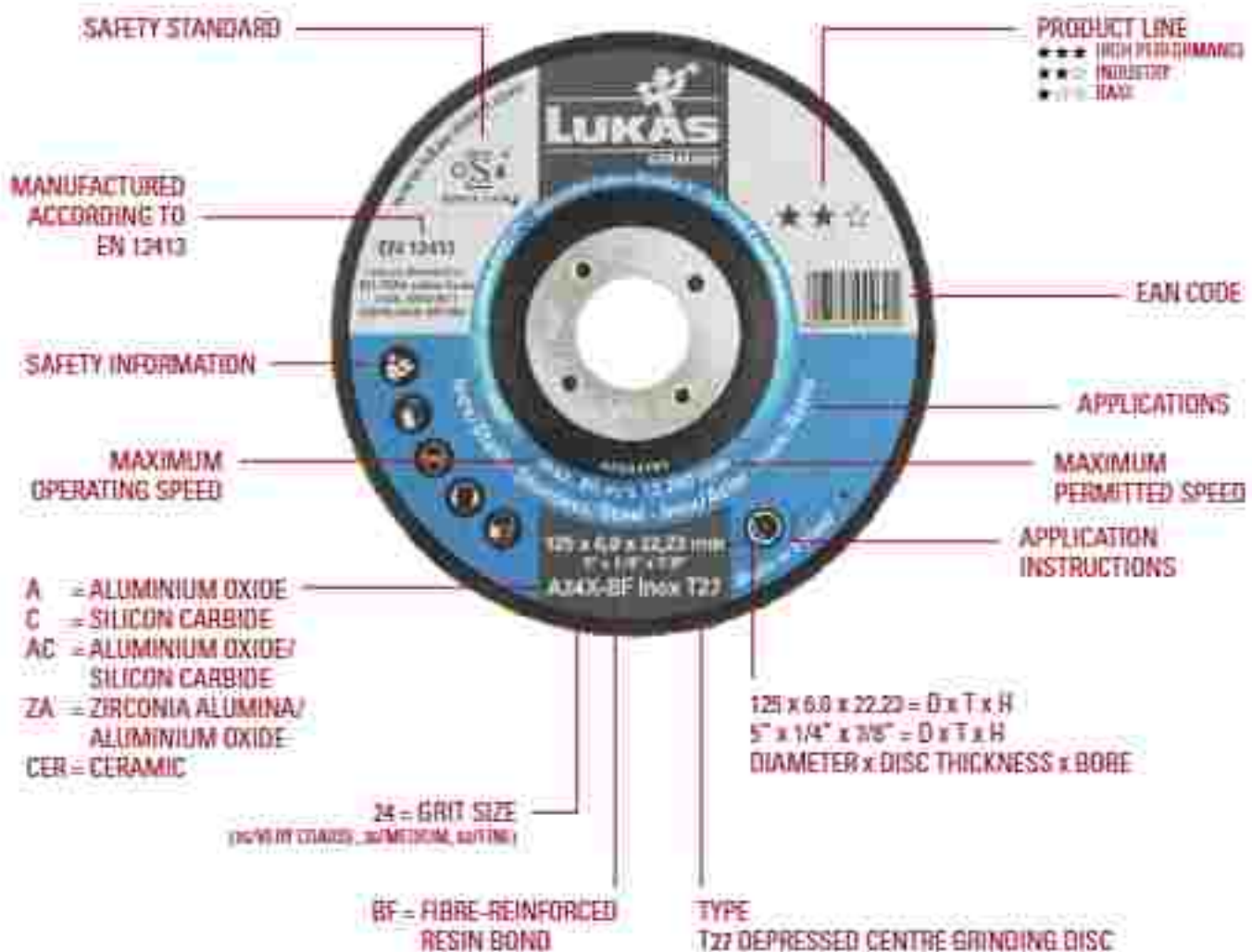
The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.2.1).



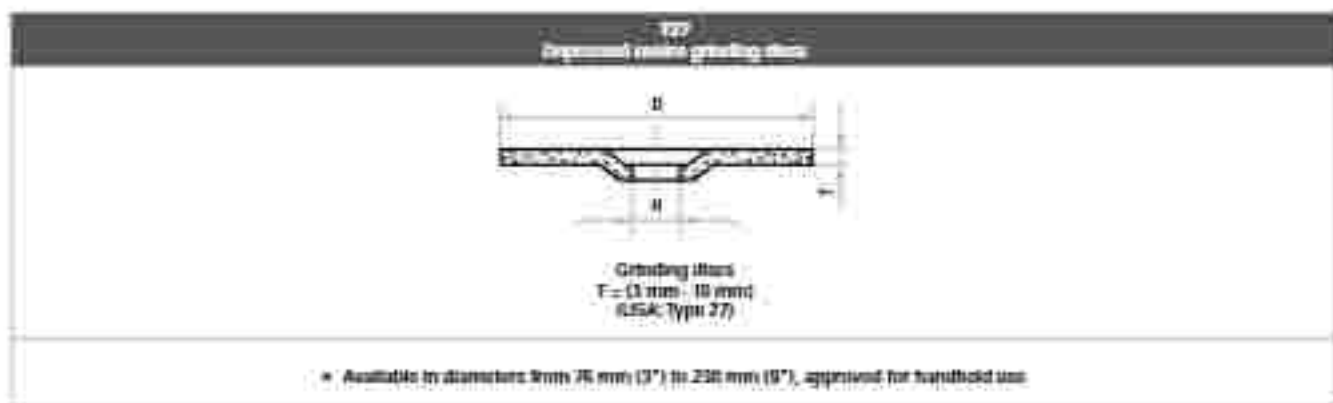


## LABELLING

## All important markings on the label



## TYPES OF RESIN-BONDED GRINDING DISCS

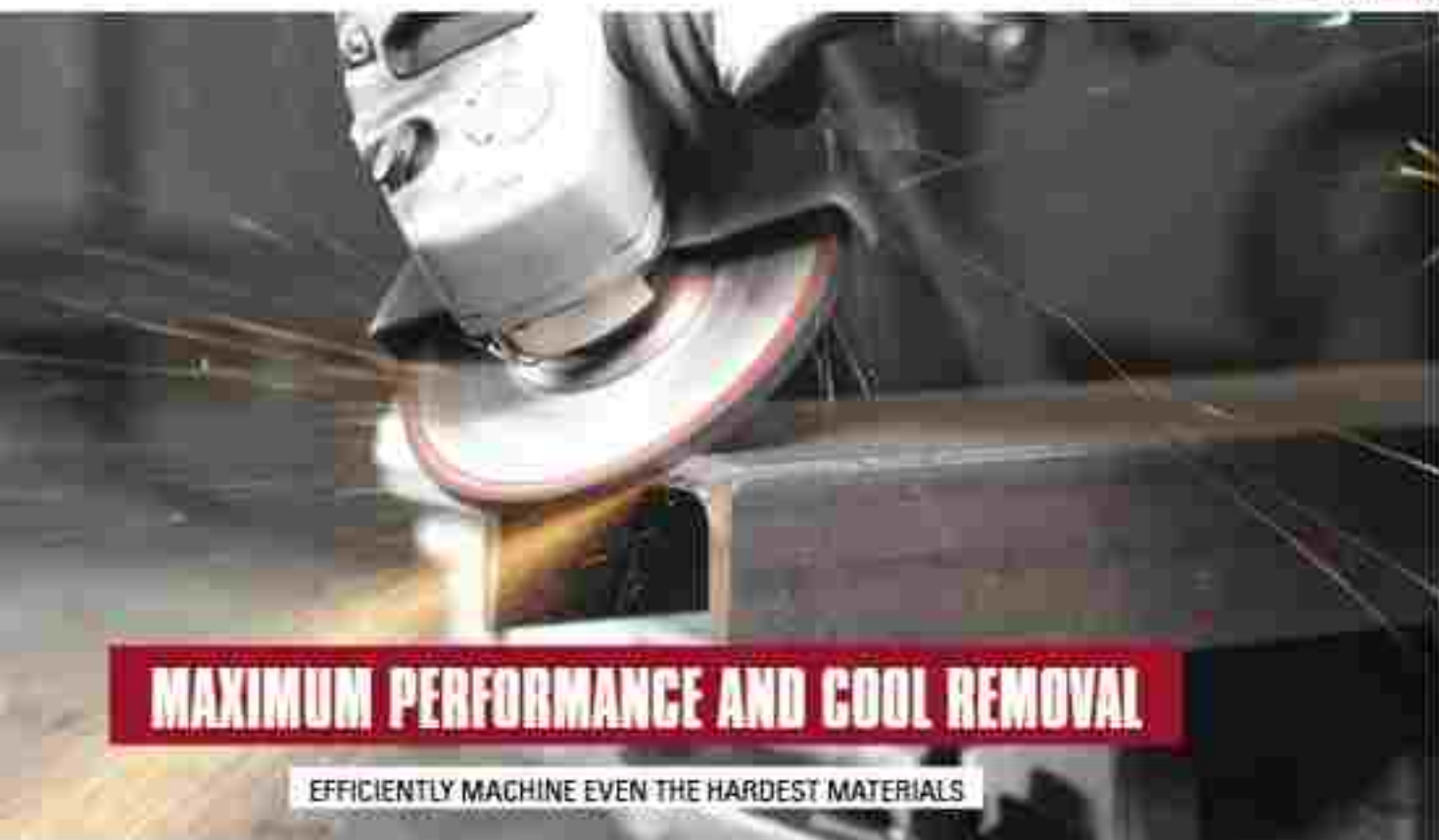


AREA OF USE

# Overview of types of LUKAS grinding discs

Type	Product line	Material				
		Steel	Cast iron	Aluminium	Stainless steel	Cast stainless
Handheld grinding discs for angle grinders 	★★★	 Pages 275 and 276	 Page 276			
	★★☆	 Page 277	 Page 278	 Page 280	 Page 281	 Page 281
	★☆☆		 Page 279			
Diamond flap wheels for angle grinders 	★★☆				 Page 282	
Tungsten carbide granulate flap disc for angle grinders 	★★☆				 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 iron without any blue discoloration 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

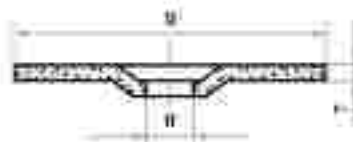
the particles break off, due to wear, new, sharp abrasive particles are immediately exposed. Thanks to this self-sharpening effect, the grinding discs achieve outstanding tool lives.

### AGGRESSIVE REMOVAL WITH LITTLE FINISHING WORK

Hard materials like iron 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.



- extremely hard and sharp for an impressively long tool life
- energy optimized 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	V <sub>max</sub> rpm	Tool lifetime
AS00ES21V9802	T27 115x75	CEB 300-BF Iron	115	70	22.25	13,300	26
AS00ES27V9802	T27 125x70	CEB 300-BF Iron	125	70	22.25	12,300	26
AS00ES24V9802	T27 180x70	CEB 300-BF Iron	180	75	22.25	8,500	26
AS00ES29V9802	T27 230x70	CEB 300-BF Iron	230	70	22.25	6,800	26

Recommended for





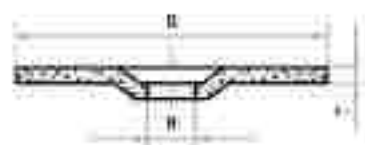
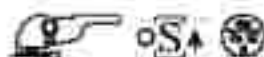
## LUKAS GRINDING DISCS IN 3-STAR QUALITY

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

### 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
- process removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

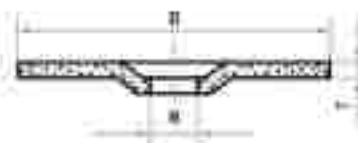
★★★

Product number	Description	Quality	D mm	T mm	H mm	Max. rpm	Price (unit)
A5213401V9802	T27 115x10	A26U-BF Inox	115	10	22.23	13,300	18
A5213402V9802	T27 125x10	A26U-BF Inox	125	10	22.23	12,300	18
A5213403V9802	T27 150x10	A26U-BF Inox	150	10	22.23	6,200	10



## 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



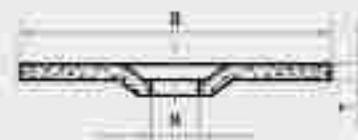
★ ★ ☆

Product number	Description	Quality	D mm	T mm	H mm	v <sub>max</sub> (rpm)	Price (€)
A500100V9802	T27 115x6.0	A24X-SF Inox	115	6.0	22.25	13,300	10
A500101V9802	T27 125x6.0	A24X-SF Inox	125	6.0	22.25	12,200	10
A500102V9802	T27 150x6.0	A24X-SF Inox	150	6.0	22.25	8,500	10
A500104V9800	T27 230x6.0	A24X-SF Inox	230	6.0	22.25	6,600	10



## 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	v <sub>max</sub> (rpm)	Price (€)
A500107V9802	T27 100x6.0	A34/38S-SF Inox	100	6.0	16.00	15,300	10
A500105V98120	T27 115x6.3	A34/38S-SF Inox	115	6.0	22.25	13,300	10
A500106V98120	T27 125x6.0	A34/38S-SF Inox	125	6.0	22.25	12,200	10
A500103V9800	T27 150x6.0	A34/38S-SF Inox	150	6.0	22.25	10,200	10
A500108V9802	T27 180x6.0	A34/38S-SF Inox	180	6.0	22.25	8,500	10
A500109V9802	T27 230x6.0	A34/38S-SF Inox	230	6.0	22.25	6,600	10

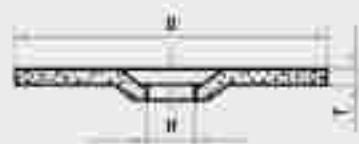
## TWO WORK STEPS WITH ONE TOOL

CUTTING AND GRINDING WITHOUT CHANGING TOOLS: THE COOL JOBBER FROM LUKAS



PRACTICAL, PRECISE AND SAFE DISCOVER THE LUKAS COOL JOBBER ON PAGES 20

### Grinding disc for machining steel



- optimized 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 ergonomic working with little use of force

★★★

Product number	Description	Quality	D mm	T mm	H mm	Max. rpm	Peak condition
AS012401V9801	TZF 115x20	AJAX-BF Steel	115	20	22.23	13,300	10
AS012403V9801	TZF 125x20	AMX-BF Steel	125	20	22.23	12,100	10
AS013405V9801	TZF 180x20	AMX-BF Steel	180	20	22.23	8,500	10
AS013409V9801	TZF 230x20	AJAX-BF Steel	230	20	22.23	6,600	10

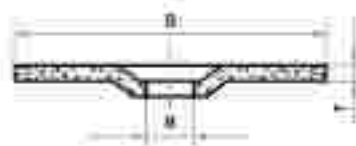
Recommended for: Steel





## Grinding disc for machining steel

- cut steel with ease
- tested quality: high level of safety through regular testing
- process: removal with high speed
- low colour and dust levels in daily use
- allows for economical working with little use of force



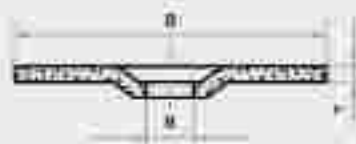
★★★

Product number	Description	Quality	D mm	T mm	H mm	$v_{max}$ rpm	Part number
A50007V9802	T27 115x6.0	A3438T8F Steel	115	6.0	22.25	11,300	10
A50017V9802	T27 125x6.0	A3438T8F Steel	125	6.0	22.25	12,200	10
A50018TV9802	T27 230x6.0	A3438T8F Steel	230	6.0	22.25	6,600	10



## Grinding disc for machining steel

- designed for easy machining of steel
- tested quality: high level of safety through regular testing
- process: removal with high speed
- low colour 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	$v_{max}$ rpm	Part number
A50066TV9802	T27 115x6.0	A3438S-8F Steel	115	6.0	22.25	11,300	10
A50066TV9802	T27 125x6.0	A3438S-8F Steel	125	6.0	22.25	12,200	10
A50066TV9802	T27 125x6.0	A3438S-8F Steel	125	6.0	22.25	12,200	10
A50067TV9802	T27 150x6.0	A3438S-8F Steel	150	6.0	22.25	10,300	10
A50067TV9802	T27 180x6.0	A3438S-8F Steel	180	6.0	22.25	8,500	10
A50067TV9802	T27 230x6.0	A3438S-8F Steel	230	6.0	22.25	6,600	10

## 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"

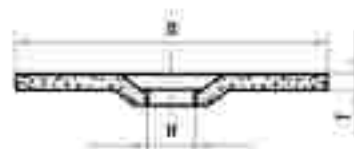
The major advantage of this grinding disc is that the "smearing" effect can be avoided. When machining pure aluminium and soft alloys, soft chips can stick to the aluminium edges if the tool is not designed specifically for this purpose. However, LUKAS grinding discs were developed and tested for aluminium. 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	E mm	H mm	R <sub>max</sub> µm	Peak velocity
A000108V002	727 125x10	A2M18FAu	125	70	22.23	12,200	10

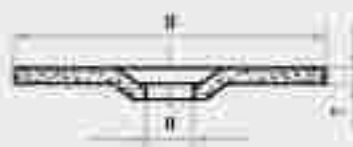
Recommended for

# 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 economical working with little use of force



## Grinding disc for machining stone **NEW**



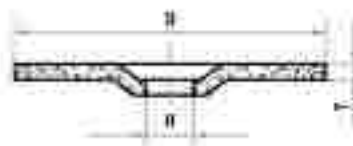
★★★

Product number	Description	Quality	D mm	T mm	H mm	R mm	Max. speed	Max. lifetime
AS11500N/98001	T27 115x6.0	CH6-BF Stone	115	6.0	22.25	13,300	10	
AS12000N/98001	T27 120x6.0	CH6-BF Stone	120	6.0	22.25	12,200	10	
AS200120V9801	T27 180x6.0	CH6-BF Stone	180	6.0	22.25	8,500	10	
AS18000N/98001	T27 180x6.0	CH6-BF Stone	180	6.0	22.25	8,500	10	

Recommended for: Stone Cast material



- 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 economical working with little use of force



## Grinding disc for machining cast material

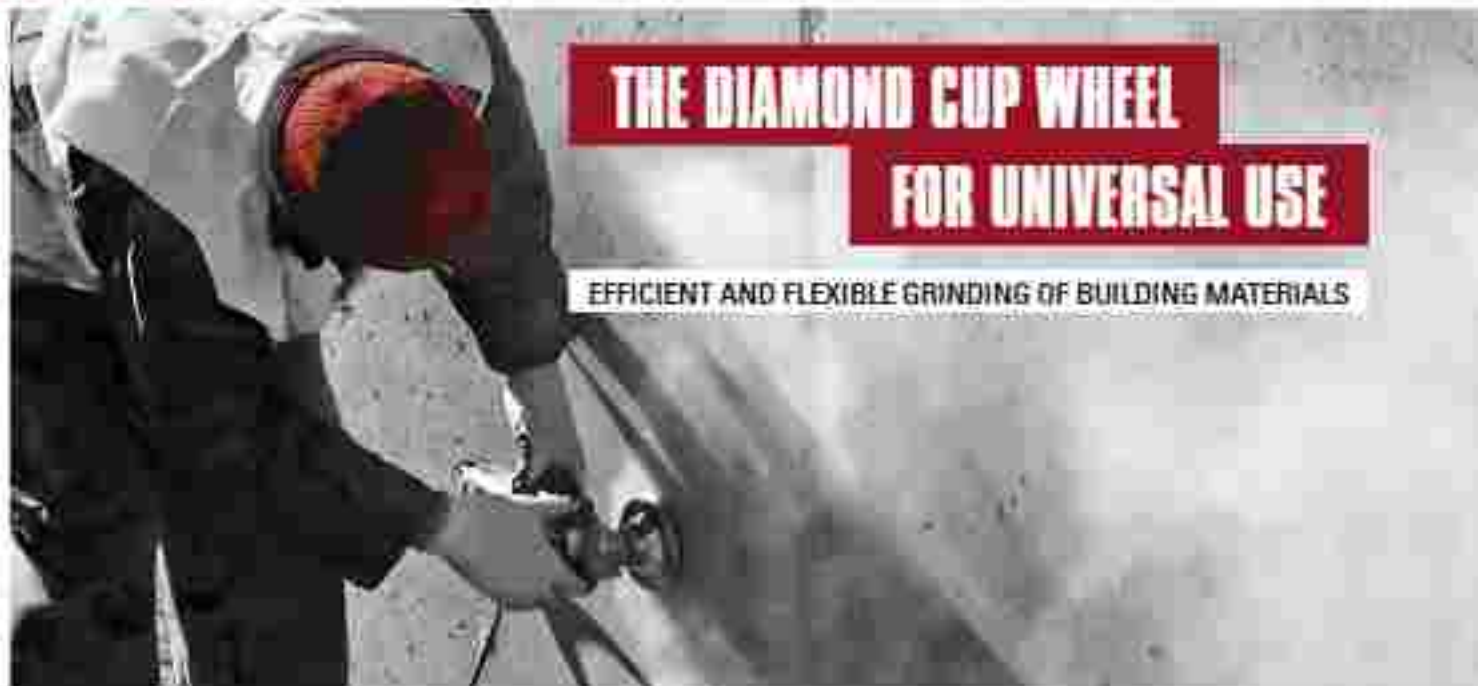


★★★

Product number	Description	Quality	D mm	T mm	H mm	R mm	Max. speed	Max. lifetime
AS201111V9801	T27 125x6.0	2A246-BF Cast	125	6.0	22.25	12,200	10	
AS201177V9801	T27 180x6.0	2A246-BF Cast	180	6.0	22.25	8,500	10	
AS201812V9801	T27 230x6.0	2A246-BF Cast	230	6.0	22.25	6,000	10	

Recommended for: Cast material





# THE DIAMOND CUP WHEEL FOR UNIVERSAL USE

EFFICIENT AND FLEXIBLE GRINDING OF BUILDING MATERIALS

## S6 diamond cup wheel

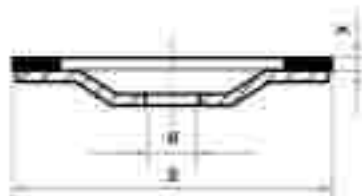


- excellent value for money
- optimized segment arrangement for high grinding performance and clean surface
- well suited for: concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice)
- also suitable for: hardened concrete, exposed aggregate concrete, dense sand lime, refractory brick and gravel

★★☆

Product number	Description	Ø mm	Segment height H mm	H mm	n <sub>max</sub> rpm	Peak condition
A3440115190003	DS7 S6	115	6	22.23	13,300	1
A3440125190003	DS7 S6	125	6	22.23	12,300	1
A3440180190003	DS7 S6	180	6	22.23	8,500	1

## 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	Ø mm	Segment height H mm	H mm	n <sub>max</sub> rpm	Peak condition
A34501151400100	DS7 S5	115	5	22.23	13,300	1
A34501251400100	DS7 S5	125	5	22.23	12,300	1

# FROM ANIMAL HOOVES TO MACHINING STONE

## TUNGSTEN CARBIDE GRANULATE-TIPPED DISCS FOR A WIDE VARIETY OF APPLICATIONS

Tungsten carbide granulate-tipped tools (HCW) 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.



### HCWT 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	Profile	Type	Ø max.	Disc size	H-grit	Price category
A18001152E	HCWT 115 E	0.8 - 1.2 E		flap	115	22.2	10,500	1
A18001153E	HCWT 115 S	1.2 - 1.8 E		flap	115	22.2	10,500	1
A1800125E	HCWT 125 S	2.5 - 3.0 E		flap	125	22.2	9,600	1

Standard 115 mm Ø Disc 22.2 mm thick 9,600 - 10,500 rpm







- 71 Coarse fleece
- 72 Brushes
- 73 Rolls and sheets

287/288  
289–295  
296–298

# CLEANING

## 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, denest, 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 cirriped 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 for 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 residues, 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



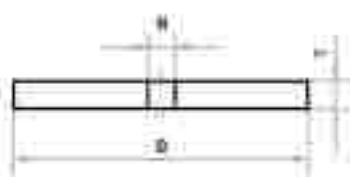
Product number	Description	D mm	T mm	H mm	Min. speed rpm	Max. speed rpm	Pack quantity
A2701150014	ASVT 115	115	13	22.25	3,300	10,500	10
A2701152014	ASVT 125	125	13	22.25	4,500	8,600	10

Recommended for:  Paint/Resin  Rust  Concrete  Adhesive  Resin/Plast  Steel  Cast-iron

ALSO TRY LUKAS AS CLEANING FLEECE WITH A PRACTICAL PLASTIC THREAD FOR FAST TOOL CHANGING ON PAGE 222



## ASVS grinding disc



- grinding disc for flange shaft grinders or drilling machines
- the all-rounder for removing paint and adhesive residues, as well as rust removal, cleaning and polishing a wide variety of surface materials
- made of resistant 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	Min. rpm	Max. rpm	Working mounting area	Pack contents
AZ290501201	ASVS 050	50	13	13	2.500	3.500	ASB 06	10
AZ290502201	ASVS 100	100	13	13	3.000	5.700	ASB 06	10
AZ2901251201	ASVS 125	125	13	13	4.000	4.500	ASB 08	10
AZ2901501201	ASVS 150	150	13	13	3.000	3.900	ASB 08	10

## 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	L mm	L mm	Pack contents
A1810021007301	ASB 06	M12	6	40	1
A1810021007302	ASB 08	M12	8	40	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 wear. 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 1083-21. However, it is always advisable to wear safety clothing when working with technical brushes.



# FLEXIBLE MACHINING OF THE MOST COMPLEX CONTOURS

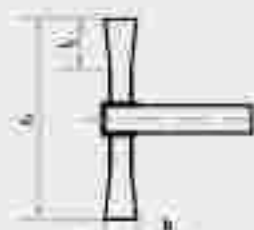
CLEANING METAL SURFACES WITH LUXAS HIGH QUALITY STEEL WIRE

## BS wheel brush with shank



crimped

knitted



- follow the contours of any workplace thanks to their flexibility
- for deburring, descaling, descaling, surface cleaning, roughening and paint stripping
- made of high quality steel wire with high tensile strength
- "Stainless" quality is used where corrosion from harmful dusts wire would impair surfaces such as stainless steel, aluminum and other non-ferrous metals
- perfect dimensional stability. fits optimally into power tools
- shank diameter: 6 mm

★★☆

Product number	Description	Material	Type	d mm	h mm	L mm	Wire Ø mm	mm mm	Pack quantity
A35290400111	BSSW 04010	steel	crimped	40	10	9	0.2	10,000	10
A35290500111	BSSW 05010	steel	crimped	50	10	12	0.2	15,000	10
A35290501410	BSSW 05014	steel	crimped	50	14	12	0.2	15,000	10
A35290600111	BSSW 06010	steel	crimped	60	10	13	0.2	15,000	10
A35290601713	BSSW 06017	steel	crimped	60	17	17	0.2	15,000	10
A35290700111	BSSW 07010	steel	crimped	70	10	15	0.2	15,000	10
A35290701713	BSSW 07017	steel	crimped	70	17	15	0.2	15,000	10
A35290750113	BSSW 07510	steel	knitted	75	10	15	0.2	25,000	10
A35290750225	BSSW 07525	stainless	knitted	75	12	15	0.1	25,000	10
A35290800111	BSSW 08010	stainless	crimped	80	10	17	0.2	15,000	10
A35290801410	BSSW 08014	stainless	crimped	80	14	17	0.2	15,000	10
A35290801713	BSSW 08017	stainless	crimped	80	17	17	0.2	15,000	10
A35290900111	BSSW 09010	stainless	crimped	90	10	19	0.2	15,000	10
A35290901713	BSSW 09017	stainless	crimped	90	17	19	0.2	15,000	10

E.111111





## BSN wheel brush

- highly flexible tool with abrasive impregnated nylon filaments
- exactly follows the contour of your workpiece
- moderately aggressive action on surfaces
- achieves an even abrasive performance and long tool life
- shank diameter: 6 mm



★★☆

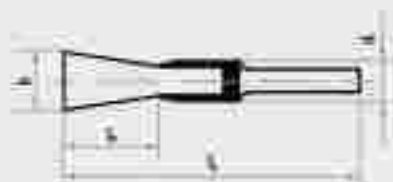
Product Number	Description	Type	a mm	b mm	c mm	grit	Part quantity
A3500520048	BSNG 05010	coarse	50	10	11	15,000	10
A3500520046	BSNF 05010	fine	50	10	11	15,000	10
A35007013048	BSNG 07012	coarse	70	13	20	15,000	10
A35007013046	BSNF 07012	fine	70	13	20	15,000	10
A35010007048	BSNG 10007	coarse	100	8	22	4,500	10
A35010008050	BSNF 10008	fine	100	8	22	4,500	10

Recommended for:  Steel  Cast  Aluminum  Titanium  Inconel



## BP end brush

- flexibly withstands the toughest challenges
- for deburring, decapping, chamfering, surface cleaning, roughening and part stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is good where residues from normal steel wire would impair the faces such as stainless steel, aluminum and other non-ferrous metals
- shank diameter: 3 mm



crimped



knitted

★★☆

Product Number	Description	Material	Type	a mm	b mm	c mm	d mm	Wire Ø mm	grit	Part quantity
A35001004	BPSM 01010	steel	crimped	10	10	20	60	0.3	20,000	10
A35001006	BPSM 01125	steel	crimped	16	17	23	65	0.3	20,000	10
A35002020134	BPSZ 02020	steel	knitted	18	20	28	77	0.25	20,000	10
A35002006	BPSW 02525	steel	crimped	22	25	25	68	0.3	10,000	10
A3500320134	BPSZ 03220	steel	knitted	22	23	28	73	0.25	20,000	10
A35003006	BPSW 03025	steel	crimped	25	30	25	68	0.3	10,000	10

Recommended for:  Steel  Cast material  Titanium

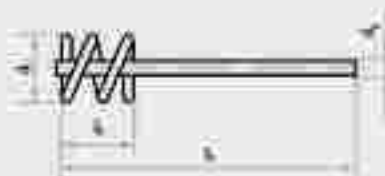
Recommended for:  Steel  Titanium

# EASILY DEBURR EVEN SMALL BORES

LUKAS PIPE BRUSHES WITH STEEL WIRE OR NYLON FILAMENTS



## RBSO pipe brush



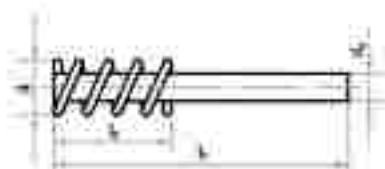
★★★

- 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	L <sub>1</sub> mm	L <sub>2</sub> mm	Ø <sub>1</sub> mm	Ø <sub>2</sub> mm	Wire Ø mm	W <sub>max</sub> µm	Pack contents
A35901025	RBSO 1025	steel	crimped	10	25	3.0	30	0.12	2,000	10
A35901125	RBSO 1125	steel	crimped	15	25	3.0	30	0.12	2,000	10
A35901625	RBSO 1625	steel	crimped	16	25	3.0	30	0.12	2,000	10
A35902525	RBSO 2525	steel	crimped	25	25	3.0	30	0.2	2,000	10

Recommended for:  Steel  Cast material  Plastic/Steel

## RBSN pipe brush



★★★

- brush with abrasion nylon and silicon carbide filaments
- deburring of bores, cross holes and O-ring grooves
- polishing and cleaning of nozzles, small and threaded bores

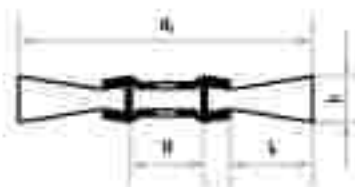
Product number	Description	Material	L <sub>1</sub> mm	L <sub>2</sub> mm	Ø <sub>1</sub> mm	Ø <sub>2</sub> mm	Wire Ø mm	W <sub>max</sub> µm	Pack contents
A3590105120	RBSN 105	C 120	10	65	3.7	125	0.8	2,000	10
A3590136120	RBSN 136	C 120	13	65	3.7	125	0.8	2,000	10
A3590165120	RBSN 166	C 120	16	65	5.2	125	0.8	2,000	10
A3590256120	RBSN 256	C 120	25	65	5.0	125	0.8	2,000	10

Recommended for:  Steel  Cast material  Plastic/Steel

## BR wheel brush, crimped



All crimped wheel brushes are supplied with adapter nuts for mounting on all standard grinding machines.



The following boron can be accommodated:

- brushes with a bore diameter of 11-40 mm:  
40 mm, 3/2 inch, 1", 22.23 mm, 30 mm,  
1 1/8 inch
- brushes with a bore diameter of 11-50 mm:  
50 mm, 3/2 inch, 1", 22.23 mm, 30 mm,  
1 1/8 inch

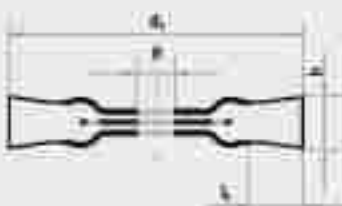
★★★

Product number	Description	Material	Type	d1 mm	d2 mm	H mm	L mm	Wire Ø mm	d <sub>max</sub> mm	Part number	
A350215022114	BRSIW 15022	steel	crimped	150	22	40	33	0.05	6,000	1	
A35022004114	BRSIW 20024	steel	crimped	200	24	50	40	0.05	8,000	1	
Recommended for: <input type="checkbox"/> Steel <input checked="" type="checkbox"/> Cast iron											
A350215025211	BRSIW 15023	stainless	crimped	150	25	50	33	0.1	6,000	1	
Recommended for: <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Cast iron <input type="checkbox"/> Stainless											

## BR wheel brush, knotted



- designed for extreme brush requirements
- can be used on commercially available angle grinders
- for deburring, descaling, demisting, 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 impact the face such as stainless steel, aluminum and other non-ferrous metals



★★★

Product number	Description	Material	Type	d1 mm	d2 mm	H mm	L mm	Wire Ø mm	d <sub>max</sub> mm	Part number	
A35021512135	BRSZ 11512	steel	knotted	115	14	22.23	26	0.5	12,500	1	
A35021514235	BRSZ 12514	steel	knotted	125	14	22.23	26	0.5	12,500	1	
A35021701435	BRSZ 12014	steel	knotted	120	14	22.23	27	0.5	8,000	1	
Recommended for: <input type="checkbox"/> Steel <input checked="" type="checkbox"/> Cast iron											
A35021101204	BRSZ 11512	stainless	knotted	115	14	22.23	26	0.35	12,500	1	
A350212514235	BRSZ 12514	stainless	knotted	125	14	22.23	26	0.5	12,500	1	
Recommended for: <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Cast iron <input type="checkbox"/> Stainless											



## BK conical brush



conical

knitted



- with practical M14 thread
- for deburring, deccaling, 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 surface such as stainless steel, aluminum and other non ferrous metals.

★★★

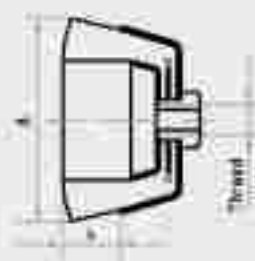
Product number	Description	Material	Type	d mm	h mm	L mm	Thread	Wire Ø mm	Wires per inch	Part number
A2501002114	BKSW 10012	steel	conical	100	10	20	M14	0.35	12,500	1
A2501002115	BKIZ 10013	steel	knitted	100	13	20	M14	0.5	12,500	1
Recommended for: <input type="checkbox"/> Steel <input checked="" type="checkbox"/> Corrosion										
A2501002213	BKSW 10012	stainless	conical	100	10	20	M14	0.3	12,500	1
A2501002215	BKIZ 10013	stainless	knitted	100	13	20	M14	0.5	12,500	1
Recommended for: <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Corrosion										

## BTC cup brush



conical

knitted



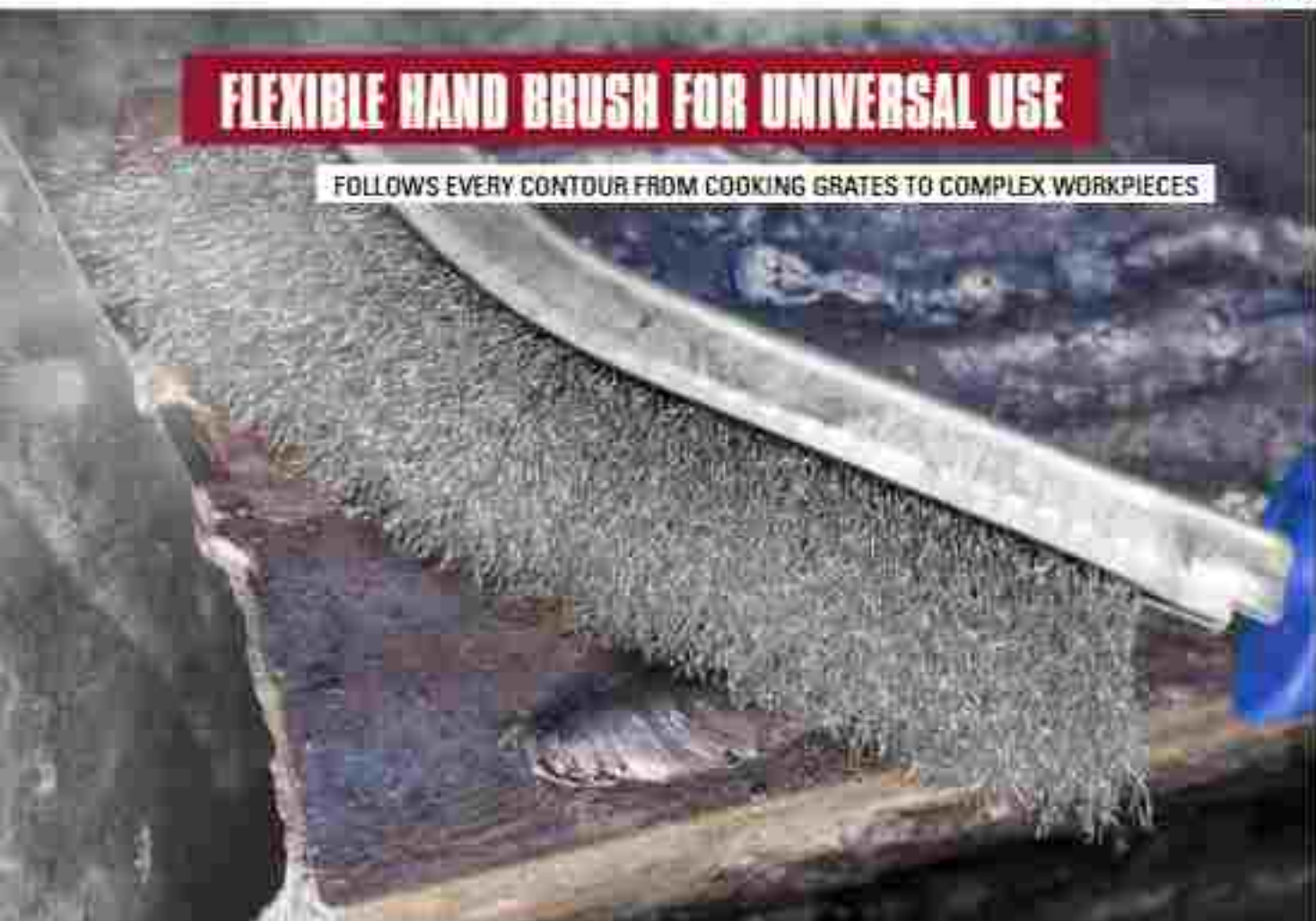
- with practical M14 thread
- for deburring, deccaling, derusting, surface cleaning, roughening and paint stripping
- made of high quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surface such as stainless steel, aluminum and other non ferrous metals.

★★★

Product number	Description	Material	Type	d mm	L mm	Thread	Wire Ø mm	Wires per inch	Part number
A3504002014	BTW 0620 G	steel	conical	60	20	M14	0.35	12,000	1
A3504002015	BTZ 0630 G	steel	knitted	60	20	M14	0.5	12,500	1
A3504002016	BTZ 0630 G	steel	knitted	60	20	M14	0.5	9,000	1
A3504002014	BTW 0625 G	steel	conical	60	25	M14	0.35	8,500	1
A35041003014	BTW 10030 G	steel	conical	100	30	M14	0.35	9,000	1
Recommended for: <input type="checkbox"/> Steel <input checked="" type="checkbox"/> Corrosion									
A35040021213	BTW 0621 G	stainless	conical	60	20	M14	0.3	12,000	1
A35040020214	BTZ 0630 G	stainless	knitted	60	20	M14	0.35	12,500	1
Recommended for: <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Corrosion									

# 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 contour of every workplace thanks to their flexibility
- perform a wide variety of manual jobs such as: deburring, discarding, demisting, 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 impact the piece such as stainless steel, aluminium and other non ferrous metals



steel



stainless

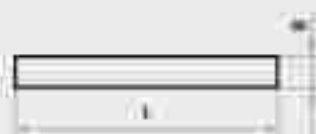


Product number	Description	Material	Ø mm	L mm	L mm	L mm	Wire Ø mm	Pack quantity
A350725525013	BH4/S 25525	steel	15	30	205	130	0.35	1
Recommended for: <input type="checkbox"/> Steel <input checked="" type="checkbox"/> Non-ferrous								
A350725525113	BH4/V 25525	stainless	15	30	205	130	0.3	1
Recommended for: <input checked="" type="checkbox"/> Steel <input type="checkbox"/> Non-ferrous								

## 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 optimize manual grinding tasks.

★★

Product number	Description	Grit	Width B mm	Length L m	Price indicator
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: Steel Stainless Cast iron Plastic Other



# PERFECT SURFACES

USE LUKAS SHEETS OF ABRASIVE CLOTH FOR MANUAL OPTIMISATION



## SLB sheets of abrasive cloth



- for practical manual working
- 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 quantity
A382523020040	SLB 230200	NK 40	230	200	50
A382523020060	SLB 230200	NK 60	230	200	50
A382523020080	SLB 230200	NK 80	230	200	50
A382523020100	SLB 230200	NK 100	230	200	50
A382523020120	SLB 230200	NK 120	230	200	50
A382523020140	SLB 230200	NK 140	230	200	50
A382523020160	SLB 230200	NK 160	230	200	50
A382523020180	SLB 230200	NK 180	230	200	50
A382523020200	SLB 230200	NK 200	230	200	50
A382523020240	SLB 230200	NK 240	230	200	50
A382523020280	SLB 230200	NK 280	230	200	50
A382523020400	SLB 230200	NK 400	230	200	50
A382523020800	SLB 230200	NK 800	230	200	50

Recommended for: Steel Stainless Cast iron Non-ferrous 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 W (mm)	Length L (m)	Pack (units)
A38011502301	SVB 150230	A Medium	red-brown	150	230	10
A38011502302	SVB 150230	A Fine	green	150	230	10
A38011502303	SVB 150230	A Very Fine	red-brown	150	230	10
A38011502304	SVB 150230	C Ultra Fine	grey	150	230	10

### 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 W (mm)	Length L (m)	Pack (units)
A382011501012	SVR 115	A Fine	green	115	10	1
A382011501013	SVR 115	A Very Fine	red-brown	115	10	1
A382011501024	SVR 115	C Ultra Fine	grey	115	10	1



# 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 low 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 (at maximum load)	Connecting thread
0.05–0.5 m <sup>3</sup> /min	G 1/4"
0.15–0.8 m <sup>3</sup> /min	G 3/8"
0.5–1.5 m <sup>3</sup> /min	G 1/2"
0.8–6.0 m <sup>3</sup> /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

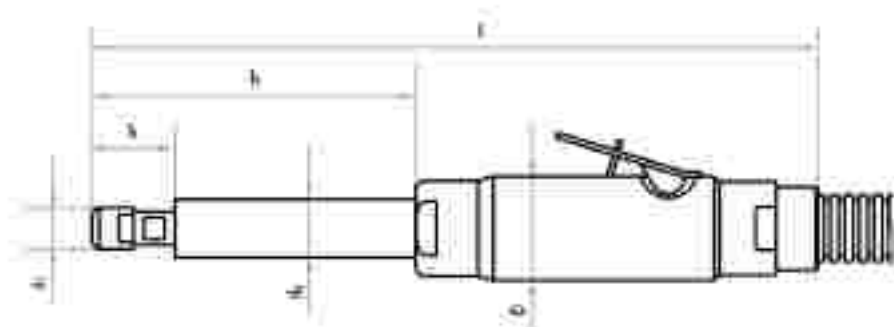
All of our power tools have a robust aluminium casing and are designed for use in harsh environments. The motors cannot overheat even when used continuously at maximum power. As part of our full quality control policy, all tools are subjected to speed and performance tests before they leave the factory.

## 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 type	Power kW	K mm	L mm	S mm	T mm	U mm	V mm	Page	
Belt grinder, insulated	AMN 30-03H	30.000	0.300	19	28			8 - 88	36	220	300
Straight grinder, insulated	AMN 12-030 GD	12.000	0.300	16	26				35	195	300
	AMN 15-030 GD	15.000	0.300	16	26				35	195	
	AMN 12-030 GH	12.000	0.300	16	26				35	195	
Straight grinder with extension, insulated	AMN 15-039 GHZ	15.000	0.700	24	35	24	440		46	630	305
Straight grinder, insulated	AMN 19-100 GH	19.000	1.000	24	32	34	146		51	350	300
	AMN 19-100 GHK	19.000	1.000	24	44				51	345	
Straight grinder, insulated	AMN 25-030 GD	20.000	0.300	16	26				35	195	300
	AMN 25-030 GH	20.000	0.300	16	26				35	195	
Straight grinder, insulated	AMN 30-030 GD	30.000	0.300	14	18				36	190	300
	AMN 30-039 GH	30.000	0.300	14	19				36	190	
Straight grinder, insulated	AMN 32-027 GD	32.000	0.270	13	20	23		35	29	210	300
Straight grinder, insulated	AMN 45-030 GD	45.000	0.300	14	18				36	190	300
	AMN 45-030 GH	45.000	0.300	14	19				36	190	
Straight grinder, insulated	AMN 55-01H GD	55.000	0.710	9	14				30	125	311
Straight grinder, insulated	AMN 72-01H GD	72.000	0.730	10	15				29	105	312
Conditioning machine	ESM 1010 S	1.300 - 3.650	1.300								313

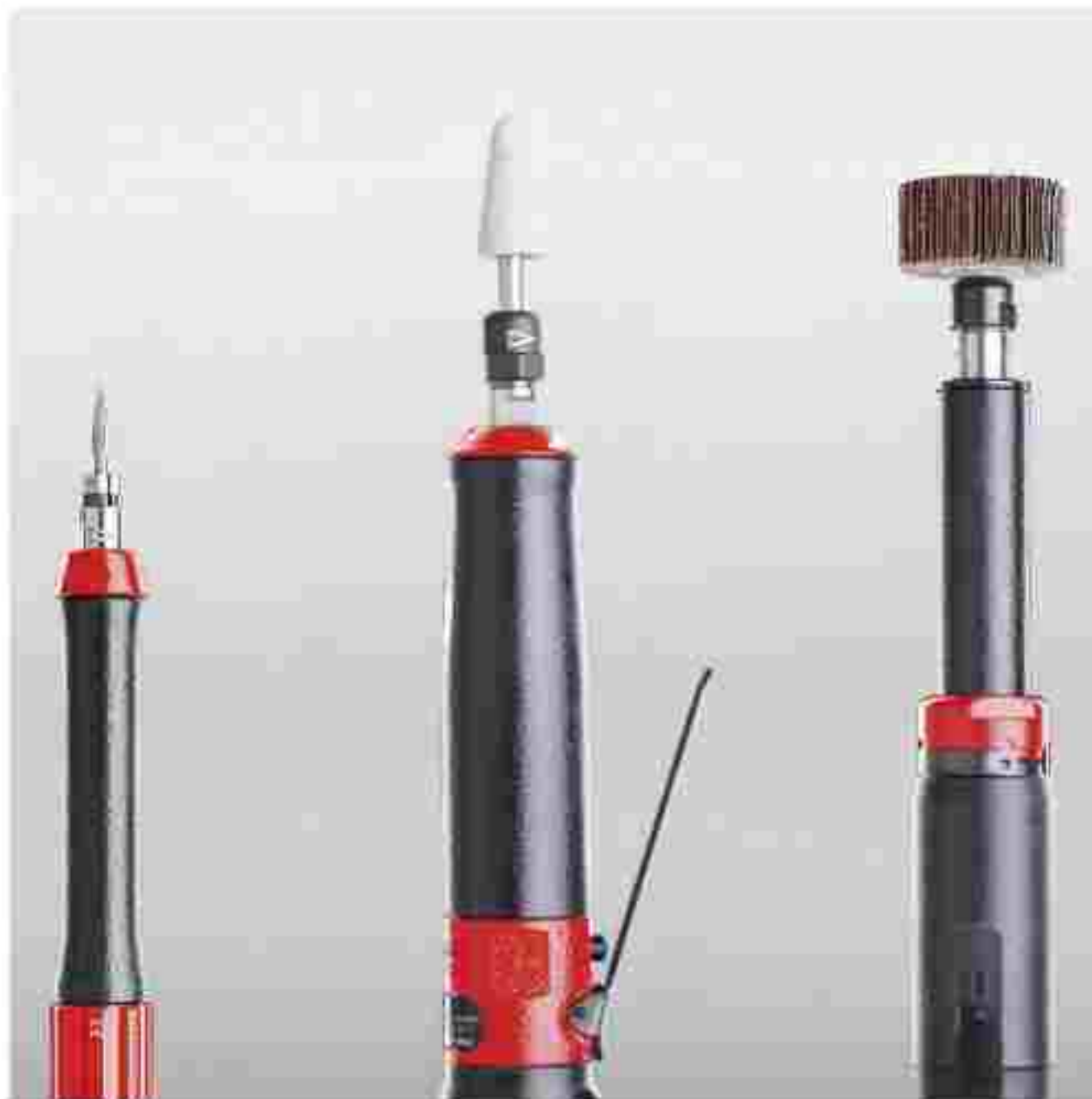
## MADE TO TACKLE THE TOUGHEST CHALLENGES

### 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 hood hose
- exhaust air hose with muffler
- collet 6 mm
- opening tool/spanner

## Special accessories:

- collets for 3.2 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"
- belt arms in various dimensions (length, width and roll diameter) available from stock

## Technical details:

- length: approx. 375 mm
- height: approx. 86 mm
- weight: approx. 0.90 kg
- drive type: servo motor

► Further technical details can be found on page 301.



★★★

Product number	Description	Type	Min speed (rpm)	Power (W)	Air consumption under load (l/min)	Average belt peripheral speed (m/s)	Maximal force on rim (N)	Part availability
A3003302111	AMM 30 BSM	Levor	30,000	83	0.45	28	6	1



**Suitable long belts are available from stock.**

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

## SBL finishing belt



★★★

Product number	Description	GR	# grit	Length (mm)	Width	Part availability
A30001303050801	SBLT	NK 60	13	305	robustly flexible	100
A30001303200801	SBLT	NK 80	13	305	robustly flexible	100
A30001303251301	SBLT	NK 120	13	305	robustly flexible	100

## Straight grinder, insulated



### Technical details:

- length: approx. 175 mm
- casing diameter: 34.5 mm
- weight: approx. 0.99 kg
- drive type: vane motor, integrated speed control

► Further technical details can be found on page 283.

### Included with the machine:

- air lock hose
- exhaust air hose with muffler
- collar: 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	Value	Weight (approx.)	Power (W)	Max. commutator motor speed (rpm)	Collar Ø (mm)	Exhaust hose size (mm)	Price (incl. tax)
A385510111	AMIN 12-030 GD	Twist	12,000	8.2	6.40	6	8	1
A385510211	AMIN 12-030 GH	Lever	12,000	8.2	6.40	6	8	3
A38551015003	AMIN 15-030 GD	Twist	15,000	8.2	6.50	6	8	1

Can be used with the following LHMAT tools:		Dimension	Catalogue page
AMIN 12-030 GD / GH	Tungsten carbide burrs	up to Ø 20 mm	17-41
	HSS burrs	up to Ø 8 mm	46-55
	SPV/M mounted flap wheels	Ø 40 mm	175-180
	SR mounted flap wheels	Ø 30 mm	172
	SFA mounted flap wheels	Ø 15 mm, 20 mm, 30 mm	171
	SBZY abrasive bands	up to Ø 30 mm	196-198, 201
	SBRK abrasive bands	up to Ø 36 mm	200
	SBZY/SBRK abrasive rolls	up to Ø 20 mm	206-208
	SK/SRS abrasive caps	up to Ø 21 mm	211-213
	SBRK abrasive strokes	0805, 1305, 1805	205
	P1 polishing points	4020	191
	P2 polishing points	Ø 20 mm	194
	P5 polishing points	up to Ø 32 mm	193
	AMIN 15-030 GD	Tungsten carbide burrs	up to Ø 16 mm
HSS burrs		up to Ø 4 mm	46-55
SR mounted flap wheels		Ø 30 mm	172
SFA mounted flap wheels		Ø 15 mm, 20 mm, 30 mm	171
SBZY abrasive bands		up to Ø 25 mm	197-199
SBRK abrasive bands		up to Ø 29 mm	202
SBZY/SBRK abrasive rolls		up to Ø 20 mm	206-208
SK/SRS abrasive caps		up to Ø 16 mm	211-213
SBRK abrasive strokes	0805, 1305	205	

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



## Straight grinder with spindle extension, insulated

### Included with the machine:

- air lock hose
- exhaust air hose with muffler
- two spindle extensions (each 200 mm long)
- collet 0 mm
- operating lock/spinner

### Special accessories:

- spindle extensions, 200 mm (max. spindle extensions up to 1200 mm)
- collets for Ø 5 mm, 8 mm, 3/16", 1/4", 5/16"

### Technical details:

- length approx. 675 mm (also incl. two spindle extensions)
- casing diameter: 47 mm
- weight approx. 2.1 kg
- drive type: worm motor, integrated speed control

➔ further technical details can be found on page 201.



Product number	Description	Motor	Blow speed (rpm)	Power (W)	Air consumption (under load) (l/min)	Collet Ø (mm)	Maximum hose size (mm)	Part. accessories
A382102 H3802	AMM 15-070 G-H3	Level	15.300	0,7	0,2	Ø	III	3

Can be used with the following (HAKA) tools		Dimensions	Delivery page
AMM 15-070 G-H3	SPL/SFB/SFT/SFE/SFC mounted flap wheels	up to Ø 40 mm	164 - 171
	SH mounted flap wheels	Ø 30 mm	172
	SFA mounted flap wheels	Ø 15 mm, 20 mm, 30 mm	173
	SSTy spiral belts	up to Ø 25 mm	187 - 199
	SSEB spiral belts	up to Ø 25 mm	202
	SSTy/SSTKE abrasive rolls	up to Ø 25 mm	206 - 208
	SK-SKS abrasive cups	up to Ø 55 mm	210 - 213
	SHKE abrasive sleeves	Ø80, 100	211
	P1 polishing points	Ø 32 mm	197
	P2 polishing points	Ø 18 mm	198



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





## Straight grinder, insulated



### Technical details:

- length AMN 19-100 GEI approx. 310 mm
- length AMN 19-100 GIK approx. 190 mm
- grinding diameter: 52 mm
- weight GEI approx. 2.3 kg
- weight GIK approx. 1.7 kg
- drive type: universal motor
- integrated speed control

► For further technical details can be found on page 301.

### Included with the machine:

- air feed hose
- exhaust air filter with muffler
- collet 6 mm
- operating tool (screw)

### Special accessories:

- collets for 2/8 mm, 9 mm, 3/16", 1/4", 5/16"



Product number	Description	Voltage	Max speed (rpm)	Power (kW)	All accessories included (number of pieces)	Collet Ø (mm)	Maximal wheel size (mm)	Tool number
A3925102115	AMN 19-100 GEI	Line	13,000	1	1	6	12	1
A39251021001	AMN 19-100 GIK	Line	13,000	1	1	6	12	1

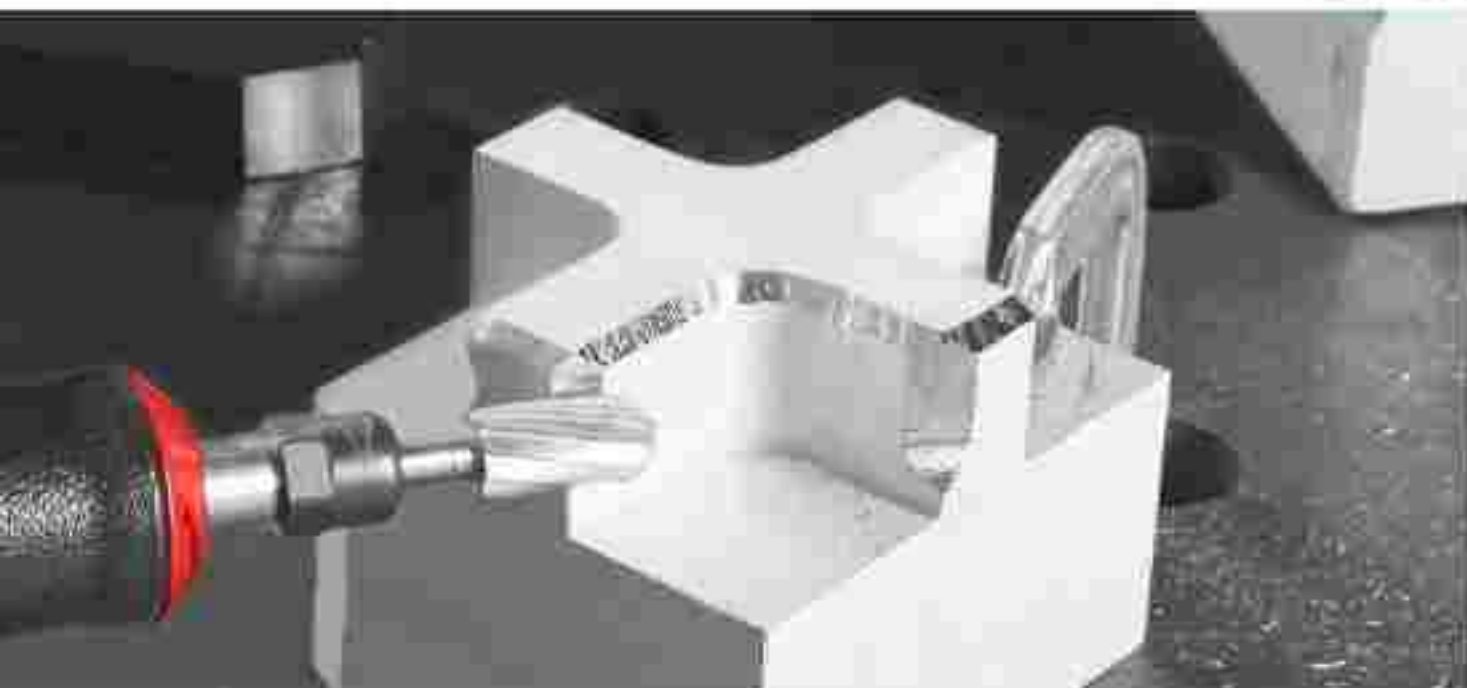
AMN 19-100 GIK/GEI

### Can be used with the following accessories:

		Dimensions	Collet size (mm)
	Tungsten carbide burrs	up to Ø 12 mm	17-42
	HSS burrs	up to Ø 4 mm	50-55
	Mounted points	up to Ø 50 mm	75-85
	P1 polishing points	up to Ø 50 mm	90-101
	P2 polishing points	up to Ø 12 mm	90-104
	P3 polishing points	up to Ø 16 mm	90-107
	P5 polishing points	up to Ø 50 mm	113
	P6 polishing points	up to Ø 16 mm	116-121
	SK/GES abrasive cups	up to Ø 13 mm	211-214
	GR7/GR8 abrasive rolls	up to Ø 13 mm	216-220
	SEZY abrasive bands	up to Ø 16 mm	221-226
	SEKE abrasive bands	up to Ø 20 mm	227



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



## Straight grinder, insulated

### Included with the machine:

- air food hose
- exhaust air filter with muffler
- collet: 6 mm
- operating tool/spinner

### Special accessories:

- collet for 2.8 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: universal motor
- integrated speed control

- Further technical details can be found on page 201



★★★

Product number	Description	Motor	Idle speed (rpm)	Power (kW)	Air consumption (normal/boost settings)	Collet Ø mm	Handled bore size mm	Peak rotation
A388310120	AMN 20-030 GD	Tool	20,000	0.3	0.55	6	8	1
A388310100	AMN 20-030 GH	Tool	20,000	0.3	0.45	6	8	1

Can be used with the following (EMAG) tools		Dimensions	Collage page
AMN 20-030 GD / GH	Flange carbide burrs	up to Ø 12 mm	17 - 43
	HSS burrs	up to Ø 4 mm	50 - 54
	SFL mounted flap wheels	Ø 20 mm	144 - 155
	SD2V abrasive bands	up to Ø 18 mm	187 - 198
	SDKE abrasive bands	up to Ø 20 mm	202
	SD2V/SDKE abrasive caps	up to Ø 13 mm	206 - 208
	SK/SKS abrasive caps	up to Ø 13 mm	210 - 214
	SDKE abrasive stones	Ø 20	220
	Mounted points, Shank-Ø mm	Ø 22 mm, 25 mm, 30 mm, 40 mm	23 - 83
	FS polishing points	Ø 13 mm	100 - 104



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



## Straight grinder, insulated



### Technical details:

- length: approx. 176 mm
- casing diameter: 34.5 mm
- weight: approx. 0.70 kg
- drive type: universal motor  
integrated speed control

► For further technical details can be found on page 301.

### Included with the machine:

- air food hood
- exhaust air hose with muffler
- collet: 6 mm
- operating tool/brush

### Special accessories:

- collets for: 2.5 mm, 3.25 mm, 4 mm, 5 mm, 1/8", 3/16", 1/4"



Product number	Description	Voltage	W/A speed (rpm)	Power (W)	Air consumption (normal load) (l/min)	Collet Ø (mm)	Handled item size (mm)	Tool condition
A300310130	AMM 30-250 GD	Netz	30.000	0.3	0.45	6	6	1
A3003102130	AMM 30-250 GH	Netz	30.000	3.5	0.45	6	6	1

Can be used with the following accessories		Dimensions	Collet Ø (mm)
HD / GD / GH / GS / NW	Tungsten carbide burrs	up to Ø 8 mm	6 - 6.2
	VSS burrs	up to Ø 3 mm	6 - 6.2
	Multistep points	up to Ø 3.2 mm	6 - 6.2
	P1 polishing points	up to Ø 3.2 mm	6 - 6.2
	P2 polishing points	up to Ø 14 mm	6 - 6.2
	P3 polishing points	up to Ø 16 mm	6 - 6.2
	P5 polishing points	up to Ø 3.2 mm	6 - 6.2
	P6 polishing points	up to Ø 12 mm	6 - 6.2
	EK/SRS abrasive caps	up to Ø 10 mm	6 - 6.2
	SEZY abrasive bands	up to Ø 12 mm	6 - 6.2



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: 8 mm
- operating tool/spinner

### Special accessories:

- collet for Ø 5 mm, 1/8", 1/4"

### Technical details:

- length: approx. 200 mm
- casing diameter: approx. 20 mm
- spindle casing diameter: approx. 22 mm
- weight: approx. 0.40 kg
- drive type: air motor
- foot of exhaust air (partial), can be shut off

► Further technical details can be found on page 201.



Product number	Description	Material	Spindle speed (rpm)	Power (W)	Air consumption (volume flow rate)	Collet Ø (mm)	Exhaust hose size (mm)	Peak velocity
A3903301132	AMH 23-027 GD	Twist	32,000	0,22	0,3	8	6	1

Can be used with the following LHM tools		Dimensions	Delivery page
AMH 23-027 GD	Tungsten carbide burrs	up to Ø 8 mm	17 - 43
	HSS burrs	up to Ø 8 mm	50 - 52
	Mounted points	up to Ø 32 mm	73 - 81
	P1 polishing points	up to Ø 32 mm	86 - 101
	P2 polishing points	up to Ø 10 mm	80 - 104
	P3 polishing points	up to Ø 10 mm	86 - 107
	P5 polishing points	up to Ø 32 mm	113
	P6 polishing points	up to Ø 12 mm	120
	SH/ERS abrasive caps	up to Ø 10 mm	211 - 214
	ESFY abrasive bands	up to Ø 17 mm	180



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: vana motor

► For further technical details can be found on page 301.

### Included with the machine:

- air food hose
- universal air hose with quick fix
- collet: 6 mm
- operating tool/spacer

### Special accessories:

- cones for: 2.5 mm, 3.25 mm, 4 mm, 5 mm, 1.6" (31.75), 1.4"

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Product number	Description	Voltage	Max speed (rpm)	Power (W)	Air consumption (normal load volume)	Collet Ø (mm)	Handled beam size (mm)	Peak condition
A300310145	RAMM 45-250 GD	240V	45,000	0.5	0.5	6	6	1
A3003102145	RAMM 45-250 GH	240V	45,000	3.5	0.5	6	6	1

Can be used with the following 125x42 items		Dimensions	Collet size (mm)
RAMM 45-250 GD / GH	Tungsten carbide burrs	up to 42.5 mm	57-62
	Mixed points	up to 42.5 mm	75-80
	P1 polishing points	up to 42.5 mm	100-105
	P2 polishing points	up to 42.5 mm	105-108
	P3 polishing points	up to 42.5 mm	106-107
	P5 polishing points	up to 42.5 mm	113
	P8 polishing points	up to 42.5 mm	120
	SD/SDK abrasive cups	up to 42.5 mm	211-214
	SBZY abrasive bands	up to 42 mm	198



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

## Straight grinder, insulated

### Properties:

- most powerful tool in its class
- compact design
- lockable speed switch

### Included with the machine:

- air flood hose
- exhaust air hose with muffler
- collet 3 mm
- operating tool/spinner

### Special accessories:

- collets for Ø 7 mm, 3.75 mm, 1/8", 3/32"

### Technical details:

- length: approx. 330 mm
- casing diameter: 16 mm
- weight: approx. 0.34 kg
- drive type: vane motor

► Further technical details can be found on page 303.



Product number	Description	Value	Max. speed (rpm)	Power (W)	All dimensions unless stated otherwise	Collet Ø (mm)	Weight (incl. case) (kg)	Peak current (A)
A320310155	AMN 65-011 GD	Twist	55,000	6.11	0.15	3	3	3

Can be used with the following L&L&L tools		Dimensions	Ordering part
AMN 65-011 GD	Tungsten carbide burrs	up to Ø 5 mm	15-43
	Maximil points	up to Ø 16 mm	77-85
	P1 polishing points	up to Ø 16 mm	100-101
	P2 polishing points	up to Ø 5 mm	102-104
	P5 polishing points	up to Ø 16 mm	117
	SD/SLS abrasive caps	up to Ø 5 mm	231-234
	ESLV abrasive bands	up to Ø 16 mm	166



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



## Straight grinder, insulated



### Technical details:

- length: approx. 154 mm
- casing diameter: 225 mm
- weight: approx. 0.45 kg
- drive type: vana motor

► Further technical details can be found on page 301

### Included with the machine:

- air food hose
- retract air hose with yuffile
- collet: 3 mm
- operating tool/spinner

### Special accessories:

- collets for: Ø 2 mm, Ø 2.25 mm, 1/8", 3/32"

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Product number	Description	Value	Max. speed (rpm)	Power (W)	Air consumption (with standard settings)	Collet Ø (mm)	Maximal hose size (mm)	Part number
A5001101122	AMN 72-013 GD	Twist	22,000	8.13	0.21	3	5	1

Can be used with the following L2250 tools		Dimension	Collet size (mm)
AMN 72-013 GD	Tungsten carbide files	up to Ø 4 mm	10–42
	Mounted points	up to Ø 13 mm	75–85
	F1 polishing points	up to Ø 13 mm	100–110
	F2 polishing points	up to Ø 4 mm	112–124
	F5 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 (brush)
- double gear reduction, long service life
- dust-protected bearings low wear
- Suitable for metal, wood or plastic surfaces without transition can be achieved with the ideal tool.

### With the appropriate tool, perfect for:

- conditioning
- structuring
- polishing
- finishing
- smoothing
- deburring
- rust finishing

### Technical details:

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

► Further technical details can be found on page 301.



★★★

Product number	Description	Min speed (rpm)	Power (W)	Red max. Ø (mm)	Roll width (mm)	Roll length (mm)	Roll quantity
A338ESM1310	ESM 1310 E	1,300-3,050	13	120	100	10	1

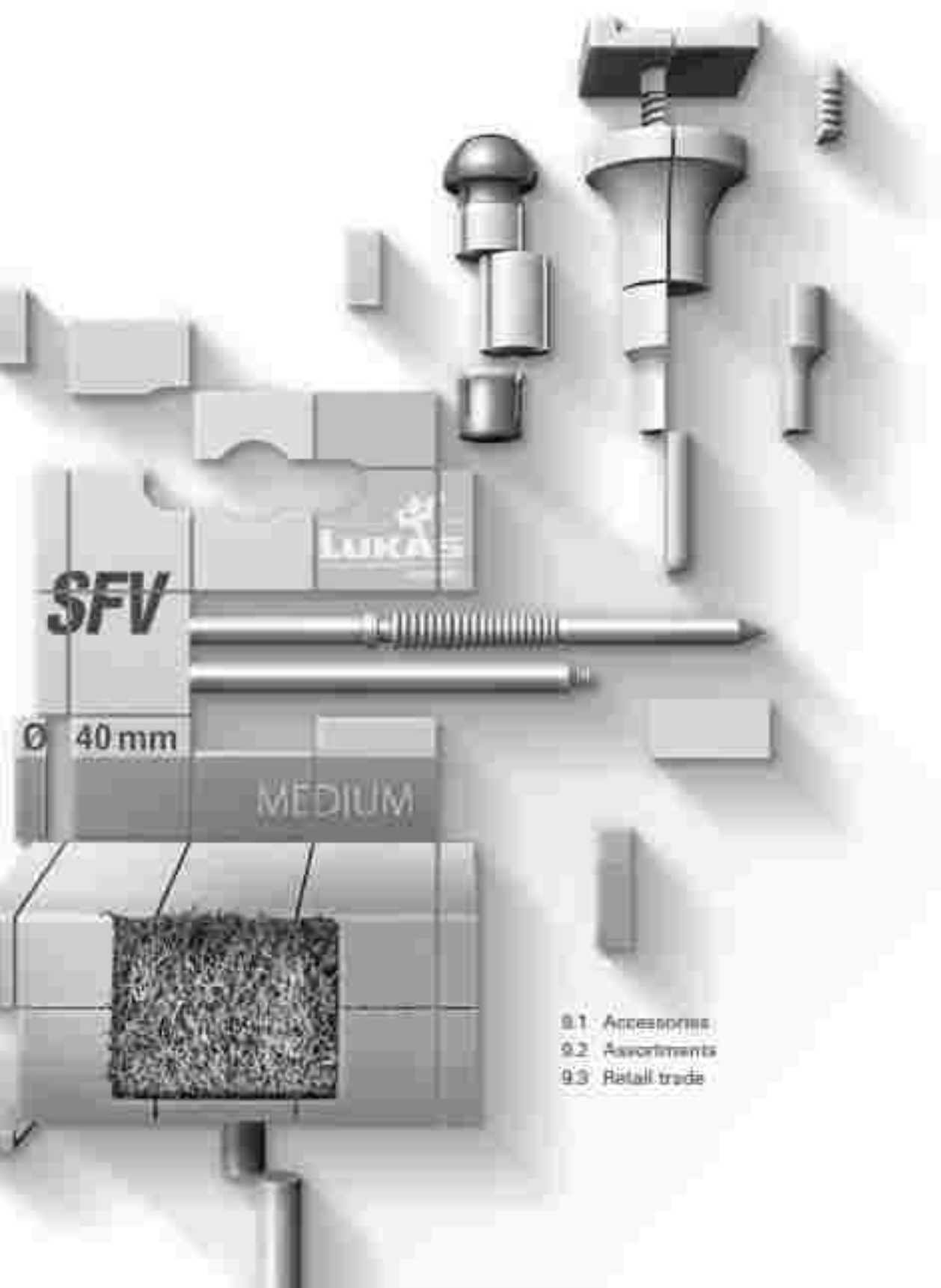
ESM 13 V/S	Can be used with the following 13.5V tools		Dimensions	Roll length (mm)
	PE polishing rolls		100 x 50 mm, 100 x 100 mm	120
	SEZY abrasive belt rolls		100 x 100 mm	200
	LWL/LWW/LWM/LWP abrasive flap rolls		100 x 50 mm, 100 x 100 mm	130-135



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





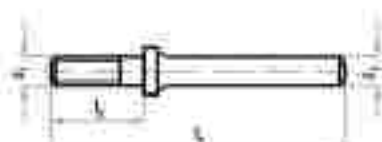


# ACCESSORIES AND RETAIL TRADE

- 9.1 Accessories
- 9.2 Assortments
- 9.3 Retail trade

316–318  
319–323  
324–333

## Arbors for felt polishing wheels



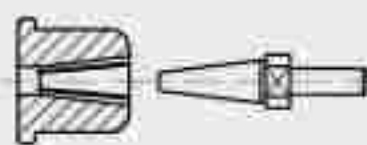
**Included (per arbor):**

- two washers, diameter 10 mm
- two washers, diameter 30 mm
- one hex nut



Product number	Description	Material	L mm	d mm	L <sub>1</sub> mm	n <sub>max</sub> rpm	Part quantity
A1630780	AGR 780	Alu	20	6	63	1000	5
A1630781	AGR 381	Alu	30	6	73	1200	5

## Mounting system for polishing wheels

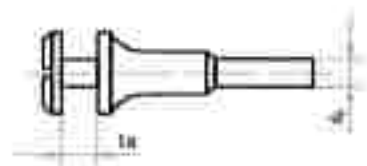


The mounting system for polishing wheels consists of a plastic sleeve (MCA) and a mounting arbor with 8 mm diameter shaft (K25), which is solely applicable to shape SE 1 in the diameters 100H Ø 25 and 100D Ø 25. This system is not designed to be used for polishing wheels with larger diameters. The maximum 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	Part quantity
A681028000	Mounting system MCA + K25-1	1

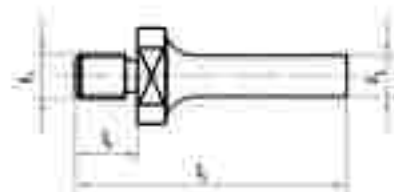
## Arbors for small cutting and rough grinding wheels



Product number	Description	Shaft diameter / diameter mm	L mm	d mm	Part quantity
A3880060104	AGR 88	6	11-4	6	1
A3880061104	AGR 61	10	11-4	6	1
A3880061046	AGR 610	10	4-8	8	1



## Arbors for tools with an internal thread

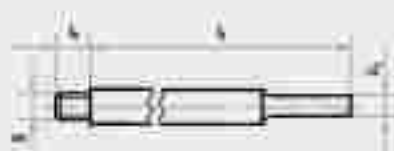


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Product number	Description	Ø	L mm	Ø mm	L mm	Part quantity
A5E03421	ASB 342 B	M10	12	8	32	3
A5E03422	ASB 342 C	M12	14	8	34	3
A5E03424	ASB 342 D	M8	10	8	30	3
A5E03442	ASB 344 B	M10	17	8	32	3
A5E03443	ASB 344 C	M12	14	8	34	3
A5E03462	ASB 346 B	M10	12	10	32	3



## Tool adapters for SFI mounted flap wheels



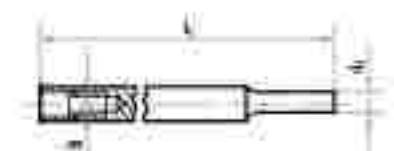
► only for use with the LUKAS mounted flap wheels on page 172

★★★

Product number	Description	Ø mm	L mm	Ø mm	L mm	Part quantity
A3E30404	WACH 0404	6	00	M4	4	1
A3E30407	WACH 0407	6	30	M4	7	1
A3E30609	WACH 0609	6	100	M6	9	1
A3E30612	WACH 0612	6	100	M6	12	1



## Tool adapter for SFA mounted flap wheels



► only for use with the LUKAS inserted flap wheels on page 172

★★★

Product number	Description	Ø mm	L mm	R	Part quantity
A7E30519	WACA 05	6	100	M5	1







## Carbide burrs assortments

- Always the right tool to hand. LUXAS' 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 quantity
A10300010	F10 S3	27 Steel	3	10 parts: HFA 0313 HFC 0313 HFD 0313 HFE 0313 HFF 0313	1
A103001000	F10 S8	27 Steel	6	10 parts: HFA 0316 HFC 1225 HFD 1210 HFE 0610 HFF 0620	1
A103001020	Assortment	242 Incol/Steel	6	10 parts: HFA 0610 HFC 1225 HFD 0610 HFE 1225	1
A103002000	Assortment	29 Alu	3	5 parts: HFA 0313 HFE 0313	1
A103002006	Assortment	29 Alu	6	5 parts: HFA 0610 HFE 0610	1



## ZX Universal carbide burrs assortments

- Always the right tool to hand. LUXAS' 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 quantity
A10300053	F5 S3 BASE-X	ZX	3	5 parts: HFA 0313 HFE 0313	1
A10300056	F5 S6 BASE-X	ZX	6	5 parts: HFA 1225 HFE 1225	1







## 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 turning 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 exceptionally long tool life
- also machines hard materials efficiently



Assortment 46

Assortment 14 ★★

Product number	Description	Quality	Shank diameter mm	Content per pack	Part numbers	
A204700001402	Assortment 14	EKR	3 x 30	14 parts: ZY 0225 ZY 0510 ZY 0816 ZY 1121 ZY 1404 ZY 1704	ZY 0306 ZY 0611 ZY 1010 KU 0808 ZY 2006 ZY 0408 ZY 0810 ZY 1013 ZY 1303	1
A204600000202	Assortment 46	EKR	6 x 40	46 parts: ZY 0225 ZY 0510 ZY 0816 ZY 1010 ZY 1303 ZY 1604 ZY 1904 ZY 2202 ZY 2505 ZY 2806 ZY 3102 ZY 3403 ZY 3703 ZY 4003 SP 1220 KE 1640 KU 1810 KU 2020	ZY 0306 ZY 0610 ZY 1020 ZY 1315 ZY 1616 ZY 2006 ZY 2302 ZY 2610 ZY 2902 ZY 3202 ZY 3502 SP 0816 SP 1020 KE 1630 KE 2040 KU 1816 KU 2026 ZY 0408 ZY 0816 ZY 1020 ZY 1320 ZY 1620 ZY 2020 ZY 2340 ZY 2620 ZY 3008 ZY 3408 ZY 3808 KE 1630 KE 2040 KU 1816 KU 2026	1



## 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 turning different tools
- just as suitable for use in the home, hobby workshop or in industry



Assortment 36, EKR

Assortment 36, EKI

★★

Product number	Description	Quality	Shank diameter mm	Content per pack	Part numbers	
A204800003611	Assortment 36	EKR	3 x 30	36 parts: D1 D6 D11 D16 D21 D26 D31 D36	D2 D7 D12 D17 D22 D27 D32 D37 D4 D9 D14 D19 D24 D29 D34 D39 D4 D9 D14 D19 D24 D29 D34 D39 D44 D49 D54 D59 D64 D69 D74 D79 D84 D89 D94 D99	1
A204000003602	Assortment 36	EKI	3 x 30	16 parts: D1 D6 D11 D16 D21 D26 D31 D36	D2 D7 D12 D17 D22 D27 D32 D37 D4 D9 D14 D19 D24 D29 D34 D39 D44 D49 D54 D59 D64 D69 D74 D79 D84 D89 D94 D99	1

## NOW 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.

- optimized 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	Part availability	
A200000003353	Assortment 10	NOW	3 x 30	10 parts: ZY 0400 ZY 1011 KJ 0404 WR 1011	ZY 0010 SP 0510 KJ 0000 ZY 0010 SP 0010 KJ 0000	1

## Group P1 polishing points assortment



- ideal for finishing cast materials, hardened and unhardened, alloyed and non-alloyed steel.
- manufactured in line with DIN 93170.
- a match for all polishing requirements.
- 14 different shapes for quick tool change.

★★☆

Product number	Description	Content per pack	Part availability
A2000114	Assortment 134	14 parts: P1ZY 0400.00 P1ZY 1010.00 P1ZY 1012.00 P1ZY 0510.00 P1ZY 1013.00 P1ZY 1014.00 P1ZY 0010.00 P1ZY 1015.00 P1ZY 1016.00 P1ZY 0710.00 P1ZY 1201.00 P1ZY 2000.00 P1ZY 0010.00 P1ZY 1012.00	1

## 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: 277 mm x 189 mm x 46 mm



★★★

Product number	Description	Quantity	Content	Pack contents		
A210000001001	WS 45 NCS	50 pieces 100 per pack	Abrasive caps, grade #60-100: SKKES 0515 SKZY5 0510 SKZY5 0713 SKZY5 1015 SKKES 1125	SKWNS 0811 SKWNS 0713 SKWNS 0915	SKWKS 0511 SKWKS 0713	1
		24 pieces 30 per pack 15 per pack	Abrasive caps, grade #80-90: SKWNS 1015 SKZY5 1317 SKWNS 1626	SKWNS 1319 SKWNS 1626	SKWNS 1319 SERES 1832	
		2 per pack	Mandrels, shank 3 mm: GTZY 0510 GTWN 0713 GTZY 1015 GTWN 1319	GTWS 0511 GTWK 0713 GTWN 1015 GTWK 1319	GTWK 0911 GTZY 0713 GTWK 1015 GTZY 1317	
		1 per pack	Mandrels, shank 6 mm: GTNE 0815 GTNE 1025	GTWN 1626 GTWN 1626	GTWN 1626 GTWN 1626	

Recommended for: Steel Cast iron Aluminum Cast aluminum Plastic/Steel 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 iD 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 740 Inox/Steel and ZX Universal in practical retail packaging. [Pages 326/328](#)

**FLAP WHEELS**  
S2L, S1V and S2M flap wheels in metal packaging for a wide variety of applications. [Page 321/322](#)

**DIAMOND CUTTING DISCS**  
The efficient diamond cutting disc for the construction site and the responsive option for cutting tiles in retail packaging. [Page 327](#)

**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 lifting your customers. [Visit our product. Page 328](#)

**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 change your color area the way you want.

**COUNTER DISPLAY, LOCKABLE**  
For the presentation and individual sale of LUKAS tools. Place it on your sales counter or shelves. [Page 326](#)

**COUNTER DISPLAY**  
Counter display for up to 10 metal boxes of LUKAS cutting disc sets for direct dispensing to customers. [Page 328](#)

**DISPLAY WALL**  
Appeal to customers directly with LUKAS products. [Page 326](#)

## LUKAS PRODUCT HIGHLIGHTS FROM YOUR DISPLAY STAND

Milling tools	<a href="#">Page 43</a>	Flap wheels	<a href="#">Pages 104 - 109</a>
H2E special drill	<a href="#">Page 67</a>	LSL flap wheels in attractive clink with thread	<a href="#">Page 102</a>
Diamond dry drills	<a href="#">Page 61</a>	Fibre discs with backing plate	<a href="#">Pages 236 - 241</a>
Diamond drill bit for socket outlets	<a href="#">Page 63</a>	Cutting discs	<a href="#">Pages 244 - 255</a>
PSPT range	<a href="#">Pages 117 - 119</a>	Diamond cutting discs	<a href="#">Pages 260 - 267</a>
Small grinding points with soft stainless steel	<a href="#">Page 125</a>	Grinding discs	<a href="#">Pages 270 - 281</a>
IQ series tools	<a href="#">Pages 134 - 137</a>	ASVT grinding disc	<a href="#">Page 287</a>
Additional mounted flap wheels	<a href="#">Pages 152 - 161</a>		

## Display stand



★★★

- stable, self-supporting display stand with perforated panel
- sustained presentation

Product number	Description	Dimensions (H x B x D) cm	Accessories	Price (incl. tax)
A29404	Display stand	1 x 3.10 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 (H x B x D) mm	Price (incl. tax)
A29406	Counter display	146 x 440 x 140	1





## 3-star cutting disc set

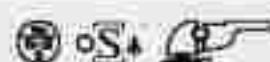


The practical packaging for construction sites, etc.

- cutting disc in metal box
- securely packaged
- protected from moisture

★★★

Product number	Description	Quality	D mm	T mm	H mm	R <sub>max</sub> rpm	Peak condition
A1007231V987700	141 115x1.0	AG0Z-8F Inox	115	1.0	22.23	13,300	10
A1007233V987700	141 125x1.0	AG1Z-8F Inox	125	1.0	22.23	12,000	10



## 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	R <sub>max</sub> rpm	Peak condition
A1005841V987700	141 115x1.0	AG0X-8F Inox	115	1.0	22.23	13,300	10
A1005842V987700	141 125x1.0	AG0X-8F Inox	125	1.0	22.23	12,000	10



## 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	R <sub>max</sub> rpm	Peak condition
A1004643V987700	141 115x1.0	AG0S-8F Inox	115	1.0	22.23	13,300	10
A1002822V987700	141 125x1.0	AG0S-8F Inox	125	1.0	22.23	12,000	10

## 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	Price indicator
A422004822	Counter display for tungsten carbide burrs	235 x 250 x 400	HFA 0313.03.ZX HFA 1225.06.ZX HFC 1020.06.ZX HFD 0820.06.ZX HFG 0313.03.ZX HFG 1225.06.ZX HFF 1020.06.ZX HFA 0620.06.ZX HFC 0313.03.ZX HFC 1225.06.ZX HFD 1000.06.ZX HFG 0620.06.ZX HFM 0313.03.ZX HFF 1225.06.ZX HFA 1020.06.ZX HFC 0820.06.ZX HFC 0605.03.ZX HFD 1210.06.ZX HFD 1000.06.ZX HFF 0620.06.ZX	1

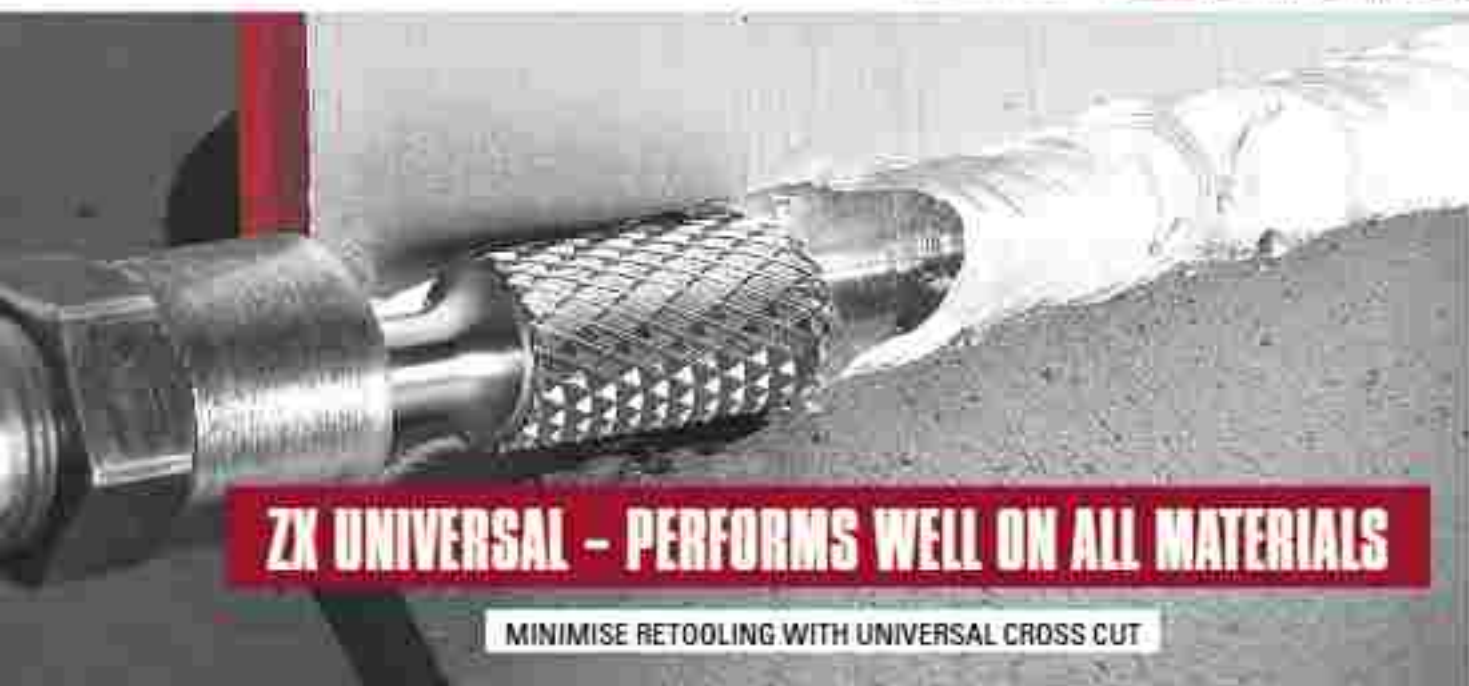
## 742 Inox/Steel burr



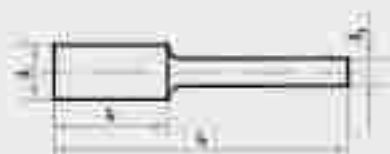
- one burr for two materials: perfectly process steel and stainless steel with just a single tool
- in retail packaging
- high chip volume thanks to coarse cut for spark working
- faceted tooling for perfect surface results
- smooth running, low vibration tool without chatter thanks to improved cutting angle

★★☆☆

Product number	Description	Cut	Similar to (DIN norm)	d mm	L mm	d1 mm	L1 mm	Price indicator
A1001020620F1	HFA 0620.06	242 Inox/Steel	71A 0620	6	20	6	60	1
A1001122506F1	HFA 1225.06	242 Inox/Steel	71A 1225	12	25	6	85	1
A1003060606F1	HFC 0620.06	242 Inox/Steel	WRG 0620	6	20	6	60	1
A1001122506F1	HFC 1225.06	242 Inox/Steel	WRG 1225	12	25	6	85	1
A1003060606F1	HFD 0620.06	242 Inox/Steel	KUD 0620	6	20	6	60	1
A1003060606F1	HFD 0820.06	242 Inox/Steel	KUD 0820	6	20	6	60	1
A1001121006F1	HFD 1210.06	242 Inox/Steel	KUD 1210	12	25	6	85	1
A1006062006F1	HFF 0620.06	242 Inox/Steel		6	20	6	60	1
A1001122506F1	HFF 1225.06	242 Inox/Steel	HFE 1225	12	25	6	85	1
A1006062006F1	HFG 0620.06	242 Inox/Steel	SPG 0620	6	20	6	60	1
A1001122506F1	HFG 1225.06	242 Inox/Steel	SPG 1225	12	25	6	85	1



## ZK 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 5363	d mm	L mm	d <sub>c</sub> mm	L <sub>c</sub> mm	Part position
A1001031322F1	HFA 0113.03 ZX	ZX	ZFA 0113	3	13	3	40	1
A1001020432F1	HFA 0204.03 ZX	ZX	ZFA 0204	4	20	4	60	1
A10011215622F1	HFA 1125.06 ZX	ZX	ZFA 1125	12	25	6	65	1
A10020313322F1	HFC 0113.03 ZX	ZX	WHC 0113	3	13	3	40	1
A1002020432F1	HFC 0204.03 ZX	ZX	WHC 0204	4	20	4	60	1
A10021215622F1	HFC 1125.06 ZX	ZX	WHC 1125	12	25	6	65	1
A10030615322F1	HFC 0615.03 ZX	ZX	KUD 0615	6	15	3	35	1
A10030716322F1	HFC 0716.03 ZX	ZX	KUD 0716	7	16	3	47	1
A10031215622F1	HFC 1215.06 ZX	ZX	KUD 1215	12	16	6	51	1
A11101020432F1	HFF 0204.06 ZX	ZX	---	4	20	4	60	1
A111011215622F1	HFF 1125.06 ZX	ZX	BBF 1125	12	25	6	65	1
A10040313322F1	HFG 0113.03 ZX	ZX	SPG 0113	3	13	3	40	1
A10040204322F1	HFG 0204.03 ZX	ZX	SPG 0204	4	20	4	60	1
A100411215622F1	HFG 1125.06 ZX	ZX	SPG 1125	12	25	6	65	1
A10050113222F1	HFM 0113.03 ZX	ZX	SXM 0113	3	11	3	40	1

Recommended for: Steel Cast material Stainless Other



## 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	Stock diameter (mm)	Quality	Content	Part number
A2066W0567ZF1	Ceramic assortment	8	Ceramic	5 parts: ZY 1832, ZY 1832, SP 1326, KU 1393, KE 1832	1

## Inox mounted point assortment



- for non-hardening steel
- 4 different shapes for fast tool changes in specialist retail packaging
- excellent stock removal performance, also under adverse conditions

★★☆

Product number	Description	Stock diameter (mm)	Quality	Content	Part number
A2048004627WF1	Inox assortment	8	NK BA	4 parts: ZY 1332.06 NK 24 N BA soft ZY 2040.06 NK 24 N BA soft ZY 74088.06 NK 24 N BA soft KU 2525.06 NKBK 24 N BA SE	1

## 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	Stock diameter (mm)	Quality	Content	Part number
A2049005603F1	Steel assortment	8	ESP	5 parts: ZY 1832.06 ERK 48 N V4 ZY 2525.06 ERK 36 N V4 WKS 2625.06 ERK 60 N V4 KU 2525.06, ERK 36 N V4 KE 1832.06, ERK 48 N V4	1

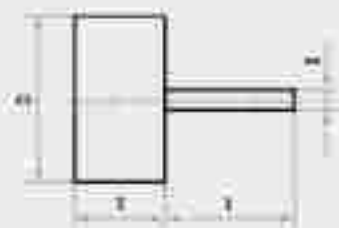
## EFFICIENT AND PRODUCTIVE SURFACE GRINDING

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, dusting, fettling, deburring, surface grinding, decorative finishing and bonding
- impressive tool life working with various materials



★★★

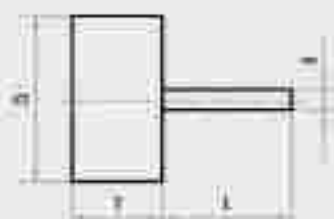
Product number	Description	Grk	D mm	T mm	d mm	L mm	Flap type	Flap type	Peak cutting
A2200030103068F1	SFL 03010.03	NK 30	30	10	3	40	16,000	10,000	1
A2200030103088F1	SFL 03010.03	NK 30	30	10	3	40	16,000	10,000	1
A2200030101308F1	SFL 03010.03	NK 130	30	10	3	40	16,000	10,000	1
A2200040200088F1	SFL 04020.04	NK 30	40	20	6	40	12,000	10,100	1
A2200040200088F1	SFL 04020.04	NK 30	40	20	6	40	12,000	10,100	1
A2200040200120F1	SFL 04020.04	NK 120	40	20	6	40	12,000	10,100	1
A2200060300048F1	SFL 06030.06	NK 30	60	30	6	40	8,000	12,700	1
A2200060300048F1	SFL 06030.06	NK 30	60	30	6	40	8,000	12,700	1
A2200060300088F1	SFL 06030.06	NK 30	60	30	6	40	8,000	12,700	1
A2200060300120F1	SFL 06030.06	NK 120	60	30	6	40	8,000	12,700	1

# THE FINISHING TOUCH FOR SURFACES

ABRASIVE FLEECE FOR MANUAL USE



## SFV mounted flap wheels



- flap wheels with regular aluminum oxide in retail packaging
- consisting of abrasive fleece flaps radially located around the hub of the tool
- ideal for matting, conditioning, polishing, finishing and the surface finishing

★★☆

Product number	Description	Quality	Qty	D mm	T mm	d mm	L mm	$n_{flap}$ /flap	$n_{flap}$ /pack	Pack contents
A2383040206104FT	SFV 04020.06	A 104	NK 100	40	25	6	40	1500	14,000	1
A2383040206106FT	SFV 04020.06	A 106	NK 100	40	20	6	40	2500	14,000	1
A2383040206104FT	SFV 06020.06	A 104	NK 100	60	30	6	40	5,000	3,000	1
A2383040206106FT	SFV 06020.06	A 106	NK 100	60	30	6	40	5,000	3,000	1

## SFM mounted flap wheels



- flap wheels with regular aluminum oxide in retail packaging
- in a combination of abrasive flaps and cloth for a high stock removal performance
- suitable for cleaning, smoothing, pre-finishing, grinding and skiving

★★☆

Product number	Description	Quality	Qty	D mm	T mm	d mm	L mm	$n_{flap}$ /flap	$n_{flap}$ /pack	Pack contents
A2304060206104FT	SFM 04020.06	A 104/150	NK 100/150	40	20	6	40	1500	14,000	1
A2304060206106FT	SFM 04020.06	A 106/150	NK 100/150	40	20	6	40	1500	14,000	1
A2304060206104FT	SFM 06020.06	A 104/150	NK 100/150	60	30	6	40	5,000	3,000	1
A2304060206106FT	SFM 06020.06	A 106/150	NK 100/150	60	30	6	40	5,000	3,000	1







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  - SBL finishing belt ..... 204, 303
  - SBZY abrasive band, cylindrical shape, without lining ..... 201
  - SBZY Ceramic abrasive band, cylindrical shape ..... 198
  - SBZY regular aluminium oxide abrasive band, cylindrical shape ..... 198/199
  - SBZY Z-Power abrasive band, cylindrical shape ..... 198
  - SBZY zirconia alumina abrasive band, cylindrical shape ..... 197
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  - STKE hard abrasive band mandrel, conical shape ..... 202
  - STWS soft abrasive band mandrel, cylindrical shape ..... 203
  - STZY hard abrasive band mandrel, cylindrical shape ..... 200
  - STZY soft abrasive band mandrel, cylindrical shape ..... 200/201
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    - PSR self-clamping abrasive disc, wide abrasive fleece ..... 225
    - PSR self-clamping zirconia alumina abrasive disc ..... 224
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    - PSK adhesive regular aluminium oxide abrasive disc ..... 229
    - PSK adhesive silicon carbide abrasive disc ..... 228
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# General terms and conditions

## I. SCOPE OF APPLICATION

- 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 conclusively based on our General Terms of Business which are deemed accepted upon 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.
- Our auxiliary agreements hereto or in addition to these terms of business do not exist. Any auxiliary 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.
- These General Terms of Business only apply to companies, legal entities under public law or public special funds or assets ("Gesetzestragern") pursuant to German law.

## II. OFFERS AND PROPOSALS

- Our offers and proposals are subject to design and test testing. 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.
- 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.
- We reserve the right of ownership and copyright in all products, 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

- An order is deemed accepted if it has been confirmed in writing or delivered.
- Content and scope of an order are subject to order confirmation.
- The buyer is liable for the correctness of any documents to be supplied by them, such as drawings, samples, etc. Our agreements about dimensions, etc. are required to be in writing.

## IV. PRICING

- Our prices are quoted in euros or works. Excludes taxes pursuant to Incoterms 2010, including packaging, freight, postage, customs duties and tariffs, and insurance. Savings and discounts are based on the basic price. The same applies to any partial or express agreements requested by the buyer.
- The minimum order value is EUR 120.00 net. For orders under EUR 120.00 we charge a handling fee of EUR 15.00.
- All prices are net prices and subject to the currently applicable VAT.
- 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 or, in the 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

- Payments are due within 14 days of the date of invoice less 2% discount or 30 days net. Payments are deemed to be made in full if they are received in our accounts no later than on the due date.
- In the event of default, interest at the legal rate of currently 5% 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.
- Fast deliveries are always required to be paid upfront or by cash on delivery.
- 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 state of the buyer, we are entitled to withhold further deliveries. In the 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, next in the case of payment by check. After the highest copy 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 debt and obligations arising in connection with these parts of the contract already fulfilled by us or in connection with orders or not yet fulfilled contracts.
- We retain the right to accept any accounts receivable in a third party.
- The buyer is only entitled to a set-off if his counterclaims are not judicial, 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

- The delivered goods remain our property (goods subject to retention of title) until full payment of all claims against 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.
- The buyer is obliged to insure 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.

- The buyer is entitled to process, combine, mix and/or re-use 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.
- 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 in or, at the time of conclusion of the delivery contract, the accounts receivable against any such purchase or other third party in connection with the resale, as collateral for our accounts receivable. We accept any such assignment. We subvert the buyer, until further notice, to collect the assigned accounts receivable. We are entitled to revoke this authorization if our assigned accounts receivable are in jeopardy including, but not limited to the buyer being in default with their payments. The authorization 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 authorization, we are entitled and the buyer is obliged to notify the debtor of the assigned accounts receivable about such assignment. The buyer must in turn form 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 goods delivery items and hand over to us all information and documents regarding the assigned accounts receivable. Upon request of the buyer, we undertake to return 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.
- Extraordinary disposal of the collateral, including but not limited to possession or non-possession items or assignment and security agreements, requires our prior consent. In the event of loss 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 essential. The corresponding 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, loss or other type of measure and the replacement of the goods subject to retention of title, insofar as these costs cannot be collected from any third party.
- 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 VI 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

- 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 signed down payment and (iv) the fulfilment of all other obligations incumbent on the buyer.
- 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 events directly occurred at our site or at our sub-supplier's site, rendering them unable to supply us on time, including but not limited to operational disruptions, acute shortages of industrial or job services, or similar.
- 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 command or matching supply agreement in good time ("Kaufvertrag/Dienstleistungvertrag") 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.
- If the delivery or service becomes impossible due to the events mentioned in sections 7 and 8, 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.
- In a reasonable event, we are entitled to make partial deliveries.

## VIII. SCOPE AND EXECUTION OF DELIVERY; TRANSFER OF RISK

- The scope of delivery is subject to our delivery note. The minimum order quantity is one packaging unit.
- Incompleteness in quantity must be communicated within eight days upon receipt of goods.
- Items in 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.
- Due to manufacturing conditions, changes of up to +/- 15% of the ordered quantity are permissible for products not held in stock.
- We reserve the right to technical modifications of our products resulting from continued 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 dispatch from our warehouse or, in the case of drop shipping, at the time of dispatch from the supplier's site. This also applies to any form of damage 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 extend 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 invoice upon the expiration date.

#### CK. 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 incurred from such rectification provided that costs are not incurred 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, misuse, 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 us and our vicarious agents, as per §§78 German Civil Code, with intent or gross negligence. We are, for (damages liable to) for any breach of warranty, §4 when accepting a procurement risk or any other trading assurances, but in the event of culpable personal injury to life, body or health or to the property within the scope of the German Product Liability Act, in the event of culpable breach of statutory contractual duties, i.e. of any such obligation that renders the proper execution of the contract possible in the

- first place and the fulfillment 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 potential liability of our staff, employees, 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 commitment 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 11 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 <http://ilubac.org.uk/privacy-policy> or <http://ilubac.com/privacy-policy> or as attached. In 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 Eschborn, 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 firms or assets ("öffentlich-rechtliche 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.

Revised: December 2023

## CONDITIONS

List prices quoted are ex works (Eschborn) 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 in 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 dispatched and invoiced in full.

## RETURNS AND EXCHANGES

Any returns or exchanges, for whatever reason, must be received by us (cargo 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.

Reprints 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 lock up post



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



Belted machine



Flexible shaft grinder



Bench cut-off machine



Pistol 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

● Iron/Steel

◐ Steel

● Aluminum

● 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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Vöhringhe Schieß- und Feilswerk-  
zeugfabrik GmbH & Co. KG  
Gebrüder Lukas Straße 1  
51806 Hingelshausen, Germany  
Phone: +49 2203 94 0  
Fax: +49 2203 94 327 (Domestic Sales)  
Fax: +49 2203 94 000 (International Sales)  
lukas-erzett.de

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## PRODUCTION AND SALES LOCATIONS



### LUKAS-ERZETT

Vereinigte Stahl- und Eiswerk-  
zuegefabriken GmbH & Co. KG  
Gebäude-Lukas Straße 1  
57769 Engelskirchen, Germany  
Phone +49 2283 940  
Fax +49 2283 94.327 (Domestic Sales)  
Fax +49 2283 94.300 (International Sales)  
info@lukas-erzett.de

Kaplan Group Limited  
Chengli Road  
Economic Business Park Ordubashi  
CO4 9C9 Erzurum  
Phone +44 1206 753500  
Fax +44 1206 75 1212  
akras@erzett.kaplangroup.com.tr

LUKAS-ERZETT  
Vereinigte Stahl- und Eiswerk-  
zuegefabriken GmbH & Co. KG  
C/ Vitoria, 1 Pol. Ind. El Llano  
28970 Manzanares de Madrid  
Phone 902 828 824  
Fax 902 824 525  
info@lukas-erzett.de

Beijing Representative Office  
Room 222A - 29th Floor  
C-King Apartment  
Bld. III Madison East Rd.  
300080 Haidian District Beijing  
Phone +86 10 62983328  
Fax +86 10 62960016  
beijing@lukas-erzett.com.cn

LUKAS CZ spol. s r.o.  
Tuzovská 67b  
35134 Skutina  
Phone +420 267 879000  
Fax +420 267 879013  
skutina@lukas.cz  
www.lukas-erzett.com

LUKAS ARKADYEV SA (PTY) LTD  
12th Marriot Avenue  
Ditshabane  
1401 Germiston  
Phone +27 11 6257050  
Fax +27 11 6720144  
arkadyev@lukas.co.za  
www.lukas.co.za

LUKAS Tools Trading Shanghai Co. Ltd.  
In German Centre  
Unit 212 II - Block 2, Tower 1  
28 Kayan Road  
Zhang Jiang Hi Tech Park  
Pudong New District  
201 203 Shanghai  
shanghai@lukas-erzett.com